JAWS FOR ALL
COMMON MANUAL
AND POWER CHUCKS

JAWS 9



SMW® AUTOBLOK

SMW-AUTOBLOK jaw programm

Jaws for all common manual and power chucks

- Special jaws according to the customer drawings
- Turn keys = complete engineering and manufacturing of top tooling

Your advantage:

- 90 % of the jaws are avialable from stock
- Technical support from our experienced specialists
- Economic price
- Full warranty
- Own production
- We use high quality steel



Orders for stock items received until 3:00 O`clock pm ship out the same day



SMW-AUTOBLOK Meckenbeuren





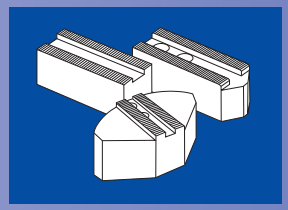
SMW-AUTOBLOK Caprie (Turin) - Italien

SMW® AUTOBLOK

soft top jaws

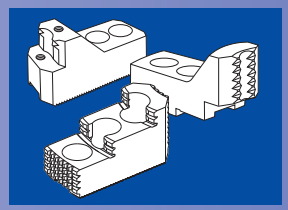
steel ■ aluminium

INCH serration
1/16" x 90° or 3/32" x 90°



hard top jaws

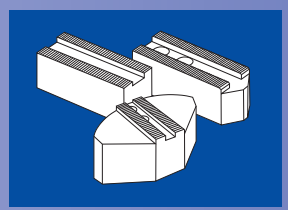
INCH serration
1/16" x 90° or 3/32" x 90°



soft top jaws

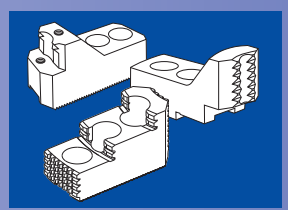
steel ■ aluminium

METRIC serration
1,5 x 60° or 3 x 60°

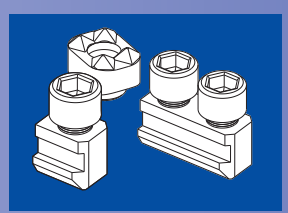


hard top jaws

METRIC serration
1,5 x 60° or 3 x 60°

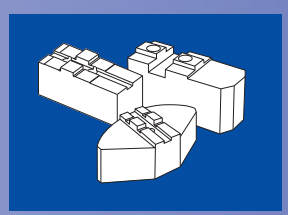


- T-nuts
- grippers



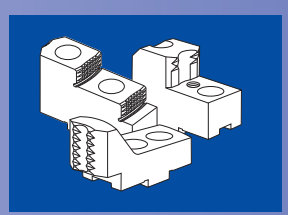
soft top jaws

tongue & groove



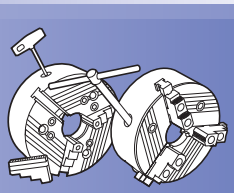
hard top jaws

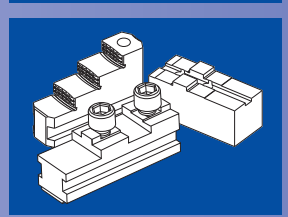
tongue & groove



quick jaw change

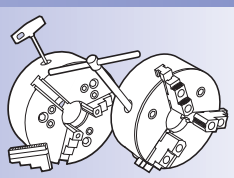
for manual and power chucks
straight modular serration System SMW/Reishauer

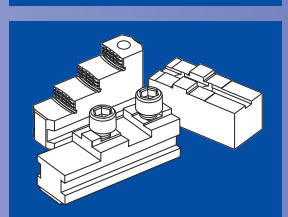




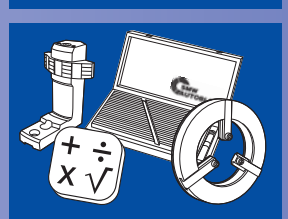
quick jaw change

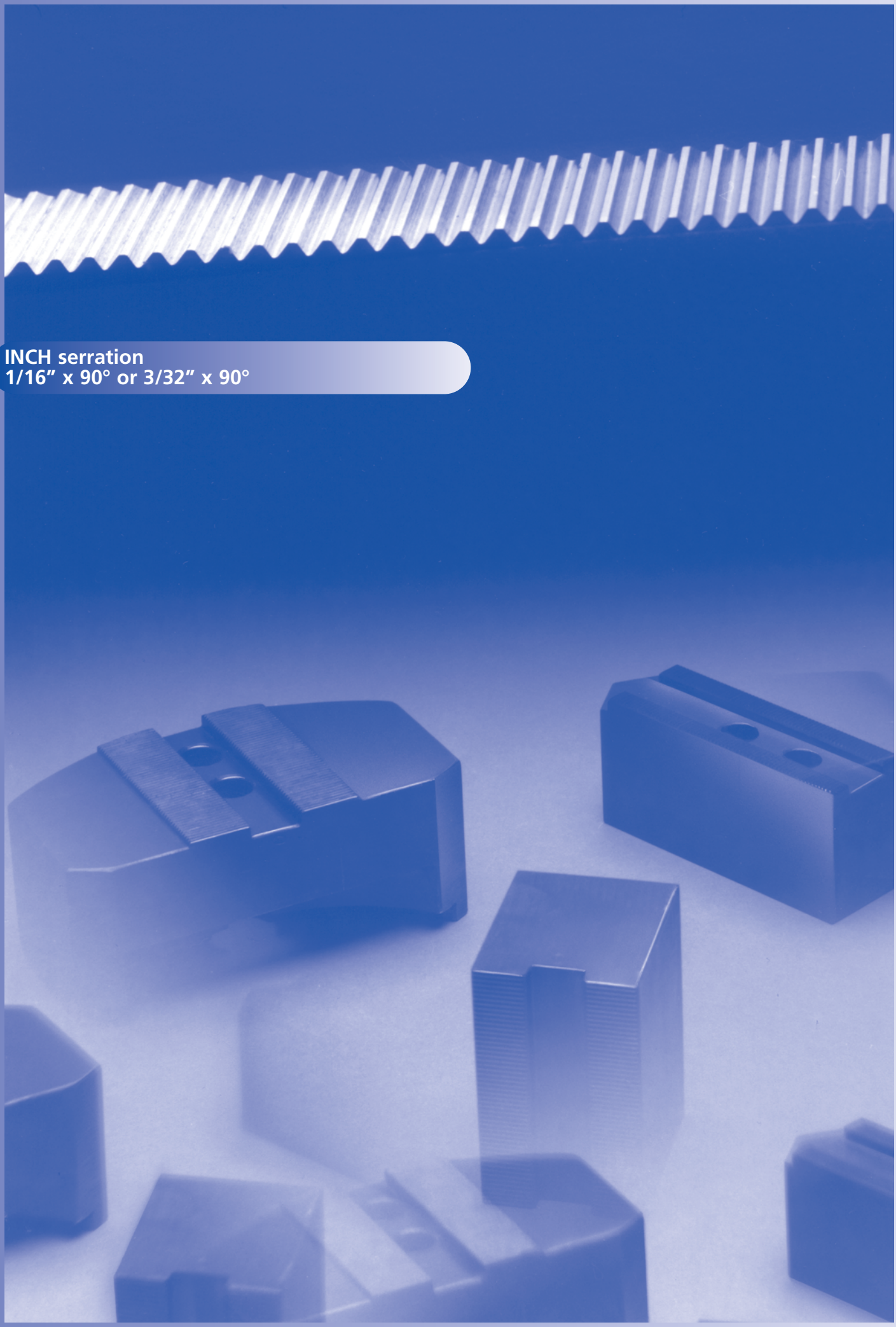
for manual and power chucks
helix modular serration System Forkardt





- special jaws
- boring rings
- dress and cleaning plate
- calculations

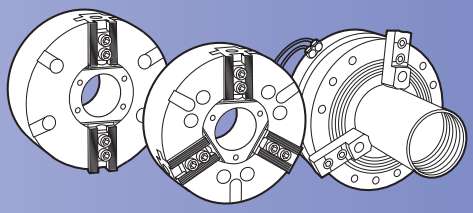



INCH serration
1/16” x 90° or 3/32” x 90°

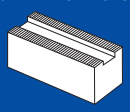
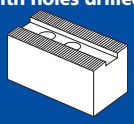
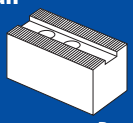
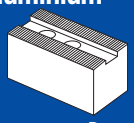
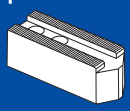
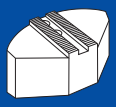
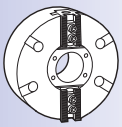
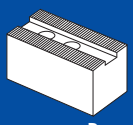
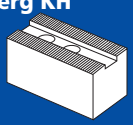
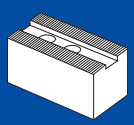
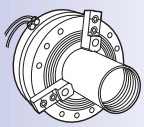
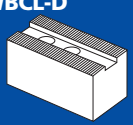
soft top jaws

steel ■ aluminium

INCH serration
1/16" x 90° or 3/32" x 90°



SMW-AUTOBLOK Berg Forkardt Röhm Schunk

MAB-D	soft top jaws	16MnCr5	blank w.o. holes	**MAB-D** blank w.o. holes  Page 7
MAB-DL	soft top jaws extended versions	16MnCr5	blank w.o. holes	
MAB-D	soft top jaws (Bolt pattern to customer request)	16MnCr5	with holes drilled	**MAB-D** with holes drilled  Page 7
MWB-D	soft top jaws	16MnCr5	standard	**MWB-D** tall  Page 8
MWB-DA	alum.-top jaws	aluminium F50		**MWB-DA** aluminium  Page 10
LWB-D	soft top jaws	16MnCr5	low profile	**LWB-D** low profile  Page 12
AWB-D	soft top jaws	16MnCr5	tipped	**AWB-D** tipped  Page 14
SBS-D	soft pie jaws	16MnCr5		**SBS-D**  Page 16
SBA-D	alum. pie jaws	aluminium F50		**SBA-D** aluminium  Page 18
MAB-D	soft top jaws 2 jaw chuck	16MnCr5		**MAB-D** 2 pieces/set  Page 20
WBSA-D	soft top jaws for SMW-AUTOBLOK-chucks	C45 (flame hardenable)		**WBSA-D**  Page 21
WBB-D	soft top jaws for Berg-chucks type KH	16MnCr5		**WBB-D** Berg KH  Page 22
WBR-D	soft top jaws for Röhm-chucks type KFD-HS Schunk-chucks type HSG			**WBR-D**  Page 22
WBC-D	soft top jaws for pneumatic front-end chucks			**MWB-D, WBC-D WBCL-D**  Page 23

safety advise:
Top jaws are safety components, which can unter high load depending on their use.
Max grip forces and speeds must not be exceeded at any time.
For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

Hardening instruction for soft jaws

Material 16MnCr5 (1.7131)



1. Preheat to 500 ° Celsius.
2. Carburise at 930 ° Celsius.
   Carburising depth is appr. 0,1 mm per hour.
3. Harden at 850 ° Celsius and quench in oil at 100 ° Celsius.
4. Wash and clean from oil.
5. Temper at 150 - 180 ° Celsius according to requested hardness about 2 hours.
6. Regrind the serration in case of distortion.

Material C45 (1.0503)



The carbon necessary for hardening is already in the material. Partial (such as clamping area) is possible by induction hardening.
A distortion of the contact surface can be eliminated or reduced in most cases.

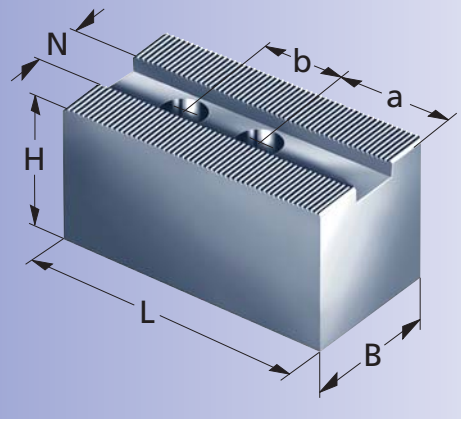
1. Partial preheating to 870 - 930 ° Celsius (1 - 3 mm deep).
2. Quench harden in emulsion.
3. Temper at 150 - 180 ° Celsius according to requested hardness about 2 hours.

⚠ Jaws from Material C45 must be inspected for cracks after induction hardening.

soft top jaws columns
MAB-D
blank w. o. holes and with holes drilled

INCH serration
1/16" x 90° or 3/32" x 90°

Material: 16MnCr5
serration ground



Type	Id.-No. blank w.o. holes	Id.-No. with holes drilled*	B	H	L	N	serration	a + b	DIN 912	kg/piece blank w.o. holes
MAB-D 1002	081562	032932	35	50	60	10	1/16" x 90°	*	M 6	0,80
MAB-D 1202	081564	032934	35	50	70	12	1/16" x 90°	*	M 8	0,90
MAB-D 1401	090717	091315	40	40	90	14	1/16" x 90°	*	M 10	1,07
MAB-D 1402	090718	091316	40	60	90					1,63
MAB-D 1701	081565	032935	35	50	70	17	1/16" x 90°	*	M 12	0,90
MAB-D 1710	081566	032936	40	40	70					0,83
MAB-D 1711	081567	032937	40	40	90					1,07
MAB-D 1712	081568	032938	40	40	105					1,20
MAB-D 1713	081569	032939	40	60	70					1,27
MAB-D 1714	081571	032940	40	60	90					1,63
MAB-D 1715	081572	032941	40	60	120					1,90
MAB-D 1716	081573	032942	40	80	90					2,13
MAB-D 1718	081575	032944	40	120	90					3,30
MAB-D 1730	081576	032945	50	80	90					2,70
MAB-D 1751	081579	032948	60	60	90					2,40
MAB-D 1760	081583	032952	80	60	90					3,15
MAB-D 2101	081584	032953	45	60	90	21	1/16" x 90°	*	M 16	2,03
MAB-D 2111	081588	032956	50	50	120					2,00
MAB-D 2112	081589	032957	50	80	90					2,77
MAB-D 2113	081590	032958	50	80	120					3,63
MAB-D 2114	035239	091317	50	100	120					4,50
MAB-D 2115	090721	091318	50	80	150					4,60
MAB-D 2120	081591	032959	60	60	90					2,43
MAB-D 2125	081596	032964	60	100	120					5,60
MAB-D 2126	081597	032965	60	120	120					6,80
MAB-D 2141	233366	233367	80	80	120					5,90
MAB-D 2501	081599	032967	60	60	140	25,5	3/32" x 90°	*	M 20	3,80
MAB-D 2502	081600	032968	60	80	140					3,80
MAB-D 2503	081601	032969	60	100	155					7,07
MAB-D 2504	081602	032970	60	120	155					8,60
MAB-D 2505	081603	032971	60	150	155					10,20
MAB-D 2506	090720	091319	60	100	200					9,20
MAB-D 2511	081605	032973	80	80	140					7,00

soft top jaws columns
MAB-DL
long version

Type	Id.-No.	B	H	L	N	serration	kg/piece
MAB-DL 120	233363	35	60	420	12	1/16" x 90°	6,70
MAB-DL 140	233364	35	60	420	14	1/16" x 90°	6,70
MAB-DL 170	233365	40	60	420	17	1/16" x 90°	7,60
MAB-DL 171	233310	40	100	420	17	1/16" x 90°	12,80
MAB-DL 210	233316	50	60	420	21	1/16" x 90°	9,40
MAB-DL 211	233368	50	120	420	21	1/16" x 90°	19,30
MAB-DL 250	233369	60	100	420	25,5	3/32" x 90°	19,20

Other dimensions on request.
Use the data sheet on page 24 for ordering.

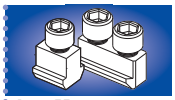
* Indicate when ordering the version with holes drilled



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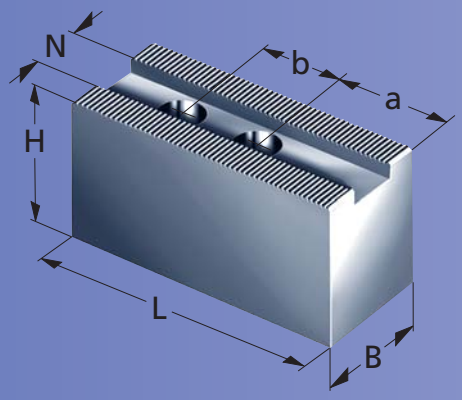

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soft top jaws
MWB-D

INCH serration
1/16" x 90° or 3/32" x 90°

Material: 16MnCr5
serration ground



Type	Id.-No.	B	H	L	N	serration	a + b for DIN 912	kg/ set	SMW-AUTOBLOK	SMW	Autoblok
MWB-D 111	**007094**	20	30	50	8	1/16" x 90°	26,5 + 12 M6	0,6	HFKN-D110	HFKS 110-26	
MWB-D 130	**013488**	30	40	55	12	1/16" x 90°	29 + 16 M8	1,2	AN/AL- D 125 BH/HB/PB-D 130 BB-D 140 SP/STP 125	KDV 130	ODN 125 GHDN 125
MWB-D 165	**233372**	35	60	70	14	1/16" x 90°	33 + 16 M10	2,5	HFKN-D 165 SP/STP160 AN/AL/BH/HB-D 165 BHD-FC 165 PB/PBI/RC-D 165 AP/NT-D 170 BB-D 175 HYND-S 180		
MWB-D 160	**013489**	40	60	70	17	1/16" x 90°	33 + 22 M12	3,1	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/ PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 160/200/250 KDVG 160/200/250 KFV 160/200 HFK/HFKS 160/200 KFMF 160/200	ODL 200 ODN 200/220 HDL 200 HDN 200/220 GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
MWB-D 200	**013490**	40	60	90	17	1/16" x 90°	43 + 22 M12	4,2	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/ PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 200/250 KDVG 200/250 KFV 200 HFK/HFKS 160/200 KFMF 200	ODL 200 ODN 200/220/250 S HDL 200 HDN 200/220/250 S GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
MWB-D 250	**013491**	50	80	120	21	1/16" x 90°	62 + 28 M16	9,3	HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250* AN/AL/BH/BB-D 315* BHD-FC 250/315* RC-D 250/305/400* CC 350Z HB/PB/PBI-D 250/315* AP/APL/NT-D 315* HYND-S 250/315*	KDV 315/400 KDVG 315/400 KFV 250/315 HFK/HFKS 250/270/315 KFMF 250/315 SP/STP/STWP 250 SP/STP/STWP 315 LP 250	ODL 250/315/400 ODN 250/315/400 HDL 250/315/400 HDN 200/315/400 GHD/FC 250/305/400 GHDN 250/315/400 HDB 300 CD 250/315-65/315-85 250 RCD 305 RCD
MWB-D 400	**013492**	60	90	155	25,5	3/32" x 90°	90 + 35 M20	16,3	HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/460/500/600 BB-N ES 400/460/500/600 BB-AZ-ES 500 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYD-S 400/500 HYDL-S 400/500/550/630/800 HYDLL-S 550/630	KDV 500 KDVG 500 KFV 400/500/630/800 HFK/HFKS 400/500	

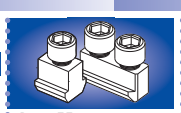
* with single T-nuts only

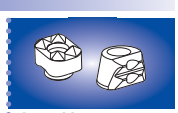


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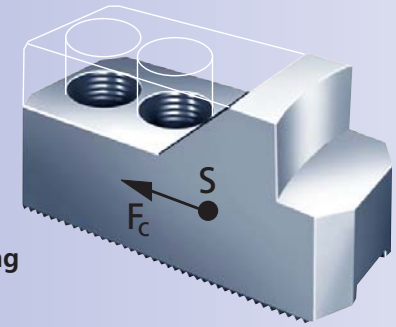


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**Reduced jaw mass =
Reduced loss of grip force on the chuck under rotation.
Always lighten the top jaws when using them at high speeds!**

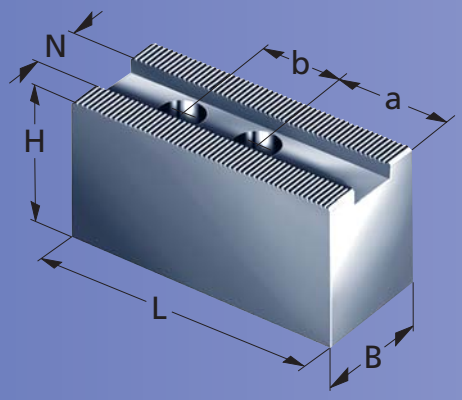


Berg	Forkardt	Röhm	Schunk
KF 3/130	KTH 130/140	KFD 130 • KFH 140 KFD-HS 160/175 KFD-HE 170 LVE 125/160	HSG 160 ROTA NCD 165
KF 160/200 HES 160/200 HESF 160/200 KHFF 200	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF/ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
KF 160/200 HES 160/200 HESF 160/200 KHFF 200	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF/ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
KF 250/315 HES 250/315 HESF 250/315 KHFF 250/315	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD/ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
KF 400/500/630 HES 400/500/630 HESF 400/500/630 KHFF 400	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500

soft top jaws aluminium

MWB-DA light version

INCH serration
1/16" x 90° or 3/32" x 90°
Material: aluminium (tensile strength = 500 N/mm²)

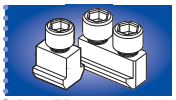


Type	Id.-No.	B	H	L	N	serration	a + b for DIN 912	kg/ set	SMW-AUTOBLOK	SMW	Autoblok
MWB-DA 165	**036011**	40	60	70	14	1/16" x 90°	36 + 22 M10	1,1	HFKN-D 165 SP/STP 160 AN/AL/BH/HB-D 165* BHD-FC 165* PB/PBI/RC-D 165* AP/NT-D 170* BB-D 175* HYND-S 180*	SP 160 STP 160	GHD-FC 165 GHDN 165
MWB-DA 200	**081645**	40	60	90	17	1/16" x 90°	43 + 22 M12	1,5	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/ PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 160/200/250 KDVG 160/200/250 KFV 160/200 HFK/HFKS 160/200 KFMF 160/200	ODL 200 ODN 200/220/250 S HDL 200 HDN 200/220/250 S GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
MWB-DA 250	**081646**	50	80	120	21	1/16" x 90°	62 + 28 M16	3,3	HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250* AN/AL/BH/BB-D 315* BHD-FC 250/315* RC-D 250/305/400* CC 350Z HB/PB/PBI-D 250/315* AP/APL/NT-D 315* HYND-S 250/315*	KDV 315/400 KDVG 315/400 KFV 250/315 HFK/HFKS 250/270/315 KFMF 250/315 SP/STP/STWP 250 SP/STP/STWP 315 LP 250	ODL 250/315/400 ODN 250/315/400 HDL 250/315/400 HDN 200/315/400 GHD/FC 250/305/400 GHDN 250/315/400 HDB 300 CD 250/315-65/315-85 250 RCD 305 RCD
MWB-DA 400	**081647**	60	100	155	25,5	3/32" x 90°	94 + 35 M20	6,5	HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/460/500/600 BB-N ES 400/460/500/600 BB-AZ-ES 500 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYD-S 400/500 HYDL-S 400/500/550/630/800 HYDLL-S 550/630	KDV 500 KDVG 500 KFV 400/500/630/800 HFK/HFKS 400/500	

* with single T-nuts only



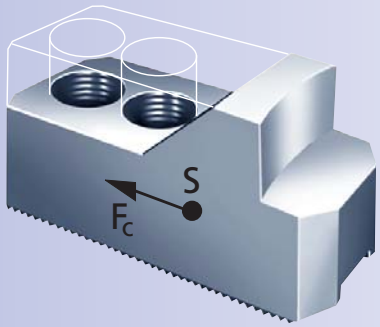
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- Less jaw mass (3 x lighter than steel jaws)
- Higher chip removal at higher speeds

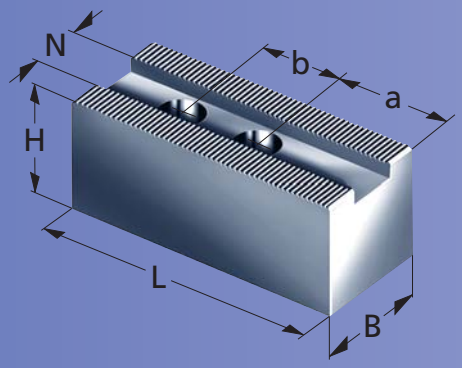
Also Aluminium jaws are subject to centrifugal force. Also lighten these jaws for less loss of grip force!



Berg	Forkardt	Röhm	Schunk
			TP 160 Rota TP 160
KF 160/200 HES 160/200 HESF 160/200 KHFF 200	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF/ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
KF 250/315 HES 250/315 HESF 250/315 KHFF 250/315	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD/ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
KF 400/500/630 HES 400/500/630 HESF 400/500/630 KHFF 400	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500

soft top jaws

LWB-D shallow design



INCH serration
1/16" x 90° or 3/32" x 90°

Material: 16MnCr5
serration ground

Type	Id.-No.	B	H	L	N	serration	a + b for DIN 912	kg/ set	SMW-AUTOBLOK	SMW	Autoblok
LWB-D 160	**081613**	40	40	80	17	1/16" x 90°	43 + 22 M12	2,0	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 160/200/250 KDVG 160/200/250 KFV 160/200 HFK/HFKS 160/200 KFMF 160/200	ODL 200 ODN 200/220 HDL 200 HDN 200/220 GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
LWB-D 200	**081615**	40	40	90	17	1/16" x 90°	53 + 22 M12	2,7	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 200/250 KDVG 200/250 KFV 200 HFK/HFKS 160/200 KFMF 200	ODL 200 ODN 200/220/250 S HDL 200 HDN 200/220/250 S GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
LWB-D 250	**081617**	50	50	120	21	1/16" x 90°	70 + 28 M16	5,1	HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250* AN/AL/BH/BB-D 315* BHD-FC 250/315* RC-D 250/305/400* CC 350Z HB/PB/PBI-D 250/315* AP/APL/NT-D 315* HYND-S 250/315*	KDV 315/400 KDVG 315/400 KFV 250/315 HFK/HFKS 250/270/315 KFMF 250/315 SP/STP/STWP 250 SP/STP/STWP 315 LP 250	ODL 250/315/400 ODN 250/315/400 HDL 250/315/400 HDN 200/315/400 GHD/FC 250/305/400 GHDN 250/315/400 HDB 300 CD 250/315-65/315-85 250 RCD 305 RCD
LWB-D 400	**081620**	60	60	140	25,5	3/32" x 90°	80 + 35 M20	9,4	HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/460/500/600 BB-N ES 400/460/500/600 BB-AZ-ES 500 AN/AL/BB -D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYD -S 400/500 HYDL-S 400/500/550/630/800 HYDLL-S 550/630	KDV 500 KDVG 500 KFV 400/500/630/800 HFK/HFKS 400/500	

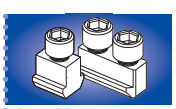
* with single T-nuts only

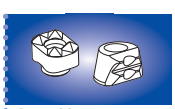


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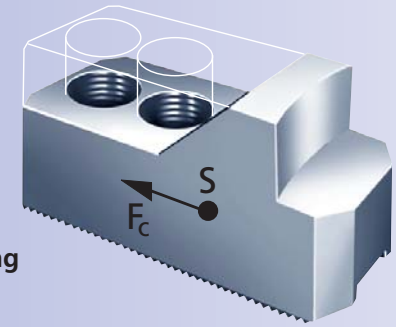


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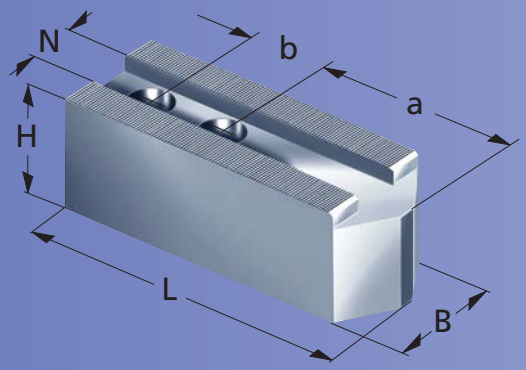
**Reduced jaw mass =
Reduced loss of grip force on the chuck under rotation.
Always lighten the top jaws when using them at high speeds!**



Berg	Forkardt	Röhm	Schunk
KF 160/200 HES 160/200 HESF 160/200 KHFF 200	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF/ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
KF 160/200 HES 160/200 HESF 160/200 KHFF 200	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF/ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
KF 250/315 HES 250/315 HESF 250/315 KHFF 250/315	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD/ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
KF 400/500/630 HES 400/500/630 HESF 400/500/630 KHFF 400	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500

soft top jaws

AWB-D low/tipped version



INCH serration
1/16" x 90°

Material: 16MnCr5
serration ground

Type	Id.-No.	B	H	L	N	serration	a + b for DIN 912	kg/ set	SMW-AUTOBLOK	SMW	Autoblok
AWB-D 110	**038258**	20	20	55	8	1/16" x 90°	30 + 12 M6	0,55	HFKN-D 110	HFKS 110-26	
AWB-D 165	**035954**	40	40	80	14	1/16" x 90°	43 + 22 M10	2,0	HFKN-D 165 SP/STP 160 AN/AL/BH/HB-D 165* BHD-FC 165* PB/PBI/RC-D 165* AP/NT-D 170* BB-D 175* HYND-S 180*	SP 160 STP 160	GHD-FC 165 GHDN 165
AWB-D 160	**081614**	40	40	80	17	1/16" x 90°	43 + 22 M12	2,0	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 160/200/250 KDVG 160/200/250 KFV 160/200 HFK/HFKS 160/200 KFMF 160/200	ODL 200 ODN 200/220 HDL 200 HDN 200/220 GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
AWB-D 200	**081616**	40	40	90	17	1/16" x 90°	53 + 22 M12	2,7	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/ PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 200/250 KDVG 200/250 KFV 200 HFK/HFKS 160/200 KFMF 200	ODL 200 ODN 200/220/250 S HDL 200 HDN 200/220/250 S GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
AWB-D 250	**081618**	50	50	120	21	1/16" x 90°	70 + 28 M16	5,3	HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250* AN/AL/BH/BB-D 315* BHD-FC 250/315* RC-D 250/305/400* CC 350Z HB/PB/PBI-D 250/315* AP/APL/NT-D 315* HYND-S 250/315*	KDV 315/400 KDVG 315/400 KFV 250/315 HFK/HFKS 250/270/315 KFMF 250/315 SP/STP/STWP 250 SP/STP/STWP 315 LP 250	ODL 250/315/400 ODN 250/315/400 HDL 250/315/400 HDN 200/315/400 GHD/FC 250/305/400 GHDN 250/315/400 HDB 300 CD 250/315-65/315-85 250 RCD 305 RCD
AWB-D 315	**081619**	50	50	140	21	1/16" x 90°	90 + 28 M16	9,4	HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 315* BHD-FC 315* RC-D 305/400* CC 350Z HB/PB/PBI-D 315* AP/APL/NT-D 315* HYND-S 315*	KDV 315/400 KDVG 315/400 KFV 315 HFK/HFKS 270/315 KFMF 315	ODL 315/400 ODN 315/400 HDL 315/400 HDN 315/400 GHD/FC 305/400 GHDN 315/400 HDB 300 CD 315-65/315-85 305 RCD

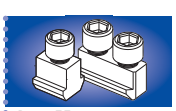
* with single T-nuts only

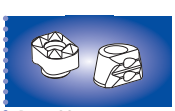


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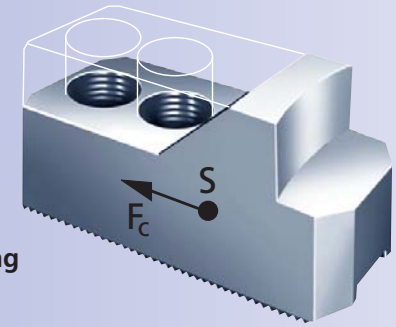


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**Reduced jaw mass =
Reduced loss of grip force on the chuck under rotation.
Always lighten the top jaws when using them at high speeds!**



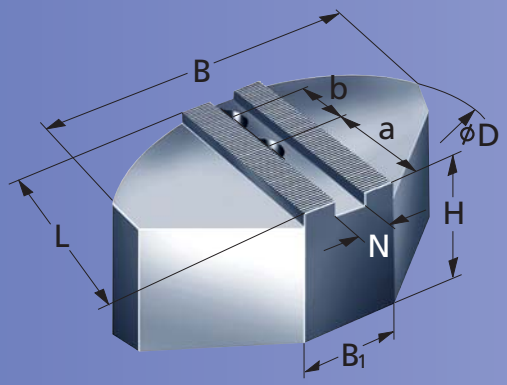
Berg	Forkardt	Röhm	Schunk
			TP 160 ROTA TP 160
KF 160/200 HES 160/200 HESF 160/200 KHFF 200	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF/ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
KF 160/200 HES 160/200 HESF 160/200 KHFF 200	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF/ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
KF 250/315 HES 250/315 HESF 250/315 KHFF 250/315	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD/ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
KF 315 HES 315 HESF 315 KHFF 315	QLK/QLC 315 QLK/QLC-KS 315/400 QLK/QLC-LS 315 QLC-AG 315 KG/KT/KP/KTG/KTN/KTGF 315 KLNC/NH/NHF 315 KS 315/400 KSPS 300 KSH/KSHF 315/400 HF315 UVE315	KFD/KFD-HF 315 KFH/KFH-F/KFH-G/KFH-NC 315 KFD-AF 315 KFD-HE 315 KFL 315/400 SPD/SPO 300 LVE 305/315	TH/THF/HSL 315 ROTA NC/ROTA NCD/ROTA NCF 315 ROTA NCO 315 ROTA NCK plus 315 ROTA TP 315 TP 315

soft pie jaws

SBS-D

INCH serration
1/16" x 90° or 3/32" x 90°

Material: 16MnCr5
serration ground



Type	Id.-No.	B	B_1	H	L	D	N	serration	a + b for DIN 912	kg/ set	SMW-AUTOBLOK	SMW	Autoblok
SBS-D 165	**035154**	120	40	60	60	160	14	1/16" x 90°	25 + 22 M10	5,6	HFKN-D 165 SP/STP160 AN/AL/BH/HB-D 165* BHD-FC 165* PB/PBI/RC-D 165* AP/NT-D 170* BB-D 175* HYND-S 180*	SP 160 STP 160	GHD-FC 165 GHDN 165
SBS-D 160	**081639**	120	40	60	60	160	17	1/16" x 90°	25 + 22 M12	5,6	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 160/200/250 KDVG 160/200/250 KFV 160/200 HFK/HFKS 160/200 KFMF 160/200	ODL 200 ODN 200/220 HDL 200 HDN 200/220 GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
SBS-D 200	**081640**	140	60	60	70	200	17	1/16" x 90°	35 + 22 M12	8,3	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 200/250 KDVG 200/250 KFV 200 HFK/HFKS 160/200 KFMF 200	ODL 200 ODN 200/220/250 S HDL 200 HDN 200/220/250 S GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
SBS-D 250/21	**081642**	180	100	70	80	250	21	1/16" x 90°	35 + 28 M16	13,6	HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250* AN/AL/BH/BB-D 315* BHD-FC 250/315* RC-D 250/305/400* CC 350Z HB/PB/PBI-D 250/315* AP/APL/NT-D 315* HYND-S 250/315*	KDV 315/400 KDVG 315/400 KFV 250/315 HFK/HFKS 250/270/315 KFMF 250/315 SP/STP/STWP 250 SP/STP/STWP 315 LP 250	ODL 250/315/400 ODN 250/315/400 HDL 250/315/400 HDN 200/315/400 GHD/FC 250/305/400 GHDN 250/315/400 HDB 300 CD 250/315-65/315-85 250 RCD 305 RCD
SBS-D 400	**133459**	330	150	85	155	440	25,5	3/32" x 90°	85 + 35 M20	55,0	AP/AP-L/NT-D 400* BB-N 400/460/500/600 BB-N ES 400/460/500/600 BB-AZ-ES 500 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYD-S 400/500 HYDL-S 400/500/550/630/800 HYDLL-S 550/630	KDVG 500 KFV 400/500/630/800 HFK/HFKS 400/500	

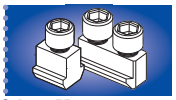
* with single T-nuts only



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Application/customer's benefit

➤ Less deformation of easy deformed parts with wrap around jaws

**Pie jaws are heavy!
High jaw mass =
high loss of grip force under rotation.
Lighten the jaws for high speeds!**

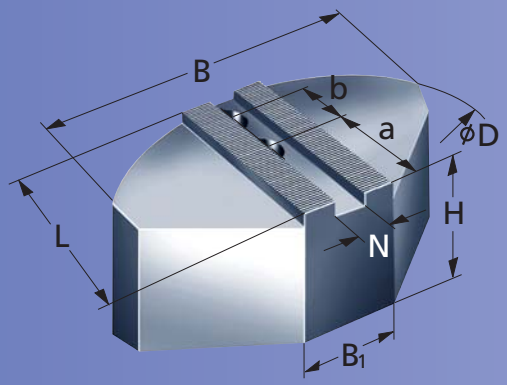
Berg	Forkardt	Röhm	Schunk
			TP 160 ROTA TP 160
KF 160/200 HES 160/200 HESF 160/200 KHFF 200	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF/ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
KF 200 HES 200 HESF 200 KHFF 200	QLK/QLC 200 QLK/QLC-KS 200/250 QLK/QLC-LS 200 QLC-AG 200 NH/NHF 200 KL/KT/KTG/KTN/KS-PS 200 KS 200/250 KSF 200 KGH/KGHF/KTH 200 KG/KP 200 UVE 200/250	KFD/KFD-HF 200 KFH/KFH-F/KFH-G/KFH-NC 200 KFD-AF 200 KFD-HE 210 SPD/SPO 215 LVE 200	TH/THF/HSL 210 ROTA NCD 210 ROTA NC/ROTA NCF/ROTA NCO 210 ROTA NCK plus 210/250 ROTA 2B ROTA TP 200 TP 200
KF 250/315 HES 250/315 HESF 250/315 KHFF 250/315	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD/ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
KF 400/500/630 HES 400/500/630 HESF 400/500/630 KHFF 400	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500

soft pie pie jaws alum.

SBA-D light version

INCH serration
1/16" x 90° or 3/32" x 90°

Material: aluminium (tensile strength = 500 N/mm²)

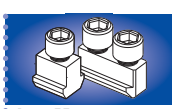


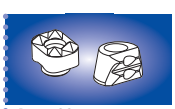
Type	Id.-No.	B	B_1	H	L	D	N	serration	a + b for DIN 912	kg/ set	SMW-AUTOBLOK	SMW	Autoblok
SBA-D 165	**035155**	120	40	60	60	160	14	1/16" x 90°	25 + 22 M10	1,9	HFKN-D 165 SP/STP160 AN/AL/BH/HB-D 165* BHD-FC 165* PB/PBI/RC-D 165* AP/NT-D 170* BB-D 175* HYND-S 180*	SP 160 STP 160	GHD-FC 165 GHDN 165
SBA-D 160	**081648**	120	40	58	60	160	17	1/16" x 90°	25 + 22 M12	1,9	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 160/200/250 KDVG 160/200/250 KFV 160/200 HFK/HFKS 160/200 KFMF 160/200	ODL 200 ODN 200/220 HDL 200 HDN 200/220 GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
SBA-D 200	**081649**	140	50	58	75	200	17	1/16" x 90°	35 + 22 M12	3,0	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 200/250 KDVG 200/250 KFV 200 HFK/HFKS 160/200 KFMF 200	ODL 200 ODN 200/220/250 S HDL 200 HDN 200/220/250 S GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
SBA-D 250/21	**081651**	180	70	78	90	250	21	1/16" x 90°	35 + 28 M16	6,0	HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250* AN/AL/BH/BB-D 315* BHD-FC 250/315* RC-D 250/305/400* CC 350Z HB/PB/PBI-D 250/315* AP/APL/NT-D 315* HYND-S 250/315*	KFV 250 HFK/HFKS 250/270 KFMF 250 SP/STP/STWP 250 LP 250	ODL 250 ODN 250 HDL 250 GHD/FC 250 GHDN 250 CD 250 250 RCD
SBA-D 315	**081652**	240	150	78	110	320	21	1/16" x 90°	60 + 28 M16	10,5	HFKN-D 315 HB/PB/PBI-D 315* SP/SP-L 350 BHD-FC 315* AN/AL/BH/BB-D 315* CC 350Z RC-D 305/400* HYND-S 315* AP/APL/NT-D 315*	KDV 315/400 KDVG 315/400 KFV 315 HFK/HFKS 270/315 KFMF 315 SP/STP/STWP 315	ODL 315/400 ODN 315/400 HDL 315/400 HDN 315/400 GHD/FC 305/400 GHDN 315/400 HDB 300 CD 315-65/315-85 305 RCD
SBA-D 400	**231072**	330	150	98	160	440	25,5	3/32" x 90°	85 + 35 M20	26,0	HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/460/500/600 BB-N ES 400/460/500/600 BB-AZ-ES 500 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYD-S 400/500 HYDL-S 400/500/550/630/800 HYDLL-S 550/630	KDV 500 KDVG 500 KFV 400/500/630/800 HFK/HFKS 400/500	

* with single T-nuts only



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Application/customer's benefit

- Less deformation of easy deformed parts with wrap around jaws

Advantage of Aluminium pie jaws

- Less jaw mass (3 x lighter than steel jaws)
- higher chip removal at higher speeds.

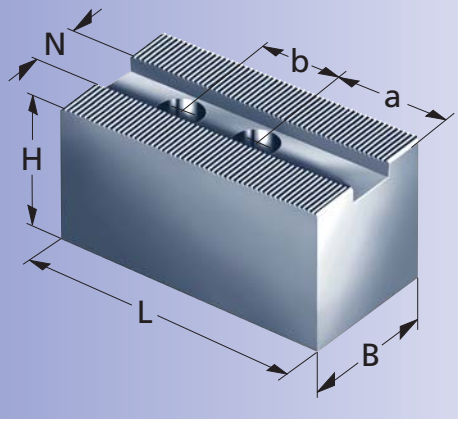
Also Aluminium pie jaws are subject to centrifugal force.
Also lighten these jaws for less loss of grip force!

Berg	Forkardt	Röhm	Schunk
			TP 160 ROTA TP 160
KF 160/200 HES 160/200 HESF 160/200 KHFF 200	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 • KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 • UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF/ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
KF 200 HES 200 HESF 200 KHFF 200	QLK/QLC 200 QLK/QLC-KS 200/250 QLK/QLC-LS 200 QLC-AG 200 NH/NHF 200 KL/KT/KTG/KTN/KS-PS 200 KS 200/250 • KSF 200 KGH/KGHF/KTH 200 KG/KP 200 • UVE 200/250	KFD/KFD-HF 200 KFH/KFH-F/KFH-G/KFH-NC 200 KFD-AF 200 KFD-HE 210 SPD/SPO 215 LVE 200	TH/THF/HSL 210 ROTA NCD 210 ROTA NC/ROTA NCF/ROTA NCO 210 ROTA NCK plus 210/250 ROTA TP 200 TP 200
KF 250/315 HES 250/315 HESF 250/315 KHFF 250/315	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD/ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
KF 315 HES 315 HESF 315 KHFF 315	QLK/QLC 315 QLK/QLC-KS 315/400 QLK/QLC-LS 315 QLC-AG 315 KG/KT/KP/KTG/KTN/KTGF 315 KLNC/NH/NHF 315 KS 315/400 • KSPS 300 KSH/KSHF 315/400 HF315 • UVE315	KFD/KFD-HF 315 KFH/KFH-F/KFH-G/KFH-NC 315 KFD-AF 315 KFD-HE 315 KFL 315/400 SPD/SPO 300 LVE 305/315	TH/THF/HSL 315 ROTA NC/ROTA NCD/ROTA NCF 315 ROTA NCO 315 ROTA NCK plus 315 ROTA TP 315 TP 315
KF 400/500/630 HES 400/500/630 HESF 400/500/630 KHFF 400	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500

soft top jaws
MAB-D
for 2-jaw power chuck

INCH serration
1/16" x 90°

Material: 16MnCr5/*C45



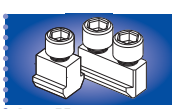
Type	Id.-No.	B	H	L	N	serration	a + b for DIN 912	kg/ set	Autoblok	SMW	Forkardt	Röhm	Schunk
MAB-D3	**013750**	70	70	95	21	1/16" x 90°	45 + 28 M16	6,0	2 CLD 200 US-2 CLD 200	KZF 200 KZF-ES 200	2 BLE 200 2 BLE 250 Mo 2 BLN 200	KFA 200	ROTA 2 B 200
MAB-D4*	**90072500**	60	60	120	25,5	1/16" x 90°	64 + 34 M20	5,2	2 CLD 250 US-2 CLD 250 2 CLD 315 US-2 CLD 315	KZF 250 KZF-ES 250 KZF 315 KZF-ES 315	2 BLE 250 2 BLE/PS 250 2 BLN 250 2 BLE/PS 300 2 BLE 315 2 BLE/PS 315 2 BLN 315 2 BLN 400	KFA 250 KFA 315	ROTA 2 B 250 ROTA 2 B 315 ROTA 2 B 400

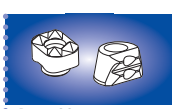


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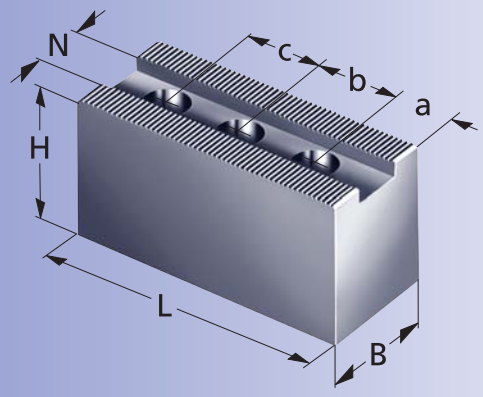

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soft top jaws
WBSA-D
for SMW-AUTOBLOK-power chucks

INCH serration
1/16" x 90° or 3/32" x 90°

Material: C45



Type	Id.-No.	B	H	L	N	serration	a + b + c for DIN 912	kg/ piece	SMW-AUTOBLOK	
WBSA-D 125*	**12071300**	30	30	60	12	1/16" x 90°	29 + 16 M8	0,3	AN/AL-D 125 BH/HB/PB-D 130 BB-D 140 SP/STP 125	
WBSA-D 165*	**12071680**	30	35	70	14	1/16" x 90°	38 + 16 M10	0,42	HFKN-D 165 SP/STP160 AN/AL/BH/HB-D 165 BHD-FC 165	PB/PBI/RC-D 165 AP/NT-D 170 BB-D 175 HYND-S 180
WBSA-D 210*	**12072130**	35	40	90	17	1/16" x 90°	47 + 23 M12	0,85	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z	HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 HYND-S 210/226
WBSA-D 260*	**12072620**	40	45	110	17	1/16" x 90°	60 + 30 M12	1,23	AP/APL/NT-260	
WBSA-D 250*	**12072500**	45	45	110	21	1/16" x 90°	60 + 30 M16	1,25	HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250 AN/AL/BH/BB-D 315 BHD-FC 250/315	RC-D 250/305/400 CC 350Z HB/ PB/PBI-D 250/315 AP/APL/NT-D 315 HYND-S 250/315
WBSA-D 315	**12073000**	50	50	125	21	1/16" x 90°	25 + 30 + 30 M16	1,85	HFKN-D 315 SP/SP-L 350 AN/AL/BH/BB-D 315 BHD-FC 315	RC-D 305/400 HYND-S 315 AP/APL/NT-D 315 CC 350Z
WBSA-D 401	**12074030**	60	60	140	21	1/16" x 90°	25 + 34 + 34 M16	3,2	RC-D 400 GH-D 400	
WBSA-D 400	**12074040**	60	60	140	25,5	3/32" x 90°	75 + 38 M20	3,2	HFKN-D 400/500 BB-N 400/460/500/600 BB-N ES 400/460/500/600 BB-AZ-ES 500 AN/AL/BB-D 400 BH-D 400/450/500/630/800	BHD-FC 400/500/630 IN/IL-D 500/630/800 HYD-S 400/500 HYDL-S 400/500/550/630/800 HYDLL-S 550/630 AP/APL/NT-D 400
WBSA-D 500	**12075050**	60	60	170	25,5	3/32" x 90°	25 + 38 + 38 M20	4,5	HFKN-D 400/500 BB-N 400/460/500/600 BB-N ES 400/460/500/600 BB-AZ-ES 500 AN/AL/BB-D 400 BH-D 400/450/500/630/800	BHD-FC 400/500/630 IN/IL-D 500/630/800 HYD-S 400/500 HYDL-S 400/500/550/630/800 HYDLL-S 550/630 AP/APL/NT-D 400
WBSA-D 610	**12075040**	75	75	160	25,5	3/32" x 90°	25 + 38 + 38 M20	5,5	HFKN-D 400/500 BB-N 400/460/500/600 BB-N ES 400/460/500/600 BB-AZ-ES 500 AN/AL/BB-D 400 BH-D 400/450/500/630/800	BHD-FC 400/500/630 IN/IL-D 500/630/800 HYD-S 400/500 HYDL-S 400/500/550/630/800 HYDLL-S 550/630 AP/APL/NT-D 400

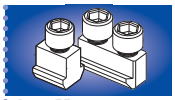
*jaws tipped



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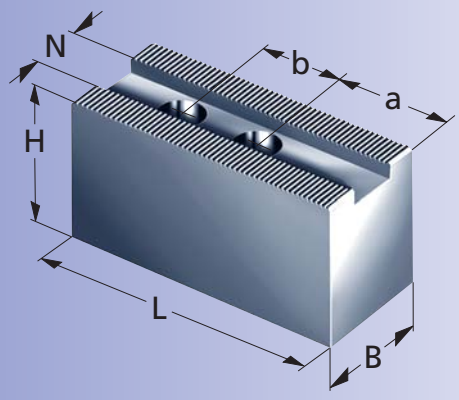

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soft top jaws
WBB-D
for Berg-power chucks

INCH serration
1/16" x 90° or 3/32" x 90°

Material: 16MnCr5
serration ground



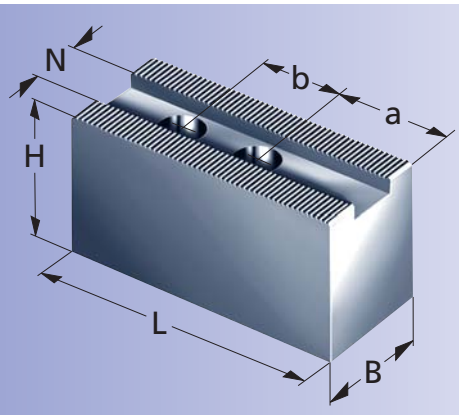
Type	Id.-No.	B	H	L	N	serration	a + b for DIN 912	kg/ set	Berg
WBB-D 211	**034241**	20	40	55	8	1/16" x 90°	30 + 14 M9	0,75	KH 110-30
WBB-D 232*	**081621**	30	45	70	10	1/16" x 90°	38 + 19 M10	1,3	KH 140-36 KH 160-45
WBB-D 235	**081622**	30	55	84	12	1/16" x 90°	45 + 21 M12	3,3	KH 175-56 KH 200-68
WBB-D 237	**081623**	35	60	90	12	1/16" x 90°	55 + 21 M12	3,6	KH 175-56 KH 200-68
WBB-D 240	**081624**	40	60	110	16	1/16" x 90°	63 + 29 M16	4,8	KH 250-91 KH 315-117
WBB-D 228	**081625**	50	80	150	20	3/32" x 90°	81 + 38 M20	8,4	KH 400-165 KH 600-165 KH 500-165

*jaws tipped

soft top jaws
WBR-D

INCH serration
1/16" x 90° or 3/32" x 90°

Material: 16MnCr5
serration ground



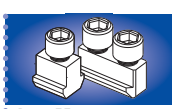
Type	Id.-No.	B	H	L	N	serration	a + b for DIN 912	kg/ set	Röhm	Schunk
WBR-D 012	**081630**	30	55	55	12	1/16" x 90°	31 + 15 M8	1,8	KFD-HS 160/175 KFD 130 KFD-HE 170 KFH 140	HSG 160 ROTA NCD 165
WBR-D 017	**081631**	40	60	70	17	1/16" x 90°	39 + 19 M12	3,1	KFD-HS 200 KFD 200 KFD-HE 210	HSG 200
WBR-D 117	**081632**	40	60	90	17	1/16" x 90°	59 + 19 M12	4,2	KFD-HS 250 KFD 200 KFD-HE 210	HSG 250
WBR-D 021	**081633**	50	60	105	21	1/16" x 90°	65 + 25 M16	6,0	KFD-HS 315 KFD 250 KFD-HE 254/315	HSG 315 ROTA NCD 250/315
WBR-D 025	**081634**	60	80	140	25,5	3/32" x 90°	89 + 31 M20	14,5	KFD-HS 400/500 KFD 400-800 KFD-HE 400	ROTA NCD 400/500

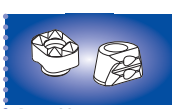


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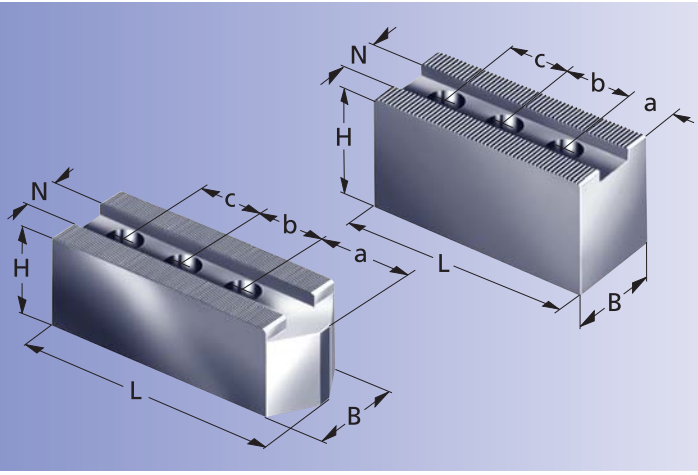


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soft top jaws
for front end power chucks



INCH serration
1/16" x 90° or 3/32" x 90°

Material: 16MnCr5/[1]C45

Type	Id.-No.	B	H	L	N	serration	a + b + c for DIN 912	kg/ set	SMW-AUTOBLOK	SMW	Röhm	Schunk
WBC-D 125*	**013795**	30	40	74	11	1/16" x 90°	35 + 18 M 8	1,6		SP 125-26 STP 125 STWP 125	LVE 125	TP 125-26 ROTA TP 125
MWB-D 130	**013488**	30	40	55	12	1/16" x 90°	29 + 16 M 8	1,2	SP 125 ab Bj. 98 STP 125			
WBSA-D 125[1]*	**12071300**		30	60	12			0,9				
AWB-D 165*	**035954**	40	40	80	14	1/16" x 90°	43 + 22 M 10	2,0	SP 160 ab Bj. 98 STP 160	SP 160-38 STP 160 STWP 160	LVE 160	TP 160-38 ROTA TP 160
AWB-D 200*	**081616**	40	40	90	17	1/16" x 90°	53 + 22 M 12	2,7	SP 200/240 STP 200/240 CC 240 Z	SP 200-52 LP 205 • STP 200 STWP 200	LVE 200	TP 200-52 ROTA TP 200
AWB-D 250*	**081618**	50	50	120	21	1/16" x 90°	70 + 28 M 16	8,2	SP 250/280/350 SP 280 STP 280	SP 250-68 • LP 250 STP 250 • STWP 250 SP 315-105 • SP 315-90 STP 315-105 STWP 315-105	LVE 250 LVE 315	TP 250/315 ROTA TP 250/315/350
AWB-D 315*	**081619**	50	50	140	21	1/16" x 90°	90 + 28 M 16	9,4	SP 350 SP-L 350 CC 350 Z			TP 315 ROTA TP 315/350
WBC-D 400	**013787**	60	80	158	25,5	3/32" x 90°	81 + 40 M 18	16,5		BB 400 • LP 380 LP 460 • BB 400 ES STP 400	LVE 400/500	TB 400 ROTA EP 380 ROTA TB 400
WBC-D 500	**013789**	60	80	185	25,5	3/32" x 90°	108 + 40 M 18	19,5		BB 500 LP 500 BB 500 ES BB 630-265 ES STP 500	LVE 630/800 LVE 1000	TB 500 ROTA EP 460 ROTA TB 500/610 ROTA TB 630-265 LH
WBSA-D 500[1]	**12075050**	60	60	170	25,5	3/32" x 90°	25 + 38 + 38 M 20	13,5	BB-N 400/460/500/600 BB-N ES 400/460/500/600			
WBC-D 502[1]	**12075140**	60	60	205	25,5	3/32" x 90°	104 + 38 + 38 M 20	16,5	BB-N 400/460/500 BB-N ES 400/460/500/600			
WBC-D 630[1]	**12076440**	80	80	240	30	3/32" x 90°	30 + 50 + 50 M 24	33,0	BB-N 630 BB-N ES 630	BB 630 STP 630 BB 630-325 ES		ROTA TB 630 TB 800/1000/1200 ROTA TB 800/850/100/1200
WBC-D 800[1]	**12078040**	80	80	320	30	3/32" x 90°	165 + 60 + 60 M 24	45,0	BB-N 800 BB-N 1000 BB-N ES 850/1000	BB 800 • BB 850 ES BB 1000 BB 1000 ES • STP 800		TB 800/1000/1200 ROTA TB 800/850/100/1200
WBCL-D 800[1]	**12079040**	80	80	390	30	3/32" x 90°	230 + 60 + 60 M 24	54,0	BB-N 800 BB-N 1000 BB-N ES 850/1000			TB 800/1000/1200 ROTA TB 800/850/100/1200

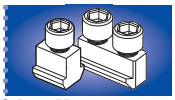
*jaws tipped



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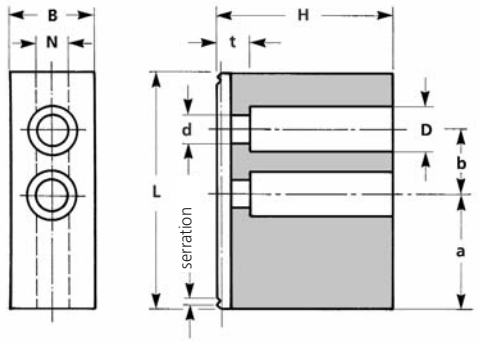
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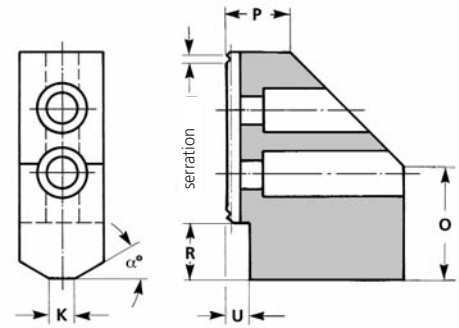
soft special jaws
on customer request

soft top jaw-blanks



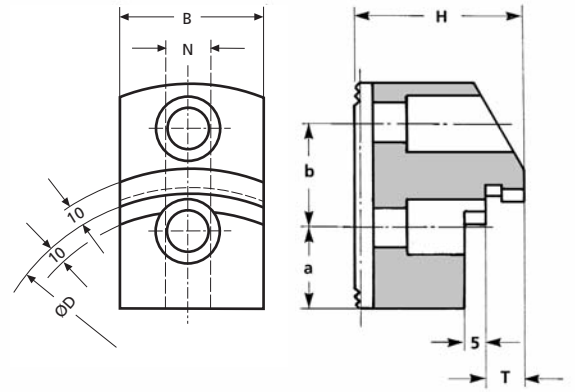
a
b
B
d
D
H
L
N
t
serration (e.g. 1/16"x90°)
material

soft top jaw-blanks



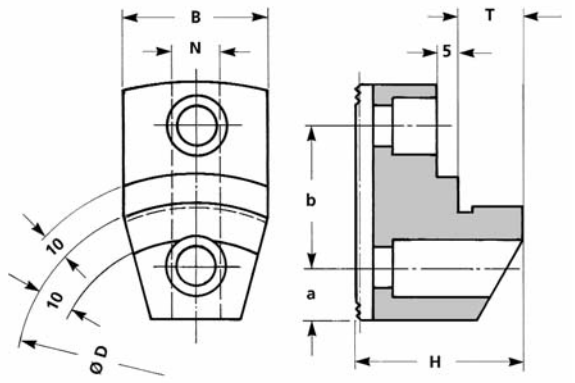
K
O
P
R
U
α°

soft top jaws for external clamping



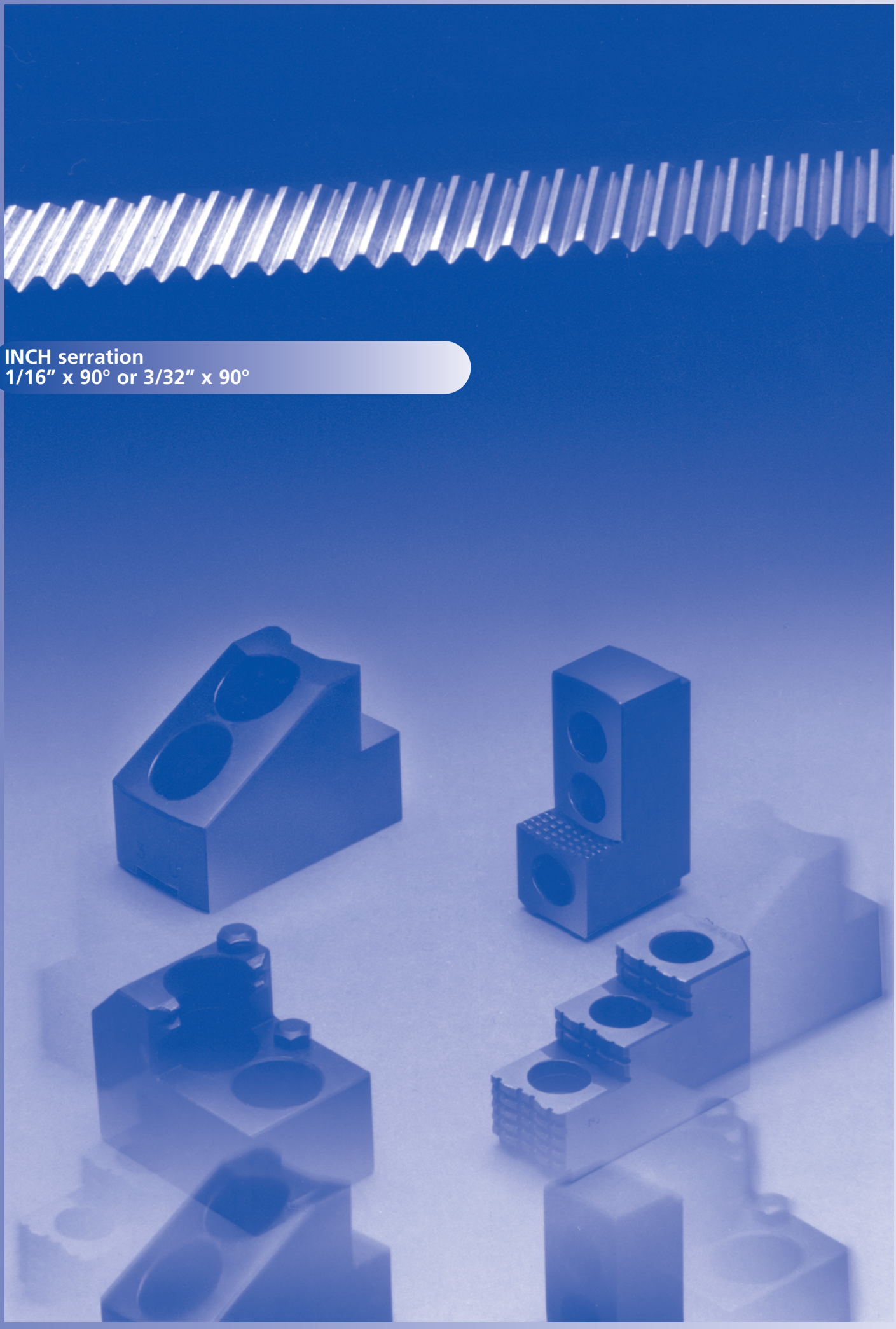
B
H
T
D
N
a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck type
material

soft top jaws for internal clamping



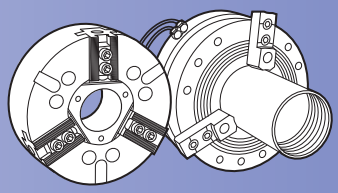
B
H
T
D
N
a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck type
material

Notes



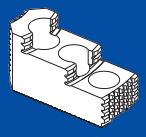
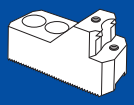
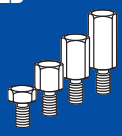
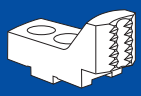
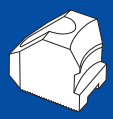
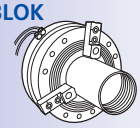
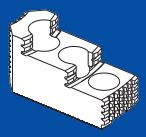
INCH serration
1/16” x 90° or 3/32” x 90°

hard top jaws



INCH serration
1/16" x 90° or 3/32" x 90°

SMW-AUTOBLOK **Berg** **Forkardt** **Röhm** **Schunk**

MHB-D	hard top jaws		**MHB-D**  Page 28
GG-D	hard roughing jaws	for internal- and external clamping	**GG-D**  Page 30
ALB	stop pins		**ALB**  Page 31
GSG-D	hard roughing jaws for bar work		**GSG-D**  Page 32
GFB-D	hard top jaws for bar pulling chucks GF 80 SMW-AUTOBLOK Röhm		**GFB-D**  Page 33
MHB-D	hard top jaws	for pneumatic front-end chucks SMW-AUTOBLOK SMW Röhm Schunk 	**MHB-D**  Page 34

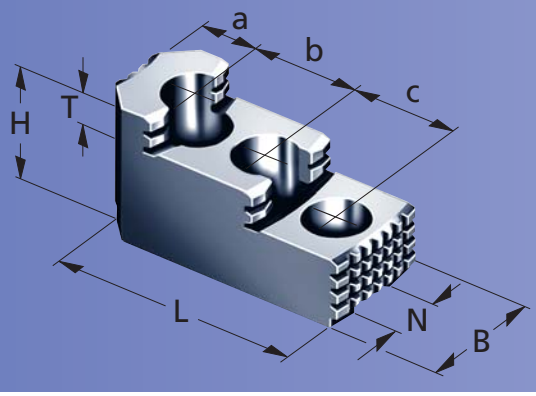
safety advise:
Top jaws are safety components, which can unter high load depending on their use.
Max grip forces and speeds must not be exceeded at any time.
For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

hard, reversible stepped top jaws

MHB-D

INCH serration
1/16" x 90° or 3/32" x 90°

serration ground

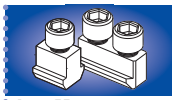


Type	Id.-No.	B	H	L	T	N	serration	a + b + c f. DIN 912	kg/ set	SMW-AUTOBLOK	SMW	Autoblok
MHB-D 110	**007076**	20	31	48	7	8	1/16" x 90°	9,5 + 12 + 12 M6	0,6	HFKN-D 110	HFKS 110-26	
MHB-D 130	**12081306**	30	34	58	8,5	12	1/16" x 90°	13 + 16 + 16 M8	0,6	AN/AL-D 125 BH/HB/PB-D 130 BB-D 140 SP/STP 125	KDV 130	ODN 125 GHDN 125
MHB-D 160	**12081636**	34	39	65	10	14	1/16" x 90°	18 + 16 + 16 M10	0,9	HFKN-D 165 SP/STP 160 AN/AL/BH/HB-D 165 BHD-FC 165 PB/PBI/RC-D 165 AP/NT-D 170 BB-D 175 HYND-S 180	SP 160 STP 160	GHD-FC 165 GHDN 165
MHB-D 200	**12082036**	40	45	82	10,5	17	1/16" x 90°	19 + 23 + 23 M12	1,71	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 200/250 KDVG 200/250 KFV 200 HFK/HFKS 160/200 KFMF 200	ODL 200 ODN 200/220/250 S HDL 200 HDN 200/220/250 S GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
MHB-D 260	**12082626**	45	56	100	16	17	1/16" x 90°	23 + 30 + 30 M12	2,55	AP/APL/NT-D260		
MHB-D 251	**12083036**	45	56	105	13,5	21	1/16" x 90°	26 + 30 + 30 M16	2,85	HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250 AN/AL/BH/BB-D 315 BHD-FC 250/315 RC-D 250/305/400 CC 350Z HB/PB/PBI-D 250/315 AP/APL/NT-D 315 HYND-S 250/315	KDV 315/400 KDVG 315/400 KFV 250/315 HFK/HFKS 250/270/315 KFMF 250/315 SP/STP/STWP 250 SP/STP/STWP 315 LP 250	ODL 250/315/400 ODN 250/315/400 HDL 250/315/400 HDN 200/315/400 GHD/FC 250/305/400 GHDN 250/315/400 HDB 300 CD 250/315-65/315-85 250 RCD 305 RCD
MHB-D 315	**12083186**	45	56	122	13,5	21	1/16" x 90°	43 + 30 + 30 M16	4,05			
MHB-D 400	**12084506**	55	73	120	22	21	1/16" x 90°	30+34+34 M16	5,1	RC-D 400		
MHB-D 500	**12084546**	60	75	140	19	25,5	3/32" x 90°	38 + 38 + 38 M20	7,5	HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/460/500/600 BB-N ES 400/460/500/600 BB-AZ-ES 500 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYD-S 400/500 HYDL-S 400/500/550/630/800 HYDLL-S 550/630	KDV 500 KDVG 500 KFV 400/500/630/800 HFK/HFKS 400/500	
MHB-D 610[1)]	**12086346**	70	75	145	32	25,5	3/32" x 90°	46 + 38 + 38 M20	9	BH-D 630/800 IN/IL-D 630/800 IHYDL-S 800		

1) 1 step only



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For highest accuracy we redommend to grind the jaws on the chuck under clamping conditions.

Berg	Forkardt	Röhm	Schunk
KF 130	KTH 130/140	KFD 130 KFH 140 KFD-HS 160/175 KFD-HE 170 LVE 125/160	HSG 160 ROTA NCD 165
KF 160/200 HES 160/200 HESF 160/200 KHFF 200	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF/ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
KF 250/315 HES 250/315 HESF 250/315 KHFF 250/315	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD/ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
KF 400/500/630 HES 400/500/630 HESF 400/500/630 KHFF 400	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500
	NH/NHF 630 KT/KTGF 630 KS 630 KSHF 630 KSL 630 UVE 630/800	KFD 630/800 LVE 630/800/1000	

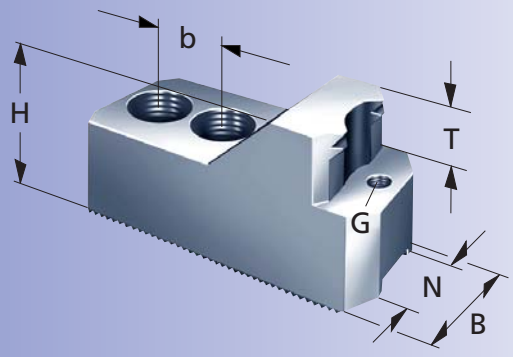
hard roughing jaws

GG-D

for external- and internal clamping

INCH serration
1/16" x 90° or 3/32" x 90°

serration ground

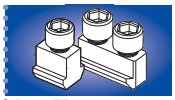


Type	Id.-No.	external clamping	internal clamping	B	H	T	G	N	serration	b	kg/ set	SMW-AUTOBLOK	SMW	Autoblok
GG-D 004	081050	47-68	110-128	35	40	20	M6	12	1/16" x 90°	16	1,2	AN/AL-D 125	KDV 130	GHDN 125
GG-D 005	081051	67-88	92-111								1,2	BH/HB/PB-D 130		ODN 125
GG-D 006	090803	87-102	74-93								1,3	BB-D 140		
												SP/STP 125		
GG-D 001	081047	25-40	-	35	40	20	M6	12	1/16" x 90°	16	1,2			
GG-D 002	081048	40-60	-								1,2			
GG-D 003	081049	60-80	-								1,1			
GG-D 004	081050	80-100	-								1,2			
GG-D 005	081051	100-120	127-146								1,2			
GG-D 006	090803	120-140	109-127								1,3			
GG-D 010	090732	25-50	-	35	45	20	M6	14	1/16" x 90°	16,5	1,2	HFKN-D 165	SP 160	GHD-FC 165
GG-D 011	090733	49-80	145-185								1,2	SP/STP 160		GHDN 165
GG-D 012	090734	80-120	115-145								1,1	AN/AL/BH/HB-D 165		
GG-D 013	090735	119-150	80-115								1,3	BHD-FC 165		
GG-D 014	090736	-	50-80		40	15					1,2	PB/PBI/RC-D 165		
												AP/NT-D 170		
												BB-D 175		
												HYND-S 180		
GG-D 020	081052	40-60	-	35	50	25	M6	17	1/16" x 90°	22	1,2		KDV 160	
GG-D 021	081053	60-80	168-188								1,2		KDVG 160	
GG-D 022	081054	80-100	144-164								1,1		KFV 160	
GG-D 023	081055	100-120	125-145								1,2		KFMF 160	
GG-D 024	081056	120-140	105-125			20					1,3		HFK 160	
GG-D 030	081057	30-60	-	35	50	25	M6	17	1/16" x 90°	22	1,2	HFKN-D 210	KDV 200	CD 200
GG-D 031	081058	60-90	210-240								1,2	SP/STP 200/240	KDVG 200	GHD-FC 210
GG-D 032	081059	90-120	180-210	40	45	20					1,2	AN/AL/BH/BB-D 210	KFV 200	HDL 200
GG-D 033	081060	120-150	150-180	40	45	20					1,3	BHD-FC 210	KFMF 200	HDN 200
GG-D 034	090811	-	120-150	40	50	25					1,2	CC 240Z	HFK 200	GHDN 210
GG-D 035	090812	-	90-120	40	50	25					1,3	HB/PB/PBI/RC-D 210	HFKS 200	ODL/ODN 200
												AP/APL/NT-D 215		RCD 210
												HYND-S 210/226		
GG-D 030	081057	40-80	-	35	50	25	M6	17	1/16" x 90°	22	1,2	AP/APL/NT-D 260*	KDV 250	HDN 220
GG-D 031	081058	80-120	210-290								1,2		KDVG 250	ODN 220
GG-D 032	081059	120-160	175-250	40	45	20					1,2			HDB 220
GG-D 033	081060	160-200	140-210	40	45	20					1,3			
GG-D 034	090811	-	120-160	40	50	25					1,2			
GG-D 035	090812	-	90-130	40	50	25					1,3			
GG-D 050	081065	40-80	-	45	59	28	M8	21	1/16" x 90°	29	2,5	HFKN-D 260	KFV 250	RCD 250
GG-D 051	081066	80-120	250-300	45							2,5	SP/STP 280	KFMF 250	GHD-FC 250
GG-D 052	081067	120-160	220-260	60							2,6	AN/AL/BH/BB-D 250	HFK 250	HDL/HDN 250
GG-D 053	081068	160-210	180-225	60							3,3	BHD-FC 250	HFKS 250	GHDN 250
GG-D 054	090817	200-250	140-180	60							3,6	RC-D 250	HFKS 270	ODL/ODN 250
GG-D 055	090818	-	100-150	60							3,4	HB/PB/PBI-D 250	SP/STP/STWP 250	
GG-D 056	090819	-	80-120	45	46	15					3,4	HYND-S 250	LP 250	
GG-D 060	081069	50-110	-	45	59	28	M8	21	1/16" x 90°	29	3,6	HFKN-D 315	KDV 315	
GG-D 061	081070	100-170	280-350	60							3,5	HB/PB/PBI-D 315	KDVG 315	
GG-D 062	080552	150-220	240-290	60							3,5	SP/SP-L 350	KFV 315	
GG-D 063	081071	210-290	175-250	60							3,6	BHD-FC 315	KFMF 315	
GG-D 064	090820	280-350	120-180	60	51	20					3,5	AN/AL/BH/BB-D 315	HFK 315	
												CC 350Z	SP/STP/STWP 315	
												RC-D 305/400		
												HYND-S 315		
												AP/APL/NT-D 315		
GG-D 080[1)]	081076	100-160	-	60	80	40	M8	25,5	3/32" x 90°	35	9,6	HFKN-D 400/500	KDV 500	
GG-D 081[1)]	019355	160-240	-								7,7	AP/AP-L/NT-D 400*	KDVG 500	
GG-D 082[1)]	081077	240-320	270-380								7,1	BB-N 400/460/500/600	KFV 400/500	
GG-D 083[1)]	081078	320-400	190-290								8,4	BB-N ES 400/460/500/600	KFV 630/800	
GG-D 084[1)]	081079	350-460	140-230								9,1	BB-AZ-ES 500	HFKS 400	
GG-D 085[1)]	081080	-	100-160		60	20					9,0	AN/AL/BB-D 400	HFK 400	
												BH-D 400/450/500/630/800	HFK 500	
												BHD-FC 400/500/630	HFKS 500	
												IN/IL-D 500/630/800		
												HYD-S 400/500		
												HYDL-S 400/500/550/630/800		
												HYDLL-S 550/630		

[1)] clamping range valid for chuck Ø 400
* with single T-nuts only



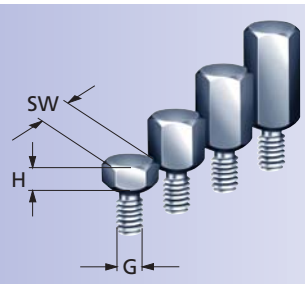
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stop pins
ALB

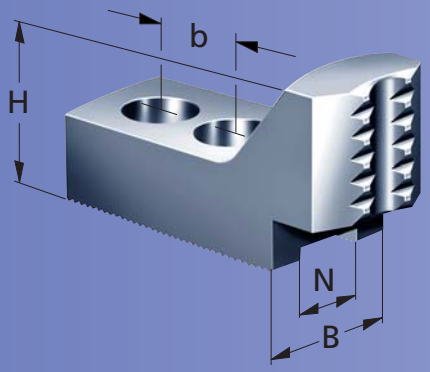
Type	Id-No.	G	H	SW
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	



Berg	Forkardt	Röhm	Schunk
KF 130	KTH 130/140	KFD 130 KFH 140 LVE 125	
		KFD-HS 160/175 KFD-HE 170 LVE 160	HSG 160 ROTA NCD 165
KF 160 HES 160 HESF 160	QLK/QLC 160/175 • QLK/QLC-LS 160 NH/NHF 160/175 KL/KT/KTG/KTN/KS-PS 160 KS 160 • KSF 175 KGH/KGHF/KTH 160/175 • UVE 160	KFD/KFD-HF 160 KFH/KFH-F/KFH-G/KFH-NC 160 KFD-AF 160 SPD/SPO 160	TH/THF/HSL 165 ROTA NCD 185 ROTA NC/ROTA NCF/ROTA NCO 165 ROTA 2B 160
KF 200 HES 200 HESF 200 KHFF 200	QLK/QLC 200 QLK/QLC-KS/LS 200 QLC-AG 200 NH/NHF 200 KL/KT/KTG/KTN/KS-PS 200 KS 200/250 • KSF 200 KGH/KGHF/KTH 200 KG/KP 200 UVE 200	KFD/KFD-HF 200 KFH/KFH-F/KFH-G/KFH-NC 200 KFD-AF 200 KFD-HE 210 SPD/SPO 215 LVE 200	TH/THF/HSL 210 ROTA NCD 210 ROTA NC/ROTA NCF/ROTA NCO 210 ROTA NCK plus 210 ROTA TP 200 • TP 200
	KL 250 KS 250 UVE 250 NHF 250-65 (Index) QLK/QLC-KS 250	KFL 250 KFD-HS 250	ROTA NCK plus 250
KF 250 HES 250 HESF 250 KHFF 250	QLK/QLC 250 QLK/QLC-LS 250 QLC-AG 250 KG/KT/KP/KTG/KTN/KTGF 250 KLNC/NH/NHF 250 KSPS 250 KSH/KSHF 250	KFD/KFD-HF 250 KFH/KFH-F/KFH-G/KFH-NC 250 KFD-AF 250 KFD-HE 254 LVE 250	TH/THF/HSL 250 ROTA NC/ROTA NCD/ROTA NCF 250 ROTA NCO 260 ROTA TP 250 TP 250
KF 315 HES 315 HESF 315 KHFF 315	QLK/QLC 315 QLK/QLC-KS 315/400 QLK/QLC-LS 315 QLC-AG 315 KG/KT/KP/KTG/KTN/KTGF 315 KLNC/NH/NHF 315 KS 315/400 • KSPS 300 KSH/KSHF 315/400 HF315 • UVE315	KFD/KFD-HF 315 KFH/KFH-F/KFH-G/KFH-NC 315 KFD-AF 315 KFD-HE 315 KFL 315/400 SPD/SPO 300 LVE 305/315	TH/THF/HSL 315 ROTA NC/ROTA NCD/ROTA NCF 315 ROTA NCO 315 ROTA NCK plus 315 ROTA TP 315 TP 315
KF 400/500/630 HES 400/500/630 HESF 400/500/630 KHFF 400	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500

hard roughing jaws for bar work

GSG-D



INCH serration
1/16" x 90° or 3/32" x 90°

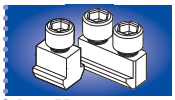
serration ground

Type	Id.-No.	clamping ranges Ø	B	H	N	serration	b for DIN 912	kg/ set	SMW-AUTOBLOK	SMW	Autoblok
GSG-D 165[1]	**091343**	15-40	30	40	14	1/16" x 90 °	22 M10	1,2	HFKN-D 165 SP/STP 160 AN/AL/BH/HB-D 165* BHD-FC 165* PB/PBI/RC-D 165* AP/NT-D 170* BB-D 175* HYND-S 180*	SP 160 STP 160	GHD-FC 165 GHDN 165
GSG-D 200[2]	**091344**	15-50	40	40	17	1/16" x 90°	22 M12	1,5	HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	KDV 200/250 KDVG 200/250 KFV 200 HFK/HFKS 200 KFMF 200	ODL 200 ODN 200/220 HDL 200 HDN 200/220 GHD/FC 210 GHDN 210 HDB 220 CD 200 210 RCD
GSG-D 250[3]	**091345**	20-70	50	50	21	1/16" x 90°	28 M16	3,5	HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250* AN/AL/BH/BB-D 315* BHD-FC 250/315* RC-D 250/305/400* CC 350Z HB/PB/PBI-D 250/315* AP/APL/NT-D 315* HYND-S 250/315*	KDV 315/400 KDVG 315/400 KFV 250/315 HFK/HFKS 250/270/315 KFMF 250/315	ODL 250/315/400 ODN 250/315/400 HDL 250/315/400 HDN 200/315/400 GHD/FC 250/305/400 GHDN 250/315/400 HDB 300 CD 250/315-65/315-85 250 RCD 305 RCD
GSG-D 400[4]	**091346**	40-100	60	60	25,5	3/32" x 90°	35 M20	8,0	HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/460/500/600 BB-N ES 400/460/500/600 BB-AZ-ES 500 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYD-S 400/500 HYDL-S 400/500/550/630/800 HYDLL-S 550/630	KDV 500 KDVG 500 KFV 400/500/630/800 HFK/HFKS 400/500	
GFB-D 1 **GFB-D 2** **GFB-D 3** **GFB-D 4** **GFB-D 5**	**016348** **016349** **016350** **016351** **016352**	5-25 25-45 45-65 65-80 80-100	25 30	39	10	1/16" x 90°	M8		GF 80		

* with single T-nuts only
1) clamping range valid for chuck Ø 165
2) clamping range valid for chuck Ø 210
3) clamping range valid for chuck Ø 260
4) clamping range valid for chuck Ø 400



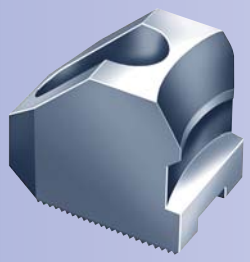
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hard top jaws

GFB-D



INCH serration
1/16" x 90° or 3/32" x 90°

serration ground

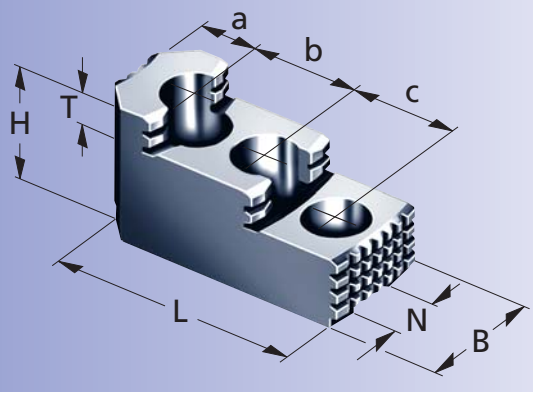
Berg	Forkardt	Röhm	Schunk
			TP 160
KF 200 HES 200 HESF 200 KHFF 200	QLK/QLC 200 QLK/QLC-KS/LS 200 QLC-AG 200 NH/NHF 200 KL/KT/KTG/KTN/KS-PS 200 KS 200/250 KSF 200 KGH/KGHF/KTH 200 KG/KP 200 UVE 200	KFD/KFD-HF 200 KFH/KFH-F/KFH-G/KFH-NC 200 KFD-AF 200 KFD-HE 210 SPD/SPO 215 LVE 200	TH/THF/HSL 210 ROTA NCD 210 ROTA NC/ROTA NCF/ROTA NCO 210 ROTA NCK plus 210/250 ROTA TP 200 TP 200
KF 250/315 HES 250/315 HESF 250/315 KHFF 250/315	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD/ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
KF 400/500/630 HES 400/500/630 HESF 400/500/630 KHFF 400	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500
		GF 80	

hard, reversible stepped top jaws for front end power chucks

MHB-D

INCH serration
1/16" x 90° or 3/32" x 90°

serration ground

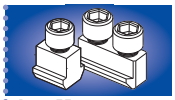


Type	Id.-No.	B	H	L	T	N	serration	a + b + c f. DIN 912	kg/ set	SMW-AUTOBLOK	SMW	Röhm	Schunk
MHB-D 125	**013817**	24	40	58	9	11	1/16" x 90°	9,5 + 18 + 18 M8	0,7		SP 125-26 STP 125 STWP 125	LV 125	TP 125-26 ROTA TP 125
MHB-D 130	**12081306**	30	34	58	8,5	12	1/16" x 90°	13 + 16 + 16 M8	0,6	SP 125-26 ab Bj. 98 STP 125 ab Bj. 98			
MHB-D 160	**12081636**	34	39	65	10	14	1/16" x 90°	18 + 16 + 16 M10	0,9	SP 160-38 STP 160	SP 160-38 STP 160 STWP 160	LVE 160	TP 160-38 ROTA TP 160
MHB-D 200	**12082036**	40	45	82	10,5	17	1/16" x 90°	19 + 23 + 23 M12	1,7	SP 200/240 STP 200/240	SP 200-52 LP 205 STP 200 STWP 200	LVE 200	TP 200-52 ROTA TP 200
MHB-D 251	**12083036**	45	56	105	13,5	21	1/16" x 90°	26 + 30 + 30 M16	2,85	SP 250/280/350 STP 280	SP 250-68 • LP 250 STP 250 • STWP 250 SP 315-90 • SP 315-105 LP 305 • STP 315-90 STP 315-105 STWP 315-105	LVE 305 LVE 250	TP 250/315 ROTA TP 250/315/350
MHB-D 315	**12083186**	50	56	122	13,5	21	1/16" x 90°	43 + 30 + 30 M16	4,05	SP 350 SP-L 350		LVE 315	TP 315 ROTA TP 315/350
MHB-D 400	**013822**	57	73	160	22	25,5	3/32" x 90°	40 + 42 + 42 M18	9,6		BB 400 • BB 400 ES STP 400/500 • BB 500 LP 380 • LP 460 LP 500 • BB 500 ES BB 630-265 ES		TB 400/500 ROTA EP 380/46 ROTA TB 400/500/610 ROTA TB 630-265 LH
MHB-D 500	**12084546**	60	75	140	19	25,5	3/32" x 90°	38 + 38 + 38 M20	7,5	BB-N 400/460 BB-N 500/600 BB-N ES 400/460 BB-N ES 500/600		LVE 400/500/630/ LVE 800/1000	
MHB-D 630[1]	**12086446**	75	85	160	30	30	3/32" x 90°	30 + 50 + 50 M24	13,5	BB-N 630-310 BB-N ES 630			ROTA TB 630
MHB-D 800[1]	**12088046**	75	85	220	30	30	3/32" x 90°	51 + 62 + 62 M24	19,5	BB-N 800-410 BB-N 1000-534 BB-N ES 850/1000			TB 800/1000/1200 ROTA TB 800/850/ ROTA TB 1000/1200

[1] 1 step only



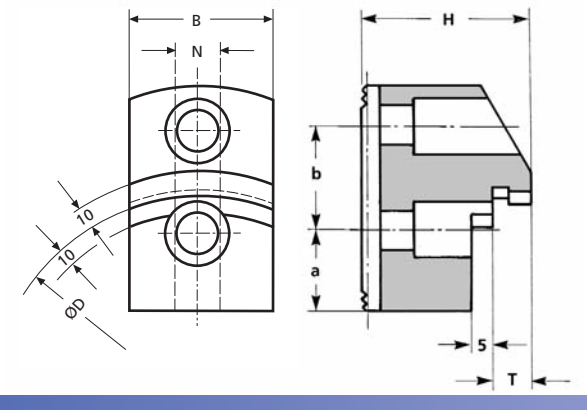
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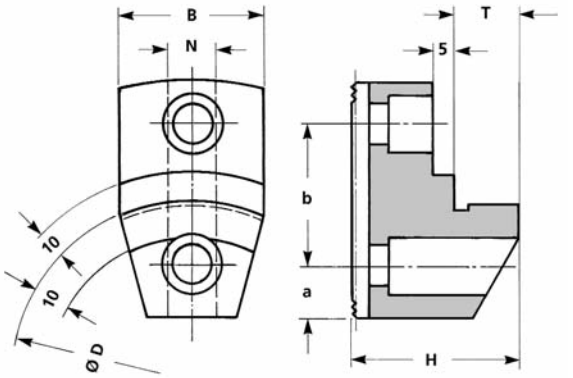
hard special jaws
on customer request

hard top jaw for external clamping



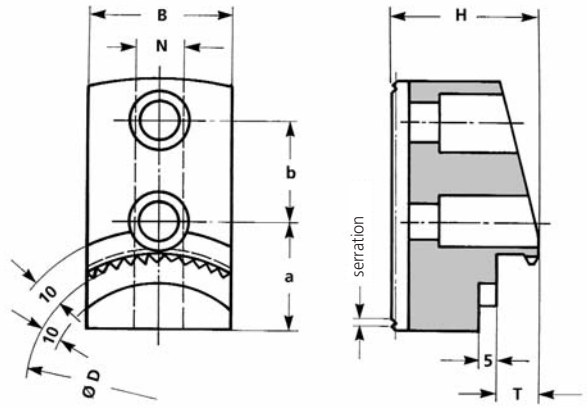
B
H
T
D
N
a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck type
material

hard top jaw for internal clamping

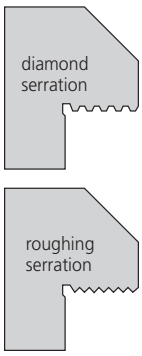


B
H
T
D
N
a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck type
material

hard top jaw for external clamping

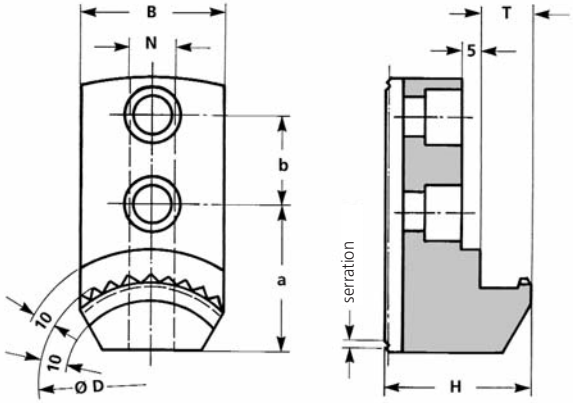


clamping area

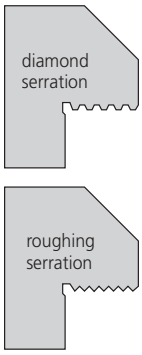


B
H
T
D
N
a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck type
material

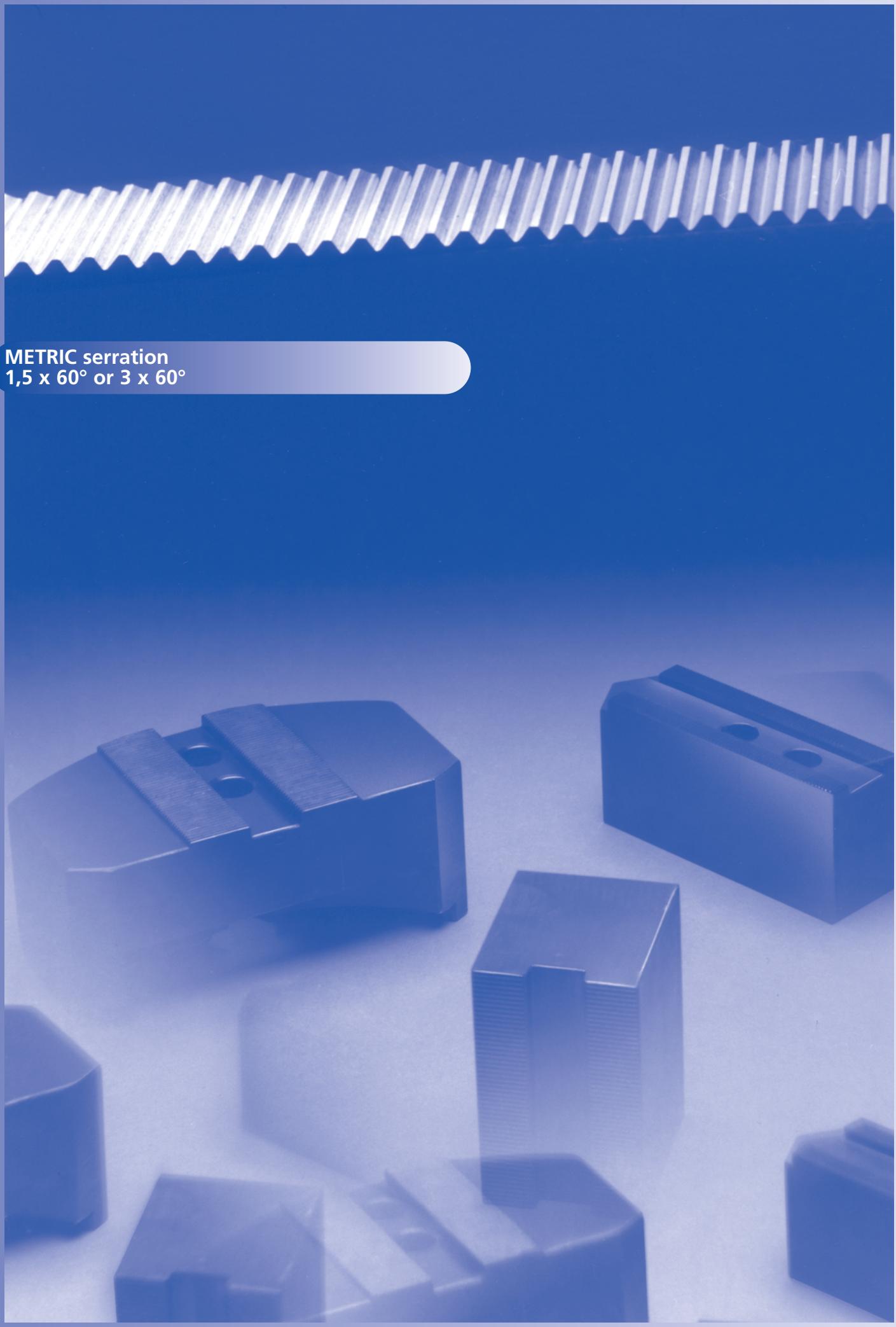
hard top jaw for internal clamping



clamping area



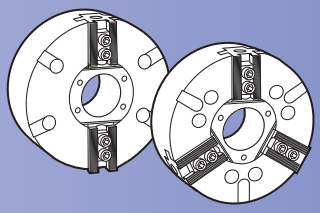
B
H
T
D
N
a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck type
material


METRIC serration
1,5 x 60° or 3 x 60°

soft top jaws

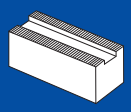
steel ■ aluminium

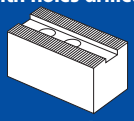
METRIC serration
1.5 x 60° or 3 x 60°

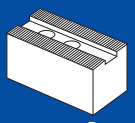


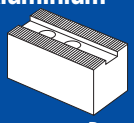
SMW-AUTOBLOK **Howa** **Kitagawa** **Schunk**

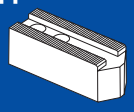
MAB-M	soft top jaws	16MnCr5	**blank w.o. holes**
MAB-ML	soft top jaws extended versions	16MnCr5	**blank w.o. holes**
MAB-M	soft top jaws (Bolt pattern to customer request)	16MnCr5	**with holes drilled**
WBJ-M	soft top jaws	16MnCr5	tall
WBJ-MA	soft top jaws	aluminium F50	light
AWB-M	soft top jaws	16MnCr5	tipped
SBJ-M	soft pie jaws	16MnCr5	
SBJ-MA	soft pie jaws	aluminium F50	
WBSA-M	soft top jaws	C45 (flame hardenable)	

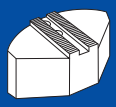
MAB-M
blank w.o. holes

Page 38

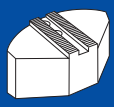
MAB-M
with holes drilled

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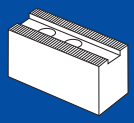
WBJ-M

Page 39

WBJ-MA
Aluminium

Page 40

AWB-M
tipped

Page 41

SBJ-M

Page 42

SBJ-MA

Page 43

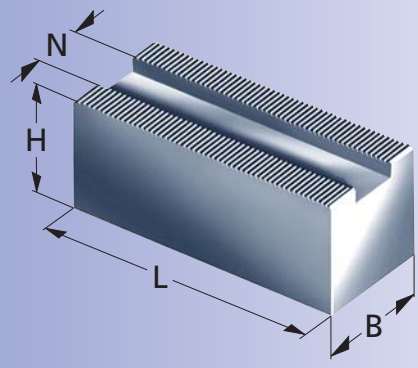
WBSA-M

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safety advise:
Top jaws are safety components, which can unter high load depending on their use.
Max grip forces and speeds must not be exceeded at any time.
For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

soft top jaw-blanks
MAB-M
blank w. o. holes and with holes drilled version

METRIC serration 1,5 x 60°

Material: 16MnCr5
serration ground



Type	Id.-No. blank w.o. holes	Id.-No. with holes drilled*	B	H	L	N	serration	a + b	DIN 912	kg/piece blank w.o. holes
MAB-M 1001	091320	091321	25	50	60	10	1,5 x 60°	* s. u.	M8	0,5
MAB-M 1201	091322	091323	30	50	80	12	1,5 x 60°	* s. u.	M10	0,9
MAB-M 1401	091324	091325	40	60	95	14	1,5 x 60°	* s. u.	M12	1,8
MAB-M 1601	091326	091327	40	80	110	16	1,5 x 60°	* s. u.	M12	2,6
MAB-M 2101	091330	091331	50	100	130	21	1,5 x 60°	* s. u.	M16	4,8

Other dimensions or serrations on request.
Use the data sheet on page 45 for ordering.

* Indicate when ordering the version with holes drilled

soft top jaw-blanks
MAB-ML
long version blank w. o. holes

METRIC serration 1,5 x 60°

Material: 16MnCr5
serration ground

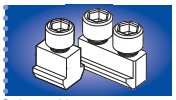
Type	Id.-No.	B	H	L	N	serration	kg/piece	
MAB-ML 1201	233340	35	60	420	12	1,5 x 60°	6,7	
MAB-ML 1401	236498	40	80	420	14	1,5 x 60°	10,2	
MAB-ML 1402	236500	60	60	420	14	1,5 x 60°	11,4	
MAB-ML 1601	231039	40	80	420	16	1,5 x 60°	10,2	
MAB-ML 1602	236499	60	60	420	16	1,5 x 60°	11,4	
MAB-ML 2101	233344	50	80	420	21	1,5 x 60°	12,7	
MAB-ML 2102	233383	60	120	420	21	1,5 x 60°	23,2	



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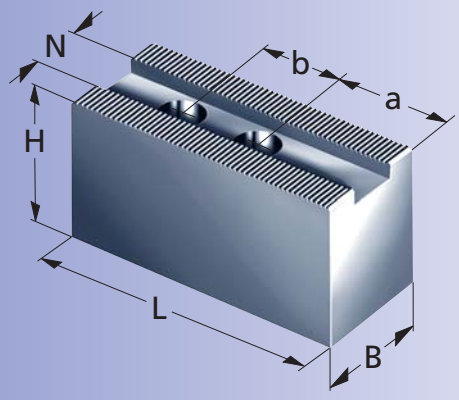
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soft top jaws

WBJ-M/WBSA-M



METRIC serration 1,5 x 60°

Material: 16MnCr5/*Material: C45 serration ground

Type	Id.-No.	B	H	L	N	serration	a + b for DIN 912	kg/ set	SMW-AUTOBLOK	Howa	Kitagawa	Schunk
WBJ-M 1001	081682	25	25	55	10	1,5 x 60°	28 + 14 M8	0,50		HO1MA4 HO24M5	AS 110 B-204/-205 N-04 NJ-04 • NL-04	
WBJ-M 1002	081683	30	40	55				0,80				
WBSA-M165***	12071621	30	35	70	12	1,5 x 60°	37 + 20 M10	1,20	HFKN-M 165 AN/AL/BH/-M 165	HO7MA6 HO15M6	AS165 B-06/-106/-160/-206	HSL 165 ROTA NC/NCF plus185
WBJ-M 1201	081688	30	40	72				1,60	BHM-FC 165 RC-M 165	HO22M6 HO24M6	BB-06/-206 • BL-206 B-07 • HJA 5-6	ROTA NCD 165-185 ROTA NCK/ROTA NCK plus165
WBJ-M 1202	081689	35	50	72				2,50	AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165	HO27M6 HO37M6 HO47M6	HOB-6 • HO-6 HOH-06/-106/-160/-206 HOS 6 • N-06/-160 NL-06	ROTA NC/NCF 165
WBSA-M210***	12072121	35	40	90	14	1,5 X 60°	45 + 25 M12	2,50	HFKN-M 210 AN/AL/BH/BB-M 210	HO7MA8 HO15MA8	AS210 B-08/-108/-200/-208	HSL 210 ROTA NCD/NCK 210
WBJ-M 1401	081690	35	50	90				3,10	BHM-FC 210	H023MA8	BB-08/-208	ROTA NC/ROTA NCF 210
WBJ-M 1402	081691	40	40	90				2,70	RC-M 210 AP/APL/NT-M 215		BL-208 • HJA 6-8 HO 8 • HOB 8	ROTA NCK plus 210 ROTA NC/NCF plus 215
WBJ-M 1403	081692	40	60	90				4,20	HB/PB/PBI-M 210		HOH-8/-108/-200/-208 HOS 8 • N-08/-200	
WBJ-M 1404	081693	40	80	90				6,00			NL-08	
WBJ-M 1405	081694	40	100	90				7,80				
WBJ-M 1601	081696	40	40	90	16	1,5 x 60°	45 + 25 M12	2,70		H07MA10		
WBJ-M 1602	081697	40	40	110				3,40		H15MA10		
WBJ-M 1603	081698	40	60	110				5,20		H23MA10		
WBJ-M 1604	081699	50	80	90				7,20		H022MA8 H024MA8 H027MA8 H073MA8 H047MA8		
WBSA-M250***	12072621	45	45	110	16	1,5 x 60°	50 + 30 M12	3,90	HFKN-M 260 AN/AL/BH/BB-M 250		AS250 B-10/-110/-210/-210X/-250	HSL 250 ROTA NC/NCD/NCF/NCK 250
WBJ-M 1611	081700	40	40	110				3,40	BHM-FC 250 RC-M 250		BB-10/-210 BL-210	ROTA NCK plus 250 ROTA NC/NCF plus 260
WBJ-M 1612	081701	40	60	110				5,20	AP/APL/NT-M 260 HB/PB/PBI-M 250		HJA 6-10/8-10 HO-10 • HOB-10	
WBJ-M 1613	081702	50	80	90			45 + 30 M12	7,20			HOH-10/-110/-210/-250 HOS-10	
WBJ-M 1614	081703	50	100	90				8,80			N-10/-250 • NL-10	
WBJ-M 1802	081706	50	50	120	18	1,5 x 60°	60 + 30 M14	6,5		H07MA12 H015M12	B-12/-300 HJA 6-12/8-12	HSL 315 ROTA NC/NCF 315
WBJ-M 1803	081707	50	80	120				9,3		H23M12 H022M10	HLA 6-15/8-15 HO-12 • HOB-12	
WBJ-M 1805	081709	50	120	120				15,6		H024M10 H027M10 H037M10 H047M10	HOH-12/300 HOS-12 N-12/-300 NL-12	
WBSA-M315***	12073001	50	50	125	21	1,5 x 60°	73 + 30 M16	5,55	HFKN-M 315 BHM-FC 315		B-212 BB-212	HSL 315 ROTA NCD/NCK 315
WBJ-M 2111	081712	60	80	126			72 + 30 M16	12,5	AN/AL/BH/BB-M 315 RC-M 305		BL-212	ROTA NC/NCK/NCF plus 315
WBJ-M 2112	236505	50	060	129			60 + 30 M16	7,8	AP/APL/NT-M 315 HB/PB/PBI-M 315			
WBJ-M 2201	081714	60	80	156	22	1,5 x 60°	87 + 43 M20	16,0			B-15/-18 B-380/-450 HOH-15 • HOH-15K HOH-380	HSL 400 ROTA NC/NCF 400

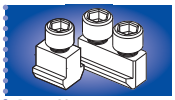
** tipped



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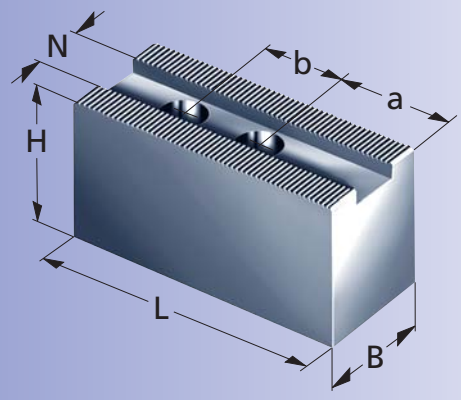

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soft top jaws alum.

WBJ-MA light version

METRIC serration 1,5 x 60°

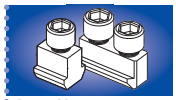
Material: aluminium (tensile strength = 500 N/mm²)



Type	Id.-No.	B	H	L	N	serration	a + b for DIN 912	kg/ set	SMW-AUTOBLOK	Howa	Kitagawa	Schunk
WBJ-MA 120	**036017**	35	50	72	12	1,5 x 60°	25 + 20 M10	0,9	HFKN-M 165 AN/AL/BH/-M 165 BHM-FC 165 RC-M 165 AP/NT-M170 BB-M 175 HB/PB/PBI-M 165	HO7MA6 HO15M6 HO22M6 HO24M6 HO27M6 HO37M6 HO47M6	AS165 B-06/-106/-160/-206 BB-06/-206 BL-206 • B-07 HJA 5-6 • HOB-6 HO-6 HOH-06/-106/-160/-206 HOS 6 N-06/-160 • NL-06	HSL 165 ROTA NC/NCF plus185 ROTA NCD 165-185 ROTA NCK/ROTA NCK plus 165 ROTA NC/NCF 165
WBJ-MA 140	**081728**	40	60	90	14	1,5 x 60°	45 + 25 M12	1,5	HFKN-M 210 AN/AL/BH/BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210	HO7MA8 HO15M8 HO23M8	AS210 B-08/-108/-200/-208 BB-08/-208 BL-208 • HJA 6-8 HO 8 • HOB 8 HOH-8/-108/-200/-208 HOS 8 N-08/-200 • NL-08	HSL 210 ROTA NCD/NCK 210 ROTA NC/ROTA NCF 210 ROTA NCK plus 210 ROTA NC/NCF plus 215
WBJ-MA 165	**081730**	40	60	110	16	1,5 x 60°	55 + 30 M12	2,7	HFKN-M 260 AN/AL/BH/BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250		AS250 B-10/-110/-210/-210X/-250 BB-10/-210 BL-210 HJA 6-10/8-10 HO-10 • HOB-10 HOH-10/-110/-210/-250 HOS-10 N-10/-250 • NL-10	HSL 250 ROTA NC/NCD/NCF/NCK 250 ROTA NCK plus 250 ROTA NC/NCF plus 260
WBJ-MA 180	**081731**	50	80	130	18	1,5 x 60°	60 + 30 M14	3,3		HO7MA12 HO15M12 H23M12 H022M10 H024M10 H027M10 H037M10 H047M10	B-12 B-300 N-12 N-300 HO-12 HOB/HOS/HOH-12 HOH 300 HJA6-12/8-12 HLA 6-12/5-18/8-15 N 12 N 300	HSL 315 ROTA NC/NCF 315
WBJ-MA 210	**039511**	50	80	130	21	1,5 x 60°	60 + 30 M16	3,8	HFKN-M 315 BHM-FC 315 AN/AL/BH/BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315		B-212 BB-212 BL-212	HSL 315 ROTA NCD/NCK 315 ROTA NC/NCK/NCF plus 315



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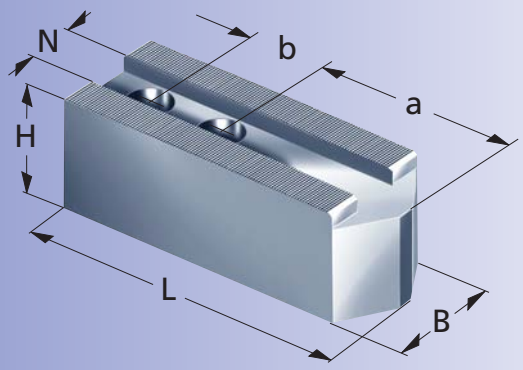
soft top jaws

AWB-M

long, tipped version

METRIC serration
1,5 x 60° or 3 x 60°

Material: 16MnCr5
serration ground



Type	Id.-No.	B	H	L	N	serration	a + b for DIN 912	kg/ set	SMW-AUTOBLOK	Howa	Kitagawa	Schunk
AWB-M 1201	**081719**	30	30	82	12	1,5 x 60°	47 + 20 M10	1,4	HFKN-M 165 AN/AL/BH/-M 165 BHM-FC 165 RC-M 165 AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165	HO7MA6 HO15M6 HO22M6 HO24M6 HO27M6 HO37M6 HO47M6	AS165 B-06/-106/-160/-206 BB-06/-206 BL-206 • B-07 HJA 5-6 HOB-6 • HO-6 HOH-06/-106/-160/-206 HOS 6 N-06/-160 • NL-06	HSL 165 ROTA NC/NCF plus185 ROTA NCK/ROTA NCK plus 165 ROTA NC/NCF 165
AWB-M 1401	**081720**	35	40	102	14	1,5 x 60°	54 + 25 M12	3,5	HFKN-M 210 AN/AL/BH/BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210	HO7MA8 HO15MA8 HO23MA8	AS210 B-08/-108/-200/-208 BB-08/-208 BL-208 • HJA 6-8 HO 8 • HOB 8 HOH-8/-108/-200/-208 HOS 8 N-08/-200 • NL-08	HSL 210 ROTA NCD/NCK 210 ROTA NCK plus 210 ROTA NC/NCF plus 215
AWB-M 1611	**081722**	40	40	125	16	1,5 x 60°	65 + 30 M12	3,2	HFKN-M 260 AN/AL/BH/BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250		AS250 B-10/-110/-210/-210X/-250 BB-10/-210 • BL-210 HJA 6-10/ 8-10 HO-10 • HOB-10 HOH-10/-110/-210/-250 HOS-10 N-10/-250 • NL-10	HSL 250 ROTA NC/NCD/NCF/NCK 250 ROTA NCK plus 250 ROTA NC/NCF plus 260
AWB-M 1802	**081723**	50	50	145	18	1,5 x 60°	85 + 30 M14	6,2		HO7MA12 HO15M12 H23M12 HO22M10 HO24M10 HO27M10 HO37M10 HO47M10	B-12/-300 HJA 6-12/8-12 HLA 6-15/8-15 HO-12 • HOB-12 HOH-12/300 HOS-12 N-12/-300 • NL-12	HSL 315 ROTA NC/NCF 315
AWB-M 2101	**236517**	50	50	145	21	1,5 x 60°	85 + 30 M16	6,2	HFKN-M 315 BHM-FC 315 AN/AL/BH/BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315		B-212 BB-212 BL-212	HSL 315 ROTA NCD/NCK 315 ROTA NC/NCK/NCF plus 315
AWB-M 400*	**036791**	60	60	140	25,5	3 x 60°	80 + 35 M20	9,6	HFKN-M 400 HFKN-M 500			

*without incline

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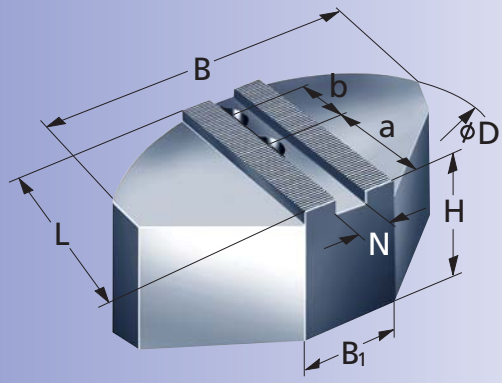
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soft pie jaws

SBJ-M

METRIC serration 1,5 x 60°

Material: 16MnCr5 serration ground



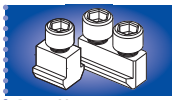
Type	Id.-No.	B	B_1	H	L	D	N	serration	a + b for DIN 912	kg/ set	SMW-AUTOBLOK	Howa	Kitagawa	Schunk
SBJ-M 160	**036016**	120	50	50	60	160	12	1,5 x 60°	25 + 20 M10	4,95	HFKN-M 165 AN/AL/BH/-M 165 BHM-FC 165 RC-M 165 AP/NT-M170 BB-M 175 HB/PB/PBI-M 165	HO7MA6 HO15M6 HO22M6 HO24M6 HO27M6 HO37M6 HO47M6	AS165 B-06/-106/-160-206 BB-06/-206 BL-206 • B-07 HJA 5-6 HOB-6 • HO-6 HOH-06/-106/-160/-206 HOS 6 N-06/-160 • NL-06	HSL 165 ROTA NC/NCF plus185 ROTA NCD 165-185 ROTA NCK 165 ROTA NCK plus 165 ROTA NC/NCF 165
SBJ-M 200	**081724**	140	60	60	70	200	14	1,5 x 60°	30 + 25 M12	8,3	HFKN-M 210 AN/AL/BH/BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210	HO7MA8 HO15MA8 HO23MA8	AS210 B-08/-108/-200/-208 BB-08/-208 BL-208 HJA 6-8 HO 8 • HOB 8 HOH-8/-108/-200/-208 HOS 8 N-08/-200 • NL-08	HSL 210 ROTA NCD/NCK 210 ROTA NC 210 ROTA NCF 210 ROTA NCK plus 210 ROTA NC 215 ROTA NCF plus 215
SBJ-M 250	**081726**	180	100	60	80	250	16	1,5 x 60°	30 + 30 M12	12,3	HFKN-M 260 AN/AL/BH/BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250		AS250 B-10/-110/-210/-210X/-250 BB-10/-210 BL-210 HJA 6-10/8-10 HO-10 • HOB-10 HOH-10/-110/-210/-250 HOS-10 N-10/-250 • NL-10	HSL 250 ROTA NC/NCD 250 ROTA NCF/NCK 250 ROTA NCK plus 250 ROTA NC 260 ROTA NCF plus 260
SBJ-M 315	**231104**	240	120	70	110	300	21	1,5 x 60°	45 + 30 M16	12,3	HFKN-M 315 BHM-FC 315 AN/AL/BH/BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315		B-212 BB-212 BL-212	HSL 315 ROTA NCD/NCK 315 ROTA NC/NCK plus 315 ROTA NCF plus 315



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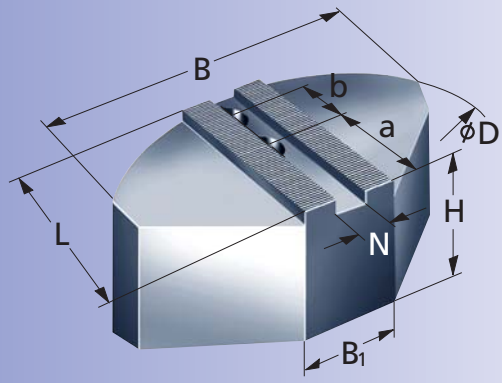

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soft pie jaws alum.

SBJ-MA light version

METRIC serration 1,5 x 60°

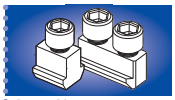
Material: aluminium (tensile strength = 500 N/mm²)



Type	Id.-No.	B	B_1	H	L	D	N	serration	a + b for DIN 912	kg/ set	SMW-AUTOBLOK	Howa	Kitagawa	Schunk
SBJ-MA 160	**036018**	120	50	58	60	160	12	1,5 x 60°	25 + 20 M10	1,9	HFKN-M 165 AN/AL/BH/-M 165 BHM-FC 165 RC-M 165 AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165	HO7MA6 HO15M6 HO22M6 HO24M6 HO27M6 HO37M6 HO47M6	AS165 B-06/-106/-160/-206 BB-06/-206 BL-206 • B-07 HJA 5-6 HOB-6 • HO-6 HOH-06/-106/-160/-206 HOS 6 N-06/-160 • NL-06	HSL 165 ROTA NC 185 ROTA NCF plus 185 ROTA NCD 165-185 ROTA NCK ROTA NCK plus 165 ROTA NC/NCF 165
SBJ-MA 200	**081732**	140	50	58	75	200	14	1,5 x 60°	35 + 25 M12	3,0	HFKN-M 210 AN/AL/BH/BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210	HO7MA8 HO15MA8 HO23MA8	AS210 B-08/-108/-200/-208 BB-08/-208 BL-208 HJA 6-8 HO 8 • HOB 8 HOH-8/-108/-200/-208 HOS 8 N-08/-200 • NL-08	HSL 210 ROTA NCD/NCK 210 ROTA NC 210 ROTA NCF 210 ROTA NCK plus 210 ROTA NC 215 ROTA NCF plus 215
SBJ-MA 250	**081734**	180	70	58	90	250	16	1,5 x 60°	40 + 30 M12	4,5	HFKN-M 260 AN/AL/BH/BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250		AS250 B-10/-110/-210/-210X/-250 BB-10/-210 BL-210 HJA 6-10/8-10 HO-10 • HOB-10 HOH-10/-110/-210/-250 HOS-10 N-10/-250 • NL-10	HSL 250 ROTA NC/NCD 250 ROTA NCF/NCK 250 ROTA NCK plus 250 ROTA NC 260 ROTA NCF plus 260
SBJ-MA 315	**236520**	240	80	78	117	320	21	1,5 x 60°	45 + 30 M16	4,5	HFKN-M 315 BHM-FC 315 AN/AL/BH/BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315		B-212 BB-212 BL-212	HSL 315 ROTA NCD/NCK 315 ROTA NC/NCK plus 315 ROTA NCF plus 315



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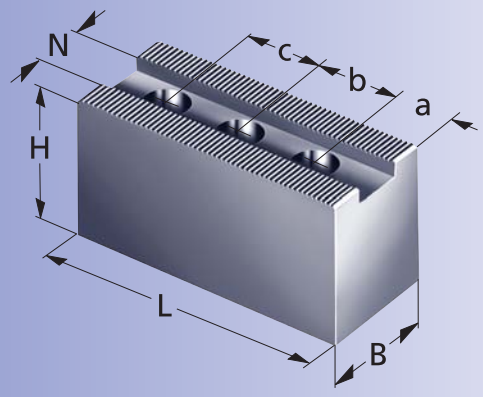
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soft top jaws

WBSA-M

METRIC serration
1,5 x 60°

Material: C45



Type	Id.-No.	B	H	L	N	serration	a + b + c for DIN 912	kg/ piece	SMW-AUTOBLOK
WBSA-M 125*	**12071301**	30	30	60	12	1,5 x 60°	29 + 16 M8	0,3	AN-/AL-M 125 BH-M 130 BB-M 140 HB/PB-M130
WBSA-M 165*	**12071621**	30	35	70	12	1,5 x 60°	34 + 20 M10	0,42	HFKN-M 165 AN/AL/BH/-M 165 BHM-FC 165 RC-M 165 AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165
WBSA-M 210*	**12072121**	35	40	90	14	1,5 x 60°	47 + 25 M12	0,85	HFKN-M 210 AN/AL/BH/BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210
WBSA-M 250*	**12072621**	45	45	110	16	1,5 x 60°	60 x 30 M12	1,3	HFKN-M 260 AN/AL/BH/BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250
WBSA-M 315	**12073001**	50	50	125	21	1,5 x 60°	25 + 30 + 30 M16	1,85	HFKN-M 315 BHM-FC 315 AN/AL/BH/BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315
WBSA-M 400	**12074031**	60	60	140	21	1,5 x 60°	25 + 34 + 34 M16	3,2	RC-M 400 GH-M 400
WBSA-M 401	**12074021**	60	60	140	22	1,5 x 60°	75 + 38 M20	3,2	AP/AP-L/NT-M 400 AN/AL -M 400 BH-M 400/450 BHM-FC 400

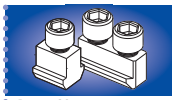
*jaws tipped



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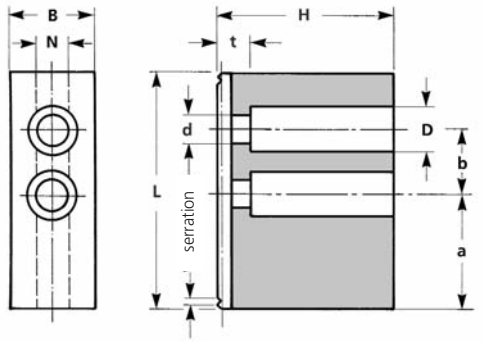
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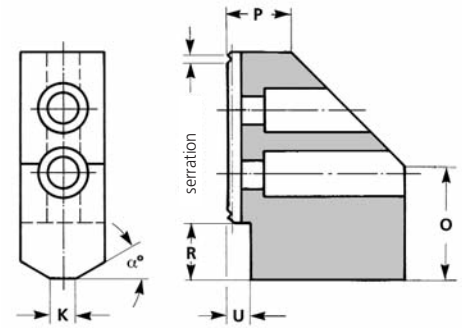
soft special jaws
on customer request

soft top jaw-blanks



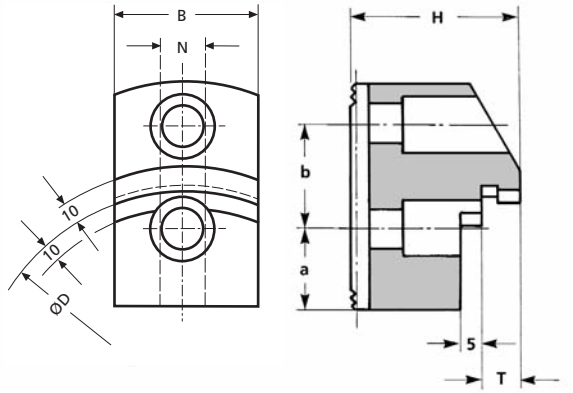
a
b
B
d
D
H
L
N
t
serration (e.g. 1,5 x 60°)
material

soft top jaw-blanks



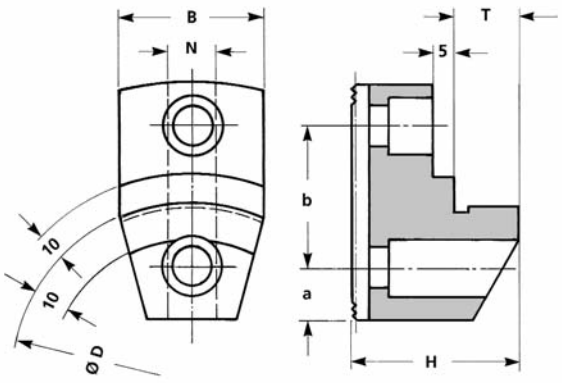
K
O
P
R
U
α°

soft top jaws for external clamping

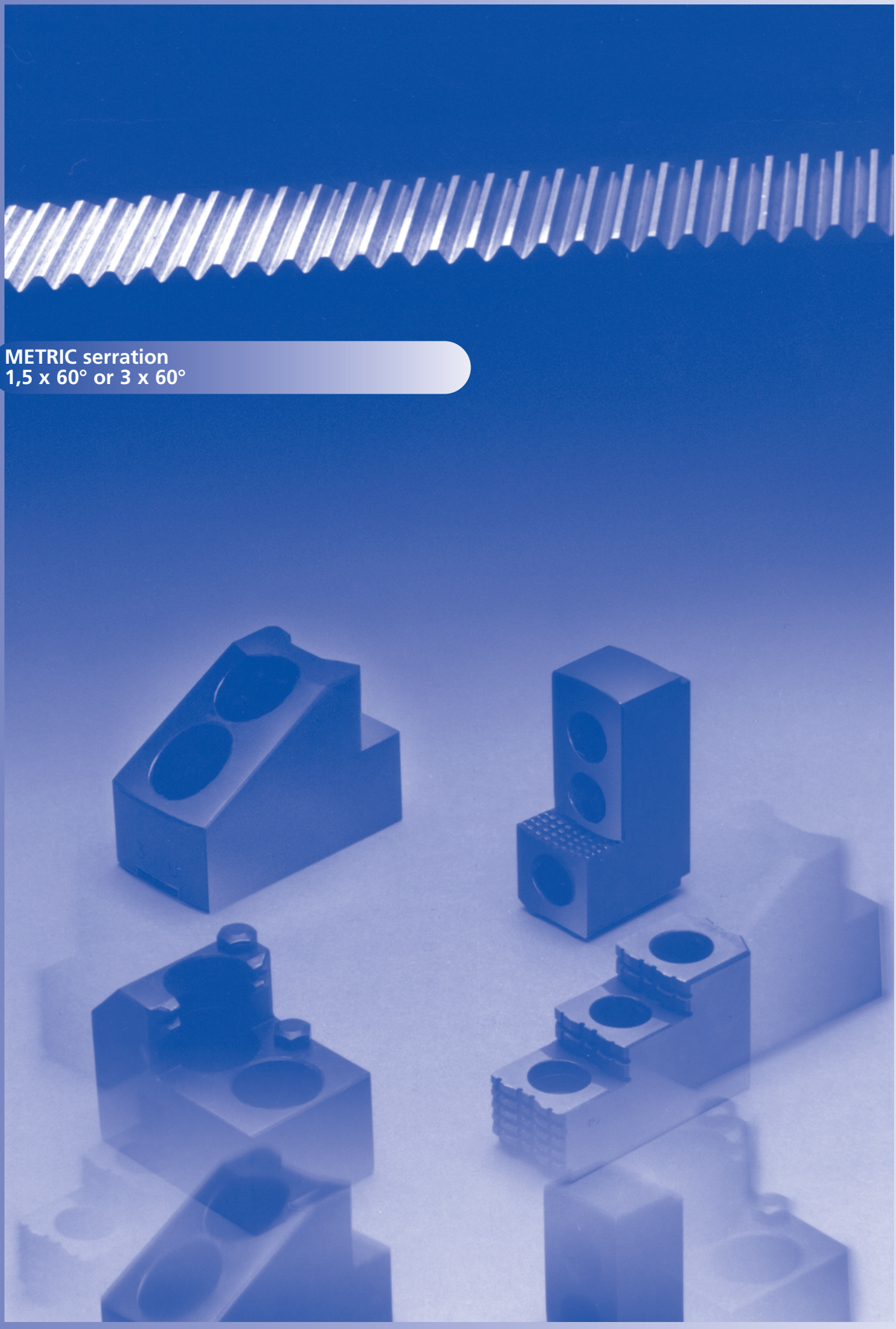


B
H
T
D
N
a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck type
material

soft top jaws for internal clamping

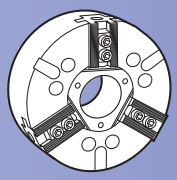


B
H
T
D
N
a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck type
material



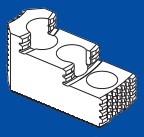
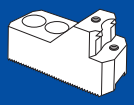
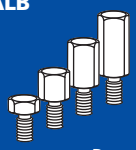
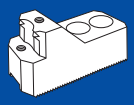
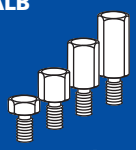
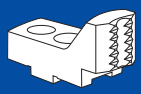
METRIC serration
1,5 x 60° or 3 x 60°

hard top jaws



METRIC serration
1,5 x 60° or 3 x 60°

SMW-AUTOBLOK Howa Kitagawa Schunk

MHB-M	hard top jaws	reversible	**MHB-M**  Page 48
SGA-M	hard roughing jaws	external clamping	**SGA-M**  Page 49
ALB	stop pins		**ALB**  Page 49
SGI-M	hard roughing jaws	internal clamping	**SGI-M**  Page 50
ALB	stop pins		**ALB**  Page 50
GSG-M	hard bar roughing jaws		**GSG-M**  Page 51

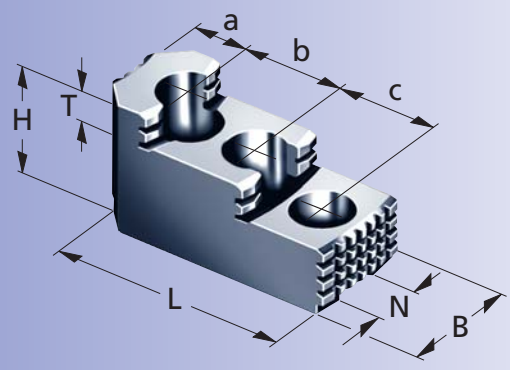
safety advise:
Top jaws are safety components, which can unter high load depending on their use.
Max grip forces and speeds must not be exceeded at any time.
For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

hard, reversible top jaws

MHB-M

METRIC serration
1,5 x 60° or 3 x 60°

serration ground

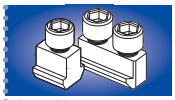


Type	Id.-No.	B	H	L	T	N	serration	a + b + c f. DIN 912	kg/ set	SMW-AUTOBLOK	Howa	Kitagawa	Schunk
MHB-M 122	**12081307**	30	34	58	9	12	1,5 x 60°	13+16+16 M8	0,6	AN/AL-M 125 BH -M 130 BB-M 140 HB/PB-M130			
MHB-M 120	**081032**	35	44	80	10	12	1,5 x 60°	24+20+20 M10	1,6	HFKN-M 165 AN/AL/BH/-M 165 BHM-FC 165 RC-M 165	HO7MA6 HO15M6 HO22M6 HO24M6	AS165 B-06/-106/-160/-206 BB-06/-206 BL-206 • B-07	HSL 165 ROTA NC/NCF plus 185 ROTA NCD 165-185 ROTA NCK 165
MHB-M 121	**12081627**	34	39	67	10	12	1,5 x 60°	14+20+20 M10	0,93	AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165	HO27M6 HO37M6 HO47M6	HJA 5-6 HOB-6 • HO-6 HOH-06/-106/-160/-206 HOS 6 N-06/-160 • NL-06	ROTA NCK plus 165 ROTA NC/NCF 165
MHB-M 140	**12082127**	40	45	86	10,5	14	1,5 x 60°	19+25+25 M12	1,8	HFKN-M 210 AN/AL/BH/BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210	HO7MA8 HO15MA8 HO23MA8	AS210 B-08/-108/-200/-208 BB-08/-208 • BL-208 HJA 6-8 • HO 8 • HOB 8 HOH-8/-108/-200/-208 HOS 8 • N-08/-200 • NL-08	HSL 210 ROTA NCD/NCK 210 ROTA NC/NCF 210 ROTA NCK plus 210 ROTA NC 215 ROTA NCF plus 215
MHB-M 160[1]	**081045**	35	42	83	15	16	1,5 x 60°	19+25+25 M12	1,5		HO7MA10 H15MA10 H23MA10 HO22MA8 H024MA8 H027MA8 H073MA8 H047MA8		
MHB-M 161	**12082627**	45	56	100	15,5	16	1,5 x 60°	23+30+30 M12	2,55	HFKN-M 260 AN/AL/BH/BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250		AS 250 B-10/-110/-210/-210X/-250 BB-10/-210 • BL-210 HJA 6-10/8-10 HO-10 • HOB-10 HOH-10/-110/-210/-250 HOS-10 N-10/-250 • NL-10	HSL 250 ROTA NC/NCD 250 ROTA NCF/NCK 250 ROTA NCK plus 250 ROTA NC 260 ROTA NCF plus 260
MHB-M 180	**081038**	50	60	109	15	18	1,5 x 60°	24+30+30 M14	5,1		HO7MA12 HO15M12 H23M12 H022M10 H024M10 H027M10 H037M10 H047M10	B-12/-300 HJA 6-12/8-12 HLA 6-15/8-15 HO-12 • HOB-12 HOH-12/300 HOS-12 N-12/-300 NL-12	HSL 315 ROTA NC/NCF 315
MHB-M 211	**12083037**	45	56	105	13,5	21	1,5 x 60°	26+30+30 M16	2,85	HFKN-M 315 BHM-FC 315 AN/AL/BH/BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315		B 212 BB-212 BL-212	HSL 315 ROTA NCD/NCK 315 ROTA NC/NCK plus 315 ROTA NCF plus 315
MHB-M 400	**12084007**	55	73	120	22	21	1,5 x 60°	30+34+34 M16	5,1	GH-M 400 RC-M 400			
MHB-M 401	**12084527**	60	75	140	19	22	1,5 x 60°	38+38 M20	7,5	AP/AP-L/NT-M 400 AN/AL-M 400 BH-M 400/450 BHM-FC 400			
MHB-M 402	**231032**	60	86	143	20	22	1,5 x 60°	33+43+43 M20	9			B15/18 • B-350/450 HOH 15 • HOH 15K HOH 380	HSL 400 ROTA NC/NCF 400
MHB-M 500[1]	**037126**	55	73	145	32	25,5	3 x 60°	46+38+38 M20	6,7	HFKN-M 400 HKFN-M 500			

[1] 1 step only



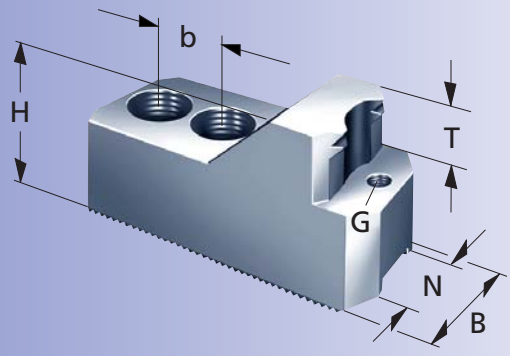
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hard roughing jaws

SGA-M for external clamping



METRIC serration 1,5 x 60°

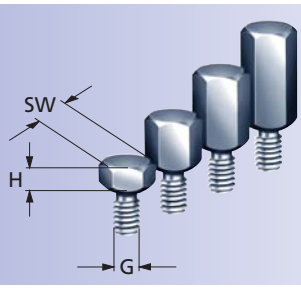
serration ground

Type	Id.-No.	clamping range Ø	B	H	T	G	N	serration	b	kg/ set	SMW-AUTOBLOK	Howa	Kitagawa	Schunk
SGA-M 010	081156	30-45	30	40	20	M6	12	1,5 x 60°	20	1,0	HFKN-M 165	HO7MA6	AS 165	HSL 165
SGA-M 020	081157	40-65									AN/AL/BH/-M 165	HO15M6	B-06/-106/-160/-206	ROTA NC plus 185
SGA-M 030	081158	65-85									BHM-FC 165	HO22M6	BB-06/-206 • BL-206	ROTA NCF plus 185
SGA-M 040	081159	85-105									RC-M 165	HO24M6	B-07 • HJA 5-6	ROTA NCD 165-185
SGA-M 050	081160	105-125			15						AP/NT-M 170	HO27M6	HOB-6 • HO-6	ROTA NCK
											BB-M 175	HO37M6	HOH-06/-106/-160/-206	ROTA NCK plus 165
											HB/PB/PBI-M 165	HO47M6	HOS 6	ROTA NC/NCF 165
													N-06/-160 • NL-06	
SGA-M 060	081161	30-50	35	50	25	M6	14	1,5 x 60°	25	1,4	HFKN-M 210	HO7MA8	AS 210	HSL 210
SGA-M 070	081162	50-75									AN/AL/BH/BB-M 210	HO15MA8	B-08/-108/-200/-208	ROTA NCD/NCK 210
SGA-M 080	081163	75-100									BHM-FC 210	HO23MA8	BB-08/-208 • BL-208	ROTA NC 210
SGA-M 090	081164	100-130		40	15						RC-M 210		HJA 6-8 • HO 8 • HOB 8	ROTA NCF 210
SGA-M 100	081165	130-160	40	40	15						AP/APL/NT-M 215		HOH-8/-108/-200/-208	ROTA NCK plus 210
											HB/PB/PBI-M 210		HOS 8	ROTA NC plus 215
													N-08/-200 • NL-08	NCF plus 215
SGA-M 200	081175	40-65	40	50	25	M6	16	1,5 x 60°	30	1,4	HFKN-M 260		AS 250	HSL 250
SGA-M 210	081176	65-100									AN/AL/BH/BB-M 250		B-10/-110/-210/-210X/-250	ROTA NC/NCD 250
SGA-M 220	081177	100-150									BHM-FC 250		BB-10/-210 • BL-210	ROTA NCF/NCK 250
SGA-M 230	081178	150-200	35								RC-M 250		HJA 6-10/8-10	ROTA NCK plus 250
											AP/APL/NT-M 260		HO-10 • HOB-10	ROTA NC plus 260
											HB/PB/PBI-M 250		HOH-10/-110/-210/-250	ROTA NCF plus 260
													HOS-10	
													N-10/-250 • NL-10	
SGA-M 331	081186	50-100	50	60	25	M8	21	1,5 x 60°	30	4,2	HFKN-M 315		B 212	HSL 315
SGA-M 341	081187	100-160									BHM-FC 315		BB-212	ROTA NCD/NCK 315
SGA-M 351	081188	160-230									AN/AL/BH/BB-M 315		BL-212	ROTA NC/NCK plus315
SGA-M 361	081189	230-300									RC-M 305			ROTA NCF plus 315
											AP/APL/NT-M 315			
											HB/PB/PBI-M 315			
SGA-M 331	081186	128-186	50	60	25	M8	21	1,5 x 60°	30	4,2	GH-M 400			
SGA-M 341	081187	178-246									RC-M 400			
SGA-M 351	081188	238-316												
SGA-M 361	081189	308-386												
SGA-M 371	085743	60-100	60	80	34	M8	22	1,5 x 60°	43	4,2			B-15/-18	HSL 400
SGA-M 372	085744	100-150											B-380/-450	ROTA NC/NCF 400
SGA-M 373	085745	150-200											HOH-15	
SGA-M 374	085746	200-250											HOH-15K	
SGA-M 375	085747	250-300								4,3			HOH-380	
SGA-M 376	085748	300-350								4,3				

stop pins

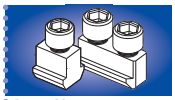
ALB

Type	Id-No.	G	H	SW
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ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	





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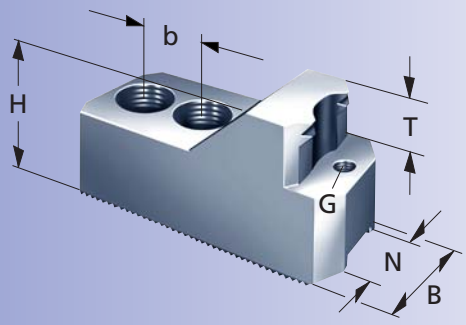
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hard roughing jaws

SGI-M for internal clamping

METRIC serration 1,5 x 60°

serration ground

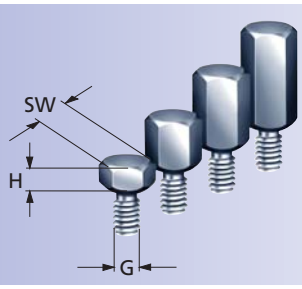


Type	Id.-No.	clamping range Ø	B	H	T	G	N	serration	b	kg/ set	SMW-AUTOBLOK	Howa	Kitagawa	Schunk
SGI-M 070 **SGI-M 080** **SGI-M 090** **SGI-M 100**	**081198** **081199** **081200** **081201**	70-95 95-120 120-145 145-170	35	50	20	M6	14	1,5 x 60°	25	1,7	HFKN-M 210 AN/AL/BH/BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210	HO7MA8 HO15MA8 HO23MA8	AS210 B-08/-108/-200/-208 BB-08/-208 BL-208 HJA 6-8 HO 8 HOB 8 HOH-8/-108/-200/-208 HOS 8 N-08/-200 NL-08	HSL 210 ROTA NCD 210 ROTA NCK 210 ROTA NC 210 ROTA NCF 210 ROTA NCK plus 210 ROTA NC plus 215 ROTA NCF plus 215
SGI-M 210 **SGI-M 220** **SGI-M 230**	**081212** **081213** **081214**	80-120 120-170 170-220	40	55	25	M8	16	1,5 x 60°	30	2,4	HFKN-M 260 AN/AL/BH/BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250		AS250 B-10/-110/-210/-210X/-250 BB-10/-210 BL-210 HJA 6-10/8-10 HO-10 HOB-10 HOH-10/-110/-210/-250 HOS-10 N-10/-250 NL-10	HSL 250 ROTA-NCK 250 ROTA NC 250 ROTA NCD 250 ROTA NCF 250 ROTA NCK 250 ROTA NCK plus 250 ROTA NC plus 260 ROTA NCF plus 260
SGI-M 331 **SGI-M 341** **SGI-M 351** **SGI-M 361**	**081220** **081221** **081222** **081223**	80-140 140-200 200-260 260-310	50	60	25	M8	21	1,5 x 60°	30	4,2	HFKN-M 315 BHM-FC 315 AN/AL/BH/BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315		B 212 BB-212 BL-212	HSL 315 ROTA NCD/NCK 315 ROTA NC plus 315 ROTA NCK plus 315 ROTA NCF plus 315
SGI-M 331 **SGI-M 341** **SGI-M 351** **SGI-M 361**	**081220** **081221** **081222** **081223**	158-226 218-286 278-346 338-396	50	60	25	M8	21	1,5 x 60°	30	4,2	GH-M 400 RC-M 400			

stop pins

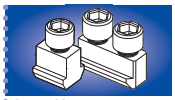
ALB

Type	Id-No.	G	H	SW
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ALB 610	**016511**		10	
ALB 615	**016512**		15	
ALB 620	**017602**		20	
ALB 805	**017603**	M8	5	13
ALB 810	**016514**		10	
ALB 815	**016515**		15	
ALB 820	**016516**		20	
ALB 825	**081191**		25	





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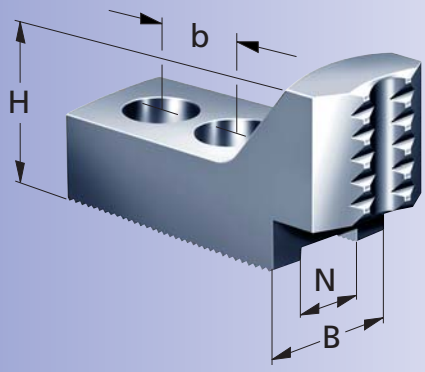
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hard bar roughing jaws

GSG-M

METRIC serration 1,5 x 60°

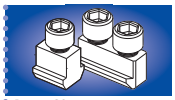
serration ground



Type	Id.-No.	clamping range Ø	B	H	N	serration	b for DIN 912	kg/ set	SMW-AUTOBLOK	Howa	Kitagawa	Schunk
GSG-M 120	**091347**	15-30	30	40	12	1,5 x 60°	20 M10	1,1	HFKN-M 165 AN/AL/BH/-M 165 BHM-FC 165 RC-M 165 AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165	HO7MA6 HO15M6 HO22M6 HO24M6 HO27M6 HO37M6 HO47M6	AS165 B-06/-106/-160/-206 BB-06/-206 BL-206 • B-07 HJA 5-6 HOB-6 • HO-6 HOH-06/-106/-160/-206 HOS 6 N-06/-160 • NL-06	HSL 165 ROTA NC plus 185 ROTA NCF plus 185 ROTA NCD 165-185 ROTA NCK 165 ROTA NCK plus 165 ROTA NC/NCF 165
GSG-M 140	**091348**	20-50	35	45	14	1,5 x 60°	25 M12	1,6	HFKN-M 210 AN/AL/BH/BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210	HO7MA8 HO15MA8 HO23MA8	AS210 B-08/-108/-200/-208 BB-08/-208 BL-208 HJA 6-8 HO 8 • HOB 8 HOH-8/-108/-200/-208 HOS 8 N-08/-200 • NL-08	HSL 210 ROTA NCD/NCK 210 ROTA NC 210 ROTA NCF 210 ROTA NCK plus 210 ROTA NC plus 215 ROTA NCF plus 215
GSG-M 160	**091349**	20-60	40	50	16	1,5 x 60°	30 M12	1,8	HFKN-M 260 AN/AL/BH/BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250		AS250 B-10/-110/-210/-210X/-250 BB-10/-210 BL-210 HJA 6-10/8-10 HO-10 • HOB-10 HOH-10/-110/-210/-250 HOS-10 N-10/-250 • NL-10	HSL 250 ROTA NC/NCD 250 ROTA NCF/NCK 250 ROTA NCK plus 250 ROTA NC plus 260 ROTA NCF plus 260
GSG-M 180	**091350**	30-80	50	50	18	1,5 x 60°	30 M14	3,6		HO7MA12 HO15M12 H23M12 HO22M10 HO24M10 HO27M10 HO37M10 HO47M10	B-12/-300 HJA 6-12/8-12 HLA 6-15/8-15 HO-12 HOB-12 HOH-12/300 HOS-12 N-12/-300 • NL-12	HSL 315 ROTA NC/NCF 315
GSG-M 210	**091351**	30-80	50	50	21	1,5 x 60°	30 M16	3,6	AN-M 315 AL-M 315 BH-M 315 BHM-FC 315 BB-M 315 PB-M 315 PBI-M 315 HB-M 315 HFKN-M 315 AP/NT-M 315		B-212 BB-212 BL-212	HSL 315 ROTA NCD/NCK 315 ROTA NC/NCK plus 315 ROTA NCF plus 315



Page 53
Page 143
Page 144



Page 62

Clamping of a sprocket

Clamping with 1 fixed and 2 floating pins



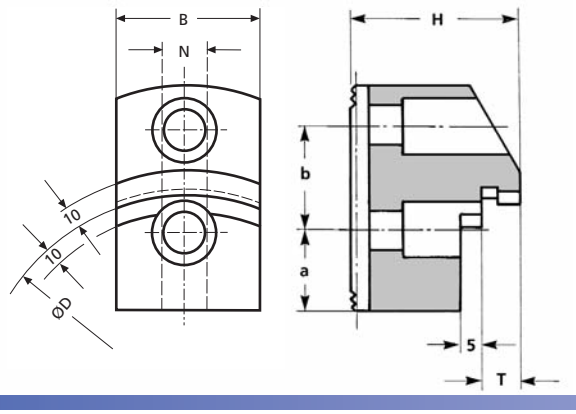
Pitch line clamping of a gear

low deformation clamping by distributing the grip force onto multiple tooth gaps



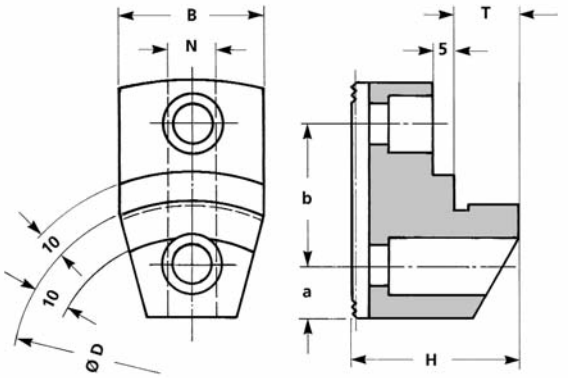
hard special jaws
on customer request

hard top jaws for external clamping



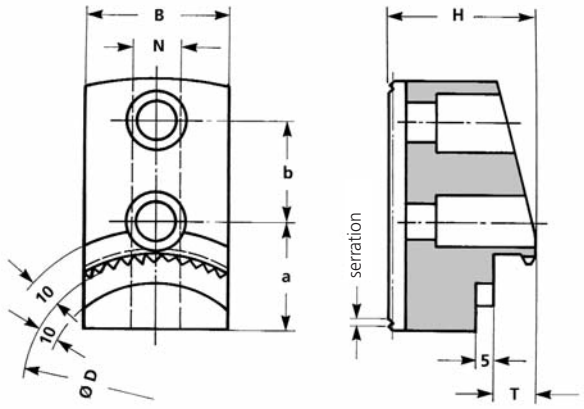
B
H
T
D
N
a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck typ
material

hard top jaws for internal clamping

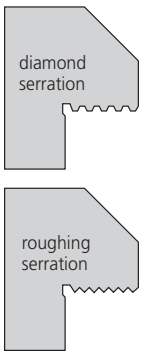


B
H
T
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a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck typ
material

hard top jaws for external clamping

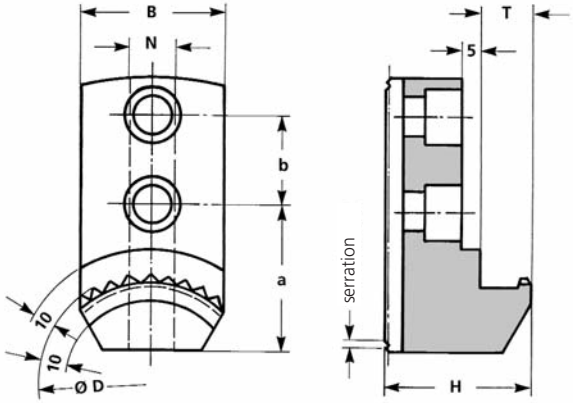


clamping area

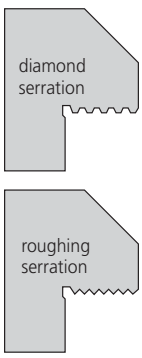


B
H
T
D
N
a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck typ
material

hard top jaws for internal clamping

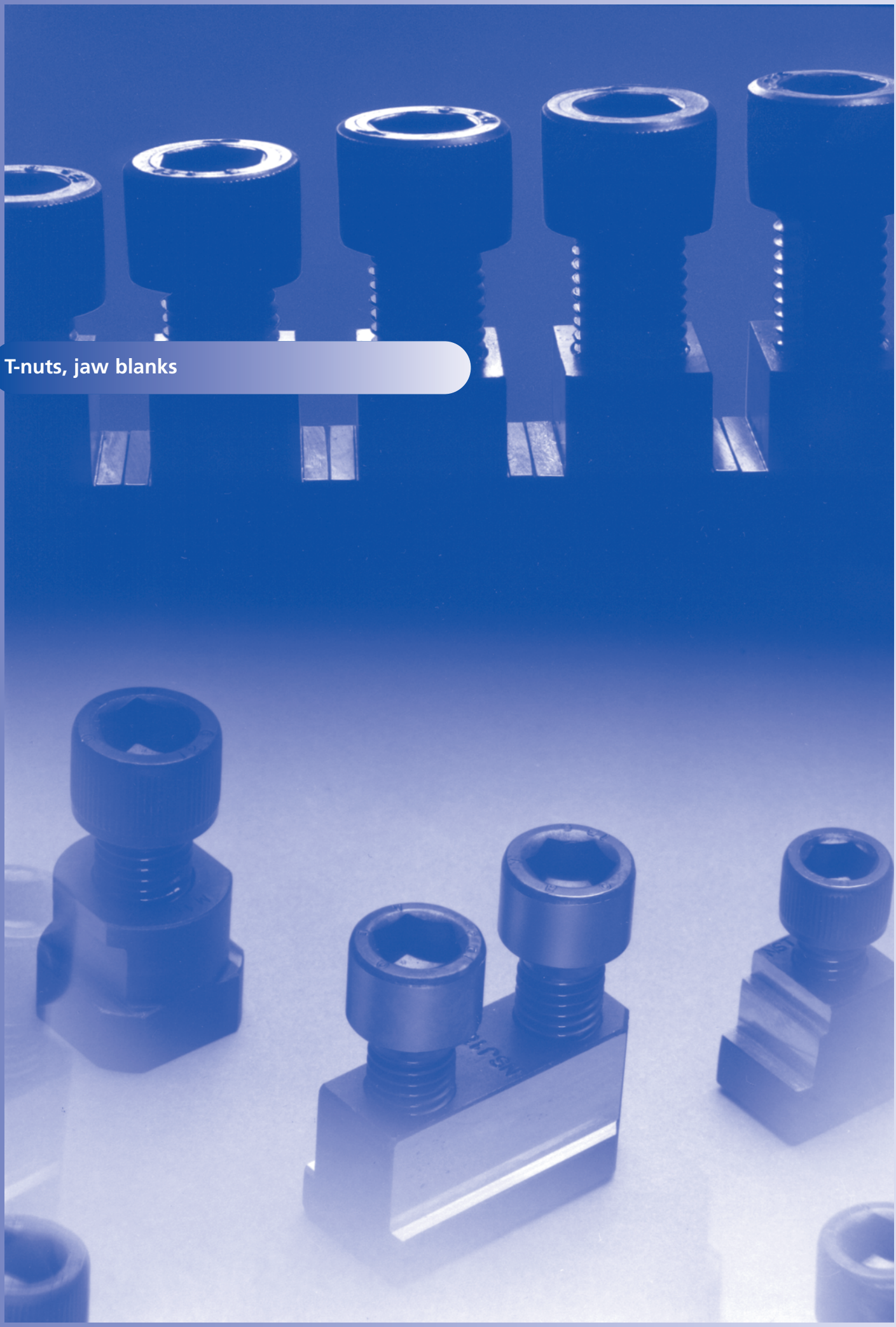


clamping area

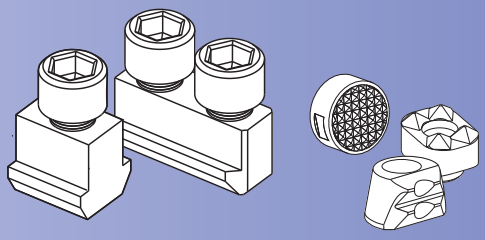


B
H
T
D
N
a
b
serration (e.g. 1,5 x 60°)
work-piece Ø
chuck maker
chuck typ
material

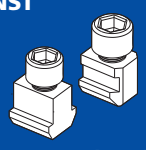
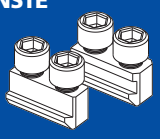
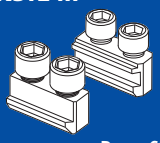
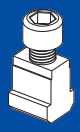
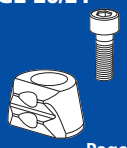
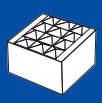
T-nuts, jaw blanks



▪ T-nuts
▪ grippers



SMW-AUTOBLOK **Berg** **Forkardt** **Howa** **Kitagawa** **Röhm** **Schunk**

NST	T-nuts for chucks **INCH serration** **1/16" x 90° or 3/32" x 90°**		**NST**  Page 56
NSTE	double T-nuts for chucks **INCH serration** **1/16" x 90° or 3/32" x 90°**		**NSTE**  Page 60
NSTE-M	double T-nuts for chucks **METRIC serration** **1,5 x 60°**		**NSTE-M**  Page 62
TS **TM**	T-nut bolts slotted nuts	only for Berg-chucks type KH	**TS, TM**  Page 64
NSO	special T-nuts to customer request		**NSO**  Page 65
UGE 10 **UGE 20** **UGE 21**	jaw blanks jaw blanks jaw blanks with one row of teeth	hardened steel hardened steel hardened steel	**UGE 10**  Page 66
			UGE 20/21  Page 66
UGE 30 **MGH**	jaw blanks clamping points	solid carbide HSS	**UGE 30**  Page 67
			MGH  Page 67
HDS-R **HDS-Q**	jaw blanks jaw blanks	round/solid carbide square/solid carbide	**HDS-R**  Page 68
			HDS-Q  Page 68
G14 **G25** **G15** **G30**	precision gripper inserts	HSS light duty pull down heavy duty pull down light duty pull down heavy duty pull down	**G**  Page 69

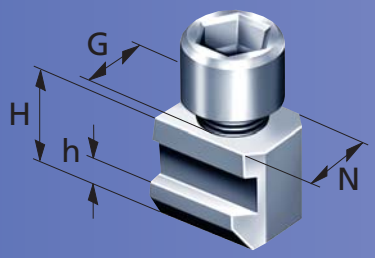
safety advise:
Top jaws are safety components, which can unter high load depending on their use.
Max grip forces and speeds must not be exceeded at any time.
For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

T-nuts

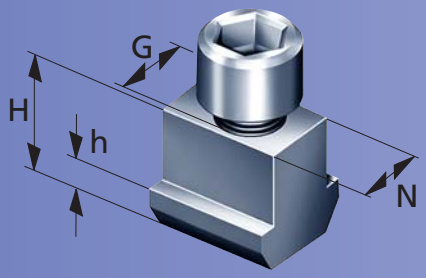
NST

quenched and ground

incl. screw
DIN 912 – 12.9

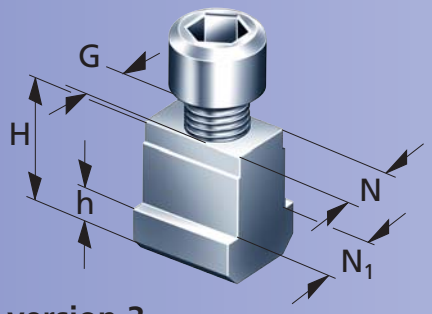


version 1



version 2

Type	Id.-No.	vers.	N	H	h	G	screw DIN 912	torque Md max. (Nm)	SMW-AUTOBLOK	SMW	Autoblok
NST 11	**013862**	2	11	21,5	7,5	M8	M8 x 30	30		SP 125 • STP 125 STWP 125	
NST 12	**081966**	2	12	17	7	M8	M8 x 20	30		KDV 130	
NST 12-1	**089810**	2	12	21,5	7,5	M8	M8 x 25	30	SP 125/98 • STP 125		
NST 14	**013863**	2	14	26,5	9,5	M10	M10 x 35	50	SP 160 • STP 165	SP 160 • STP 160 STWP 160	
NST 14-1	**085874**	2	14	20	7,5	M10	M10 x 25	50			ODN 170 • HDB 170 ODL 170 • HDN 170 HDL 170 • GHDN 165 GHD/FC 165
NST 14-2	**035958**	1	14	18,5	6,5	M10	M10 x 20	50	HFKN-D 165 • AN-D 165 AL-D 165 • BH-D 165 BHD-FC 165 • BB-D 175 HB-D 165 • PB-D 165 AP/NT-D 170 PBI-D 165 • HYDN-S 180		
NST 17-5	**064921**	1	17	18,5	6,5	M12	M12 x 25	70	HFKN-D 165		
NST 17	**016021**	2	17	23	9	M12	M12 x 30	70		HFK 160/200 HFKS 160/200 KDV 160/200/250 KDVG 160/200/250 KFV 160/200 KFMF 160/200	
NST 17-1	**085877**	2	17	22,3	8,3	M12	M12 x 30	70			ODN 200 • ODN 220 ODL 200 • HDB 200 HDN 200 • HDN 220 HDL 200 • GHDN 210 CD 200 • GHD/FC 210
NST 17-2	**034245**	1	17	20,5	7,5	M12	M12 x 25	70	HFKN-D 210 • AN-D 210 AL.-D 210 • BH-D 210 BHD-FC 210 • BB-D 210 HB-D 210 • PB-D 210 PBI-D 210 AP/APL/NT-D215/260 RC-D210 HYDN-S 210/226		
NST 17-14	**036976**	1	17/14	20,5	7,5	M12	M12 x 25	70			
NST 17-3	**081825**	2	17	21,5	9	M12	M12 x 25	70			
NST 17-4	**013864**	2	17	26,5	9,5	M12	M12 x 30	70	SP 200 • SP 240 STP 240 • CC 240 Z	SP 200 • STP 200 STWP 200 • LP 205	
NST 21	**014788**	2	21	27	11	M16	M16 x 35	150		HFK 250/270/315 HFKS 250/315 KDV 315/400 KDVG 315/400 KZF-ES 200 KZF 200 KFV 250/315 KFMF 250/315	
NST 21/17	**081812**	3	21/17	27	11	M12	M12 x 35	70			



version 3

Please observe!
Always tighten T-nuts with a torque wrench.

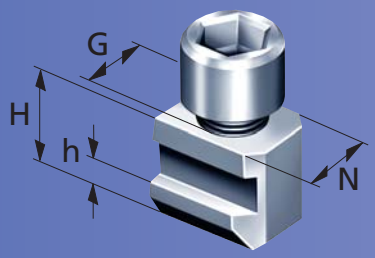
Forkardt	Röhm	Schunk
		TP 125 ROTA TP 125
3 KTH 130-33 3 KTH 140-37	KFD 130 • KFH 140 LVE 125 • KFD-HS 160	ROTA NCD 165
		TP 160 • ROTA TP 160
		ROTA NCK Plus 165 ROTA NCF 185 ROTA NC / NCF Plus 185
2BLE-PS 160/200 • 2BLEF 200 KL/KT/KTG/KTN/KS-PS 160/200 KSF 175/200 • KS/KL 250 Mo KGH/KGHF/KTH 160/175/200 KS 160/200/250 • KG/KP 200 NH/NHF 160/175/200 QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 • UVE 160/200/250		TH/THF/HSL 165/210 ROTA NCD 210 ROTA NC / ROTA NCF Plus 165
		ROTA 2 B 160 ROTA NCD 185 ROTA NC / NCF 165/210 ROTA NCO 210 ROTA NC / NCF Plus 215
	KFD 160/200 • KFD-AF 160/200 KFD-HF 160/200 • KFH-F 160/200 KFH-G 160/200 • KFH-NC 160/200 SPD 160/200 • LVE 160/200	HSG 200/250
		TP 200 ROTA TP 200
3 NH 250/315 • 3 NHF 250/315 KT 250/315 • KSH 250/315 • KSHF 250/315 3 KTGF 250/315 • KG 250/315 • KP 250-315 KLNC 250/315 • KL 250 • KSPS 250/300 • 3 NHF 290 KS 315/400 • KSH 400 • KSHF 400 UVE 315 • 3 NHF 400 (Index) 2 BLE 200 • 2 BLE 250 Mo • 2 BLN 200 QLC 250/315 GHE 250 Mo QLK/QLC-KS 315/400 • QLK/QLC-LS 250/315 QLC-AG 250/315		ROTA NC-D 250 HSL 250 TH 250 • THF 250 HSG 315 • HSL 315 ROTA NC-D 315 TH 315 • THF 315 ROTA NCF 315

T-nuts

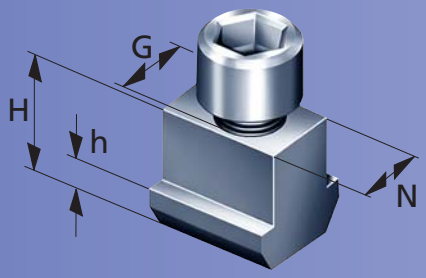
NST

quenched and ground

incl. screw
DIN 912 – 12.9



version 1



version 2

Type	Id.-No.	vers.	N	H	h	G	screw DIN 912	torque Md max. (Nm)	SMW-AUTOBLOK	SMW	Autoblok
NST 21-3	**081826**	2	21	25,5	11	M16	M16 x 35	150	GH-D 400 GH-M 400 RC-D 400 RC-M 400		ODN 250-315-400 ODL 250-315-400 HDN 250-315-400 HDL 250-315-400 GHDN 250-315-400 GHD/FC 250-305-400 CD 250/315 • HDB 300 2 CLD 200 • US-2 CLD 200
NST 21-5	**033429**	2	21	30	11	M16	M16 x 35	150	SP 250/98 SP 350 STP 250/98 • STP 280 SP 280/350	SP 250/315 LP 250/305 STP 250/315 STWP 250/315	
NST 21-6	**034197**	1	21	26,5	10	M16	M16 x 35	150	HFKN-D 260/315 AN-D 250/315		
NST 21/17-1	**034208**		21/17	26,5	10	M12	M12 x 30	70	AL-D 250/315 AN-M 315 • AL-M 315 HB-D 250/315 NT-D 315 • NT-M 315 AP-D 315 • AP-M 315 APL-D 315 • APL-M 315 BH-D 250/315 BHD-FC 250/315 BH-M 315 • BB-M 315 PB-D 250/315 BB-D 250/315 RC-D 250/305 BHM-FC 315 • RC-M 305 PBI-D 250/315 HYDN-S 250/315		
NST 25	**014812**	2	25,5	29	11	M20	M20 x 40	300	HFKN-D 400 HFKN-D 500	HFK 400/500 HFKS 400/500 KDV 500 • KDVG 500 KDS 630 • KZF 250 KZF 315/400 KZF-ES 315/400 KFV 400/500 KFV 630/800	
NST 25-1	**013866**	2	25,5	34,5	14,5	M18	M18 x 55	220		STP 400/500 LP 380/460/500 BB 400/500 BB 400/500-ES	
NST 25-3	**12065020**	2	25,5	34	15	M20	M20 x 40	300	AN/AL-D 400 BB-N 400/460/500/600 BB-N ES 400/460/500/600 BH-D 400/450/500/630/800 BHD-FC 400/450/500/630/800 CL-D 250/315 HYD-S 400	2 CLD 250/315 US-2 CLD 250/315	
NST 25-4	**12065002**	3	25,5	40	15,5	M20	M20 x 50	300	GHDN 610/640/800 HYDL-S 800 IN-D 500/630/800 IL-D 500/630/800		
NST 25-5	**199908**	2	25,5	40	15	M20	M20 x 50	300	BB-AZ 590 BB-SC 600		
NST 30	**081811**	2	30	41	15	M24	M24 x 50	450			
NST 30-1	**014827**	2	30	36	15	M24	M24 x 50	450		HFKS 630/800	
NST 30-2	**013868**	2	30	41	15	M24	M24 x 70	450			
NST 30-3	**13063900**	2	30	44	18	M24	M24 x 60	450	BB-N 630/800/1000 BB-N ES 630/800/1000 IN-D 1000/1250 BBU-AZ 630/750	STP 630/800 BB 630/800/1000 BB-ES 630/850/1000	

Please observe!
Always tighten T-nuts with a torque wrench.

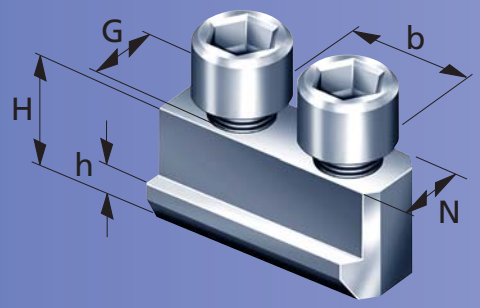
Forkardt	Röhm	Schunk
	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 • KFA 200 LVE 250/305/315	
		TP 205/315 ROTA TP 250/315
		ROTA NCO 260/315 ROTA NC 250 ROTA NCF 250 ROTA 2B 200 ROTA NC Plus 260/315 ROTA NCK Plus 315 ROTA NCF Plus 260/315
3 NH 400/500/630 • QLC 400 • QLK 400 3 NHF 400/500/630 • 3 KTGF 400/500 UVE 400/500/630/800 • KT 400/500 KG 400/500 • KL 400/500 • KLNC 400/500 KP 400 • KS 500/630 • KSH 500 • KSL 630 KSHF 630 • KL 300 • KSHF 560 • 2 BLE 250 2 BLE 315 • 2 BLE-PS 300 • 2 BLE-PS 315 2 BLE 400 • 2 BLE 500 • 2 BLE-PS 400/500 2 BLN 250/315/400		HSL 400 ROTA NC-D 400/600 ROTA NC 400 ROTA NCF 400 TH 400 THF 400 TH 500 THF 500 ROTA 2B 250/315/400
		TB 400 • TB 500 ROTA TB 400/500/610 ROTA EP 380/460 ROTA TB-LH 400/500/610
	KFH 400 • KFD 400 • LVE 400 KFH 500 • KFD 500 • LVE 500 KFD-HE 400 • KFD-HF 400 • KFD 630 • LVE 630 KFD-HF 500 • KFD 800 • LVE 1000 • KFD-HS 400 KFL 500 • KFA 250 • KFD-HS 500 • KFL 600 KFA 315 • KFH-F 400/500 KFH-G 400/500 • KFH-NC 400/500	HSG 400 • HSG 500 ROTA NCO 400/500
KS 800/1000 • KSF 1000	KFD 1000/1250	ROTA NCD 1000 • ROTA NC 1000
		ROTA TB 800/850/1000/1200 ROTA TB-LH 800/850/1000 • ROTA NC 630 ROTA TB 630 • ROTA TB-LH 630 • 630 • TH 630

double T-nuts

NSTE

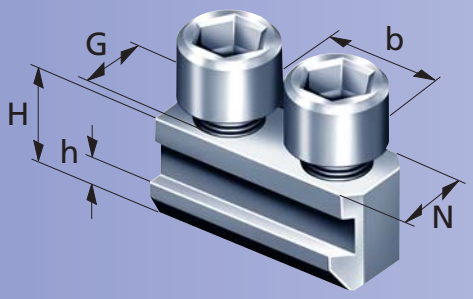
quenched and ground

incl. screw
DIN 912 – 12.9



version 2

Type	Id.-No.	vers.	N	H	h	b	G	screw DIN 912	torque Md max. (Nm)	SMW-AUTOBLOK
NSTE 08	**038265**	2	8	13,5	5	12	M6	M6 x 20	16	HFKN-D 110
NSTE 12	**12061300**	2	12	15	6,5	16	M8	M8 x 20	30	BH-D 130 PB-D 130 HB-D 130 BB-D 140
NSTE 12-1	**12061200**	1	12	15	6,5	16	M8	M8 x 20	30	AN-D 125 AL-D 125
NSTE 14	**73061650**	1	14	18,5	6,5	16,5	M10	M10 x 20	50	HFKN-D 165 • AN/AL/BH/BH-D 165 BHD-FC 165 • PB/PBI/RC-D 165 AP/NT-D 170 • BB-D 175 HYND-S 180
NSTE 17	**081813**	2	17	23	9	22	M12	M12 x 30	70	
NSTE 17-1	**081814**	2	17	21,5	9	19	M12	M12 x 30		
NSTE 17-2	**73062150**	1	17	20,5	7,5	23	M12	M12 x 25	70	HFKN-D 210 • AN-D 210 • AL-D 210 BH-D 210 • BHD-FC 210 • RC-D 210 BB-D 210 • PB-D 210 • PBI-D 210 • HB-D 210 HYDN-S 210/226 • AP-D 215 • NT-D 215
NSTE 17-3	**18062632**	1	17	20,5	7,5	30	M12	M12 x 25	70	AP/NT-D260
NSTE 21	**081815**	2	21	27	11	28	M16	M16 x 35	150	
NSTE 21-2	**73063050**	1	21	26,5	10	30	M16	M16 x 30	150	HFKN-D 260/315 • HFKN-M 315 AN/AL/BH/BB/HB/PB/PBI-D 250/315
NSTE 21-3	**034148**	1	21	26,5	10	28	M16	M16 x 30	150	AN/AL/BH/BB/PB/PBI-M 315 AP/APL/NT-D 315 • AP/APL/NT-M 315 HYND-S 250/315 • RC-D 250/305 RC-M 305 • BHD-FC 250/315 • BHM-FC 315
NSTE 25,5	**081817**	2	25,5	29	11	35	M20	M20 x 40	300	HFKN-D 400 HFKN-M 400
NSTE 25,5-1	**73065030**	1	25,5	33	14,5	38	M20	M20 x 40	300	RC-D 500 AP-D 400 • APL-D 400 NT-D 400



version 1

Please observe!
Always tighten T-nuts with a torque wrench.

SMW	Forkardt	Schunk
HFK 160/200 HFKS 160/200 KDV 160/200 KDV 250 KDVG 160/200 KDVG 250 KFV 160/200 KFMF 160/200	2 BLE-PS 160/200 • 2 BLEF 200 KL/KT/KTG/KTN/KS-PS 160/200 KSF 175/200 • KSKL 250 Mo KGH/KGHF/KTH 160/175/200 KS 160/200/250 • KG/KP 200 NH/NHF 160/175/200 QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 • UVE 160/200/250	HSL 165/210 TH 165/210 THF 165/210 ROTA NC-D 200 HSG 200 HSG 250 ROTA NC/NCF Plus 165
		ROTA NC/NCF Plus 215 ROTA NCO 210 • ROTA NCD 185 ROTA NCK Plus 210/250 • ROTA NCF 165/210 ROTA NC 165/210 • ROTA 2B 160
HFK 250/270 HFK 315 HFKS 250/315 KDV 315/400 KDVG 315/400 KZF 200 • KZF-ES 200 KFMF 250/315 KFV 250/315	3 NH 250-315 • 3 NHF 250-315 KT 250-315 • KSH 250-315 KSHF 250-315 • 3 KTGF 250-315 KG 250-315 • KP 250-315 KLNC 250-315 • KL 250 • KSPS 250-300 3 NHF 290 • KS 315-400 • KSH 400 KSHF 400 • UVE 315 • 3 NHD 400 (Index) 2 BLE 200 • 2 BLE 250 Mo QLK/QLC 250/315 • QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 • QLC-AG 250/315	HSL 250/315 ROTA NC-D 250 ROTA NC-O 250 TH 250/315 THF 250/315 HSG 315 ROTA NC-D 315 ROTA NC-O 315 ROTA NCF 315 ROTA NC 315
		ROTA NCO 260/315 ROTA 2B 200 ROTA NC 250 • ROTA NCF 250 ROTA NC Plus 260/315 ROTA NCK Plus 315 ROTA NCF Plus 260/315
HFK 400/500 • HFKS 400/500 KDV 500 • KDVG 500 KDS 630 KZF 250 • KZF-ES 250 KZF 315 • KZF-ES 315 KZF 400 • KZF 400-800	3 NH 400-500-630 • 3 NHF 400-500-630 3 KTGF 400-500 • UVE 400-500-630-800 KT 400-500 • KG 400-500 • KL 400-500 KLNC 400-500 • KP 400 • KS 500-630 KSH 500 • KSL 630 • KSHF 630 • KL 300 KSHF 560 • 2 BLE 250 • 2 BLE 315 2 BLE-PS 300 • 2 BLE-PS 315 • 2 BLE 400 2 BLE 500 • 2 BLE-PS 400-500 • QLC 400 • QLK 400	HSL 400 ROTA NC-D 400/500 ROTA NC-F 400/500 TH 400/500 THF 400/500 ROTA 2B 250/315/400

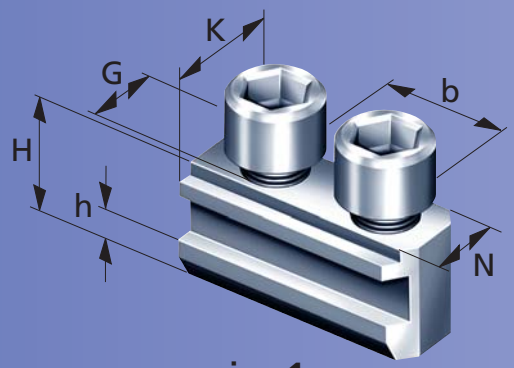
double T-nuts

NSTE-M

for base jaws with METRIC serration

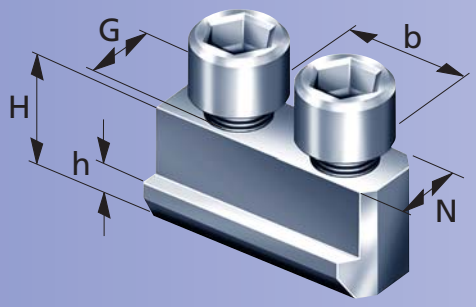
quenched and ground

incl. screw
DIN 912 – 12.9

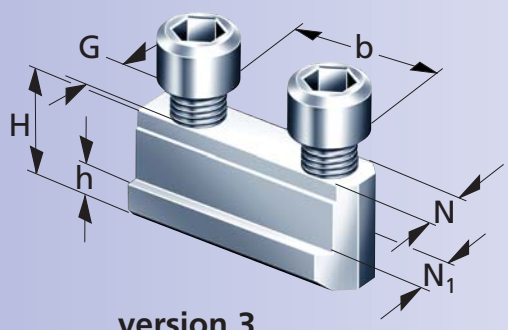


version 1

Type	Id.-No.	vers.	N	H	h	b	G	screw DIN 912	torque Md max. (Nm)	SMW-AUTOBLOK
NSTE-M 105	091508	2	10	15	5	14	M8	M8 x 20	30	
NSTE 12-1	12061200	1	12	15	6,5	16	M8	M8 x 20	30	AN-M 125 • AL-M 125
NSTE 12	12061300	2	12	15	6,5	16	M8	M8 x 20	30	BH-M 130 • BB-M 140 • HB/PB-M 130
NSTE-M 120	73061602	1	12	18,5	6,5	20	M10	M10 x 20	50	AN-M 165 • AL-M 165 • BH-M 165 • BHM-FC 165 • RC-M 165 PB-M 165 • PBI-M 165 • HB-M 165 • BB-M 175 • AP/NT-M 170
NSTE-M 121	081833	2	12	22	7	20	M10	M10 x 25	50	
NSTE-M 125	012534	2	12	18,5	7,5	20	M10	M10 x 25	50	
NSTE-M 140	73062101	1	14	20,5	7,5	25	M12	M12 x 25	70	AN-M 210 • AL-M 210 • BH-M 210 • BHM-FC 210 • RC-M 210 PB-M 210 • PBI-M 210 • HB-M 210 • BB-M 210 • AP/NT-M 215 APL-M 215
NSTE-M 141	081834	2	14	24,5	8,5	25	M12	M12 x 35	70	
NSTE-M 145	012535	2	14	20,5	8,5	25	M12	M12 x 30	70	
NSTE-M 160	73062501	1	16	26,5	10	30	M12	M12 x 30	70	AN-M 250 • AL-M 250 • BH-M 250 • BHM-FC 250 • RC-M 250 PB-M 250 • PBI-M 250 • HB-M 250 • BB-M 250
NSTE-M 160-1	18062633	1	17/16	20,5	7,5	30	M12	M12 x 30	70	AP/APL-M 260 • NT-M 260
NSTE-M 161	080547	2	16	24,5	8,5	30	M12	M12 x 35	70	
NSTE-M 162	081835	2	16	23	8	30	M12	M12 x 30	70	
NSTE-M 165	012546	2	16	21,5	8,5	30	M12	M12 x 30	70	
NSTE-M 167	081836	2	16	26,5	8,5	25	M12	M12 x 35	70	
NSTE-M 181	081837	2	18	33,5	13,5	30	M14	M14 x 45	130	
NSTE-M 187	019359	2	18	27,5	9,5	30	M14	M14 x 40	130	
NSTE 21-2	73063050	1	21	26,5	10	30	M16	M16 x 30	150	AN/AL/AP/APL/NT/BH/BB-M 315 • PP/HB/PBI-M 315 BHM-FC 315 • RC-M 305
NSTE-M 220	12064520	2	22	33	14,5	38	M20	M20 x 40	150	AP/APL/NT-M 400 • BHM -FC 400
NSTE-M 212	081839	2	21	28	11,5	30	M16	M16 x 40	150	
NSTE-M 213	236521	2	21	23	11,5	30	M16	M16 x 35	150	
NSTE-M 227	081842	3	22/24	45,5	16,5	43	M20	M20 x 60	300	
NSTE-M 22	12064020	3	25,5/22	34,5	15		M20	M20 x 40	300	AN-M 400 • AL-M 400 • BH-M 400/450



version 2



version 3

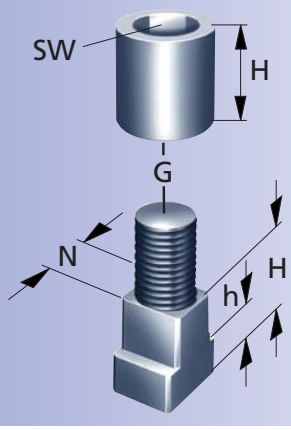
Howa	Kitagawa	Schunk
	B204 • B205	
HO 1 MA 6 • HO 7 MA 6 • HO 24 M 6 • HO 27 M 6 HO 15 M 6 • HO 22 M 6 • HO 47 M 6 • HO 37 M 6	HJA 5-6 • HO 6 • N-160 • HOS 6 • HOH 06 • N 160 B 06 • N 06 • B-160 • HOB 6 • AS 165 • HOH-160	HSL 165 (1,5 x 60°) ROTA NC/NCF 165
	B-206 • B 06 • B 106 • B 07 • HOH 106 • HOH 06 BB 06 • BB 206 • HOH 206	ROTA NCK 165 • ROTA NCK Plus 165
HO 1 MA 8 • HO 2 MA 8 • HO 23 M 8 • HO 7 M 8 HO 15 M 8	HJA 6-8 • HO 8 • HOH 08 • N-200 • HOS 8 • B 08 B-200 • HOB 8 • AS 210 • HOH-200 • N 08 • N 200	HSL 210 (1,5 x 60°) ROTA NC/NCF 210
	B-208 • B 108 • HOH 108 • HOH 208 B 208 • BB 208 • BB 08	
	B-250 • AS 250 • HOS 10 • B 10 • AS 250 HOB-10 • HO-10 • HJA 8-10 • HOH 250 • N 10 • N 250	HSL 250 (1,5 x 60°) ROTA NC/NF 250
HO 1 MA 10 • HO 2 M 10		
	B-110 • HOH 110 • B-210 • HOH 210 • BB 210 • BB 10	ROTA NCK 250 • ROTA NCK Plus 250
HO 7 MA 10 • HO 15 M 10 • HO 22 M 8 HO 47 M 8 • HO 23 M 10 • HO 27 M 8 HO 24 M 8 • HO 37 M 8		
HO 1 MA 12 • HO 2 M 12	B-300 • HO-12 • HOH-300 • HOS 12 • B 12 • N 12 HOH 12 • N-300 • HOB 12 • HLA 6-12 • HLA 6-15 HLA 8-12 • HJA 8-15	ROTA NC/NCF 315
HO 7 MA 12 • HO 22 M 10 • HO 23 M 12 HO 37 M 10 • HO 27 M 10 • HO 24 M 10 HO 15 M 12 • HO 47 M 10		HSL 315
	B 212 • HOH 212 • B-112 • HOH 112	ROTA NCK 315 • ROTA NCK Plus 315 • ROTA NCD 315 ROTA NC/NCF Plus 315
	BB 212	
	B-380 • B-15 • B-18 • B-450 • HOH 380 HOH-18 • HOB-15 • HOB 18 • HOH 15	HSL 400 ROTA NC/NCF 400

Please observe!
Always tighten T-nuts with a torque wrench.

T-nuts Berg

TS - T-nut bolts

TM - slotted nuts



Type	Id.-No.	N	H	h	G	SW	torque Md max. (Nm)	chuck
TS 10	**087409**	10	20,3	9,3	M10	-	60	KH 140
TM 10	**087405**	-	16	-	M10	8,1	60	KH 160
TS 12	**087410**	12	23,2	9	M12	-	100	KH 175
TM 12	**087406**	-	19	-	M12	10,1	100	KH 200
TS 16	**087411**	16	26,7	12	M16	-	250	KH 250
TM 16	**087407**	-	25	-	M16	14,1	250	KH 315

Please observe!
Always tighten T-nuts with a torque wrench.

Datasheet / order form

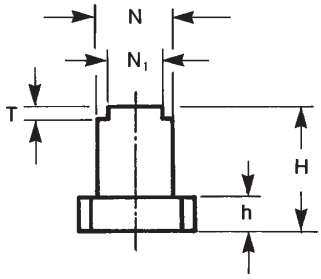
special T-nuts

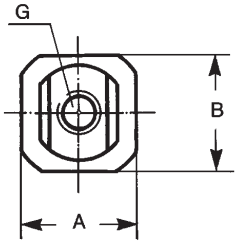
Existing top jaws can be adapted to different chucks by using stepped T-nuts.

Fill in the requested data and send with the inquiry or the PO.

T-nuts type NSO 10



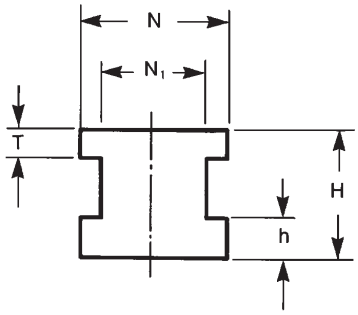


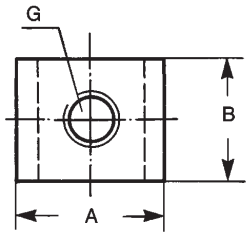


A	
B	
G	
H	
h	
N	
N_1	
T	

T-nuts type NSO 20



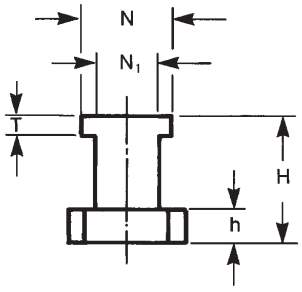


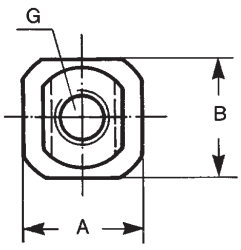


A	
B	
G	
H	
h	
N	
N_1	
T	

T-nuts type NSO 30



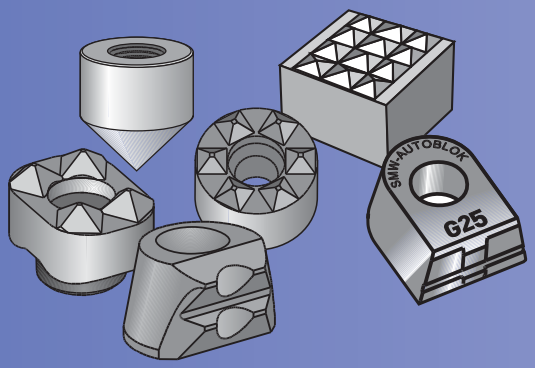




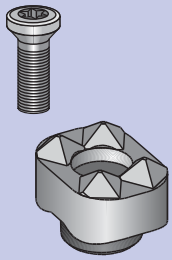
A	
B	
G	
H	
h	
N	
N_1	
T	

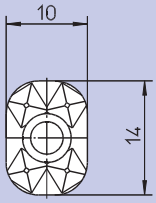
grippers

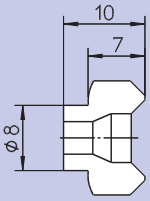
UGE
MGH
HDS
G



UGE 10 Id.-No. 081845F, special steel hardened







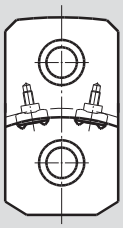
Parts included: Gripper with Torx screw

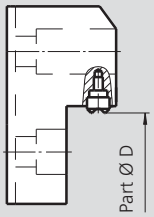
The universal gripper with unique features (patented):

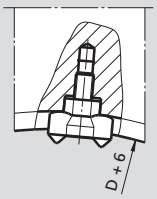
- For flat and round clamping surfaces
- For external and internal gripping
- Front mounting of bolts
- Gripper seat, round or flat, and thread is easy to produce
- Hardening of gripper seat necessary
- Torx screw driver Id. No. 085961
- Torx screw M4 x 13.5 Id. No. 033010

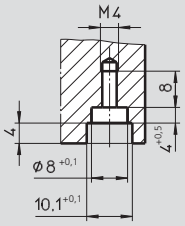
Mounting instruction:

1. Part Ø D + 6 mm (0.23 inch) + workstop + slot has to be turned or milled. Please note corrected dimensions according to sketch.
2. Drill and tap
3. Harden jaw

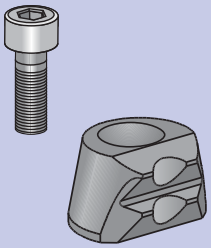


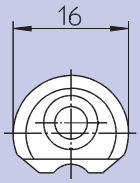


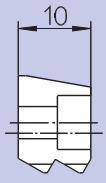




UGE 20 Id.-No. 087414, special steel hardened
UGE 21 Id.-No. 233348 (grip insert with one row of teeth)







Parts included: Gripper with head socket screw M4 x 12 DIN 912

The gripper with the unique shape (patented):

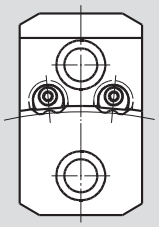
- Pull-down effect by wedge shape design
- Can be used for self-centering or swivelling
- Gripper seat: Milling, drilling and tapping can easily be machined with the inclined milling tool
- No hardening of jaws necessary
- For external or internal clamping
- Head socket screw M4 x 12 DIN 912, Id. No. 010145

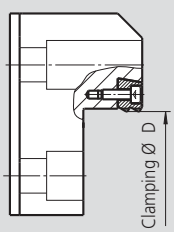
Mounting instruction:

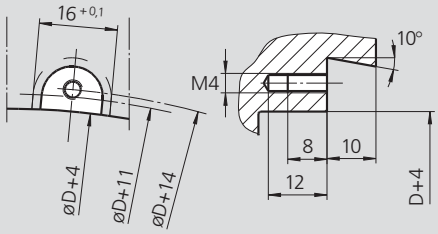
1. Part Ø D + 4 mm (0.16 inch) + workstop turning or milling
2. Milling of pocket + drilling and tapping

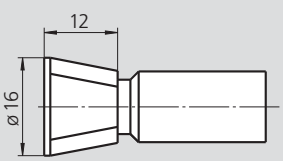
Inclined milling tool HSS
Id.-No. 033611

Inclined milling tool Solid Carbide
Id.-No. 138711







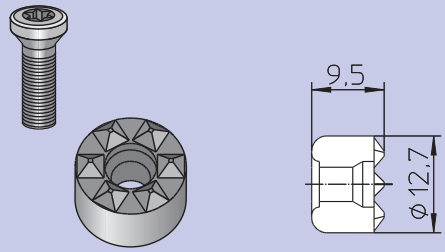


The economical solution:
Roughing jaws with exchangeable grippers:

- Made from standard SMW-AUTOBLOK jaws.
- Economical, because only the worn out gripper is changed in seconds.
- Extended life compared to standard roughing jaws.

Features:
- Safe gripping of rough material/forgings/castings made from standard or high tensile strength material.
- Increased gripping allows heavier cuts.
- Fast change of worn out grippers.

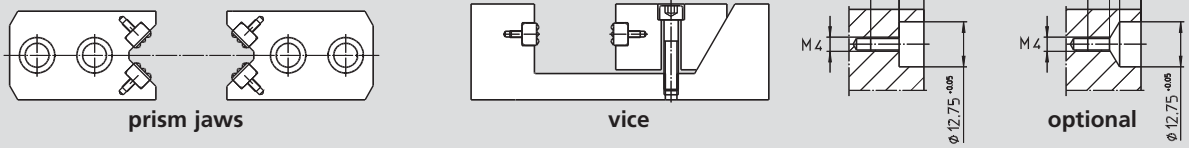
UGE 30 Id.-No. 089822, Solid Carbide



Parts included: Gripper with Torx screw

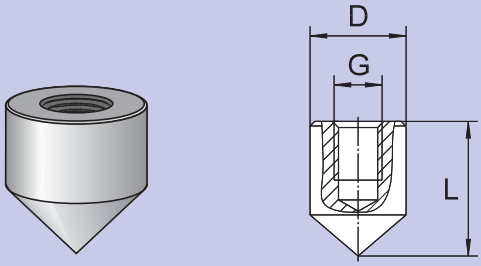
Gripper for prism jaws and fixtures (patented):
- For external and internal gripping of rectangular parts
- For chuck jaws, fixture jaws and fixtures
- Front mounting of bolt
- Gripper seat: drilling and tapping can easily be done. Bottom of seat can be either 120° (standard drill tool) or flat
- For high production hardening of gripper pocket recommended
- Torx screw driver Id. No. 085961
- Torx-screw M4 x 13,5 Id.-No. 033010

Mounting instruction
1. Drilling 12.7 Ø bottom of seat 120° or flat
2. Tapping of thread



prism jaws | vice | optional

MGH, HSS hardened

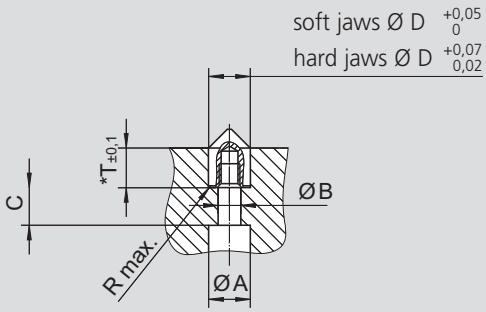


Parts included: Hardened point without screw

Clamping points for jaws
- For external and internal gripping
- Increasing gripping allows for heavier cuts
- Rear mounting of bolts
- Point seat can easily be machined: drilling only

Mounting instruction:

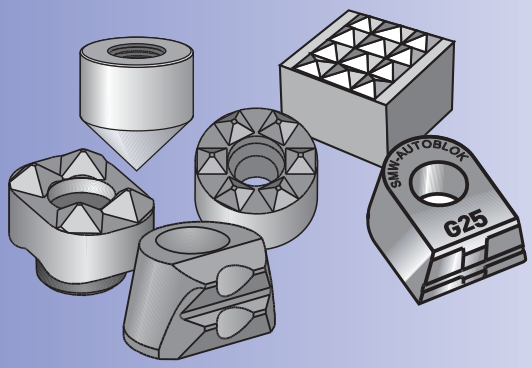
Type Id.-No.		MGH 6 081851	MGH 8 087805	MGH 10 081852	MGH 12 081853
D	mm	6	8	10	12
L	mm	10	12	14	16
G	mm	M3	M4	M5	M6
A	mm	6	8	10	11
B	mm	3.4	4.5	5.5	6.6
C	mm	9	9	9	11
T	mm	7.5	8.5	9.5	10.5
R	mm	0.3	0.5	0.5	0.5
screw	DIN 912	M3 x 14	M4 x 14	M5 x 14	M6 x 16



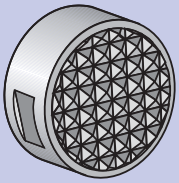
*equal per seth within 0,1 mm

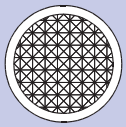
Grippers

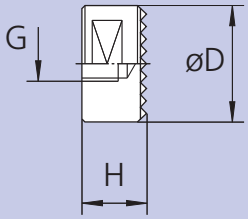
UGE
MGH
HDS
G



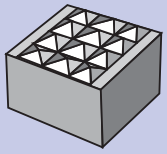
HDS-R Solid Carbide soldered in

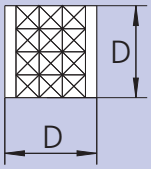


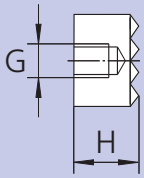




HDS-Q Solid Carbide soldered in







Grippers for jaws, fixtures and so on

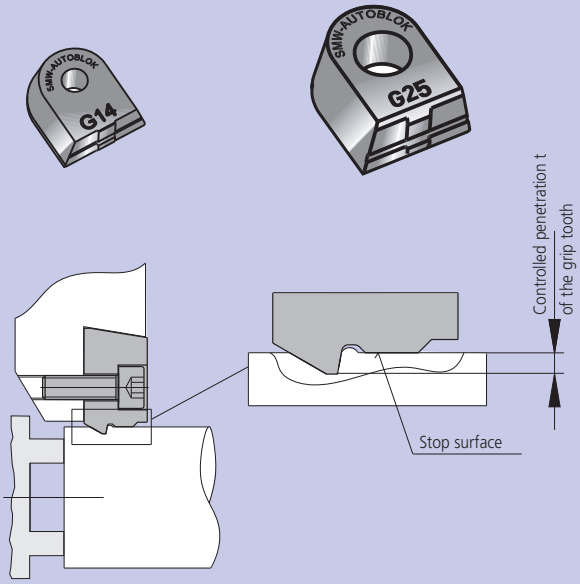
- For o.d. gripping
- Increase of the transmittable torque on raw or machined work pieces
- Rear mounting threads or side gaces for locking
- The pocket can easily be machined

Type	Id.-No.	D	H	G	max. load force F[1)]	rec. mounting bore-Ø + 0,05	rec. mounting bore depth
HDS-R 10	081846	10	10	M5	800 daN	10	9,0
HDS-R 11	081847	12,7	9,5	M5	1100 daN	12,7	8,5
HDS-R 12	081848	12,7	12,7	M6	1100 daN	12,7	11,5
HDS-R 13	081849	15,8	9,5	M6	2000 daN	15,8	8,5
HDS-R 14	081850	19	9,5	M6	3000 daN	19	8,5
HDS-Q 15	033058	12,7	9,5	M6	2000 daN	–	–

[1)] Values valid only if all tips are engaged.

Precision gripper inserts
G14 und G25 with pull down

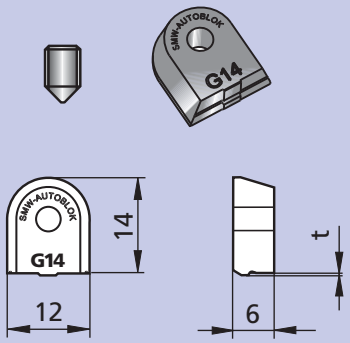
G14 + G25



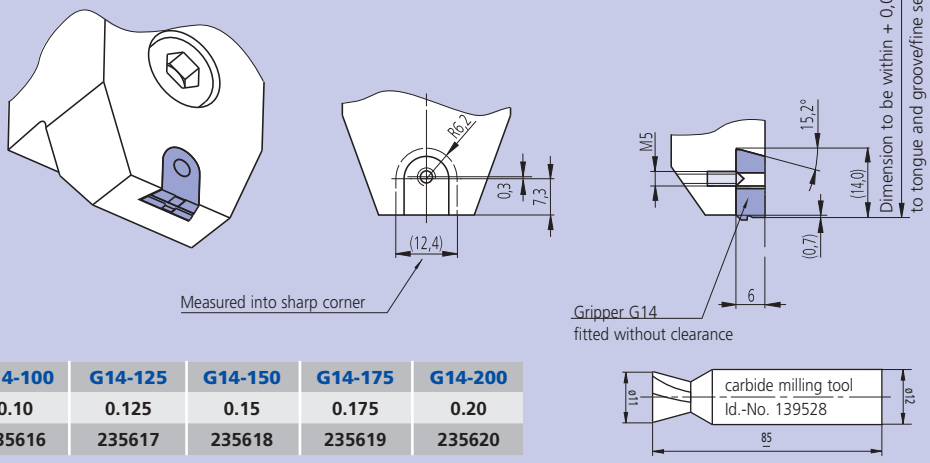
G-gripper characteristics

- **Type G grippers have a stop surface for a controlled penetration of the grip tooth**
- The workpiece is clamped concentric on the stop surface, so that the clamping dia. and the machining dia. are concentric
- The high precision of the gripper guarantees concentricity even after replacing worn out grippers
- Highest torque transmission is guaranteed with the combination of friction and positive drive
- The geometry of the gripper creates a pull down effect on the workpiece
- TIN coated high speed steel for long life
- You can select the corresponding gripper for all applications according to the grindstock allowance
- Gripper with controlled penetration 0.070–0.30 mm are standard
- Special grippers are available on request

G14 (light duty version) material: HSS

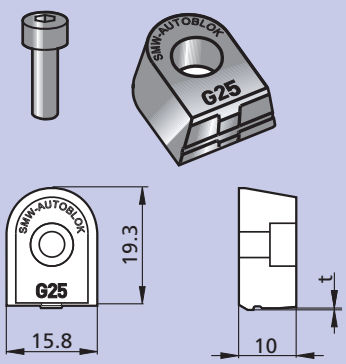


Mounting dimension

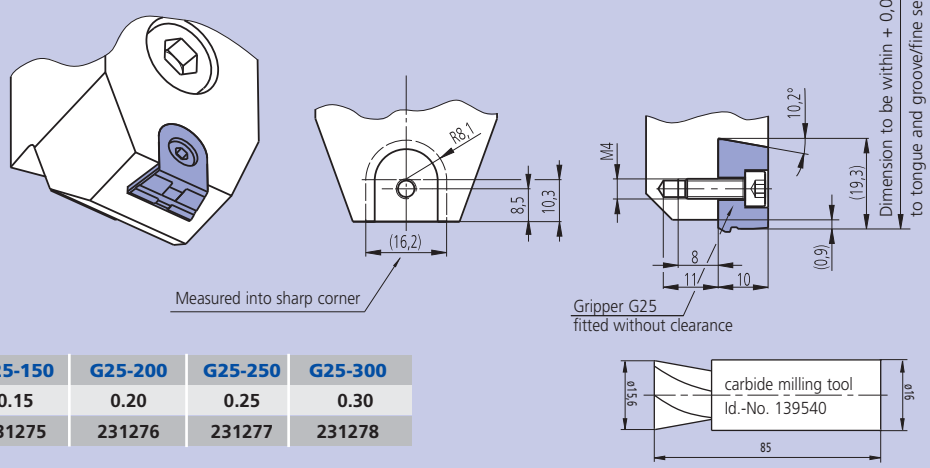


SMW-AUTOBLOK Type	G14-070	G14-100	G14-125	G14-150	G14-175	G14-200
Controlled penetration t	0.07	0.10	0.125	0.15	0.175	0.20
Id.-No.	235615	235616	235617	235618	235619	235620

G25 (heavy duty version) material: HSS



Mounting dimension

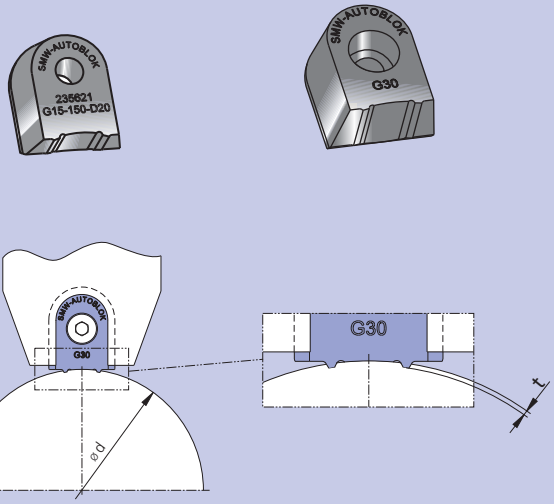


SMW-AUTOBLOK Type	G25-100	G25-150	G25-200	G25-250	G25-300
Controlled penetration t	0.10	0.15	0.20	0.25	0.30
Id.-No.	232704	231275	231276	231277	231278

Precision gripper inserts

G15 und G30 for highest torque transmission

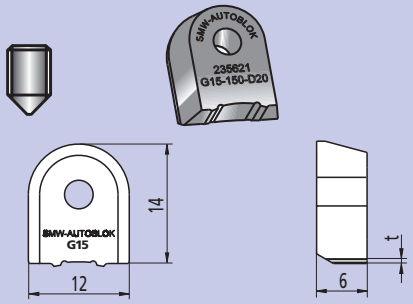
G15 + G30

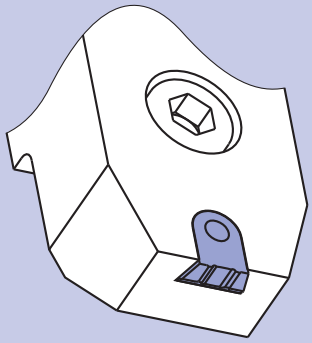


G-gripper characteristics

- **Type G grippers have a stop surface for a controlled penetration of the grip tooth**
- The workpiece is clamped concentric on the stop surface, so that the clamping dia. and the machining dia. are concentric
- The high precision of the gripper guarantees concentricity even after replacing worn out grippers
- Highest torque transmission is guaranteed with the combination of friction and positive drive
- TIN coated high speed steel for long life
- You can select the corresponding gripper for all applications according to the grindstock allowance
- Gripper with controlled penetration 0.15–0.30 mm are standard
- Special grippers are available on request

G15 (light duty version) material: HSS





SMW-AUTOBLOK type	G15-150	G15-200	G15-250
Work piece-Ø d		17 - 21	
Controlled penetration t	0.15	0.20	0.25
Id.-No.	235621	235622	235623

SMW-AUTOBLOK type	G15-150	G15-200	G15-250
Work piece-Ø d		22 - 27	
Controlled penetration t	0.15	0.20	0.25
Id.-No.	237762	237763	237764

SMW-AUTOBLOK type	G15-150	G15-200	G15-250
Work piece-Ø d		28 - 34	
Controlled penetration t	0.15	0.20	0.25
Id.-No.	235624	235625	235626

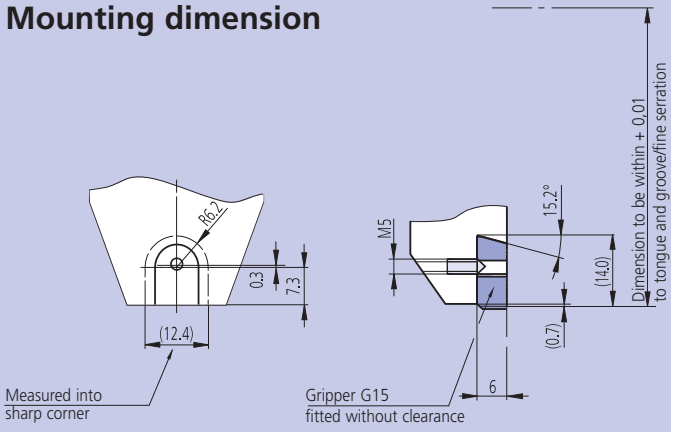
SMW-AUTOBLOK type	G15-150	G15-200	G15-250
Work piece-Ø d		35 - 42	
Controlled penetration t	0.15	0.20	0.25
Id.-No.	237765	237766	237767

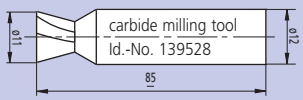
SMW-AUTOBLOK type	G15-150	G15-200	G15-250
Work piece-Ø d		43 - 53	
Controlled penetration t	0.15	0.20	0.25
Id.-No.	235627	235628	235629

SMW-AUTOBLOK type	G15-150	G15-200	G15-250
Work piece-Ø d		54 - 78	
Controlled penetration t	0.15	0.20	0.25
Id.-No.	237400	237401	237402

SMW-AUTOBLOK type	G15-150	G15-200	G15-250
Work piece-Ø d		79 - 175	
Controlled penetration t	0.15	0.20	0.25
Id.-No.	237409	237410	237411

Mounting dimension

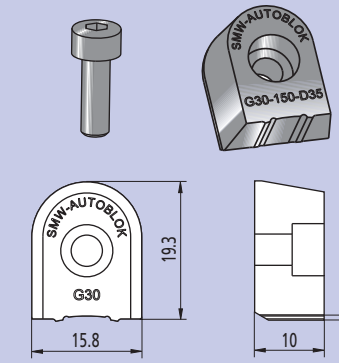


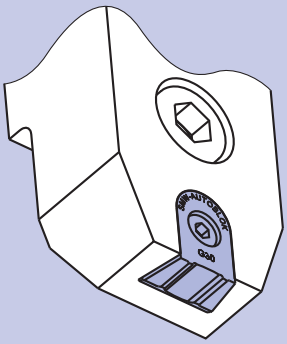


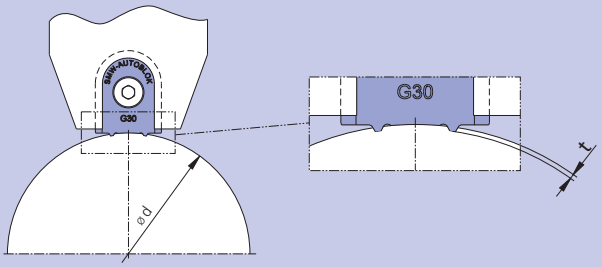
Precision gripper inserts

G30 for highest torque transmission

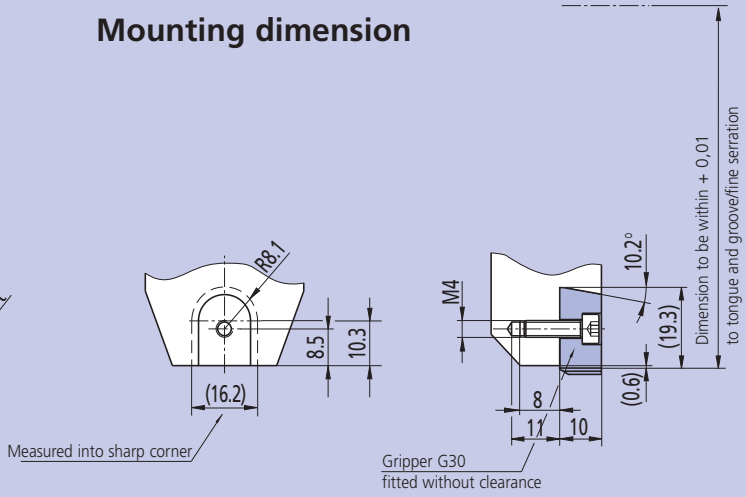
G30 (heavy duty version)
material: HSS







Mounting dimension



SMW-AUTOBLOK type	G30-200	G30-250	G30-300
Work piece-Ø d		24 - 32	
Controlled penetration t	0.20	0.25	0.30
Id.-No.	237841	237842	237843

SMW-AUTOBLOK type	G30-200	G30-250	G30-300
Work piece-Ø d		33 - 42	
Controlled penetration t	0.20	0.25	0.30
Id.-No.	233481	233482	233483

SMW-AUTOBLOK type	G30-200	G30-250	G30-300
Work piece-Ø d		43 - 52	
Controlled penetration t	0.20	0.25	0.30
Id.-No.	233421	233422	233423

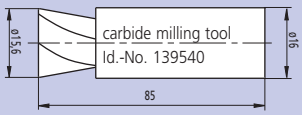
SMW-AUTOBLOK type	G30-200	G30-250	G30-300
Work piece-Ø d		53 - 64	
Controlled penetration t	0.20	0.25	0.30
Id.-No.	233485	233486	233487

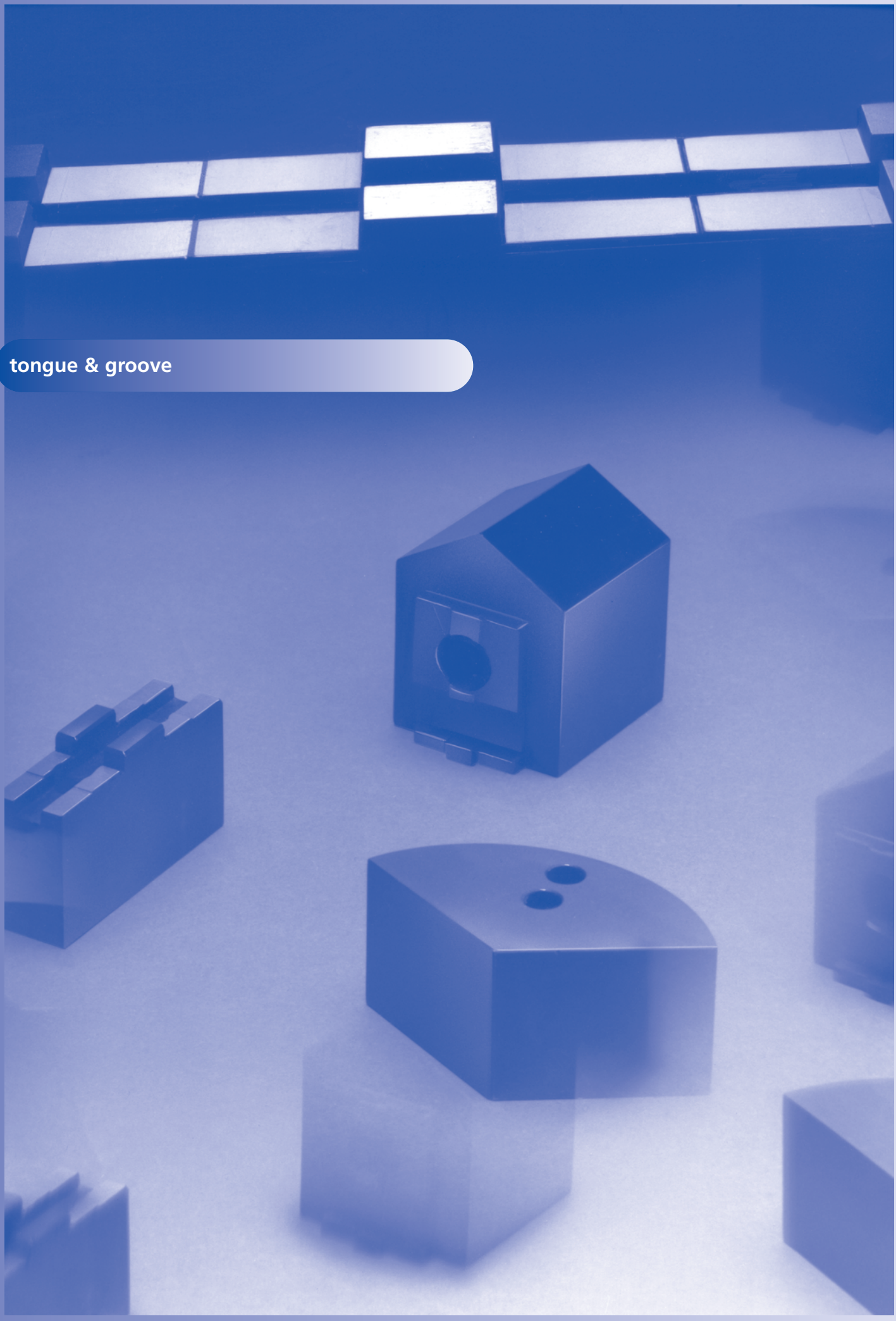
SMW-AUTOBLOK type	G30-200	G30-250	G30-300
Work piece-Ø d		65 - 84	
Controlled penetration t	0.20	0.25	0.30
Id.-No.	234811	234812	234813

SMW-AUTOBLOK type	G30-200	G30-250	G30-300
Work piece-Ø d		85 - 119	
Controlled penetration t	0.20	0.25	0.30
Id.-No.	237291	237292	237293

SMW-AUTOBLOK type	G30-200	G30-250	G30-300
Work piece-Ø d		120 - 174	
Controlled penetration t	0.20	0.25	0.30
Id.-No.	237299	237300	237301

SMW-AUTOBLOK type	G30-200	G30-250	G30-300
Work piece-Ø d		175 - 335	
Controlled penetration t	0.20	0.25	0.30
Id.-No.	237422	237423	237424

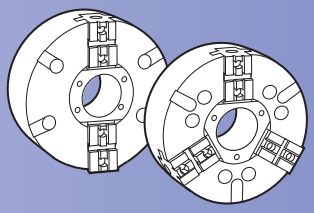



tongue & groove

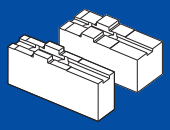
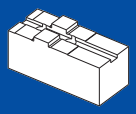
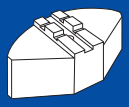
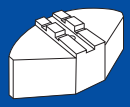
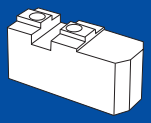
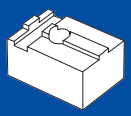
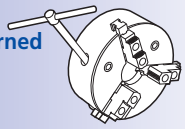
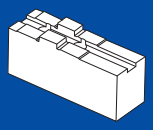
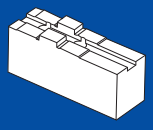
soft top jaws

steel ■ aluminium

tongue & groove



SMW-AUTOBLOK **Berg** **Forkardt** **Kitagawa** **Röhm** **Schunk**

WAK	soft top jaws 16MnCr5	standard	**WAK, WAKS**  Page 74
WAKS	soft top jaws 16MnCr5	wide version	
WAK-A	alum.-top jaws aluminium F50		**WAK-A**  Page 76
SBK	soft pie jaws 16MnCr5		**SBK**  Page 77
SBK-A	alum.-pie jaws aluminium F50		**SBK-A**  Page 78
WBR	soft top jaws 16MnCr5		**WBR**  Page 79
WBK	soft top jaws 16MnCr5		**WBK**  Page 79
WA-RN	soft top jaws 16MnCr5	manual chucks Amestra Ladner Pratt-Burned Röhm 	**WA-RN**  Page 80
WAKA	soft top jaws C45	all chucks American standard 	**WAKA**  Page 81

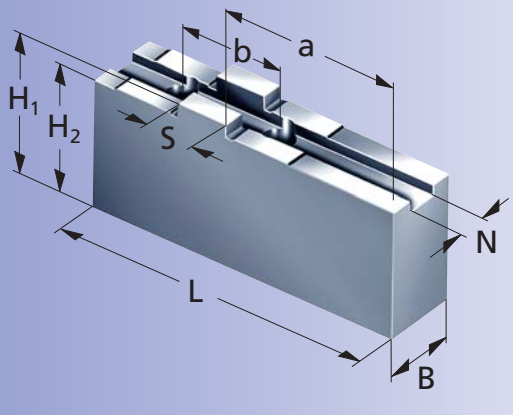
safety advise:
Top jaws are safety components, which can unter high load depending on their use.
Max grip forces and speeds must not be exceeded at any time.
For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

soft top jaws

WAK for quick jaw change

tongue & groove

Material: 16MnCr5



Type	Id.-No.	B	H_1	H_2	L	N	S	a	b	kg/ set	SMW-AUTOBLOK	SMW	Berg	Forkardt	Kita-gawa	Röhm	Schunk
WAK 125-10	**016633**	20	30	27,5	55	14 (Slot)	5 (Slot)	25	20	0,6		RMG 125		F 125 F+125		Duro 125	
WAK 140-10	**012490**	20	40	35,5	69	8	18	26	32	0,9	KNCS-N 140	KNCS 140				Duro-NC 140 Duro-NC 168	
WAK 160-10	**012491**	20	40	35,5	85	8	18	42	32	1,2	HG-N 160 HG-F 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	KHNC 160 KHNC 185	F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJ 306	Duro 160 Duro-NC 160 Duro-NCE 160 Duro-NC 175 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW165 ROTA THW plus 165/185 ROTA-G 160 • THW165 ROTA-S160 ROTA NCW185 ROTA-NCR200
WAK 200-10	**012492**	22	46	42	105	10	20	50	40	2,0	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	KHNC 200	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 308	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA-S plus200 ROTA THW210 ROTA THW plus215 ROTA-G 200 THW 210R/F ROTA NCW 225 ROTA-S200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
WAK 250-10	**012493**	30	55	50	125	12	20	70	40	3,6	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	KHNC 250 KHNC 315	F 250 UNC 250/315 KTNC 250 KTNC 280 KTNCV 250 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 310 QJ 312	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
WAK 400-10	**012494**	35	60	54	145	12	26	74	54	5,8	HG-N 400 HG-F 315 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	KHNC 400	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJ15	Duro 315 Duro-NC 315 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW315-F
WAK 500-10	**012495**	50	80	73	180	18	30	100	60	13,7	HG-N 500 HG-N 630 HG-F 400 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800	HG 500 HG 630 KNCS 500 KNCS 630	KHNC 500	F 400/500 L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400 F+500L	QJ21 QJ24	Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S plus 400/500 ROTA THW 500/630/800 ROTA-G 500 ROTA-S 400/500 THW 500-R/F ROTA THWB 400/500 THW 630-R
WAK 630-10	**080930**	60	120	112	260	24	40	149	82	28,5	HG-F 630			F 630 F+ 630		Duro 630 Duro-NC 630	ROTA-S plus 630/800/1000 ROTA-S 630/800/1000 ROTA-G 630

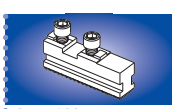
Other dimensions on request.
Use the data sheet on page 82 for ordering.

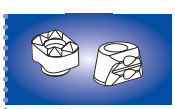


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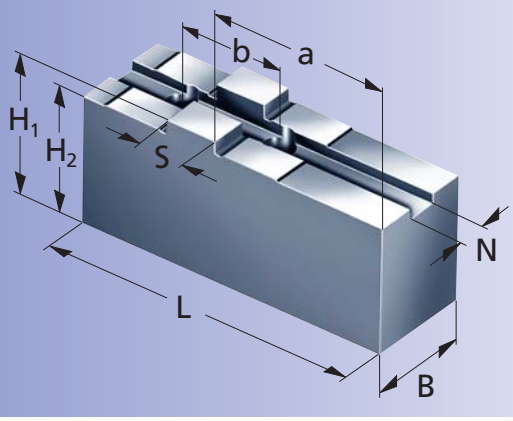

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soft top jaws wide version

WAKS for quick jaw change

tongue & groove

Material: 16MnCr5



Type	Id.-No.	B	H_1	H_2	L	N	S	a	b	kg/ set	SMW-AUTOBLOK	SMW	Berg	Forkardt	Kita-gawa	Röhm	Schunk
WAKS 140-10	**012496**	35	40	35,5	63	8	18	25	32	1,5	KNCS-N 140	KNCS 140				Duro-NC 140 Duro-NC 168	
WAKS 160-10	**080931**	25	50	45,5	85	8	18	42	32	1,8	HG-N 160	RMG 160	KHNC 160	F 160	QJ306	Duro 160	ROTA-S plus 160
WAKS 160-20	**080932**	30	55	50,5	85			48	32	2,2	HG-F 160	HG 160	KHNC 185	KTNC 160		Duro-NC 160	ROTA THW 165
WAKS 160-30	**080933**	40	80	75,5	70			26	32	3,4	KNCS-N 170	KNSP 160		KTNCV 160		Duro-NC 175	ROTA THW plus 165/185
												KNCS 160		KTNCV 175		Duro-NCE 160	ROTA-G 160
												KNCS 175		FNC 175		Duro-NCE 175	THW 165
														F+160		Duro-NCES 175	ROTA-S 160
																	ROTA NCW 185
																	ROTA-NCR 200
WAKS 200-10	**080934**	30	55	51	100	10	20	57	40	2,9	HG-N 210	RMG 200	KHNC 200	F 200	QJ308	Duro 200	ROTA-S plus 200
WAKS 200-20	**080935**	30	70	66	100			45	40	3,4	HG-F 210	HG 200		KTNC 200		Duro-NC 200	ROTA THW 210
WAKS 200-30	**012497**	40	40	36	70			27	40	1,9	KNCS-N 210	KNSP 200		KTNCV 200		Duro-NC 225	ROTA THW plus 215
WAKS 200-31	**080936**	40	60	56	90			43	40	3,9	KNCS-N 225	KNCS 200		FNC 200		Duro-NCE 200	ROTA-G 200
WAKS 200-32	**036733**	40	80	76	95			52	40	5,8	KNCS-NB 210	KNCS 210		F+200		Duro-NCES 200	THW 210R/F
											KNCS-NB 225						ROTA NCW 225
																	ROTA-S 200
																	ROTA NCWF 210
																	ROTA THWB 210
																	ROTA THW vario 215
WAKS 250-10	**080937**	40	60	55	125	12	20	70	40	5,7	HG-N 260	RMG 250	KHNC 250	F 250	QJ310	Duro 250	ROTA-S plus 250
WAKS 250-11	**080938**	40	80	75	125			70	40	7,5	HG-N 315	HG 250	KHNC 315	UNC 250/315	QJ312	Duro-NC 250	ROTA-THW 250/315
WAKS 250-12	**080939**	40	100	95	125			70	40	9,6	HG-F 260	HG 315		KTNC 250		Duro-NCE 250	ROTA THW plus 260/315
WAKS 250-13	**080940**	40	120	115	125			70	40	11,5	KNCS-N 260/275	KNCS 250		KTNC 280		Duro-NCE 315	ROTA-G 250/315
WAKS 250-20	**012498**	60	60	55	90			44	40	6,2	KNCS-N 315/340	KNCS 260		KTNCV 250		Duro-NCES 250	THW 250/265-R/F
WAKS 250-21	**080942**	60	60	55	110			60	40	7,6	KNCS-NB 260	KNCS 315		KTNC 315		Duro-NCES 315	ROTA NCW 265/315
WAKS 250-22	**080943**	60	80	75	90			44	40	9,4	KNCS-NB 315			KTNCV 315			ROTA-S 250
WAKS 250-23	**080944**	60	80	75	110			60	40	11,5	KNCS-NB 340			FNC 250			ROTA-NCWF 250/315
WAKS 250-30	**012499**	80	60	55	90			44	40	8,5				FNC 315			ROTA THWB 265
WAKS 250-31	**080945**	80	80	75	110			60	40	14,1				F+250			THW 315-R
WAKS 400-10	**080946**	40	60	54	110	12	26	54	54	4,9	HG-N 400	RMG 315	KHNC 400	F 315	QJ15	Duro 315	ROTA-S plus 315
WAKS 400-11	**080947**	40	60	54	145			89	54	6,7	HG-F 315	HG 400		UNC 400		Duro-NC 315	ROTA THW 400
WAKS 400-12	**080948**	40	100	94	145			89	54	11,1	KNCS-N 400	KNCS 400		KTNC 360		Duro-NCE 400	THW 400-R/F
WAKS 400-13	**080949**	40	120	114	145			89	54	13,5	KNCS-NB 400			KTNC 400		Duro-NCES 400	ROTA-G 400
WAKS 400-14	**080950**	40	150	146	145			89	54	16,9				KTNCV 400			ROTA-S 315
WAKS 400-20	**080951**	60	60	54	110			54	54	7,6				FNC 400			ROTA THWB 315
WAKS 400-21	**080952**	60	80	74	110			54	54	10,3				F+315			THW 315-F
WAKS 400-22	**080953**	60	100	94	110			54	54	14,1							
WAKS 400-30	**012500**	80	70	64	100			44	54	11,0							
WAKS 500-10	**080954**	60	80	73	155	18	30	90	60	13,8	HG-N 500	HG 500	KHNC 500	F 400/500 L	QJ21	Duro 400/500	ROTA-S plus 400/500
WAKS 500-12	**080956**	60	120	113	155			90	60	19,5	HG-N 630	HG 630		UNC 500	QJ24	Duro-NC 400/500	ROTA THW 500/630/800
WAKS 500-20	**080957**	80	80	73	155			90	60	15,5	HG-F 400	KNCS 500		KTNC 500/630		Duro-NCE 500	ROTA-G 500
WAKS 500-21	**080958**	80	100	93	155			90	60	26,3	KNCS-N 500	KNCS 630		KTNCV 500/630			THW 630-R
WAKS 500-30	**012501**	90	80	73	130			65	60	16,4	KNCS-N 630			FNC 500/630			ROTA-S 400/500
WAKS 500-31	**012502**	100	80	73	150			85	60	20,0	KNCS-NB 500			F+400			THW 500-R/F
											KNCS-NB 630			F+500			ROTA THWB 400/500
											KNCS-NB 800						

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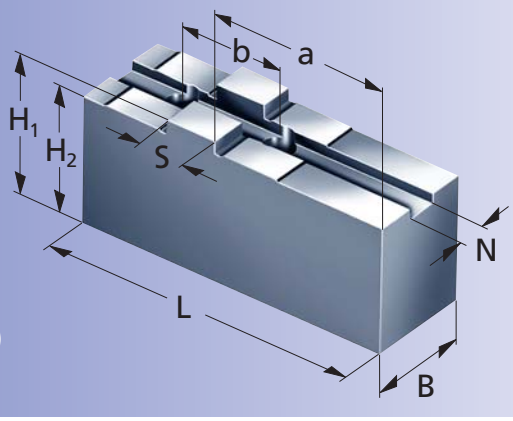
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soft top jaws alum. light version

WAK-A for quick jaw change

tongue & groove

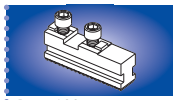
Material: aluminium (tensile strength ca. 500 N/mm²)



Type	Id.-No.	B	H_1	H_2	L	N	S	a	b	kg/ set	SMW-AUTOBLOK	SMW	Berg	Forkardt	Kita-gawa	Röhm	Schunk
WAK-A 160	**080959**	25	50	45,5	85	8	18	42	32	0,7	HG-N 160 HG-F 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	KHNC 160 KHNC 185	F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJ306	Duro 160 Duro-NC 160 Duro-NCE 160 Duro-NC 175 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA-S 160 ROTA NCW 185 ROTA-NCR 200
WAK-A 200	**080960**	25	50	46	105	10	20	50	40	0,9	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	KHNC 200	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 308	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA-S plus 200 ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R/F ROTA NCW 225
WAK-A 210	**035222**	40	60	56	90	10	20	43	40	1,65							ROTA-S 200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
WAK-A 250	**080961**	40	60	55	125	12	20	70	40	2,0	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	KHNC 250 KHNC 315	F 250 UNC 250/315 KTNC 250 KTNC 280 KTNCV 250 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 310 QJ 312	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
WAK-A 400	**080962**	40	60	54	145	12	26	74	54	2,4	HG-N 400 HG-F 315 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	KHNC 400	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJ 15	Duro 315 Duro-NC 315 Duro-NCE 400 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW 315-F
WAK-A 500	**035142**	50	80	73	180	18	30	100	60	5,1	HG-N 500 HG-N 630 HG-F 400 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800	HG 500 HG 630 KNCS 500 KNCS 630	KHNC 500	F 400/500 L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400 F+500	QJ 21 QJ 24	Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S plus 400/500 ROTA THW 500/630/800 ROTA-G 500 THW 630-R ROTA-S 400/500 THW 500-R/F ROTA THWB 400/500



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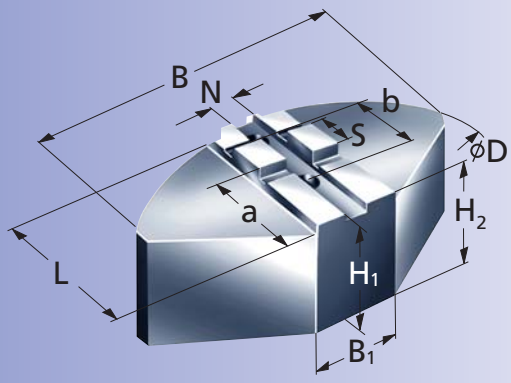

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soft pie jaws

SBK for quick jaw change

tongue & groove

Material: 16MnCr5



Type	Id.-No.	B	B_1	H_1	H_2	L	N	S	a	b	D	kg/ set	SMW-AUTOBLOK	SMW	Berg	Forkardt	Kita-gawa	Röhm	Schunk
SBK 160	**080963**	120	40	50	46	60	8	18	23	32	160	4,5	HG-N 160 HG-F 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	KHNC 160 KHNC 185	F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJ 306	Duro 160 Duro-NC 160 Duro-NCE 160 Duro-NC 175 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA-S160 ROTA NCW 185 ROTA-NCR 200
SBK 200	**080964**	140	65	60	56	70	10	20	27	40	200	8,4	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	KHNC 200	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 308	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA-S plus 200 ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R/F ROTA NCW 225 ROTA-S 200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
SBK 250	**080965**	180	70	60	55	90	12	20	44	40	250	11,2	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	KHNC 250 KHNC 315	F 250 UNC 250/315 KTNC 250 KTNCV 250 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 310 QJ 312	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
SBK 400	**080966**	240	120	75	69	110	12	26	54	54	320	25,2	HG-N 400 HG-F 315 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	KHNC 400	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJ 15	Duro 315 Duro-NC 315 Duro-NCE 400 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW315-F

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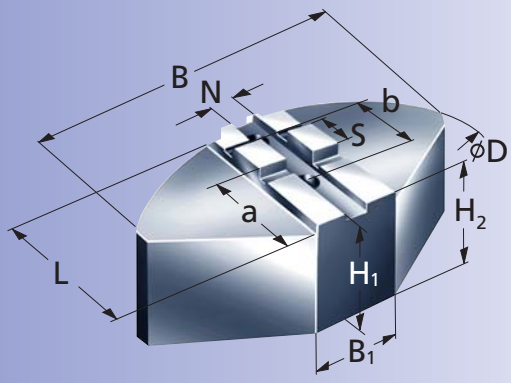
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soft pie jaws alum. light version

SBK-A for quick jaw change

tongue & groove

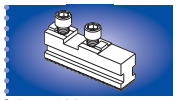
Material: aluminium (tensile strength ca. 500 N/mm²)



Type	Id.-No.	B	B_1	H_1	H_2	L	N	S	a	b	D	kg/ set	SMW-AUTOBLOK	SMW	Berg	Forkardt	Kita-gawa	Röhm	Schunk
SBK-A 160	**080967**	120	40	50	46	60	8	18	23	32	160	1,6	HG-N 160 HG-F 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	KHNC 160 KHNC 185	F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJ 306	Duro 160 Duro-NC 160 Duro-NC 175 Duro-NCE 160 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THWplus165/185 ROTA-G 160 THW 165 ROTA-S160 ROTA NCW 185 ROTA-NCR 200
SBK-A 200	**080968**	140	55	60	56	75	10	20	27	40	200	3,1	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	KHNC 200	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 308	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA-S plus 200 ROTA THW 210 ROTA THWplus 215 ROTA-G 200 THW 210R/F ROTA NCW 225 ROTA-S200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
SBK-A 250	**080969**	180	70	60	55	90	12	20	44	40	250	4,3	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	KHNC 250 KHNC 315	F 250 UNC 250/315 KTNC 250 KTNCV 250 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 310 QJ 312	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THWplus260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
SBK-A 400	**080970**	240	120	75	69	110	12	26	54	54	320	9,3	HG-N 400 HG-F 315 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	KHNC 400	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJ 15	Duro 315 Duro-NC 315 Duro-NCE 400 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW 315-F
SBK-A 500	**085193**	330	150	90	83	160	18	30	95	60	440	21,4	HG-N 500 HG-N 630 HG-F 400 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800	HG 500 HG 630 KNCS 500 KNCS 630	KHNC 500	F 400/500 L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400 F+500	QJ 21 QJ 24	Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S plus 400/500 ROTA THW 500/630/800 ROTA-G 500 THW 630-R ROTA-S 400/500 THW 500-R/F ROTA THWB 400/500



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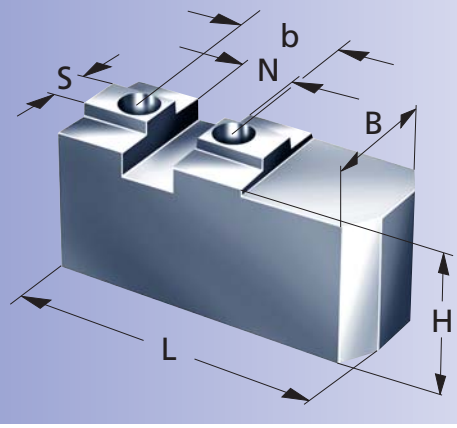

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soft top jaws
WBR
for 2- and 3-jaw power chuck

tongue & groove

Material: 16MnCr5

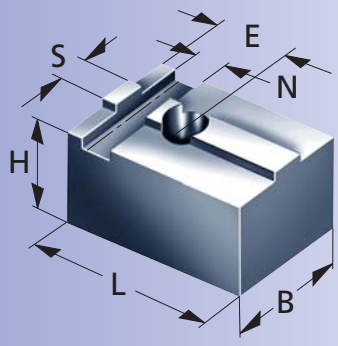


Type	Id.-No.	B	H	L	S	N	b	kg/ set	SMW-AUTOBLOK	SMW	Röhm
WBR 1101	**013843**	25	30	51	8	8	15	0,7	HFKN-C 110	HFKS 110	KFD 110 KFD 125

soft top jaws
WBK
for 2- and 3-jaw power chuck

tongue & groove

Material: 16MnCr5/*C45



Type	Id.-No.	B	H	L	S	N	E	kg/ piece	SMW-AUTOBLOK	SMW	Berg	Forkardt	Röhm	Schunk
WBK 0801*	**90040800**	30	30	38	8	8	14	0,18	CL-C 80		MF 3/80 MFZ 2/80 MFZ 3/80 KF 2/80			
WBK 0851**	**080983**	22	30	40	8	8	-	0,16					KFD 85	
WBK 0951**	**080984**	22	40	44,5	8	8	-	0,25					KFD 95	
WBK 1001*	**90041000**	30	30	48	8	8	20	0,23	CL-C 100		MF 2/100 MF 3/100 MFZ 2/100 MFZ 3/100 KF 2/100 KF 3/100			
WBK 1201*	**90041300**	35	35	57	14	16	27	0,4	CL-C 125 US 2 CL-C 125	KZF 125 KZF-ES 125		2 BLE 125 2 BLN 125	KFA 125 KFD-G 125	ROTA 2 B 125
WBK 1602*	**90041600**	40	40	75	18	18	34	0,72	CL-C 160 US 2 CL-C 160	KZF 160 KZF-ES 160		2 BLE 160 2 BLE PK 160 2 BLN 160	KFA 160 KFD-G 160	ROTA 2 B 160

* material C45
**jaws tipped

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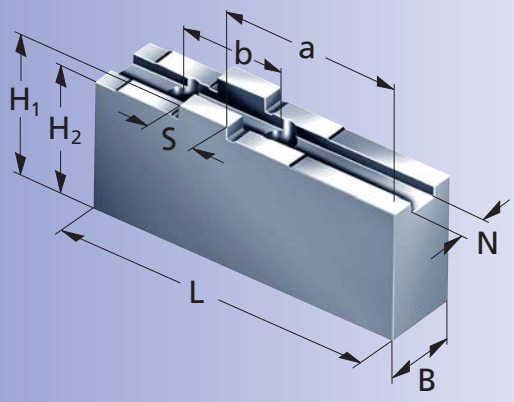
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soft top jaws

WA-RN

2, 3 and 4 jaw versions for scroll chucks and face plates



tongue & groove

Product Amestra, Ladner, Röhm, Pratt-Burned
Material: 16MnCr5

Type	Id.-No.	B	H_1	H_2	L	N	S	a	b	DIN 912	kg/piece	Röhm
WA-RN 160	**081006**	30	45	42	74	7,96	12,67	32,2	38,1	M8	0,6	ZGU 140 ZGU 160 ZGF 160 ZSU 140 ZSU 160
WA-RN 200	**081007**	30	50	47	87	7,96	12,67	38,7	44,5	M8	0,8	ZGD 200/230 ZGU 200 ZGF 200 ZSU 200 UGU 200 USU 200
WA-RN 250	**081008**	35	60	57	103	12,72	19,02	43,5	54	M12	1,35	ZGD 250/270 ZGU 250 ZSU 260 ZGF 250 UGU 260 USU 260
WA-RN 315	**081009**	40	60	57	120	12,72	19,02	53	63,5	M12	1,9	ZGD 315 ZGU 315 ZSU 315 ZGF 315 UGU 310/350 USU 310/350
WA-RN 350/400	**081010**	50	80	73,7	137	12,72	19,02	62	76,2	M16	3,3	ZGD 400 ZGU 350 ZGU 400 ZSU 350 ZSU 400 ZGF 350 ZGF 400 UGU 400/450 USU 400/450



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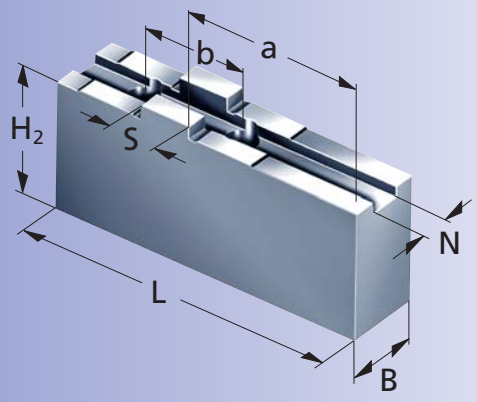
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soft top jaws
WAKA
2, 3 and 4 jaw versions

American standard tongue & groove

Material: C45



Type	Id.-No.	B	H_2	L	N	S	a	b	DIN 912	kg/piece	SMW-AUTOBLOK
WAKA 165	**12041660**	30	32	80	7,94	12,68	43,6	38,1	M10	0,58	RAN 160 AN-C 165 HB-C 165 PB-C 165 PBI-C 165 AP-C 170 NT-C 170
WAKA 210	**12042060**	35	37	100	7,94	12,68	58,66	44,4	M12	0,92	RAN 200 AN-C 210 HB-C 210 PB-C 210 PBI-C 210 AP-C 215 APL-C 215 NT-C 215
WAKA 250	**12042560**	45	42	120	12,7	19,03	68,5	54	M16	1,25	AN-C 250 HB-C 250 PB-C 250 PBI-C 250 RAN 250 AP-C 260 APL-C 260 NT-C 260
WAKA 315	**12043060**	50	47	140	12,7	19,03	80,5	63,5	M16	2,15	AN-C 315 HB-C 315 PB-C 315 PBI-C 315 RAN 315 AP-C 315 APL-C 315 NT-C 315
WAKA 400	**12044050**	60	55	165	12,7	19,03	95,5	76,2	M20	3,6	AN-C 400 AP-C 400 APL-C 315 NT-C 400 RAN 400
WAKA 500	**12045050**	75	70	165	12,7	19,03	95,5	76,2	M20	5,5	IL-C 500 IL-C 630 IL-C 800 IN-C 500 IN-C 630 IN-C 800

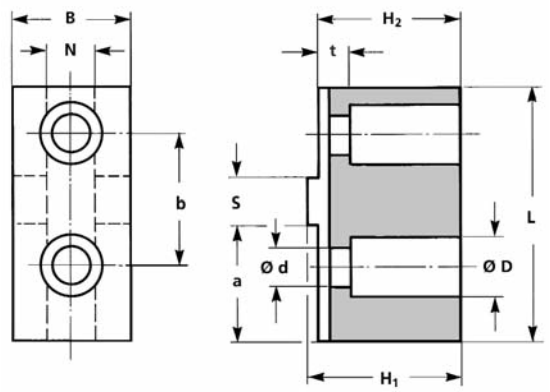
HARDENING-INSTRUCTION
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Special
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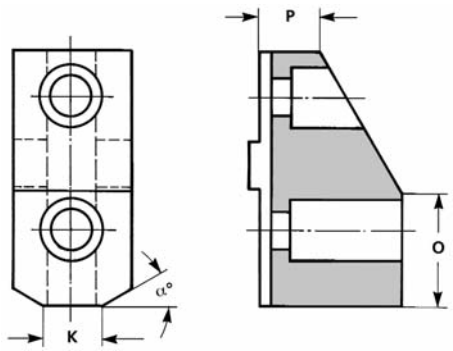
soft special jaws
on customer request

soft top jaw-blanks



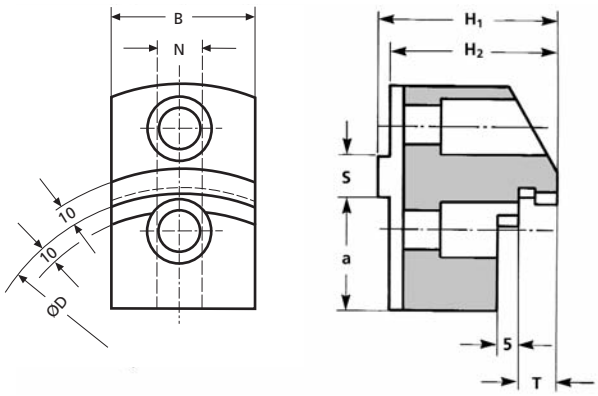
a
b
B
d
D
H_1
H_2
L
N
S
t

Additional dimensions for lightening



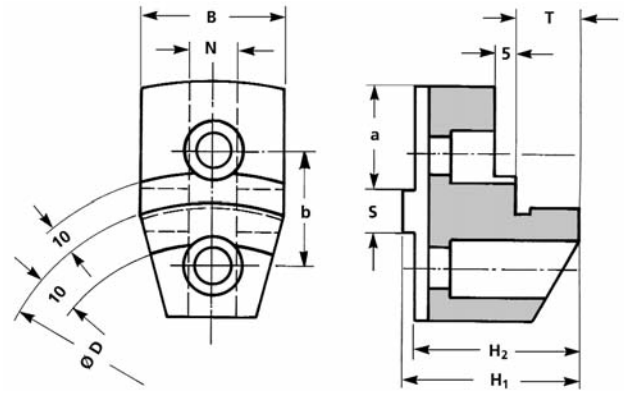
K
O
P
α°
work-piece Ø
chuck maker
chuck type
material

soft top jaws for external clamping



B
H_1
H_2
T
D
N
S
a
b
work-piece Ø
chuck maker
chuck type
material

soft top jaws for internal clamping



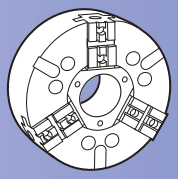
B
H_1
H_2
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a
b
work-piece Ø
chuck maker
chuck type
material

Notes

tongue & groove

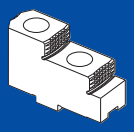
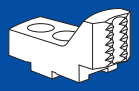
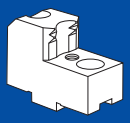
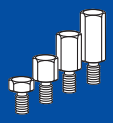


hard top jaws



tongue & groove

SMW-AUTOBLOK Berg Forkardt Kitagawa Röhm Schunk

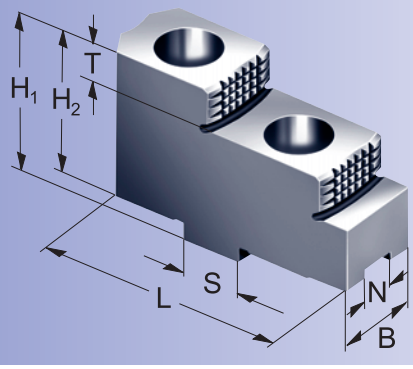
GUA	hard top jaws	**GUA**  Page 86
GSK	hard bar roughing jaws	**GSK**  Page 87
GGK	hard roughing jaws	**GGK**  Page 88
ALB	stop pins	**ALB**  Page 88

safety advise:
Top jaws are safety components, which can unter high load depending on their use.
Max grip forces and speeds must not be exceeded at any time.
For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

hard, reversible top jaws

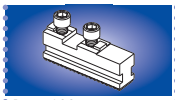
GUA for quick jaw change

tongue & groove



Type	Id.-No.	B	H_1	H_2	L	T	N	S	kg/ set	SMW-AUTOBLOK	SMW	Berg	Forkardt	Kita-gawa	Röhm	Schunk
GUA 160	**012484**	20	36,5	32,5	63	7,5	8	18	0,6	HG-N 160 HG-F 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	KHNC 160 KHNC 185	F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJ 306	Duro 160 Duro-NC 160 Duro-NCE 160 Duro-NC 175 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA-S 160 ROTA NCW 185 ROTA-NCR 200
GUA 200	**012485**	22	42	38	75	10	10	20	0,8	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	KHNC 200	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 308 QJ 8"	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA-S plus 200 ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210 R/F ROTA NCW 225 ROTA-S 200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
GUA 250	**012486**	30	55	50	90	14	12	20	1,9	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	KHNC 250 KHNC 315	F 250 UNC 250/315 KTNC 250 KTNCV 250 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 310 QJ 312 QJ 10" QJ 12"	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
GUA 400	**012487**	36	62	56	105	15	12	26	3,2	HG-N 400 HG-F 315 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	KHNC 400	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJ 15	Duro 315 Duro-NC 315 Duro-NCE 400 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW 315-F
GUA 500	**012488**	45	75	70	130	20	18	30	10,8	HG-N 500 HG-N 630 HG-F 400 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800	HG 500 HG 630 KNCS 500 KNCS 630	KHNC 500	F 400/500 L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400 F+500L	QJ 21 QJ 24	Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S plus 400/500 ROTA THW 500/630/800 ROTA-G 500 THW 630-R ROTA-S 400/500 THW 500-R/F ROTA THWB 400/500
GUA 631	**035959**	65	89	97	185	30	24	40	15	HG-F 630			F 630 F+ 630		Duro 630 Duro-NC 630	ROTA-S plus 630/800/1000 ROTA-S 630/800/1000 ROTA-G 630

Only jaws that are ground on the chuck under clamping condition guarantee hightest repeatability.


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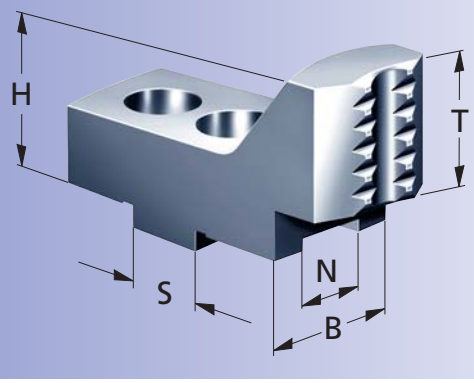


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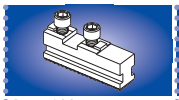
hard bar roughing jaws

GSK for quick jaw change

tongue & groove



Type	Id.-No.	clamping ranges Ø	B	H	T	N	S	kg/ set	SMW-AUTOBLOK	SMW	Berg	Forkardt	Kita-gawa	Röhm	Schunk
GSK 160	**091359**	12-40	20	40	30	8	18	0,8	HG-N 160 HG-F 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	KHNC 160 KHNC 185	F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJ 306	Duro 160 Duro-NC 160 Duro-NCE 160 Duro-NC 175 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA-S 160 ROTA NCW 185 ROTA-NCR 200
GSK 200	**091360**	15-50	22	40	30	10	20	0,8	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	KHNC 200	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 308 QJ 8"	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA-S plus 200 ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R/F ROTA NCW 225 ROTA-S 200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
GSK 250	**091361**	15-60	30	45	35	12	20	1,4	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	KHNC 250 KHNC 315	F 250 UNC 250/315 KTNC 250 KTNCV 250 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 310 QJ 312 QJ 10" QJ 12"	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
GSK 400	**091362**	30-90	35	50	40	12	26	2,2	HG-N 400 HG-F 315 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	KHNC 400	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJ 15	Duro 315 Duro-NC 315 Duro-NCE 400 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW 315-F



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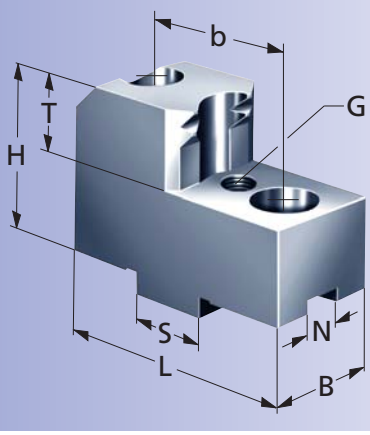
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hard roughing jaws

GGK for quick jaw change

tongue & groove

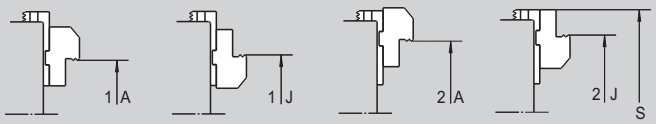
for SMW-AUTOBLOK-chucks



Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	SMW-AUTOBLOK	*clamping ranges Ø external-A_1	*clamping ranges Ø internal-J_1	*clamping ranges Ø external-A_2	*clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	KNCS-N 140	25-53	125-162	-	-
GGK 1752	012465								68	1,0		36-56	128-168	-	-
GGK 1753	012466								60	1,0		55-81	101-135	-	-
GGK 1754	012467								56	0,9		80-105	75-109	-	-
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	KNCS-N 170	25-62	133-171	33-80	155-190
GGK 1753	012466								60	1,0	HG-N 160	32-61	134-172	42-79	153-181
GGK 1754	012467								56	0,9	HG-F 160	52-89	107-145	70-107	125-163
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	KNCS-N 210	29-59	187-252	36-87	-
GGK 2002	012470								66	1,3	KNCS-NB 210	57-122	121-186	94-150	158-215
GGK 2003	012471								66	1,3	HG-N 210	93-149	85-140	131-187	122-178
GGK 2004	012472			15					85	1,7	HG-F 210		62-100		72-137
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	KNCS-N 225	30-69	-	45-106	-
GGK 2002	012470								66	1,3	KNCS-NB 225	67-132	131-197	105-170	169-235
GGK 2003	012471								66	1,3		104-169	95-160	141-207	134-199
GGK 2004	012472			15					85	1,7		-	68-110	-	74-148
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS-N 260	45-85	197-274	61-148	254-342
GGK 2502	012474								72	2,3	KNCS-NB 260	78-154	132-208	141-218	195-272
GGK 2503	012475								78	2,6	HG-N 260	1107-184	109-175	159-247	152-238
GGK 2504	012476								108	3,2	HG-F 260	-	-	-	80-156
GGK 2501	012473	40	50	22	M6	12	20	40	94	3.0	KNCS-N 275	49-100	201-289	65-163	258-357
GGK 2502	012474								72	2.3		82-169	136-223	145-233	199-287
GGK 2503	012475								78	2.6		111-199	113-190	163-262	156-253
GGK 2504	012476								108	3.2		-	-	-	84-171
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS-N 315	34-100	210-300	-	300-370
GGK 2502	012474								72	2,3	KNCS-NB 315	90-175	-	170-262	-
GGK 2503	012475								78	2,6	HG-N 315	-	110-210	206-292	-
GGK 2505	012477			15					84	2,8		-	82-150	-	-
GGK 2501	012473	40	50	22	M6	12	20	40	94	3.0	KNCS-N 340	60-126	236-326	-	326-396
GGK 2502	012474								72	2.3		116-201	-	196-288	-
GGK 2503	012475								78	2.6		-	136-236	232-318	-
GGK 2504	012476								84	2.8		-	108-186	-	-
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	KNCS-N 400	78-188	258-378	143-263	333-453
GGK 4002	012479								91	3,5	KNCS-NB 400	-	140-263	258-378	-
GGK 4003	012480								147	3,6	HG-N 400 HG-F 315	-	118-243	-	-
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KNCS-N 500	100-210	280-420	210-350	415-560
GGK 5002	012482								108	6,7	KNCS-NB 500	-	155-295	330-470	-
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2	HG-N 500 HG-F 400	-	100-240	-	-
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KNCS-N 630	80-240	265-450	240-440	460-650
GGK 5002	012482								108	6,7	KNCS-NB 630	-	140-320	380-560	-
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2	HG-N 630	-	100-240	-	-

* clamping range valid for chuck type KNCS-N and KNCS-NB

clamping range

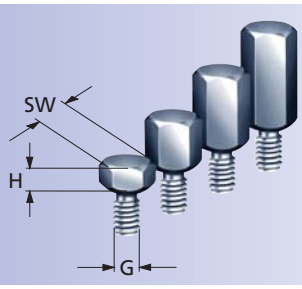


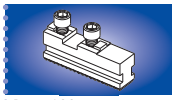
Base jaw position "**P**" Base jaw position "**O**"

stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	





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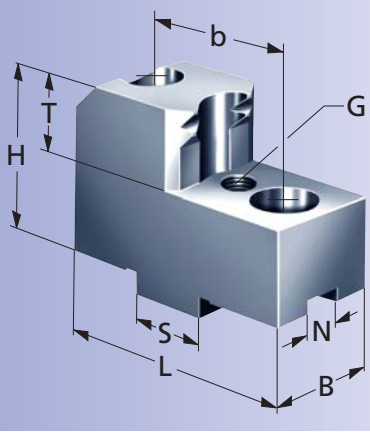
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hard roughing jaws

GGK for quick jaw change

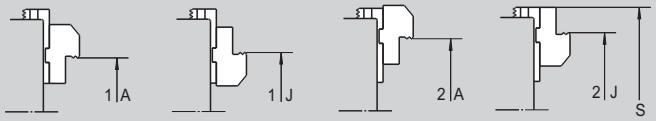
tongue & groove

for SMW-AUTOBLOK-chucks

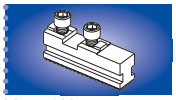


Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	SMW	*clamping ranges Ø external-A_1	*clamping ranges Ø internal-J_1	*clamping ranges Ø external-A_2	*clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	KNCS 175	25-58			
GGK 1752	012465								68	1,0			138-168	38-72	
GGK 1753	012466								60	1,0			110-140	68-100	
GGK 1754	012467								56	0,9			80-112	96-130	
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	KNCS 200			35-78	
GGK 2002	012470								66	1,3	KNCS 210	60-100	125-165	95-135	160-200
GGK 2003	012471								66	1,3			88-130	130-172	
GGK 2004	012472			15					85	1,7					62-106
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS 250	40-64	190-250	64-128	252-310
GGK 2502	012474								72	2,3			120-190	128-195	
GGK 2503	012475								78	2,6			104-150	160-224	
GGK 2504	012476								108	3,2					75-125
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS 260	40-75	193-266	65-135	255-330
GGK 2502	012474								72	2,3			123-195	134-207	
GGK 2503	012475								78	2,6			102-174	163-237	
GGK 2504	012476								108	3,2					70-142
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS 315	49-95	202-288	95-180	288-370
GGK 2503	012475								78	2,6			102-202	180-280	
GGK 2505	012477			15					84	2,8			82-150		
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS 315-91	45-110	210-200	110-200	300-370
GGK 2503	012475								78	2,6			110-210	200-290	
GGK 2505	012477			15					84	2,8			82-160		
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	KNCS 400	50-160	230-350	115-235	305-425
GGK 4002	012479								91	3,5			112-235	230-350	
GGK 4003	012480								147	3,6			90-215		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KNCS 500	80-190	260-400	170-310	375-520
GGK 5002	012482								108	6,7			135-275	290-430	
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2			100-220		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KNCS 630	80-240	265-450	240-440	460-650
GGK 5002	012482								108	6,7			140-320	380-560	
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2		-	100-220	-	-

clamping range



Base jaw position "**P**" Base jaw position "**O**"



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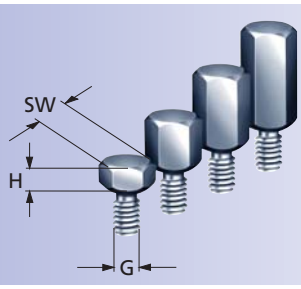


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stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	

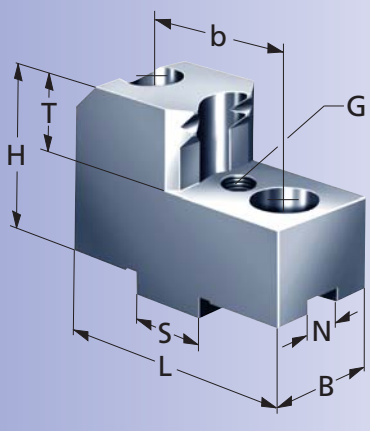


hard roughing jaws

GGK for quick jaw change

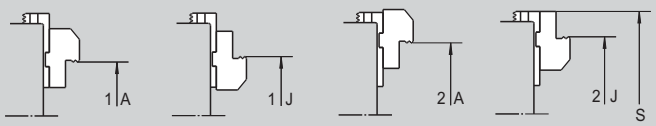
tongue & groove

for Berg-chucks



Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Berg	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	KHNC 160	28-65			
GGK 1752	012465								68	1,0	KHNC 185		140-175	55-90	
GGK 1753	012466								60	1,0			110-145	85-120	
GGK 1754	012467								56	0,9			80-115	110-145	
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	KHNC 200	30-45		50-95	
GGK 2002	012470								66	1,3		50-108	120-175	108-158	175-220
GGK 2003	012471								66	1,3			85-135	145-195	
GGK 2004	012472			15					85	1,7			55-78		78-125
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KHNC 250	38-80	195-270	75-145	270-320
GGK 2502	012474								72	2,3			125-195	145-215	
GGK 2503	012475								78	2,6			105-170	175-245	
GGK 2504	012476								108	3,2					80-150
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KHNC 315	40-150	210-330	90-120	280-370
GGK 2502	012474								78	2,6			110-230	190-310	
GGK 2505	012477			15					84	2,8			80-200		
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	KHNC 400	50-205	230-385	115-270	305-450
GGK 4002	012479								91	3,5			115-270	230-385	
GGK 4003	012480								147	3,6			95-250		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KHNC 500	70-280	280-480	180-380	385-590
GGK 5002	012482								108	6,7			150-350	300-500	
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2			105-290		

clamping range

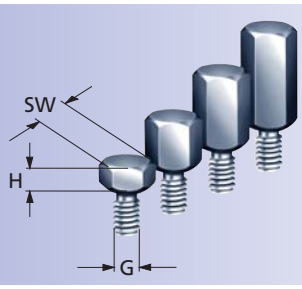


Base jaw position "**P**" Base jaw position "**O**"

stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	





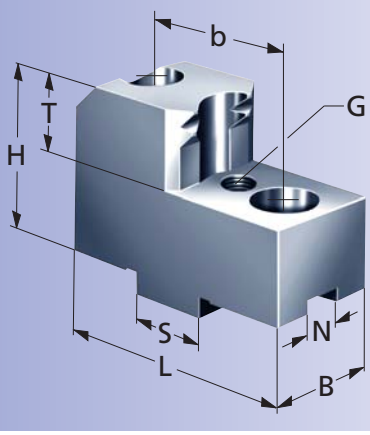
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hard roughing jaws

GGK for quick jaw change

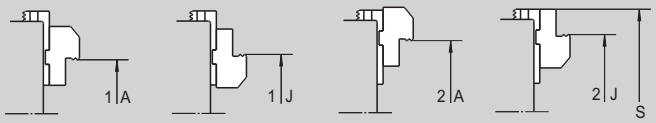
tongue & groove

for Forkardt-chucks

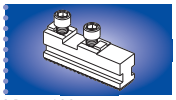


Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Forkardt	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	3 KTNC 160	25-38			
GGK 1752	012465								68	1,0	KTNCV 160		135-150	45-72	
GGK 1753	012466								60	1,0	F 160		105-122	72-102	
GGK 1754	012467								56	0,9	F+160		78-94	102-128	
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	3 KTNC 200			38-65	
GGK 2002	012470								66	1,3	F 200	52-78	120-140	95-125	160-190
GGK 2003	012471								66	1,3	F+200		82-105	130-160	
GGK 2004	012472			15					85	1,7					65-95
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	3 KTNC 250		180-216	72-102	262-290
GGK 2502	012474								72	2,3	F 250		120-150	140-172	
GGK 2503	012475								78	2,6	F+250		104-120	170-202	
GGK 2504	012476								108	3,2					80-108
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	3 KTNC 280	38-52	190-242	74-128	262-310
GGK 2502	012474								78	2,6			120-174	142-195	
GGK 2505	012477			15					84	2,8					78-130
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	3 KTNC 360	50-110	220-300	105-190	295-380
GGK 4002	012479								91	3,5	F 315	140-225	110-185	220-305	
GGK 4003	012480								147	3,6	F+315		90-215		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	3 KTNC 500	70-190	245-400	150-310	370-520
GGK 5002	012482								108	6,7	F 500 L	150-310	130-275	280-430	244-400
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2	F+500 L		110-220		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	3 KTNC 630	70-300	225-510	150-420	360-630
GGK 5002	012482								108	6,7		150-430	140-390	270-550	244-520
GGK 5003	012483	50	63	25					130	6,2			100-220		

clamping range



Base jaw position "**P**" Base jaw position "**O**"



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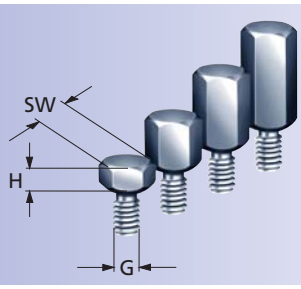


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stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	

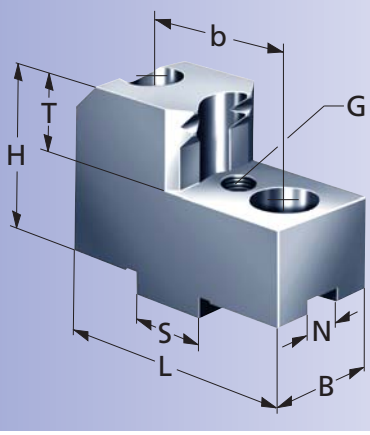


hard roughing jaws

GGK for quick jaw change

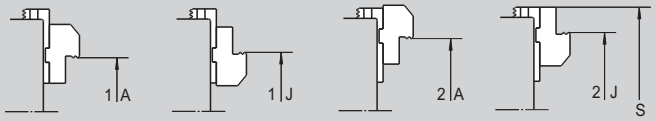
tongue & groove

for Forkardt-chucks



Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Forkardt	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	KTNCV 175	30-80			
GGK 1752	012465								68	1,0	FNC 175		126-190	48-110	160-220
GGK 1753	012466								60	1,0				80-140	142-202
GGK 1754	012467								56	0,9			84-148	104-166	118-180
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	KTNCV 200	44-106			
GGK 2002	012470								66	1,3	FNC 200	58-120	120-180	100-162	172-234
GGK 2003	012471								66	1,3		96-158	90-152	142-204	136-198
GGK 2004	012472			15					85	1,7			55-95		65-95
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KTNCV 250	40-90	200-285	80-170	272-360
GGK 2502	012474								72	2,3	FNC 250	75-163	128-216	150-238	220-308
GGK 2503	012475								78	2,6		95-183	102-190	172-260	172-260
GGK 2504	012476								108	3,2			75-100		88-176
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KTNC 315	40-118	200-320	80-200	275-395
GGK 2502	012474								78	2,6	KTNCV 315	65-185	125-245	150-270	202-322
GGK 2505	012477			15					84	2,8	FNC 315		73-190	180-300	170-290
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	KTNC 400	50-180	220-340	100-265	315-425
GGK 4002	012479								91	3,5	KTNCV 400	140-260	120-220	220-340	185-305
GGK 4003	012480								147	3,6	FNC 400		95-215		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KTNCV 500	60-235	255-440	160-350	375-560
GGK 5002	012482								108	6,7	FNC 500			280-470	255-445
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2			110-280		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KTNCV 630	60-335	225-525	160-460	375-675
GGK 5002	012482								108	6,7	FNC 630			280-580	255-555
GGK 5003	012483	50	63	25					130	6,2			110-380		

clamping range

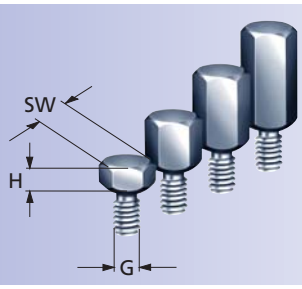


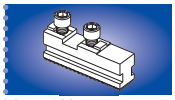
Base jaw position "**P**" Base jaw position "**O**"

stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	





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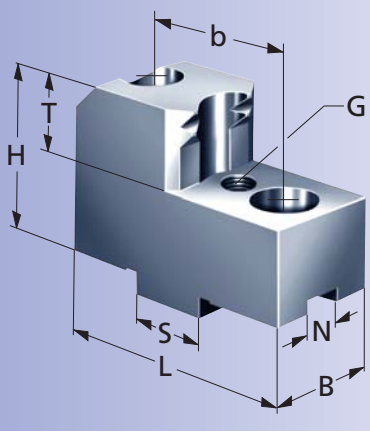
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hard roughing jaws

GGK for quick jaw change

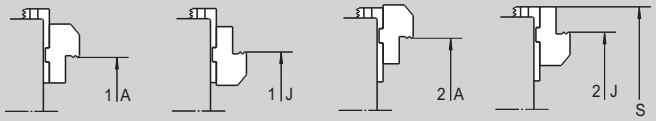
tongue & groove

for Kitagawa-chucks

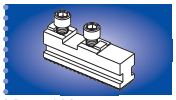


Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Kitagawa	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	QJ 306	25-62	133-171	33-80	155-190
GGK 1753	012466								60	1,0		32-61	134-172	42-79	153-181
GGK 1754	012467								56	0,9		52-89	107-145	70-107	125-163
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	QJ 308	30-69	-	45-106	-
GGK 2002	012470								66	1,3	QJ 8"	67-132	131-197	105-170	169-235
GGK 2003	012471								66	1,3		104-169	95-160	141-207	134-199
GGK 2004	012472			15					85	1,7		-	68-110	-	74-148
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	QJ 310	45-85	197-274	61-148	254-342
GGK 2502	012474								72	2,3	QJ 10"	78-154	132-208	141-218	195-272
GGK 2503	012475								78	2,6		1107-184	109-175	159-247	152-238
GGK 2504	012476								108	3,2		-	-	-	80-156
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	QJ 312	34-100	210-300	-	300-370
GGK 2502	012474								72	2,3	QJ 12"	90-175	-	170-262	-
GGK 2503	012475								78	2,6		-	110-210	206-292	-
GGK 2505	012477			15					84	2,8		-	82-150	-	-
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	QJ 15	78-188	258-378	143-263	333-453
GGK 4002	012479								91	3,5		-	140-263	258-378	-
GGK 4003	012480								147	3,6		-	118-243	-	-
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	QJ 21	100-210	280-420	210-350	415-560
GGK 5002	012482								108	6,7		-	155-295	330-470	-
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2		-	100-240	-	-
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	QJ 24	80-240	265-450	240-440	460-650
GGK 5002	012482								108	6,7		-	140-320	380-560	-

clamping range



Base jaw position "**P**" Base jaw position "**O**"



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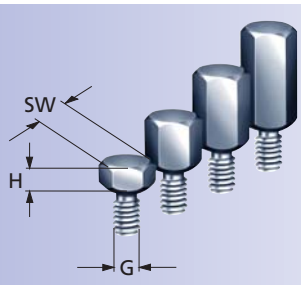


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stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	

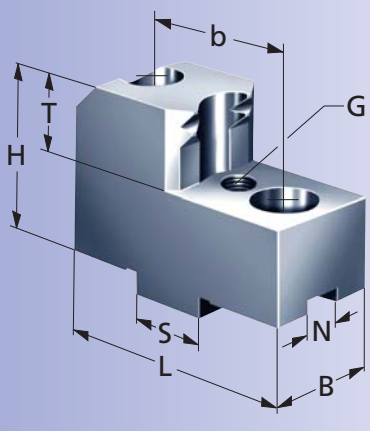


hard roughing jaws

GGK for quick jaw change

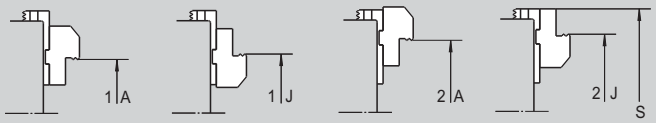
tongue & groove

for Röhm-chucks



Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Röhm	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	Duro-NC 160	28-70	-		
GGK 1752	012465								68	1,0	Duro-NCE 160		138-180	50-100	
GGK 1753	012466								60	1,0	Duro 160		110-150	85-135	
GGK 1754	012467								56	0,9			85-120	110-160	
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	Duro-NC 175	36-78			
GGK 1752	012465								68	1,0	Duro-NCES 175		146-188	58-108	
GGK 1753	012466								60	1,0			118-158	93-143	
GGK 1754	012467								56	0,9			93-128	118-168	
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	Duro-NC 200			28-75	
GGK 2002	012470								66	1,3	Duro-NCE 200	55-130	125-195	100-180	170-240
GGK 2003	012471								66	1,3	Duro 200		90-160	140-210	
GGK 2004	012472			15					85	1,7	Duro-NCES 200		55-100		
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	Duro-NC 250	38-95	195-280	80-160	270-300
GGK 2502	012474								72	2,3	Duro-NCE 250		125-205	145-225	
GGK 2503	012475								78	2,6	Duro 250		110-180	180-260	
GGK 2504	012476								108	3,2	Duro-NCES 250				80-170
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	Duro-NCE 315	66-139	223-324	108-204	298-344
GGK 2502	012474								72	2,3	Duro-NCES 315		153-249	173-269	
GGK 2503	012475								78	2,6			138-224	208-304	
GGK 2504	012476								108	3,2					108-214
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	Duro-NC 315	50-150	220-330	120-220	
GGK 4002	012479								91	3,5	Duro 315		110-220	220-320	
GGK 4003	012480								147	3,6			85-200		
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	Duro-NCE 400	128-206	298-386	198-276	
GGK 4002	012479								91	3,5			188-276	298-376	
GGK 4003	012480								147	3,6			163-256		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	Duro-NC 400	65-175	260-380	165-285	380-430
GGK 5002	012482								108	6,7	Duro 400		140-260	285-400	
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2			105-200		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	Duro-NCE 500	101-289			436-604
GGK 5002	012482								108	6,7			296-494	221-404	
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2			176-374		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	Duro-NC 500	65-235	260-440	185-350	400-550
GGK 5002	012482								108	6,7	Duro 500		140-320	310-480	

clamping range

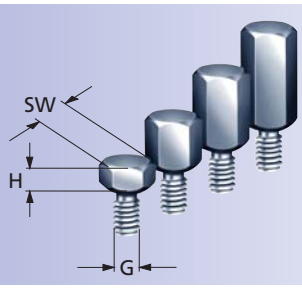


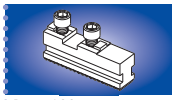
Base jaw position "**P**" Base jaw position "**O**"

stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	





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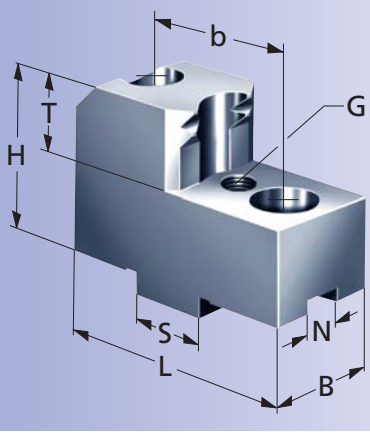
Page 97
Page 143

hard roughing jaws

GGK for quick jaw change

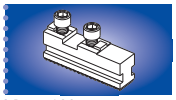
tongue & groove

for Schunk-chucks



Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Schunk	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	ROTA-S plus 160	25-50	-	-	-
GGK 1752	012465								68	1,0	ROTA THW 165		133-160	38-67	
GGK 1753	012466								60	1,0	ROTA THW plus 165		105-134	66-95	
GGK 1754	012467								56	0,9	ROTA-G 160 THW 165 ROTA-S 160		78-106	95-125	
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	ROTA-S plus 200	30-55	185-230	45-94	-
GGK 2002	012470								66	1,3	ROTA THW 210	60-110	130-178	100-145	165-215
GGK 2003	012471								66	1,3	ROTA THW plus 215	100-150	90-135	140-185	130-175
GGK 2004	012472			15					85	1,7	ROTA-G 200 THW 210R/F ROTA-S 200 ROTA NCWF 210 ROTA THWB 210	-	55-84	-	70-120
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	ROTA-S plus 250	35-70	200-265	65-138	265-330
GGK 2502	012474								72	2,3	ROTA-THW 250	80-145	130-195	143-205	190-260
GGK 2503	012475								78	2,6	ROTA THW plus 260	110-175	100-165	174-237	165-230
GGK 2504	012476								108	3,2	ROTA-G 250 THW 250/265-R/F ROTA NCW 265 ROTA-S 250 ROTA-NCWF 250 ROTA THWB 265	-	-	-	80-145
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	ROTA THW 315	40-92	205-280	94-179	294-370
GGK 2502	012474								72	3,0	ROTA THW plus 315	85-161	135-210	170-249	219-300
GGK 2503	012475								78	2,6	ROTA-G 315	115-190	105-180	203-278	194-270
GGK 2505	012477			15					84	2,8	ROTA-NCW 315 ROTA- NCWF 315 THW 315-R	-	85-150	-	-
GGK 4001[1]	012478	50	55	25	M8	12	26	54	104	4,8	ROTA-S plus 315	50-162	230-350	118-240	305-430
GGK 4002[1]	012479								91	3,5	ROTA THW 400	162-283	110-230	240-360	190-308
GGK 4003[1]	012480								147	3,6	THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW315-F	-	100-220	-	-
GGK 5001[2]	012481	60	74	35	M8	18	30	60	125	8,8	ROTA-S plus 400/500	80-190	260-400	170-310	380-520
GGK 5002[2]	012482								108	6,7	ROTA THW 500	170-310	140-280	265-405	260-400
GGK 5003[2]	012483	50	63	25	M8	18	30	60	130	6,2	ROTA-G 500 ROTA-S 400/500 THW 500-R/F ROTA THWB 400/500	-	100-210	-	-
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	ROTA THW 630	80-230	260-445	220-430	430-640
GGK 5002	012482								108	6,7	THW 630-R	170-350	140-325	315-525	310-520
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2		-	100-250	-	-

1) clamping range valid for chuck Ø 400
2) clamping range valid for chuck Ø 500



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Page 122

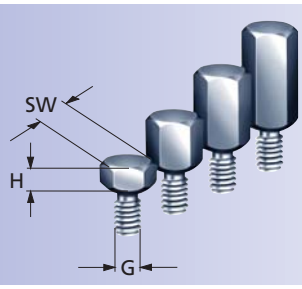


Page 97
Page 143

stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	



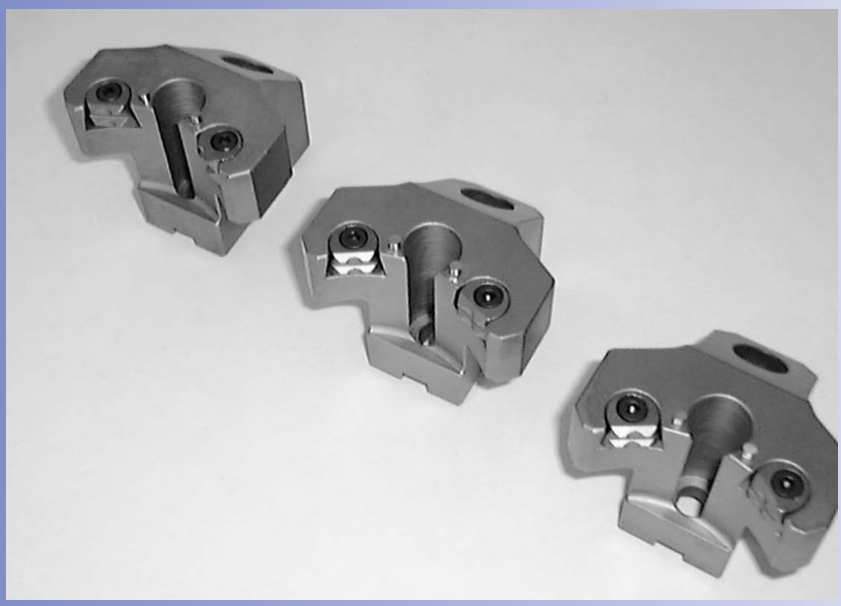
Special jaws for a forging

2-jaw chuck:
1 jaw fix, 1 jaw swivelling



Jaws with hard grippers

Economic made from soft jaw blanks



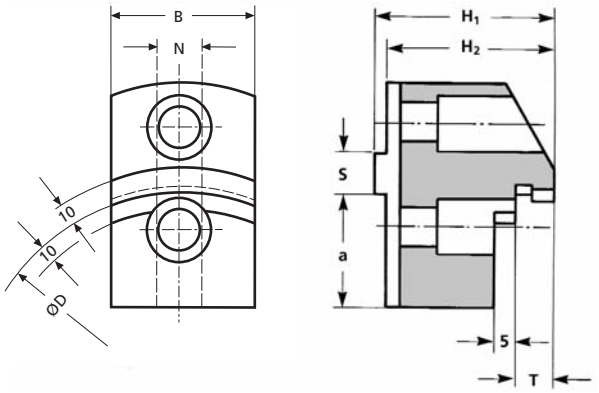
Hard prism jaws

Clamping of a square work piece in a 3-jaw chuck



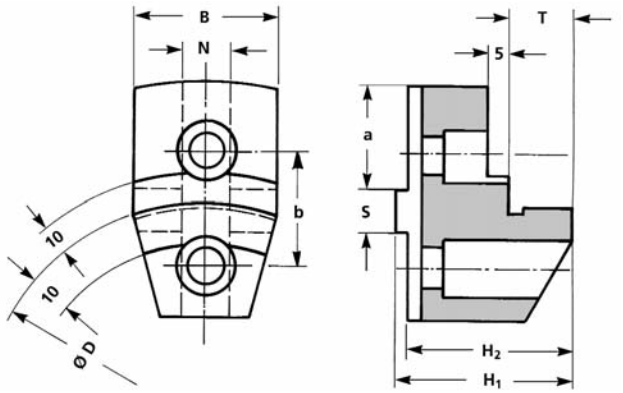
hard special jaws
on customer request

hard top jaws for external clamping



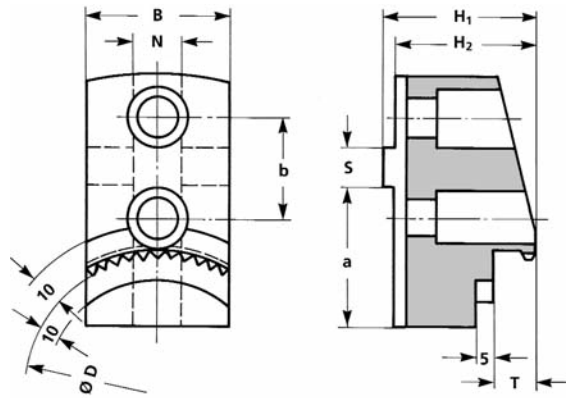
B
H_1
H_2
T
D
N
S
a
b
work-piece Ø
chuck maker
chuck type
material

hard top jaws for internal clamping

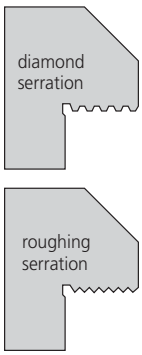


B
H_1
H_2
T
D
N
S
a
b
work-piece Ø
chuck maker
chuck type
material

hard top jaws for external clamping

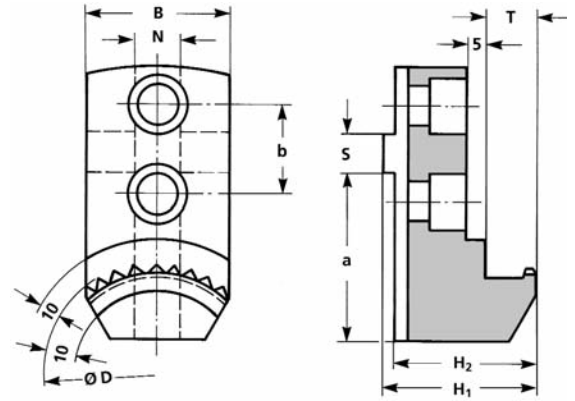


clamping area

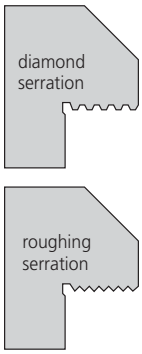


B
H_1
H_2
T
D
N
S
a
b
work-piece Ø
chuck maker
chuck type
material

hard top jaws for internal clamping

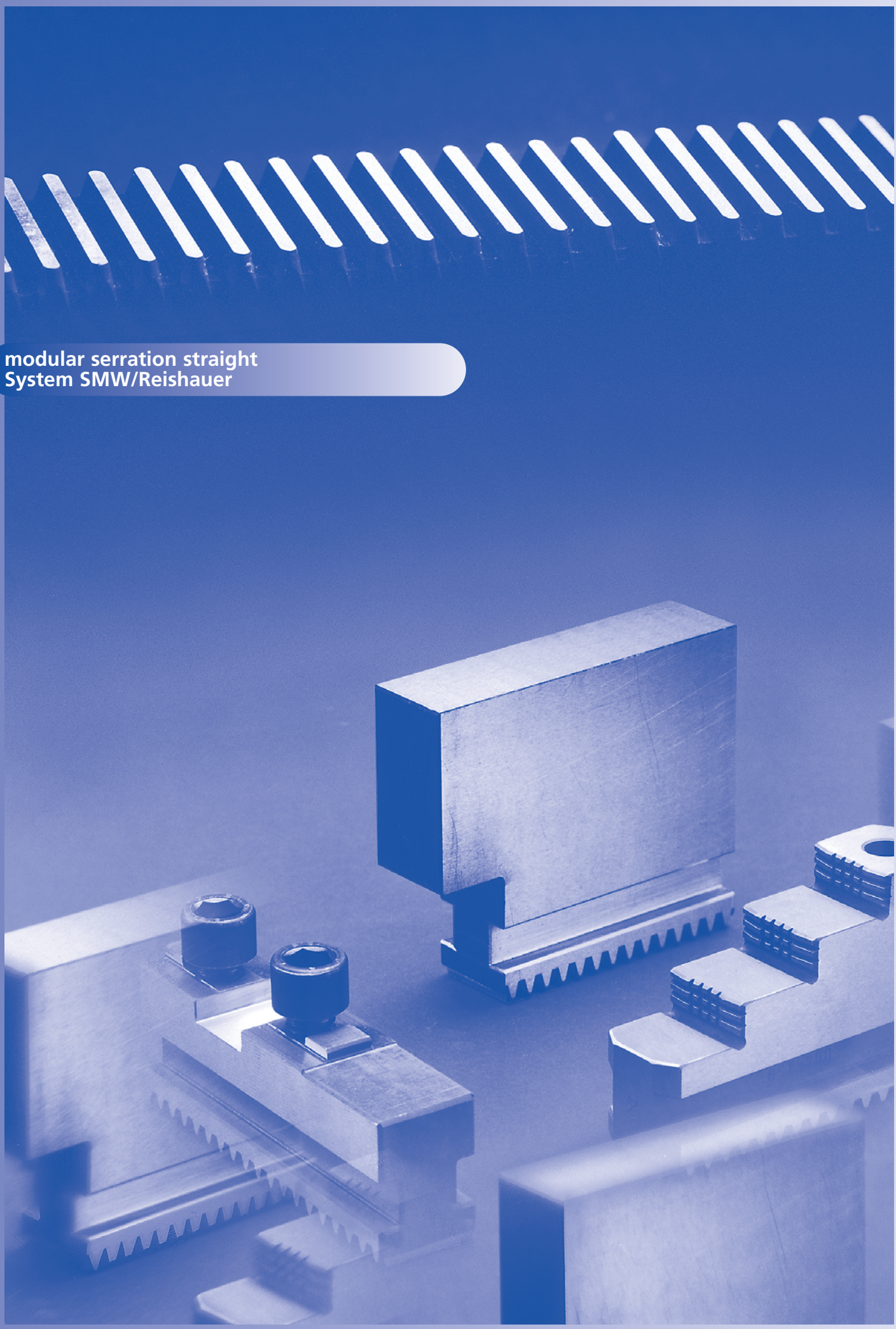


clamping area



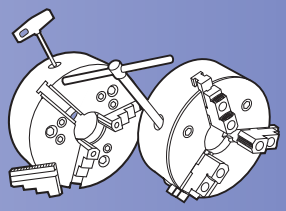
B
H_1
H_2
T
D
N
S
a
b
work-piece Ø
chuck maker
chuck type
material

modular serration straight
System SMW/Reishauer

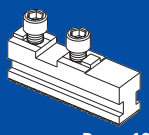
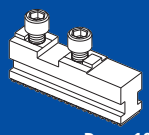
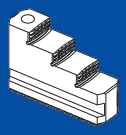
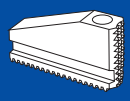
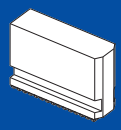
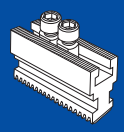
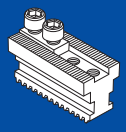
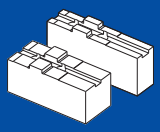
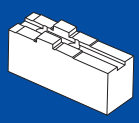
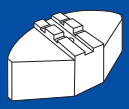
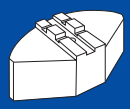
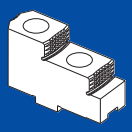
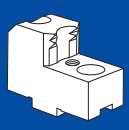
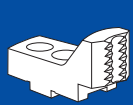
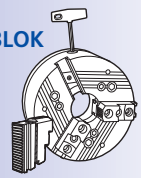
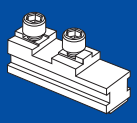
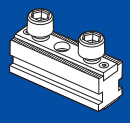


jaws for quick jaw change chuck

modular serration straight System SMW/Reishauer



SMW-AUTOBLOK	SMW	Kitagawa	Röhm	Schunk
HG-N KNCS-N KNCS-NB	HG KNCS	QJ	Duro NCES	ROTA-THW/NCW ROTA-THW plus ROTA-G

GBK	hard base jaws		**GBK**  Page 100	**GBKS**  Page 101
GBKS	hard base jaws with 1/2 tooth pitch offset			
GST	hard stepped monoblock jaws		**GST**  Page 102	**GES**  Page 103
GES	hard monoblok roughing jaws			
UVB	monoblock jaws quenched		**UVB**  Page 104	
KOB	kombi base jaws		**KOB**  Page 105	**KLG-D, KLG-M**  Page 106
KLG-D	kombi base jaws			
KLG-M	kombi base jaws			
WAK	soft top jaws 16MnCr5	standard	**WAK, WAKS**  Page 108	**WAK-A**  Page 110
WAKS	soft top jaws 16MnCr5	wide version		
WAK-A	alu.-top jaws aluminium F50			
SBK	soft pie jaws 16MnCr5		**SBK**  Page 111	**SBK-A**  Page 112
SBK-A	alum. soft pie jaws aluminium F50			
GUA	hard top jaws		**GUA**  Page 113	
GGK	hard roughing jaws		**GGK**  Page 114	**GSK**  Page 117
GSK	hard bar roughing jaws			
GBK-B	hard base jaws wide version	only for SMW-AUTOBLOK KNCS-NB 	**GBK-B**  Page 118	**GBK-BD**  Page 118



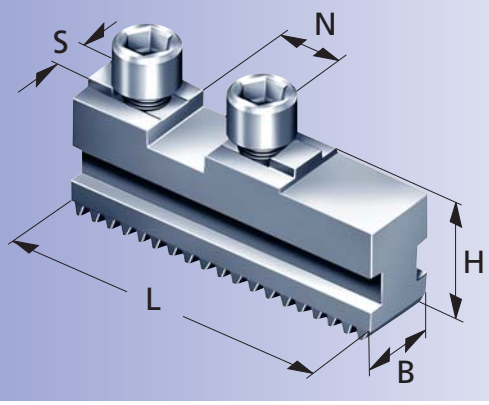
safety advise:
Top jaws are safety components, which can unter high load depending on their use.
Max grip forces and speeds must not be exceeded at any time.
For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

hard base jaws

GBK for quick jaw change

modular serration straight
System SMW/Reishauer

incl. jaw mounting bolts DIN 912-12.9



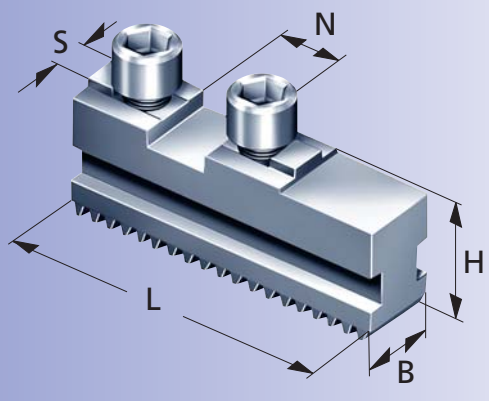
Type	Id.-No.	B	H	L	N	S	G x length	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
GBK 140	**012438**	20	27,5	56	18	8	M8 x 20	0,6	KNCS-N 140	KNCS 140			
GBK 160	**012439**	20	27,5	65	18	8	M8 x 20	0,7	KNCS-N 170 HG-N 160	KNCS 160 KNCS 175 KNSP 160 HG 160 RMG 160	QJ 306	DURO-NCES 175	ROTA THW 165 ROTA THW plus 165/185 ROTA NCW 185 ROTA-G 160 THW 165
GBK 200	**012440**	22	29,5	85	20	10	M8 x 20	1,0	KNCS-N 210 KNCS-N 225 HG-N 210	KNCS 200 KNCS 210 KNSP 200 HG 200 RMG 200	QJ 308	DURO-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
GBK 250	**012441**	26	37	104	20	12	M12 x 25	1,8	KNCS-N 260 HG-N 260 KNCS-N 275	KNCS 250 KNCS 260 HG 250 RMG 200	QJ 310	DURO-NCES 250	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
GBK 315	**012442**	32	43	115	20	12	M12 x 25	2,7	KNCS-N 315 HG-N 315 KNCS-N 340	KNCS 315 HG 315	QJ 312	DURO-NCES 315	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R
GBK 400	**012443**	32	43	125	26	12	M12 x 30	3,0	KNCS-N 400 HG-N 400	KNCS 400 HG 400 RMG 315	QJ 15	DURO-NCES 400	ROTA THW 400 THW 400-R ROTA-G 400
GBK 500	**012444**	45	57	160	30	18	M16 x 45	7,1	KNCS-N 500 HG-N 500	KNCS 500 HG 500	QJ 21		ROTA THW 500 THW 500-R ROTA-G 500
GBK 630	**012445**	45	57	200	30	18	M16 x 45	9,0	KNCS-N 630 HG-N 630	KNCS 630 HG 630	QJ 24		ROTA THW 630 THW 630-R ROTA THW 800

hard base jaws

GBKS for quick jaw change

modular serration straight with 1/2 tooth pitch offset
System SMW/Reishauer

incl. jaw mounting bolts DIN 912-12.9

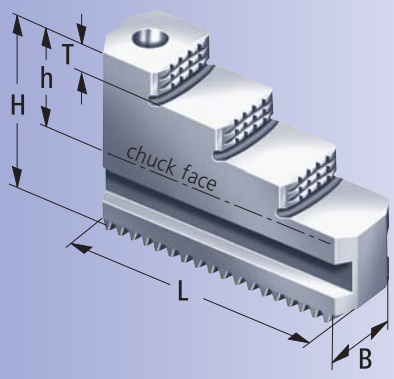


Type	Id.-No.	B	H	L	N	S	G x length	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
GBKS 140	**013733**	20	27,5	56	18	8	M8 x 20	0,6	KNCS-N 140	KNCS 140			
GBKS 160	**013735**	20	27,5	65	18	8	M8 x 20	0,7	KNCS-N 170 HG-N 160	KNCS 160 KNCS 175 KNSP 160 HG 160 RMG 160	QJ 306	DURO-NCES 175	ROTA THW 165 ROTA THW plus 165/185 ROTA NCW 185 ROTA-G 160 THW 165
GBKS 200	**013737**	22	29,5	85	20	10	M8 x 20	1,0	KNCS-N 210 KNCS-N 225 HG-N 210	KNCS 200 KNCS 210 KNSP 200 HG 200 RMG 200	QJ 308	DURO-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
GBKS 250	**013739**	26	37	104	20	12	M12 x 25	1,8	KNCS-N 260 HG-N 260 KNCS-N 275	KNCS 250 KNCS 260 HG 250 RMG 200	QJ 310	DURO-NCES 250	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
GBKS 315	**013741**	32	43	115	20	12	M12 x 25	2,7	KNCS-N 315 HG-N 315 KNCS-N 340	KNCS 315 HG 315	QJ 312	DURO-NCES 315	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R
GBKS 400	**013743**	32	43	125	26	12	M12 x 30	3,0	KNCS-N 400 HG-N 400	KNCS 400 HG 400 RMG 315	QJ 15	DURO-NCES 400	ROTA THW 400 THW 400-R ROTA-G 400

hard stepped monoblock jaws

GST for quick jaw change

modular serration straight
System SMW/Reishauer



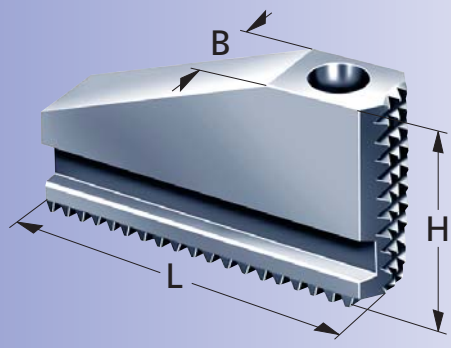
Type	Id.-No.	B	H	h	L	T	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
***GST 160-1** ***GST 160-2**	**014046** **012454**	20 20	43,5 43,5	23 23	58 58	7 7	0,6	KNCS-N 140 HG-N 160	KNCS 140 KNCS 160 KNSP 160 RMG 160 HG 160			ROTA NCW 185 THW 165 ROTA THW plus 165 ROTA THW 165
GST 170	**035867**	20	43,5	23	67	7	0,7	KNCS-N 170	KNCS 175	QJ 306	DURO-NCES 175	ROTA THW plus 185 ROTA-G 160
GST 210	**035863**	22	51	26	84	8	1,3	KNCS-N 210 KNCS-N 225 HG-N 210	KNCS 200 KNCS 210 KNSP 200 HG 200 RMG 200	QJ 308	DURO-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
GST 260	**037623**	26	60	31	100	10	2,0	KNCS-N 260 HG-N 260 KNCS-N 275	KNCS 250 KNCS 260 RMG 250 HG 250	QJ 310	DURO-NCES 250	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
GST 315	**012457**	32	66	32	117	10	3,4	KNCS-N 315 HG-N 315 KNCS-N 340	KNCS 315 HG 315	QJ 312	DURO-NCES 315	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R
GST 400	**012458**	32	70	36	137	11	4,4	KNCS-N 400 HG-N 400	KNCS 400 RMG 315 HG 400	QJ 15	DURO-NCES 400	ROTA THW 400 THW 400-R ROTA-G 400
GST 500	**012459**	45	93	46	175	20	11,7	KNCS-N 500 KNCS-N 630 HG-N 500 HG-N 630	KNCS 500 HG 500 KNCS 630 HG 630	QJ 21 QJ 24		ROTA THW 500/630 THW 500/630-R ROTA-G 500

* To cover the whole range 2 sets of stepped jaws are needed, when using **KNCS** 140 or **KNCS** 160

hard, monoblok roughing jaws

GES for quick jaw change

modular serration straight
System SMW/Reishauer



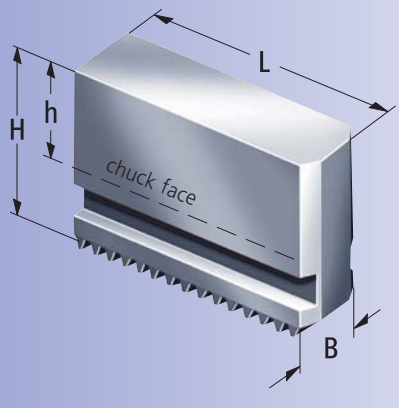
Type	Id.-No.	B	H	L	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
GES 175	**012460**	20	43,5	69	0,9	KNCS-N 170 HG-N 160	KNCS 160 KNCS 175 HG 160	QJ 306	DURO-NCES 175	ROTA THW 165 ROTA THW plus 165/185 ROTA NCW 185 ROTA-G 160 THW 165
GES 200	**012461**	22	51	90	1,4	KNCS-N 210 KNCS-N 225 HG-N 210	KNCS 200 KNCS 210 KNSP 200 HG 200	QJ 308	DURO-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
GES 250	**012462**	26	60	100	2,5	KNCS-N 260 HG-N 260 KNCS-N 275	KNCS 250 KNCS 260 RMG 250 HG 250	QJ 310	DURO-NCES 250	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
GES 315	**012463**	32	66	132	4,4	KNCS-N 315 KNCS-N 400 HG-N 315 HG-N 400 KNCS-N 340	KNCS 315 HG 315 HG 400	QJ 312 QJ 15	DURO-NCES 315 DURO-NCES 400	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R ROTA-THW 400 THW 400-R ROTA-G 400

soft monoblock jaws

UVB for quick jaw change

modular serration straight
System SMW/Reishauer

Material: 15CrNi6, quenched 800 N/mm²



Type	Id.-No.	B	H	h	L	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
UVB 140	**012446**	20	60	39	58	1,1	KNCS-N 140	KNCS 140			
UVB 160/170	**012447**	20	60	39	69	1,3	KNCS-N 170 HG-N 160	KNCS 160 KNCS 175 KNSP 160 HG 160 RMG 160	QJ 306	DURO-NCES 175	ROTA THW 165 ROTA THW plus 165/185 ROTA NCW 185 ROTA-G 160 THW 165
UVB 200	**012448**	22	70	45	84	2,0	KNCS-N 210 KNCS-N 225 HG-N 210	KNCS 200 KNCS 210 KNSP 200 HG 200 RMG 200	QJ 308	DURO-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
UVB 250	**012449**	26	90	61	107	4,2	KNCS-N 260 HG-N 260 KNCS-N 275	KNCS 250 KNCS 260 HG 250 RMG 250	QJ 310	DURO-NCES 250	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
UVB 315	**012450**	32	100	66	118	6,6	KNCS-N 315 HG-N 315 KNCS-N 340	KNCS 315 HG 315	QJ 312	DURO-NCES 315	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R
UVB 400	**012451**	32	100	66	145	9,0	KNCS-N 400 HG-N 400	KNCS 400 HG 400 RMG 315	QJ 15	DURO-NCES 400	ROTA THW 400 THW 400-R ROTA-G 400
UVB 500	**012452**	45	134	87	175	19,5	KNCS-N 500 HG-N 500	KNCS 500 HG 500	QJ 21		ROTA THW 500 THW 500-R ROTA-G 500
UVB 630	**012453**	45	134	87	230	27,5	KNCS-N 630 HG-N 630	KNCS 630 HG 630	QJ 24		ROTA THW 630 THW 630-R ROTA THW 800

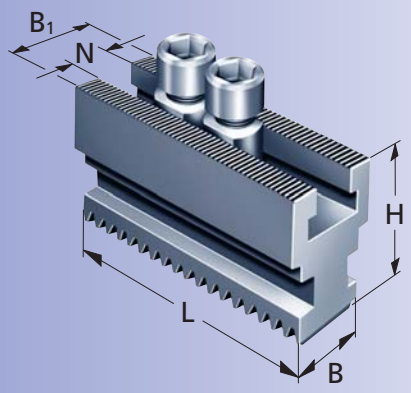
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kombi base jaws

KOB for quick jaw change

modular serration straight System SMW/Reishauer and INCH serration

incl. T-nuts and screw DIN 912-12.9



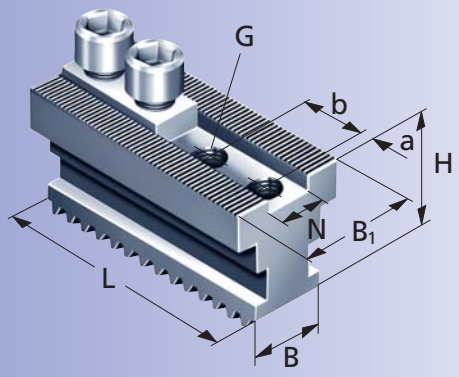
Type	Id.-No.	B	B_1	H	L	N	serration	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
KOB 200-1	**081323**	22	45	56	85	17	1/16" x 90°	3,6	KNCS-N 210 KNCS-N 225 HG-N 210	KNCS 200 KNCS 210 KNSP 200 HG 200 RMG 200	QJ 308	DURO-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
KOB 250-1	**081324**	26	45	59,5	104	17	1/16" x 90°	5,0	KNCS-N 260 HG-N 260	KNCS 250 KNCS 260	QJ 310	DURO-NCES 250	ROTA-THW 250 ROTA THW plus 260
KOB 250-2	**081325**	26	50	67	104	21	1/16" x 90°	7,9	KNCS-N 275	HG 250 RMG 250			ROTA-G 250 THW 250/265-R ROTA NCW 265
KOB 315-2	**081327**	32	50	72	115	21	1/16" x 90°	7,7	KNCS-N 315 HG-N 315 KNCS-N 340	KNCS 315 HG 315	QJ 312	DURO-NCES 315	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R
KOB 400-2	**081329**	32	60	76	125	25,5	3/32" x 90°	8,4	KNCS-N 400 HG-N 400 KNCS-N 315 HG-N 315	KNCS 400 HG 400 RMG 315	QJ 15	DURO-NCES 400	ROTA THW 400 THW 400-R ROTA-G 400
KOB 500-2	**006474**	45	64	84	160	25,5	3/32" x 90°	13,7	KNCS-N 500 HG-N 500 KNCS-N 630	KNCS 500 HG 500	QJ 21 QJ 24		ROTA THW 500 THW 500-R ROTA-G 500 ROTA THW 630 THW 630-R ROTA THW 800

kombi base jaws

KLG-D for quick jaw change

modular serration straight System SMW/Reishauer INCH serration

incl. jaw mounting bolts DIN 912-12.9 and guide rail



Type	Id.-No.	B	B_1	H	L	N	serration	G	a	b*	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
KLG-D 250-1	**081311**	26	40	46	86	17	1/16" x 90°	M12	10	22	2,7	KNCS-N 260 HG-N 260	KNCS 250 KNCS 260	QJ 310	DURO-NCES 250	ROTA-THW 250 ROTA THW plus 260
KLG-D 250-2	**081312**	26	45	50	110	21	1/16" x 90°	M16	13	28	4,2	KNCS-N 275	HG 250 RMG 250			ROTA-G 250 THW 250/265-R ROTA NCW 265
KLG-D 315-2	**081314**	32	45	55	110	21	1/16" x 90°	M16	13	28	4,5	KNCS-N 315 HG-N 315 KNCS-N 400 HG-N 400 KNCS-N 340	KNCS 315 HG 315 KNCS 400 HG 400 RMG 315	QJ 312 QJ 15	DURO-NCES 315 DURO-NCES 400	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R ROTA THW 400 THW 400-R ROTA-G 400

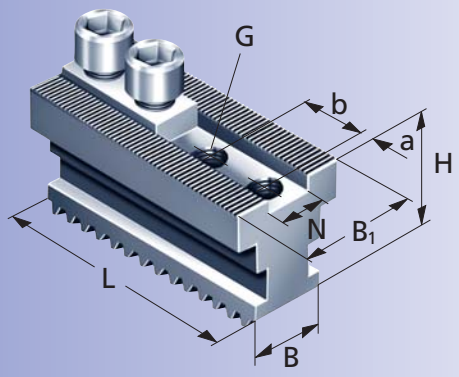
b* = 3 times (= 4 tapped holes)

kombi base jaws

KLG-M for quick jaw change

modular serration straight System SMW/Reishauer METRIC serration

incl. jaw mounting bolts DIN 912-12.9 and guide rail



Type	Id.-No.	B	B_1	H	L	N	serration	G	a	b*	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
KLG-M 200	**091378**	22	40	47	95	14	1,5 x 60°	M12	10	25	2,7	KNCS-N 210 KNCS-N 225 HG-N 210	KNCS 200 KNCS 210 KNSP 200 HG 200 RMG 200	QJ 308	DURO-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
KLG-M 250	**091379**	26	40	47	110	16	1,5 x 60°	M12	10	30	4,2	KNCS-N 260 HG-N 260 KNCS-N 275	KNCS 250 KNCS 260 HG 250 RMG 250	QJ 310	DURO-NCES 250	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
KLG-M 315	**091380**	32	50	54	120	18	1,5 x 60°	M14	15	30	4,5	KNCS-N 315 HG-N 315	KNCS 315 HG 315	QJ 312 QJ 15	DURO-NCES 315 DURO-NCES 400	ROTA-THW 315 ROTA THW plus 315
KLG-M 315-1	**236526**	32	50	57	125	21	1,5 x 60°	M16	17,5	30	4,8	KNCS-N 400 HG-N 400 KNCS-N 340	KNCS 400 HG 400 RMG 315			ROTA-G 315 ROTA NCW 315 THW 315-R ROTA THW 400 THW 400-R ROTA-G 400

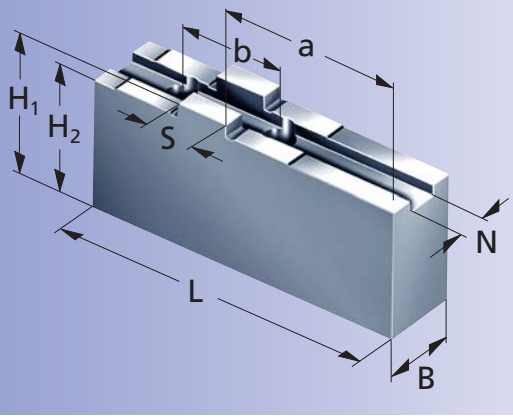
b* = 3 times (= 4 tapped holes)

soft top jaws

WAK for quick jaw change

tongue & groove

Material: 16MnCr5



Type	Id.-No.	B	H1	H2	L	N	S	a	b	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
WAK 125-10	**016633**	20	30	27,5	55	14 (Slot)	5 (Slot)	25	20	0,6		RMG 125			
WAK 140-10	**012490**	20	40	35,5	69	8	18	26	32	0,9	KNCS-N 140	KNCS 140			
WAK 160-10	**012491**	20	40	35,5	85	8	18	42	32	1,2	HG-N 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	QJ 306	Duro-NCES 175	ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA NCW185
WAK 200-10	**012492**	22	46	42	105	10	20	50	40	2,0	HG-N 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	QJ 308	Duro-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THWB 210 ROTA THW vario 215
WAK 250-10	**012493**	30	55	50	125	12	20	70	40	3,6	HG-N 260 HG-N 315 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	QJ 310 QJ 312	Duro-NCES 250 Duro-NCES 315	ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R ROTA NCW 265/315 ROTA THWB 265 THW 315-R
WAK 400-10	**012494**	35	60	54	145	12	26	74	54	5,8	HG-N 400 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	QJ15	Duro-NCES 400	ROTA THW 400 THW 400-R ROTA-G 400 ROTA THWB 315
WAK 500-10	**012495**	50	80	73	180	18	30	100	60	13,7	HG-N 500 HG-N 630 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800	HG 500 HG 630 KNCS 500 KNCS 630	QJ21 QJ24		ROTA THW 500/630/800 ROTA-G 500 THW 500/630-R ROTA THWB 400/500

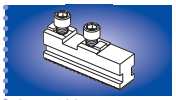
Other dimensions on request.
Use the data sheet on page 82 for ordering.



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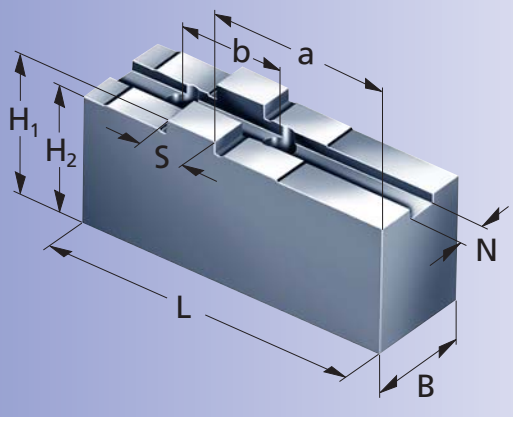

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soft top jaws wide version

WAKS for quick jaw change

tongue & groove

Material: 16MnCr5



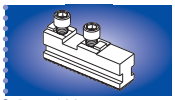
Type	Id.-No.	B	H1	H2	L	N	S	a	b	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
WAKS 140-10	**012496**	35	40	35,5	63	8	18	25	32	1,5	KNCS-N 140	KNCS 140			
WAKS 160-10	**080931**	25	50	45,5	85	8	18	42	32	1,8	HG-N 160	RMG 160	QJ306	Duro-NCES 175	ROTA THW 165
WAKS 160-20	**080932**	30	55	50,5	85			48	32	2,2	KNCS-N 170	HG 160			ROTA THW plus 165/185
WAKS 160-30	**080933**	40	80	75,5	70			26	32	3,4		KNSP 160			ROTA-G 160
												KNCS 160			THW 165
												KNCS 175			ROTA NCW 185
WAKS 200-10	**080934**	30	55	51	100	10	20	57	40	2,9	HG-N 210	RMG 200	QJ308	Duro-NCES 200	ROTA THW 210
WAKS 200-20	**080935**	30	70	66	100			45	40	3,4	KNCS-N 210	HG 200			ROTA THW plus 215
WAKS 200-30	**012497**	40	40	36	70			27	40	1,9	KNCS-N 225	KNSP 200			ROTA-G 200
WAKS 200-31	**080936**	40	60	56	90			43	40	3,9	KNCS-NB 210	KNCS 200			THW 210R
WAKS 200-32	**036733**	40	80	76	95			52	40	5,8	KNCS-NB 225	KNCS 210			ROTA NCW 225
															ROTA THWB 210
															ROTA THW vario 215
WAKS 250-10	**080937**	40	60	55	125	12	20	70	40	5,7	HG-N 260	RMG 250	QJ310	Duro-NCES 250	ROTA-THW 250/315
WAKS 250-11	**080938**	40	80	75	125			70	40	7,5	HG-N 315	HG 250	QJ312	Duro-NCES 315	ROTA THW plus 260/315
WAKS 250-12	**080939**	40	100	95	125			70	40	9,6	KNCS-N 260/275	HG 315			ROTA-G 250/315
WAKS 250-13	**080940**	40	120	115	125			70	40	11,5	KNCS-N 315/340	KNCS 250			THW 250/265-R
WAKS 250-20	**012498**	60	60	55	90			44	40	6,2	KNCS-NB 260	KNCS 260			ROTA NCW 265/315
WAKS 250-21	**080942**	60	60	55	110			60	40	7,6	KNCS-NB 315	KNCS 315			ROTA THWB 265
WAKS 250-22	**080943**	60	80	75	90			44	40	9,4	KNCS-NB 340				THW 315-R
WAKS 250-23	**080944**	60	80	75	110			60	40	11,5					
WAKS 250-30	**012499**	80	60	55	90			44	40	8,5					
WAKS 250-31	**080945**	80	80	75	110			60	40	14,1					
WAKS 400-10	**080946**	40	60	54	110	12	26	54	54	4,9	HG-N 400	RMG 315	QJ15	Duro-NCES 400	ROTA THW 400
WAKS 400-11	**080947**	40	60	54	145			89	54	6,7	KNCS-N 400	HG 400			THW 400-R
WAKS 400-12	**080948**	40	100	94	145			89	54	11,1	KNCS-NB 400	KNCS 400			ROTA-G 400
WAKS 400-13	**080949**	40	120	114	145			89	54	13,5					ROTA THWB 315
WAKS 400-14	**080950**	40	150	146	145			89	54	16,9					
WAKS 400-20	**080951**	60	60	54	110			54	54	7,6					
WAKS 400-21	**080952**	60	80	74	110			54	54	10,3					
WAKS 400-22	**080953**	60	100	94	110			54	54	14,1					
WAKS 400-30	**012500**	80	70	64	100			44	54	11,0					
WAKS 500-10	**080954**	60	80	73	155	18	30	90	60	13,8	HG-N 500	HG 500	QJ21		ROTA THW 500/630/800
WAKS 500-12	**080956**	60	120	113	155			90	60	19,5	HG-N 630	HG 630	QJ24		ROTA-G 500
WAKS 500-20	**080957**	80	80	73	155			90	60	15,5	KNCS-N 500	KNCS 500			THW 500/630R
WAKS 500-21	**080958**	80	100	93	155			90	60	26,3	KNCS-N 630	KNCS 630			ROTA THWB 400/500
WAKS 500-30	**012501**	90	80	73	130			65	60	16,4	KNCS-NB 500				
WAKS 500-31	**012502**	100	80	73	150			85	60	20,0	KNCS-NB 630				
											KNCS-NB 800				



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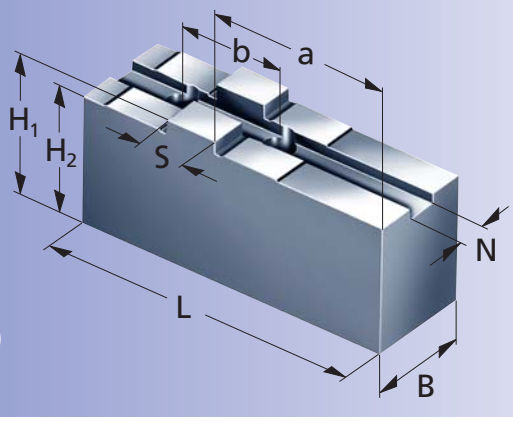

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soft top jaws alum. light version

WAK-A for quick jaw change

tongue & groove

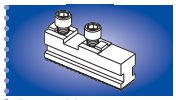
Material: aluminium (tensile strength ca. 500 N/mm²)



Type	Id.-No.	B	H1	H2	L	N	S	a	b	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
WAK-A 160	**080959**	25	50	45,5	85	8	18	42	32	0,7	HG-N 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	QJ306	Duro-NCES 175	ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA NCW185
WAK-A 200	**080960**	25	50	46	105	10	20	50	40	0,9	HG-N 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	QJ 308	Duro-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225
WAK-A 210	**035222**	40	60	56	90	10	20	43	40	1,65					ROTA THWB 210 ROTA THW vario 215
WAK-A 250	**080961**	40	60	55	125	12	20	70	40	2,0	HG-N 260 HG-N 315 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	QJ 310 QJ 312	Duro-NCES 250 Duro-NCES 315	ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R ROTA NCW 265/315 ROTA THWB 265 THW 315-R
WAK-A 400	**080962**	40	60	54	145	12	26	74	54	2,4	HG-N 400 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	QJ 15	Duro-NCES 400	ROTA THW 400 THW 400-R ROTA-G 400 ROTA THWB 315
WAK-A 500	**035142**	50	80	73	180	18	30	100	60	5,1	HG-N 500 HG-N 630 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800	HG 500 HG 630 KNCS 500 KNCS 630	QJ 21 QJ 24		ROTA THW 500/630/800 ROTA-G 500 THW 500/630-R ROTA THWB 400/500



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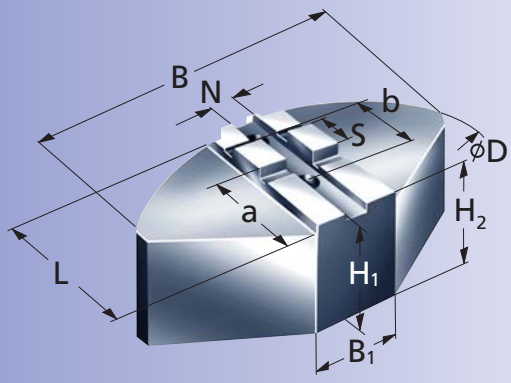

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soft pie jaws

SBK for quick jaw change

tongue & groove

Material: 16MnCr5



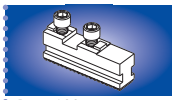
Type	Id.-No.	B	B1	H1	H2	L	N	S	a	b	D	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
SBK 160	**080963**	120	40	50	46	60	8	18	23	32	160	4,5	HG-N 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	QJ 306	Duro-NCES 175	ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA NCW 185
SBK 200	**080964**	140	65	60	56	70	10	20	27	40	200	8,4	HG-N 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	QJ 308	Duro-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THWB 210 ROTA THW vario 215
SBK 250	**080965**	180	70	60	55	90	12	20	44	40	250	11,2	HG-N 260 HG-N 315 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	QJ 310 QJ 312	Duro-NCES 250 Duro-NCES 315	ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R ROTA NCW 265/315 ROTA THWB 265 THW 315-R
SBK 400	**080966**	240	120	75	69	110	12	26	54	54	320	25,2	HG-N 400 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	QJ 15	Duro-NCES 400	ROTA THW 400 THW 400-R ROTA-G 400 ROTA THWB 315



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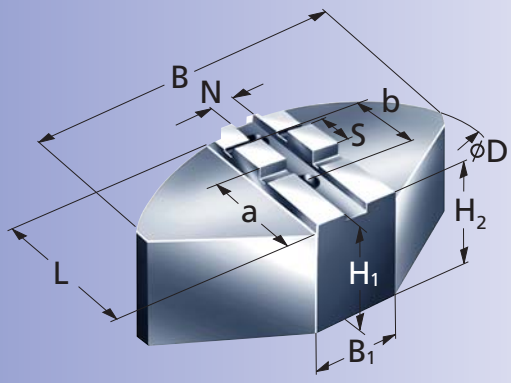

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soft pie jaws alum. light version

SBK-A for quick jaw change

tongue & groove

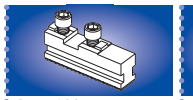
Material: aluminium (tensile strength ca. 500 N/mm²)



Type	Id.-No.	B	B1	H1	H2	L	N	S	a	b	D	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
SBK-A 160	**080967**	120	40	50	46	60	8	18	23	32	160	1,6	HG-N 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	QJ 306	Duro-NCES 175	ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA NCW 185
SBK-A 200	**080968**	140	55	60	56	75	10	20	27	40	200	3,1	HG-N 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	QJ 308	Duro-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THWB 210 ROTA THW vario 215
SBK-A 250	**080969**	180	70	60	55	90	12	20	44	40	250	4,3	HG-N 260 HG-N 315 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	QJ 310 QJ 312	Duro-NCES 250 Duro-NCES 315	ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R ROTA NCW 265/315 ROTA THWB 265 THW 315-R
SBK-A 400	**080970**	240	120	75	69	110	12	26	54	54	320	9,3	HG-N 400 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	QJ 15	Duro-NCES 400	ROTA THW 400 THW 400-R ROTA-G 400 ROTA THWB 315
SBK-A 500	**085193**	330	150	90	83	160	18	30	95	60	440	21,4	HG-N 500 HG-N 630 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800	HG 500 HG 630 KNCS 500 KNCS 630	QJ 21 QJ 24		ROTA THW 500/630/800 ROTA-G 500 THW 500/630-R ROTA THWB 400/500



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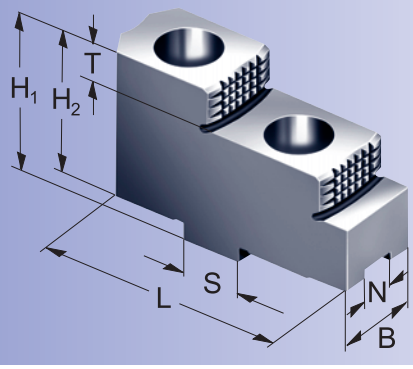

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hard, reversible top jaws

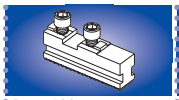
GUA for quick jaw change

tongue & groove



Type	Id.-No.	B	H_1	H_2	L	T	N	S	kg/ set	SMW-AUTOBLOK	SMW	Kita-gawa	Röhm	Schunk
GUA 160	**012484**	20	36,5	32,5	63	7,5	8	18	0,6	HG-N 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	QJ 306	Duro-NCES 175	ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA NCW 185
GUA 200	**012485**	22	42	38	75	10	10	20	0,8	HG-N 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	QJ 308	Duro-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THWB 210 ROTA THW vario 215
GUA 250	**012486**	30	55	50	90	14	12	20	1,9	HG-N 260 HG-N 315 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	QJ 310 QJ 312	Duro-NCES 250 Duro-NCES 315	ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R ROTA NCW 265/315 ROTA THWB 265 THW 315-R
GUA 400	**012487**	36	62	56	105	15	12	26	3,2	HG-N 400 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	QJ 15	Duro-NCES 400	ROTA THW 400 THW 400-R ROTA-G 400 ROTA THWB 315
GUA 500	**012488**	45	75	70	130	20	18	30	10,8	HG-N 500 HG-N 630 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800	HG 500 HG 630 KNCS 500 KNCS 630	QJ 21 QJ 24		ROTA THW 500/630/800 ROTA-G 500 THW 500/630-R ROTA THWB 400/500

Only jaws that are ground on the chuck under clamping condition guarantee hightest repeatability.



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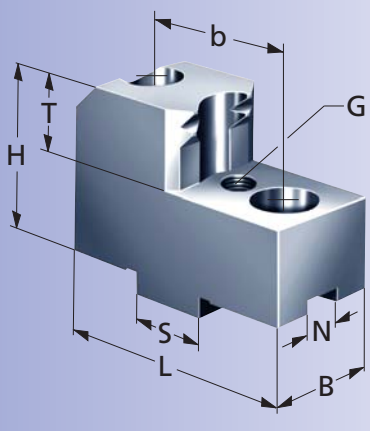
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hard roughing jaws

GGK for quick jaw change

tongue & groove

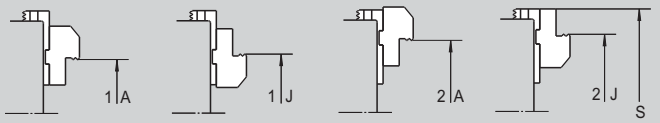
for SMW-AUTOBLOK chucks



Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	SMW-AUTOBLOK	*clamping ranges Ø external-A_1	*clamping ranges Ø internal-J_1	*clamping ranges Ø external-A_2	*clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	KNCS-N 140	28-53	125-162	-	-
GGK 1752	012465								68	1,0		36-56	128-168	-	-
GGK 1753	012466								60	1,0		55-81	101-135	-	-
GGK 1754	012467								56	0,9		80-105	75-109	-	-
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	KNCS-N 170	25-62	133-171	33-80	155-190
GGK 1753	012466								60	1,0	HG-N 160	32-61	134-172	42-79	153-181
GGK 1754	012467								56	0,9		52-89	107-145	70-107	125-163
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	KNCS-N 210	29-59	187-252	36-87	-
GGK 2002	012470								66	1,3	KNCS-NB 210	57-122	121-186	94-150	158-215
GGK 2003	012471								66	1,3	HG-N 210	93-149	85-140	131-187	122-178
GGK 2004	012472			15					85	1,7			62-100		72-137
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	KNCS-N 225	30-69	-	45-106	-
GGK 2002	012470								66	1,3		67-132	131-197	105-170	169-235
GGK 2003	012471								66	1,3		104-169	95-160	141-207	134-199
GGK 2004	012472			15					85	1,7		-	68-110	-	74-148
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS-N 260	45-85	197-274	61-148	254-342
GGK 2502	012474								72	2,3	KNCS-NB 260	78-154	132-208	141-218	195-272
GGK 2503	012475								78	2,6	HG-N 260	107-184	109-175	159-247	152-238
GGK 2504	012476								108	3,2		-	-	-	80-156
GGK 2501	012473	40	50	22	M6	12	20	40	94	3.0	KNCS-N 275	49-100	201-289	65-163	258-357
GGK 2502	012474								72	2.3		82-169	136-223	145-233	199-287
GGK 2503	012475								78	2.6		111-199	113-190	163-262	156-253
GGK 2504	012476								108	3.2		-	-	-	84-171
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS-N 315	34-100	210-300	-	300-370
GGK 2502	012474								72	2,3	KNCS-NB 315	90-175	-	170-262	-
GGK 2503	012475								78	2,6	HG-N 315	-	110-210	206-292	-
GGK 2505	012477			15					84	2,8		-	82-150	-	-
GGK 2501	012473	40	50	22	M6	12	20	40	94	3.0	KNCS-N 340	60-126	236-326	-	326-396
GGK 2502	012474								72	2.3		116-201	-	196-288	-
GGK 2503	012475								78	2.6		-	136-236	232-318	-
GGK 2504	012476								84	2.8		-	108-186	-	-
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	KNCS-N 400	78-188	258-378	143-263	333-453
GGK 4002	012479								91	3,5	KNCS-NB 400	-	140-263	258-378	-
GGK 4003	012480								147	3,6	HG-N 400	-	118-243	-	-
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KNCS-N 500	100-210	280-420	210-350	415-560
GGK 5002	012482								108	6,7	KNCS-NB 500	-	155-295	330-470	-
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2	HG-N 500	-	100-240	-	-
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KNCS-N 630	80-240	265-450	240-440	460-650
GGK 5002	012482								108	6,7	KNCS-NB 630	-	140-320	380-560	-
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2	HG-N 630	-	100-240	-	-

* clamping range valid for chuck KNCS-N and KNCS-NB

clamping range

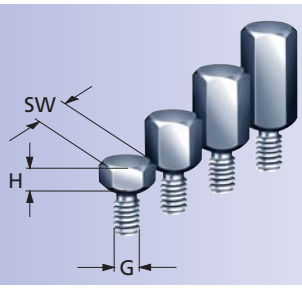


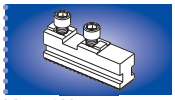
Base jaw position "**P**" Base jaw position "**O**"

stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	





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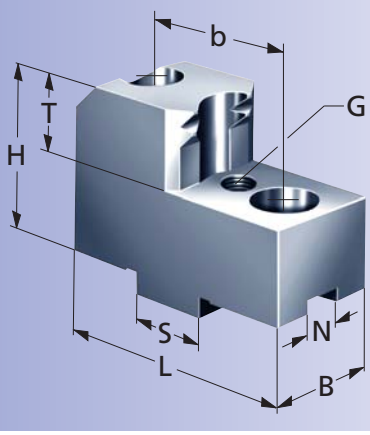
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hard roughing jaws

GGK for quick jaw change

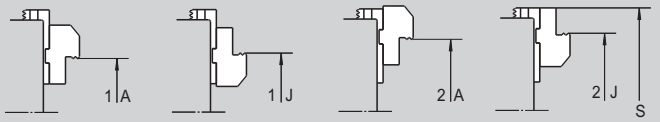
tongue & groove

for SMW chucks

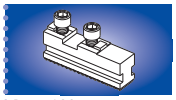


Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	SMW	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	KNCS 175	25-58			
GGK 1752	012465								68	1,0			138-168	38-72	
GGK 1753	012466								60	1,0			110-140	68-100	
GGK 1754	012467								56	0,9			80-112	96-130	
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	KNCS 200			35-78	
GGK 2002	012470								66	1,3	KNCS 210	60-100	125-165	95-135	160-200
GGK 2003	012471								66	1,3			88-130	130-172	
GGK 2004	012472			15					85	1,7					62-106
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS 250	40-64	190-250	64-128	252-310
GGK 2502	012474								72	2,3			120-190	128-195	
GGK 2503	012475								78	2,6			104-150	160-224	
GGK 2504	012476								108	3,2					75-125
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS 260	40-75	193-266	65-135	255-330
GGK 2502	012474								72	2,3			123-195	134-207	
GGK 2503	012475								78	2,6			102-174	163-237	
GGK 2504	012476								108	3,2					70-142
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS 315	49-95	202-288	95-180	288-370
GGK 2503	012475								78	2,6			102-202	180-280	
GGK 2505	012477			15					84	2,8			82-150		
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KNCS 315-91	45-110	210-200	110-200	300-370
GGK 2503	012475								78	2,6			110-210	200-290	
GGK 2505	012477			15					84	2,8			82-160		
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	KNCS 400	50-160	230-350	115-235	305-425
GGK 4002	012479								91	3,5			112-235	230-350	
GGK 4003	012480								147	3,6			90-215		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KNCS 500	80-190	260-400	170-310	375-520
GGK 5002	012482								108	6,7			135-275	290-430	
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2			100-220		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KNCS 630	80-240	265-450	240-440	460-650
GGK 5002	012482								108	6,7			140-320	380-560	
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2			100-220		

clamping range



Base jaw position "**P**" Base jaw position "**O**"



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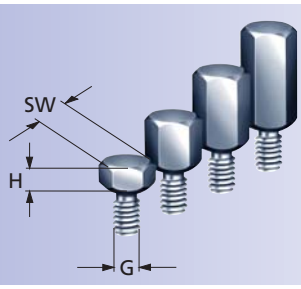


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stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	

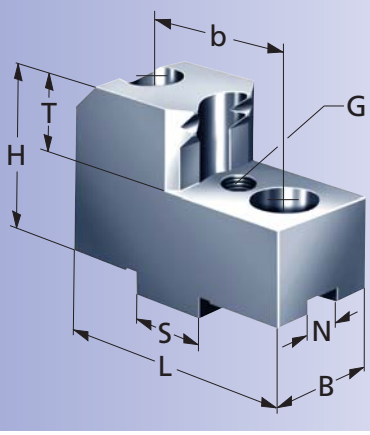


hard roughing jaws

GGK for quick jaw change

tongue & groove

for Schunk chucks



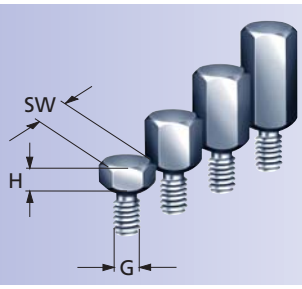
Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Schunk	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	ROTA THW 165	25-50	-	-	-
GGK 1752	012465								68	1,0	ROTA THW plus 165		133-160	38-67	
GGK 1753	012466								60	1,0	ROTA-G 160		105-134	66-95	
GGK 1754	012467								56	0,9	THW 165		78-106	95-125	
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	ROTA THW 210	30-55	185-230	45-94	-
GGK 2002	012470								66	1,3	ROTA THW plus 215	60-110	130-178	100-145	165-215
GGK 2003	012471								66	1,3	ROTA-G 200	100-150	90-135	140-185	130-175
GGK 2004	012472			15					85	1,7	THW 210-R ROTA THWB 210	-	55-84	-	70-120
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	ROTA-THW 250	35-70	200-265	65-138	265-330
GGK 2502	012474								72	2,3	ROTA THW plus 260	80-145	130-195	143-205	190-260
GGK 2503	012475								78	2,6	ROTA-G 250	110-175	100-165	174-237	165-230
GGK 2504	012476								108	3,2	THW 250/265-R ROTA NCW 265	-	-	-	80-145
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	ROTA THW 315	40-92	205-280	94-179	294-370
GGK 2502	012474								72	3,0	ROTA THW plus 315	85-161	135-210	170-249	219-300
GGK 2503	012475								78	2,6	ROTA-G 315	115-190	105-180	203-278	194-270
GGK 2505	012477			15					84	2,8	ROTA- NCW 315 THW 315-R	-	85-150	-	-
GGK 4001[1]	012478	50	55	25	M8	12	26	54	104	4,8	ROTA THW 400	50-162	230-350	118-240	305-430
GGK 4002[1]	012479								91	3,5	THW 400-R	162-283	110-230	240-360	190-308
GGK 4003[1]	012480								147	3,6	ROTA-G 400 ROTA THWB 315	-	100-220	-	-
GGK 5001[2]	012481	60	74	35	M8	18	30	60	125	8,8	ROTA THW 500	80-190	260-400	170-310	380-520
GGK 5002[2]	012482								108	6,7	ROTA-G 500	170-310	140-280	265-405	260-400
GGK 5003[2]	012483	50	63	25	M8	18	30	60	130	6,2	THW 500-R	-	100-210	-	
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	ROTA THW 630	80-230	260-445	220-430	430-640
GGK 5002	012482								108	6,7	THW 630-R	170-350	140-325	315-525	310-520
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2			100-250		

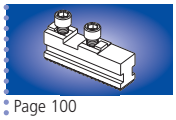
1) clamping range valid for chuck Ø 400
2) clamping range valid for chuck Ø 500

stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	




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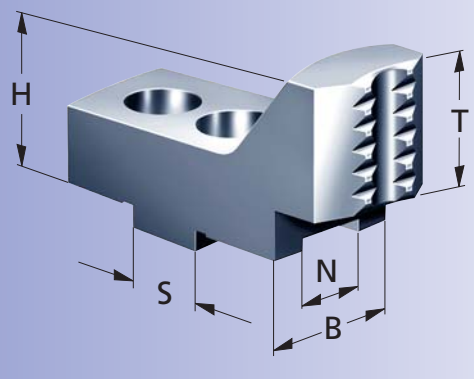


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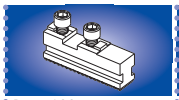
hard roughing jaws for bar work

GSK for quick jaw change

tongue & groove



Type	Id.-No.	clamping ranges Ø	B	H	T	N	S	kg/ set	SMW-AUTOBLOK	SMW	Forkardt	Kita-gawa	Röhm	Schunk
GSK 160	**091359**	12-40	20	40	30	8	18	0,8	HG-N 160 KNCS-N 170	RMG 160 HG 160 KNSP 160 KNCS 160 KNCS 175	F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJ 306	Duro-NCES 175	ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA NCW 185
GSK 200	**091360**	15-50	22	40	30	10	20	0,8	HG-N 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210	RMG 200 HG 200 KNSP 200 KNCS 200 KNCS 210	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 308	Duro-NCES 200	ROTA THW210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THWB 210 ROTA THW vario 215
GSK 250	**091361**	15-60	30	45	35	12	20	1,4	HG-N 260 HG-N 315 KNCS-N 260/275 KNCS-N 315/340 KNCS-NB 260 KNCS-NB 315 KNCS-NB 340	RMG 250 HG 250 HG 315 KNCS 250 KNCS 260 KNCS 315	F 250 UNC 250/315 KTNC 250 KTNCV 250 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 310 QJ 312	Duro-NCES 250 Duro-NCES 315	ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R ROTA NCW 265/315 ROTA THWB 265 THW 315-R
GSK 400	**091362**	30-90	35	50	40	12	26	2,2	HG-N 400 KNCS-N 400 KNCS-NB 400	RMG 315 HG 400 KNCS 400	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJ 15	Duro-NCES 400	ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA THWB 315


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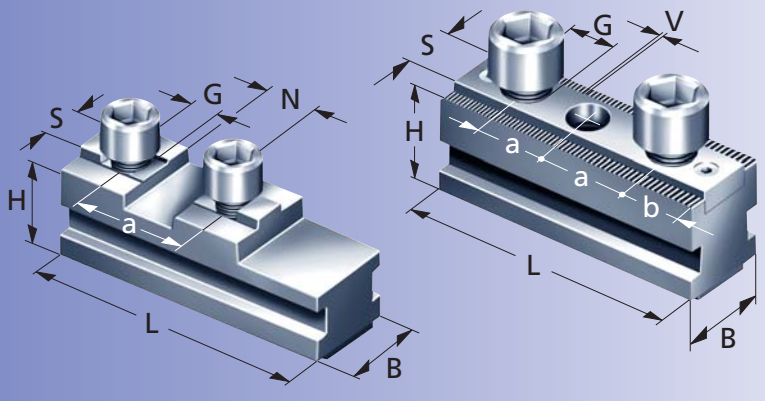


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hard base jaws
GBK-B
for quick jaw change

modular serration
System SMW/Reishauer

for KNCS-NB-chucks



GBK-B tongue & groove

Type	Id.-No.	B	H	L	N	S	G	a
GBK-B 210	138494	28	32	85	20	10	M8	40
GBK-B 260	039624	35	40	104	20	12	M12	40
GBK-B 315	039626	50	46	115	20	12	M12	40
GBK-B 400	039629	50	46	125	26	12	M12	54
GBK-B 500	035565	62	57	160	30	18	M16	60
GBK-B 630	035902	75	57	200	30	18	M16	60
GBK-B 800	064604	75	57	287	30	18	M16	60

GBK-BD INCH serration

Type	Id.-No.	B	H	L	V	S	G	a	b
GBK-BD 210	036292	28	32	85	1/16" x 90°	17	M12	2 x 23	11
GBK-BD 260	035704	35	40	104	1/16" x 90°	21	M16	1 x 30, 1 x 28	14
GBK-BD 315	036167	50	46	115	1/16" x 90°	21	M16	1 x 30, 1 x 28	14
GBK-BD 400	036293	50	46	125	3/32" x 90°	25,5	M20	2 x 38	17
GBK-BD 500	036294	62	61	160	3/32" x 90°	25,5	M20	2 x 38, 1 x 49	17
GBK-BD 630	036295	75	61	200	3/32" x 90°	25,5	M20	3 x 38, 1 x 52	18
GBK-BD 800	036296	75	61	287	3/32" x 90°	25,5	M20	5 x 38, 1 x 61	17,5

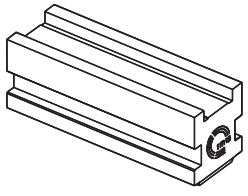
GBK-BA tongue & groove American Standard

Type	Id.-No.	B	H	L	N	S	G	a
GBK-BA 210	-	-	-	-	-	-	-	-
GBK-BA 260	-	-	-	-	-	-	-	-
GBK-BA 315	039628	50	45,8	120	19,02	12,7	5/8-11	63,5
GBK-BA 400	039631	50	45,8	146	19,02	12,7	3/4-10	76,2
GBK-BA 500	060561	62	57	168	19,02	12,7	3/4-10	76,2
GBK-BA 630	060562	75	57	203	19,02	12,7	3/4-10	76,2
GBK-BA 800	064590	75	57	287	19,02	12,7	3/4-10	76,2

GBK-BM METRIC serration

Type	Id.-No.	B	H	L	V	S	G	a	b
GBK-BM 210	035566	28	32	85	1,5 x 60°	14	M12	2 x 25	11
GBK-BM 260	035567	35	40	104	1,5 x 60°	16	M12	2 x 30	11
GBK-BM 315	035568	50	46	115	1,5 x 60°	21	M16	2 x 30	14
GBK-BM 400	035569	50	46	125	1,5 x 60°	22	M20	2 x 43	17
GBK-BM 500	035570	62	61	160	3 x 60°	25	M20	1 x 50 / 1 x 60	17
GBK-BM 630	035917	75	61	200	3 x 60°	25	M20	2 x 60	17
GBK-BM 800	036708	75	61	287	3 x 60°	25	M20	4 x 60	17

We can produce special master jaws from jaw blanks according to your request.

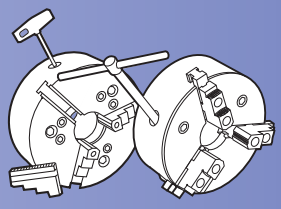


Notes

modular serration inclined
System Forkardt



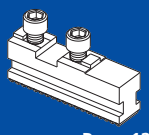
jaws for quick jaw change chucks



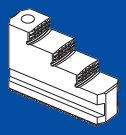
modular serration inclined System Forkardt

SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
HG-F	F, F+ KTNC KTNCV FNC	QJ	DURO DURO-NC DURO NCE	ROTA-S ROTA-S PLUS THW-F ROTA-NC WF

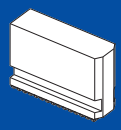
MFG hard base jaws


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FST hard stepped monoblock jaws

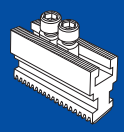

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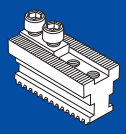
BFR monoblock jaws quenched


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KFR hard kombi base jaws with T-nuts

KLS hard kombi base jaws

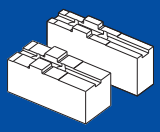

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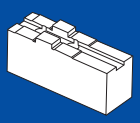

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WAK soft top jaws 16MnCr5 — standard

WAKS hard kombi base jaws 16MnCr5 — wide version

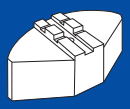
WAK-A alum. soft base jaws aluminium F50

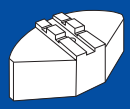

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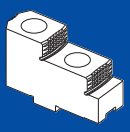
SBK soft pie jaws 16MnCr5

SBK-A alum. pie jaws aluminium F50

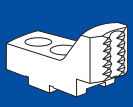

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GUA hard base jaws — reversible


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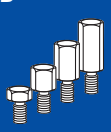
GSK hard bar roughing jaws


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GGK hard roughing jaws

ALB stop pins


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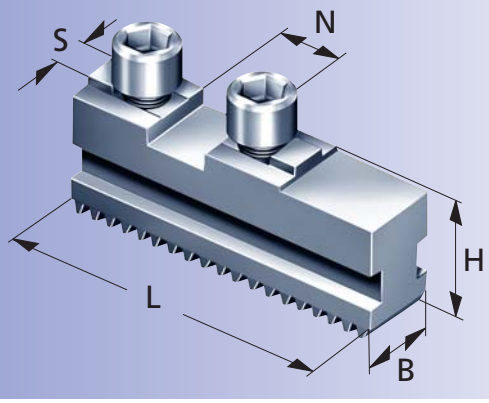
safety advise:
Top jaws are safety components, which can unter high load depending on their use.
Max grip forces and speeds must not be exceeded at any time.
For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

hard base jaws

MFG for quick jaw change

modular serration inclined
System Forkardt

incl. jaw mounting bolts DIN 912-12.9

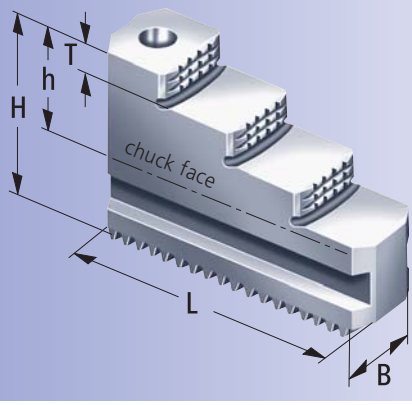


Type	Id.-No.	B	H	L	N	S	G x length	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
MFG 160	**081303**	20	29,5	74	18	8	M8 x 1 x 20	0,8	HG-F 160	F 160 F+160 KTNC 160 FNC 175 KTNCV 160/175		Duro 160 Duro-NC 160 Duro-NC 175 Duro-NCE 160	ROTA-S 160 ROTA-S PLUS 160
MFG 200	**081304**	22	35	90	20	10	M8 x 1 x 20	1,2	HG-F 210	F 200 F+200 KTNC 200 FNC 200 KTNCV 200	QJ 8" (QJ 210-43)	Duro 200 Duro-NC 200 Duro-NCE 200 Duro-NC 225	ROTA-S 200 THW 210 F ROTA-S PLUS 200 ROTA NC-WF 210
MFG 250	**081305**	26	40	110	20	12	M12 x 1,5 x 30	2,0	HG-F 260	F 250 F+250 UNC 250/315 FNC 250/315 KTNC 250/280/315 KTNCV 250/315	QJ 10/12" (QJ 254-65) (QJ 315-78)*	Duro 250 Duro-NC 250 Duro-NCE 250/315	ROTA-S 250 THW 250 F THW 265 F ROTA NC-WF 250 ROTA NC-WF 315 ROTA-S PLUS 250
MFG 315	**081306**	32	46	125	26	12	M12 x 1,5 x 35	3,3	HG-F 315	F 315 F+315 UNC 400 FNC 400 KTNC 360/400 KTNCV 400		Duro 315 Duro-NC 315 Duro-NCE 400	ROTA-S 315 THW 315 F THW 400 F ROTA-S PLUS 315
MFG 400	**081307**	45	55	160	30	18	M16 x 1,5 x 40	7,3	HG-F 400 HG-F 500	F 400/500-L F+400/500 UNC 500 KTNC 500/630 FNC 500/630 KTNCV 500/630		Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S 400 ROTA-S 500 THW 500 F ROTA-S PLUS 400 ROTA-S PLUS 500
MFG 630	**034266**	65	58	230	40	24	M20 x 45	16,2	HG-F 630	F 630 F+630		Duro 630 Duro-NC 630	ROTA-S 630 ROTA-S plus 630

hard stepped monoblock jaws

FST for quick jaw change

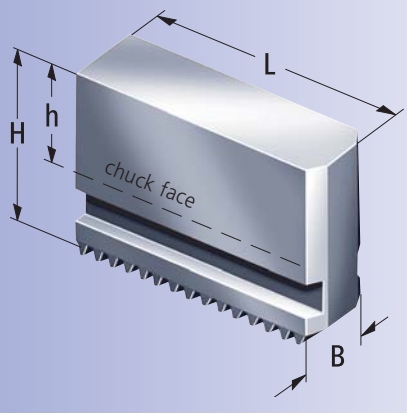
modular serration inclined
System Forkardt



Type	Id.-No.	B	H	h	L	T	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
FST 160	**081282**	20	45	24	79	7,5	1,1	HG-F 160	F 160 F+160 KTNC 160 FNC 175 KTNCV 160/175		Duro 160 Duro-NC 160/175 Duro-NCE 160	ROTA-S 160 ROTA-S PLUS 160
FST 200	**081283**	22	60	35	94	10	1,9	HG-F 210	F 200 F+200 KTNC 200 FNC 200 KTNCV 200	QJ 8" (QJ 210-43)	Duro 200 Duro-NC 200/225 Duro-NCE 200	ROTA-S 200 THW 210 F ROTA-S PLUS 200 ROTA NC-WF 210
FST 250	**081284**	26	70	40	114	14	3,3	HG-F 260	F 250 UNC250/315 F+250 FNC 250/ 315 KTNC 250/280/315 KTNCV 250/315	QJ 10/12" (QJ 254-65) (QJ 315-78)	Duro 250 Duro-NC 250 Duro-NCE 250/315	ROTA-S 250 THW 250/265 F ROTA NC-WF 250/315 ROTA-S PLUS 250
FST 315	**081285**	32	79	46	130	15	5,2	HG-F 315	F 315 F+315 UNC 400 FNC 400 KTNC 360/400 KTNCV 400		Duro 315 Duro-NC 315 Duro-NCE 300	ROTA-S 315 THW 315 F THW 400 F ROTA-S PLUS 315
FST 400	**081286**	45	93	53	167	20	10,8	HG-F 400 HG-F 500	F 400/500-L F+400/500 UNC 500 KTNC 500/630 FNC 500/630 KTNCV 500/630		Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S 400/500 THW 500 F ROTA-S PLUS 400 ROTA-S PLUS 500

soft monoblock jaws

BFR for quick jaw change



modular serration inclined System Forkardt

Material: C45, serration and guide ways are induction hardened and ground

Type	Id.-No.	B	H	h	L	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
BFR 160	**081272**	20	45	24	79	1,4	HG-F 160	F 160 F+160 KTNC 160 KTNCV 160 FNC 175 KTNCV 175		Duro 160 DURO-NC 160 Duro-NC 175 Duro-NCE 160	ROTA-S 160 ROTA-S plus 160
BFR 200	**081273**	22	60	35	94	2,6	HG-F 210	F 200 F+200 FNC 200 KTNC 200 KTNCV 200	QJ 8" (QJ 210-43)	Duro 200 Duro-NC 200 Duro-NCE 200 Duro-NC 225	ROTA-S 200 ROTA-S plus 200 ROTA NC-WF 210 THW 210-F
BFR 250	**081274**	26	70	40	115	4,4	HG-F 260	F 250 F+250 FNC 250 KTNC 250 KTNCV 250 UNC 250 KTNC 280 FNC 315 KTNC 315 KTNCV 315 UNC 315	QJ 10/12" (QJ 254-65) (QJ 315-78)	Duro 250 Duro-NC 250 Duro-NCE 250/315	ROTA-S 250 ROTA-S plus 250 ROTA NC-WF 250 ROTA NC-WF 315 THW 250 F THW 265 F
BFR 315	**081275**	32	81	46	140	7,3	HG-F 315	F 315 F+315 KTNC 360 FNC 400 KTNC 400 KTNCV 400 UNC 400		Duro 315 Duro-NC 315 Duro-NCE 400	ROTA-S 315 ROTA-S plus 315 THW 315 F THW 400 F
BFR 400	**081276**	45	93	53	176	15,7	HG-F 400 HG-F 500	F 400 F+400 F 500 L F+500 L FNC 500 KTNC 500 KTNCV 500 UNC 500 FNC 630 KTNC 630 KTNCV 630		Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S 400 ROTA-S plus 400 ROTA-S 500 ROTA-S plus 500 THW 500 F

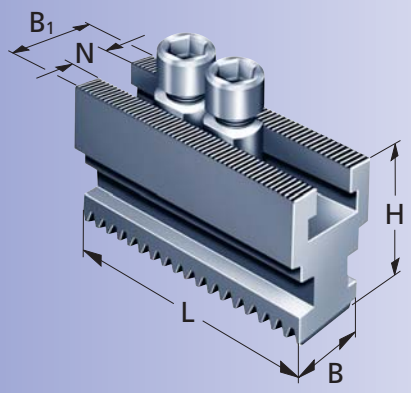
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kombi base jaws

KFR for quick jaw change

modular serration inclined System Forkardt
INCH serration

incl. T-nuts and
screw DIN 912-12.9



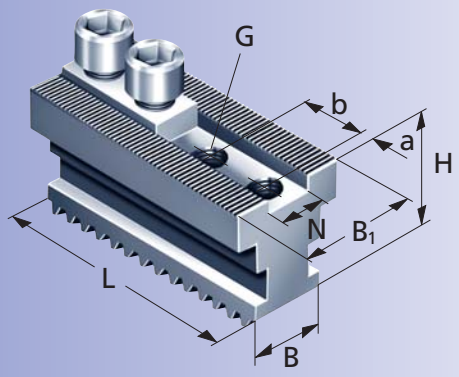
Type	Id.-No.	B	B_1	H	L	N	serration	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
KFR 200-1	**236528**	22	45	61	80	17	1/16" x 90°	3,4	HG-F 210	F 200 F+200 KTNC 200 FNC 200 KTNCV 200	QJ 8" (QJ 210-43)	Duro 200 Duro-NC 200 Duro-NCE 200 Duro-NC 225	ROTA-S 200 THW 210 F ROTA-S PLUS 200 ROTA NC-WF 210
KFR 250-1	**081330**	26	45	65	110	17	1/16" x 90°	5,0	HG-F 260	F 250 UNC250/315 F+250 FNC 250/315 KTNC 250/280/315 KTNCV 250/315	QJ 10/12" (QJ 254-65) (QJ 315-78)	Duro 250 Duro-NC 250 Duro-NCE 250/315	ROTA-S 250 THW 250 F ROTA-S PLUS 250 ROTA NC-WF 250/315 THW 265 F
KFR 250-2	**081331**	26	54	70	110	21	1/16" x 90°	5,3					
KFR 315-2	**081333**	32	54	75	125	21	1/16" x 90°	7,7	HG-F 315	F 315 UNC 400 F+315 FNC 400 KTNC 360/400 KTNCV 400		Duro 315 Duro-NC 315 Duro-NCE 400	ROTA-S 315 THW 315 F THW 400 F ROTA-S PLUS 315
KFR 400-1	**236529**	45	54	80	160	21	1/16" x 90°	12	HG-F 400	F 400/500 L UNC 500 F+400/500 KTNC 500/630 FNC 500/630 KTNCV 500/630		Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S 400/500 THW 500 F ROTA-S PLUS 400/500
KFR 400-2	**081335**	45	64	82	160	25,5	3/32" x 90°	13,7	HG-F 500				

kombi base jaws

KLS for quick jaw change

modular serration inclined System Forkardt
INCH serration

incl. jaw mounting bolts DIN 912-12.9 and guide rail

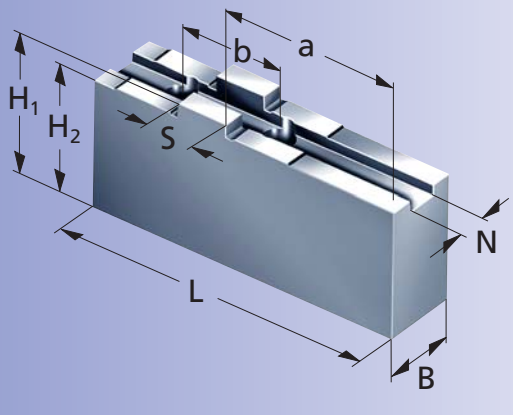


Type	Id.-No.	B	B_1	H	L	N	serration	G	a	b*	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
KLS 250-2	**081318**	26	45	50	110	21	1/16" x 90°	M16	13	28	4,2	HG-F 260	F 250 F+250 UNC 250/315 FNC 250/315 KTNC 250/280/315 KTNCV 250/315	QJ 10/12" (QJ 254-65) (QJ 315-78)	Duro 250 Duro-NC 250 Duro-NCE 250/315	ROTA-S 250 THW 250/265-F ROTA-S PLUS 250 ROTA NC-W 250 ROTA NC-W 315
KLS 315-2	**081320**	32	45	55	110	21	1/16" x 90°	M16	13	28	4,5	HG-F 315	F 315 F+315 UNC 400 FNC 400 KTNC 360/400 KTNCV 400		Duro 315 Duro-NC 315 Duro-NCE 400	ROTA-S 315 THW 315 F THW 400 F ROTA-S PLUS 315

b* = 3 times (= 4 tapped holes)

soft top jaws

WAK for quick jaw change



tongue & groove

Material: 16MnCr5

Type	Id.-No.	B	H1	H2	L	N	S	a	b	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
WAK 125-10	**016633**	20	30	27,5	55	14 (Slot)	5 (Slot)	25	20	0,6		F 125 F+125		Duro 125	
WAK 140-10	**012490**	20	40	35,5	69	8	18	26	32	0,9				Duro-NC 140 Duro-NC 168	
WAK 160-10	**012491**	20	40	35,5	85	8	18	42	32	1,2	HG-F 160	F 160 FNC 175 KTNC 160 KTNCV 160 F+160		Duro 160 Duro-NC 160 Duro-NC 175 Duro-NCE 160	ROTA-S 160 ROTA-S PLUS 160
WAK 200-10	**012492**	22	46	42	105	10	20	50	40	2,0	HG-F 210	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 8" (QJ 210-43)	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200	ROTA-S 200 THW 210-F ROTA-S PLUS 200 ROTA-NC-WF 210
WAK 250-10	**012493**	30	55	50	125	12	20	70	40	3,6	HG-F 260	F 250 UNC 250/315 KTNC 250 KTNCV 250 KTNC 265 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 10" (QJ 254-65) QJ 12" (QJ 315-78)	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315	ROTA-S 250 THW 250-F THW 265-F ROTA NC-WF 250 ROTA-S PLUS 250 ROTA-NC-WF 315
WAK 400-10	**012494**	35	60	54	145	12	26	74	54	5,8	HG-F 315	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315		Duro 315 Duro-NC 315 Duro-NCE 400	ROTA-S 315 THW 315 F THW 400-F ROTA-S PLUS 315
WAK 500-10	**012495**	50	80	73	180	18	30	100	60	13,7	HG-F 400 HG-F 500	F 400/500 L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400 F+500L		Duro 400 Duro-NC 400 Duro 500 Duro-NC 500 Duro-NCE 500	ROTA-S 400 ROTA-S 500 THW 500-F ROTA-S PLUS 400 ROTA-S PLUS 500
WAK 630-10	**080930**	60	120	112	260	24	40	149	82	28,5	HG-F 630	F 630 F+630		Duro 630 Duro-NC 630	ROTA-S 630 ROTA-S PLUS 630

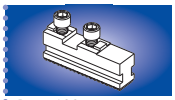
Other dimensions on request.
Use the data sheet on page 82 for ordering.



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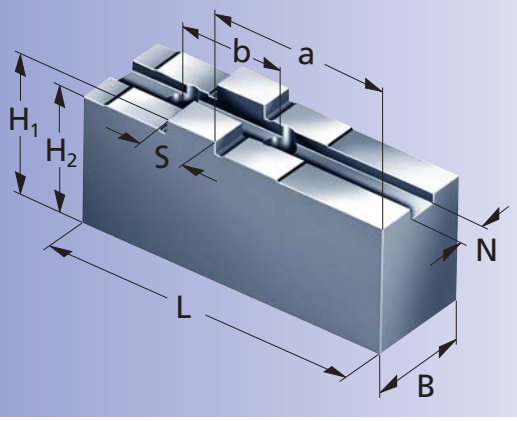

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soft top jaws wide version

WAKS for quick jaw change

tongue & groove

Material: 16MnCr5



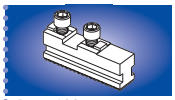
Type	Id.-No.	B	H1	H2	L	N	S	a	b	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
WAKS 140-10	**012496**	35	40	35,5	63	8	18	25	32	1,5				Duro-NC 140 Duro-NC 168	
WAKS 160-10	**080931**	25	50	45,5	85	8	18	42	32	1,8	HG-F 160	F 160		Duro 160	ROTA-S 160
WAKS 160-20	**080932**	30	55	50,5	85			48	32	2,2		KTNC 160		Duro-NC 160	ROTA-S PLUS 160
WAKS 160-30	**080933**	40	80	75,5	70			26	32	3,4		KTNCV 160 KTNCV 175 FNC 175 F+160		Duro-NC 175 Duro-NCE 160	
WAKS 200-10	**080934**	30	55	51	100	10	20	57	40	2,9	HG-F 210	F 200	QJ 8"	Duro 200	ROTA-S 200
WAKS 200-20	**080935**	30	70	66	100			45	40	3,4		KTNC 200	(QJ 210-43)	Duro-NC 200	THW 210-F
WAKS 200-30	**012497**	40	40	36	70			27	40	1,9		KTNCV 200		Duro-NC 225	ROTA-S PLUS 200
WAKS 200-31	**080936**	40	60	56	90			43	40	3,9		FNC 200		Duro-NCE 200	ROTA-NC-WF 210
WAKS 200-32	**036733**	40	80	76	95			52	40	5,8		F+200			
WAKS 250-10	**080937**	40	60	55	125	12	20	70	40	5,7	HG-F 260	F 250	QJ 10"	Duro 250	ROTA-S 250
WAKS 250-11	**080938**	40	80	75	125			70	40	7,5		UNC 250/315	(QJ 254-65)	Duro-NC 250	THW 250-F
WAKS 250-12	**080939**	40	100	95	125			70	40	9,6		KTNC 250	QJ 12"	Duro-NCE 250	THW 265-F
WAKS 250-13	**080940**	40	120	115	125			70	40	11,5		KTNCV 250	(QJ 315-78)	Duro-NCE 315	ROTA NC-WF 250
WAKS 250-20	**012498**	60	60	55	90			44	40	6,2		KTNC 265			ROTA-S PLUS 250
WAKS 250-21	**080942**	60	60	55	110			60	40	7,6		KTNC 280			ROTA-NC-WF 315
WAKS 250-22	**080943**	60	80	75	90			44	40	9,4		KTNC 315			
WAKS 250-23	**080944**	60	80	75	110			60	40	11,5		KTNCV 315			
WAKS 250-30	**012499**	80	60	55	90			44	40	8,5		FNC 250			
WAKS 250-31	**080945**	80	80	75	110			60	40	14,1		FNC 315 F+250			
WAKS 400-10	**080946**	40	60	54	110	12	26	54	54	4,9	HG-F 315	F 315		Duro 315	ROTA-S 315
WAKS 400-11	**080947**	40	60	54	145			89	54	6,7		UNC 400		Duro-NC 315	THW 315 F
WAKS 400-12	**080948**	40	100	94	145			89	54	11,1		KTNC 360		Duro-NCE 400	THW 400-F
WAKS 400-13	**080949**	40	120	114	145			89	54	13,5		KTNC 400			ROTA-S PLUS 315
WAKS 400-14	**080950**	40	150	146	145			89	54	16,9		KTNCV 400			
WAKS 400-20	**080951**	60	60	54	110			54	54	7,6		FNC 400			
WAKS 400-21	**080952**	60	80	74	110			54	54	10,3		F+315			
WAKS 400-22	**080953**	60	100	94	110			54	54	14,1					
WAKS 400-30	**012500**	80	70	64	100			44	54	11,0					
WAKS 500-10	**080954**	60	80	73	155	18	30	90	60	13,8	HG-F 400	F 400/500 L		Duro 400	ROTA-S 400
WAKS 500-12	**080956**	60	120	113	155			90	60	19,5	HG-F 500	UNC 500		Duro-NC 400	ROTA-S 500
WAKS 500-20	**080957**	80	80	73	155			90	60	15,5		KTNC 500/630		Duro 500	THW 500-F
WAKS 500-21	**080958**	80	100	93	155			90	60	26,3		KTNCV 500/630		Duro-NC 500	ROTA-S PLUS 400
WAKS 500-30	**012501**	90	80	73	130			65	60	16,4		FNC 500/630		Duro-NCE 500	ROTA-S PLUS 500
WAKS 500-31	**012502**	100	80	73	150			85	60	20,0		F+400/500			



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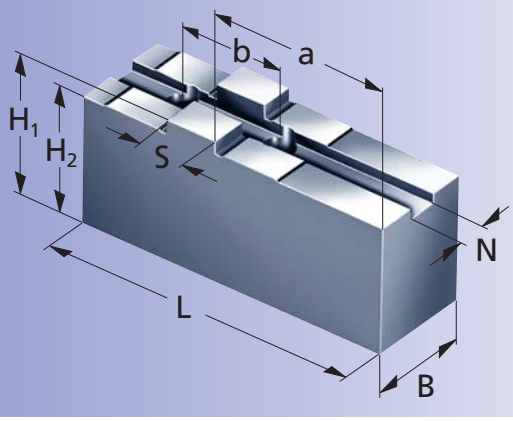

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soft top jaws alum. light version

WAK-A for quick jaw change

tongue & groove

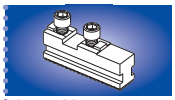
Material: aluminium (tensile strength ca. 500 N/mm²)



Type	Id.-No.	B	H1	H2	L	N	S	a	b	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
WAK-A 160	**080959**	25	50	45,5	85	8	18	42	32	0,7	HG-F 160	F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160		Duro 160 Duro-NC 160 Duro-NC 175 Duro-NCE 160	ROTA-S 160 ROTA-S PLUS 160
WAK-A 200	**080960**	25	50	46	105	10	20	50	40	0,9	HG-F 210	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 8" (QJ 210-43)	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200	ROTA-S 200 THW 210-F ROTA-S PLUS 200 ROTA NC-WF 210
WAK-A 210	**035222**	40	60	56	90	10	20	43	40	1,65					
WAK-A 250	**080961**	40	60	55	125	12	20	70	40	2,0	HG-F 260	F 250 UNC 250/315 KTNC 250 KTNCV 250 KTNC 265 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 10" (QJ 254-65) QJ 12" (QJ 315-78)	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315	ROTA-S 250 THW 250-F THW 265-F ROTA NC-WF 250 ROTA-S PLUS 250 ROTA NC-WF 315
WAK-A 400	**080962**	40	60	54	145	12	26	74	54	2,4	HG-F 315	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315		Duro 315 Duro-NC 315 Duro-NCE 400	ROTA-S 315 THW 315-F THW 400-F ROTA-S PLUS 315
WAK-A 500	**035142**	50	80	73	180	18	30	100	60	5,1	HG-F 400 HG-F 500	F 400/500 L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400/500		Duro 400 Duro-NC 400 Duro 500 Duro-NC 500 Duro-NCE 500	ROTA-S 400 ROTA-S 500 THW 500-F ROTA-S PLUS 400 ROTA-S PLUS 500



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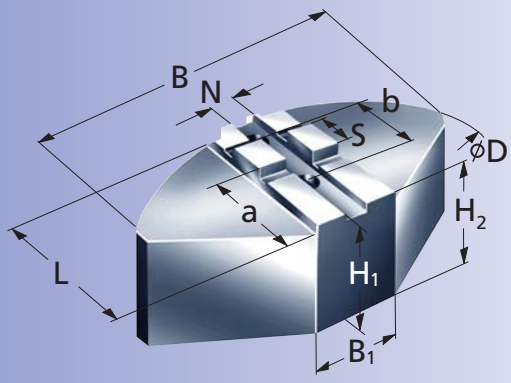
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soft pie jaws

SBK for quick jaw change

tongue & groove

Material: 16MnCr5



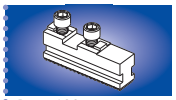
Type	Id.-No.	B	B1	H1	H2	L	N	S	a	b	D	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
SBK 160	**080963**	120	40	50	46	60	8	18	23	32	160	4,5	HG-F 160	F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160		Duro 160 Duro-NC 160 Duro-NC 175 Duro-NCE 160	ROTA-S 160 ROTA-S PLUS 160
SBK 200	**080964**	140	65	60	56	70	10	20	27	40	200	8,4	HG-F 210	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 8" (QJ 210-43)	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200	ROTA-S 200 THW 210-F ROTA-S PLUS 200 ROTA NC-WF 210
SBK 250	**080965**	180	70	60	55	90	12	20	44	40	250	11,2	HG-F 260	F 250 UNC 250/315 KTNC 250 KTNCV 250 KTNC 265 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 10" (QJ 254-65) QJ 12" (QJ 315-78)	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315	ROTA-S 250 THW 250-F THW 265-F ROTA NC-WF 250 ROTA-S PLUS 250 ROTA NC-WF 315
SBK 400	**080966**	240	120	75	69	110	12	26	54	54	320	25,2	HG-F 315	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315		Duro 315 Duro-NC 315 Duro-NCE 400	ROTA-S 315 THW 315-F THW 400-F ROTA-S PLUS 315



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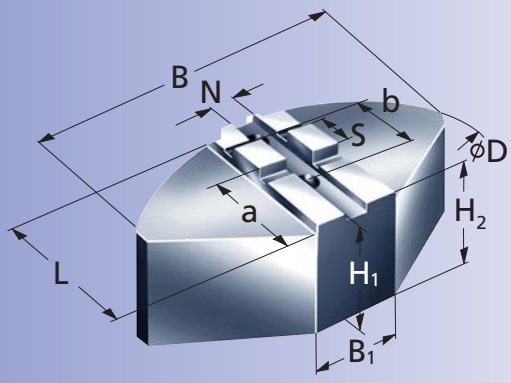

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soft pie jaws alum. light version

SBK-A for quick jaw change

tongue & groove

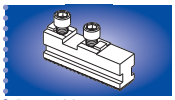
Material: aluminium (tensile strength ca. 500 N/mm²)



Type	Id.-No.	B	B1	H1	H2	L	N	S	a	b	D	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
SBK-A 160	**080967**	120	40	50	46	60	8	18	23	32	160	1,6	HG-F 160	F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160		Duro 160 Duro-NC 160 Duro-NC 175 Duro-NCE 160	ROTA-S 160 ROTA-S PLUS 160
SBK-A 200	**080968**	140	55	60	56	75	10	20	27	40	200	3,1	HG-F 210	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 8" (QJ 210-43)	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200	ROTA-S 200 THW 210-F ROTA-S PLUS 200 ROTA NC-WF 210
SBK-A 250	**080969**	180	70	60	55	90	12	20	44	40	250	4,3	HG-F 260	F 250 UNC 250/315 KTNC 250 KTNCV 250 KTNC 265 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 10" (QJ 254-65) QJ 12" (QJ 315-78)	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315	ROTA-S 250 THW 250-F THW 265-F ROTA NC-WF 250 ROTA-S PLUS 250 ROTA NC-WF 315
SBK-A 400	**080970**	240	120	75	69	110	12	26	54	54	320	9,3	HG-F 315	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315		Duro 315 Duro-NC 315 Duro-NCE 400	ROTA-S 315 THW 315-F THW 400-F ROTA-S PLUS 315
SBK-A 500	**085193**	330	150	90	83	160	18	30	95	60	440	21,4	HG-F 400 HG-F 500	F 400/500 L UNC 500 KTNC 500/630 KTNCV 500 KTNCV 630 FNC 500 FNC 630 F+400/500		Duro 400 Duro-NC 400 Duro 500 Duro-NC 500 Duro-NCE 500	ROTA-S 400 ROTA-S 500 THW 500-F ROTA-S PLUS 400 ROTA-S PLUS 500



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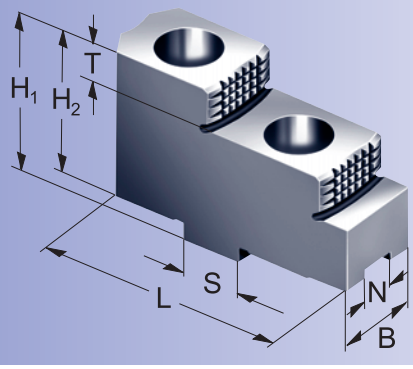

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hard, reversible top jaws

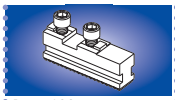
GUA for quick jaw change

tongue & groove



Type	Id.-No.	B	H_1	H_2	L	T	N	S	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
GUA 160	**012484**	20	36,5	32,5	63	7,5	8	18	0,6	HG-F 160	F 160 KTNC 160 KTNCV 160/175 FNC 175 F+160		Duro 160 Duro-NC 160 Duro-NC 175 Duro-NCE 160	ROTA-S 160 ROTA-S PLUS 160
GUA 200	**012485**	22	42	38	75	10	10	20	0,8	HG-F 210	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 8" (QJ 210-43)	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200	ROTA-S 200 THW 210-F ROTA-S PLUS 200 ROTA-NC-WF 210
GUA 250	**012486**	30	55	50	90	14	12	20	1,9	HG-F 260	F 250 UNC 250/315 KTNC 250 KTNCV 250 KTNC 265 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 10" (QJ 254-65) QJ 12" (QJ 315-78)	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315	ROTA-S 250 THW 250-F THW 265-F ROTA NC-WF 250 ROTA-S PLUS 250 ROTA-NC-WF 315
GUA 400	**012487**	36	62	56	105	15	12	26	3,2	HG-F 315	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315		Duro 315 Duro-NC 315 Duro-NCE 400	ROTA-S 315 THW 400-F ROTA-S PLUS 315 THW 315-F
GUA 500	**012488**	45	75	70	130	20	18	30	10,8	HG-F 400 HG-F 500	F 400/500 L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400/500		Duro 400 Duro-NC 400 Duro 500 Duro-NC 500 Duro-NCE 500	ROTA-S 400 ROTA-S 500 THW 500-F ROTA-S PLUS 400 ROTA-S PLUS 500
GUA 631	**035959**	65	89	97	185	30	24	40	15	HG-F 630	F 630 F+630		Duro 630 Duro-NC 630	ROTA-S 630 ROTA-S PLUS 630

Only jaws that are ground on the chuck under clamping condition guarantee hightest repeatability.


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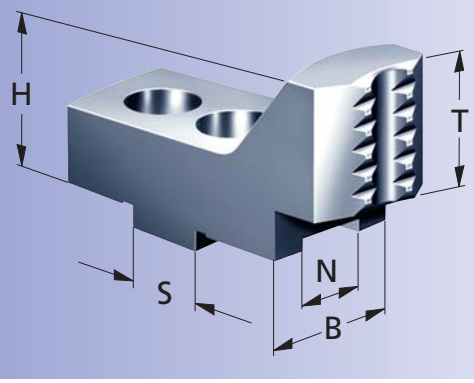


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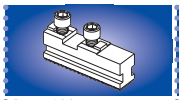
hard roughing jaws for bar work

GSK for quick jaw change

tongue & groove



Type	Id.-No.	clamping ranges Ø	B	H	T	N	S	kg/ set	SMW-AUTOBLOK	Forkardt	Kitagawa	Röhm	Schunk
GSK 160	**091359**	12-40	20	40	30	8	18	0,8	HG-F 160	F 160 FNC 175 KTNC 160 KTNCV 160 KTNCV 175 F+160		Duro 160 Duro-NC 160 Duro-NC 175 Duro-NCE 160	ROTA-S 160 ROTA-S PLUS 160
GSK 200	**091360**	15-50	22	40	30	10	20	0,8	HG-F 210	F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJ 8″ (QJ 210-43)	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200	ROTA-S 200 THW 210-F ROTA-S PLUS 200 ROTA-NC-WF 210
GSK 250	**091361**	15-60	30	45	35	12	20	1,4	HG-F 260	F 250 UNC 250/315 KTNC 250 KTNCV 250 KTNC 265 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJ 10″ (QJ 254-65) QJ 12″ (QJ 315-78)	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315	ROTA-S 250 THW 250-F THW 265-F ROTA NC-WF 250 ROTA-S PLUS 250 ROTA-NC-WF 315
GSK 400	**091362**	30-90	35	50	40	12	26	2,2	HG-F 315	F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315		Duro 315 Duro-NC 315 Duro-NCE 400	ROTA-S 315 THW 315 F THW 400-F ROTA-S PLUS 315



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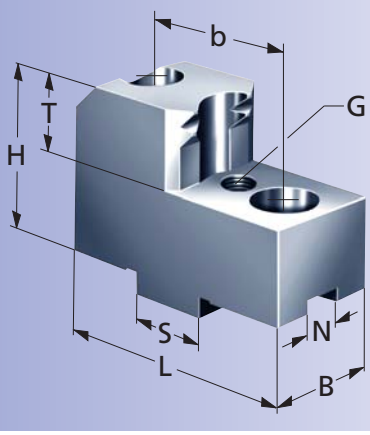
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hard roughing jaws

GGK for quick jaw change

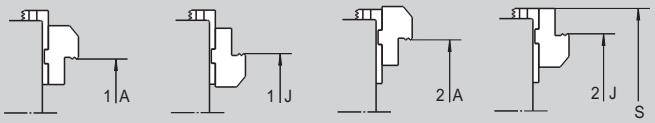
tongue & groove

for SMW-AUTOBLOK-chucks



Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	SMW-AUTOBLOK	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	**012464**	25	40	16	M5	8	18	32	64	0,9	**HG-F 160**	25-60	132-170	40-78	150-188
GGK 1753	**012466**								60	1,0		50-88	105-142	68-106	122-160
GGK 1754	**012467**								56	0,9		75-113	79-117	93-131	97-135
GGK 2001	**012469**	28	45	20	M5	10	20	40	87	1,9	**HG-F 210**	29-56	186-240	37-94	224-280
GGK 2002	**012470**								66	1,3		60-117	125-182	89-155	163-220
GGK 2003	**012471**								66	1,3		97-153	88-145	135-191	126-183
GGK 2004	**012472**			15					85	1,7		-	54-86	-	68-124
GGK 2501	**012473**	40	50	22	M6	12	20	40	94	3,0	**HG-F 260**	35-66	192-258	64-130	256-322
GGK 2502	**012474**								72	2,3		70-136	122-188	134-200	186-252
GGK 2503	**012475**								78	2,6		100-166	92-158	164-230	156-222
GGK 2504	**012476**								108	3,2		-	-	-	70-134
GGK 4001	**012478**	50	55	25	M8	12	26	54	104	4,8	**HG-F 315**	60-102	200-280	88-182	280-375
GGK 4002	**012479**								91	3,5		124-218	84-178	204-298	164-258
GGK 4003	**012480**								147	3,6		-	70-160	-	-
GGK 5001	**012481**	60	74	35	M8	18	30	60	125	8,8	**HG-F 400**	60-160	240-375	145-280	350-490
GGK 5002	**012482**								108	6,7		150-280	120-260	265-400	240-370
GGK 5003	**012483**	50	63	25	M8	18	30	60	130	6,2		-	100-180	-	-

clamping range

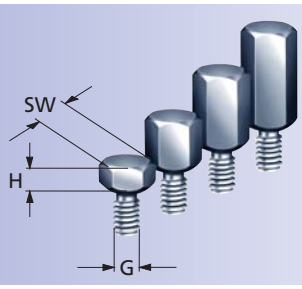


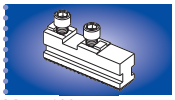
Base jaw position "**P**" Base jaw position "**O**"

stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	**016510**	M5	5	10
ALB 510	**016508**		10	
ALB 515	**016509**		15	
ALB 605	**016513**	M6	5	10
ALB 610	**016511**		10	
ALB 615	**016512**		15	
ALB 620	**017602**		20	
ALB 805	**017603**	M8	5	13
ALB 810	**016514**		10	
ALB 815	**016515**		15	
ALB 820	**016516**		20	
ALB 825	**081191**		25	





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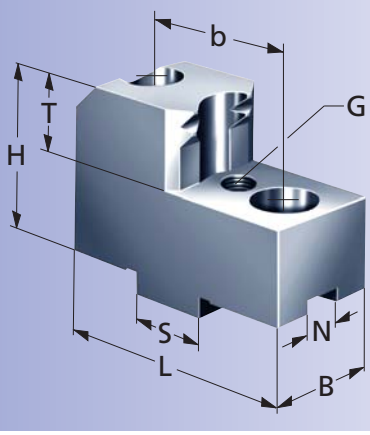
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hard roughing jaws

GGK for quick jaw change

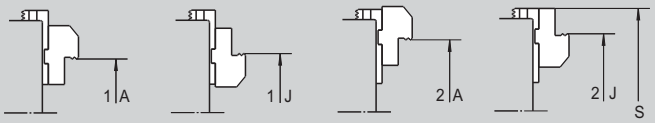
tongue & groove

for Forkardt-chucks

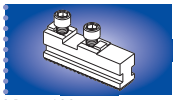


Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Forkardt	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	3 KTNC 160	25-38			
GGK 1752	012465								68	1,0	KTNCV 160		135-150	45-72	
GGK 1753	012466								60	1,0	F 160		105-122	72-102	
GGK 1754	012467								56	0,9	F+160		78-94	102-128	
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	3 KTNC 200			38-65	
GGK 2002	012470								66	1,3	F 200	52-78	120-140	95-125	160-190
GGK 2003	012471								66	1,3	F+200		82-105	130-160	
GGK 2004	012472			15					85	1,7					65-95
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	3 KTNC 250		180-216	72-102	262-290
GGK 2502	012474								72	2,3	F 250		120-150	140-172	
GGK 2503	012475								78	2,6	F+250		104-120	170-202	
GGK 2504	012476								108	3,2					80-108
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	3 KTNC 280	38-52	190-242	74-128	262-310
GGK 2502	012474								78	2,6			120-174	142-195	
GGK 2505	012477			15					84	2,8					78-130
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	3 KTNC 360	50-110	220-300	105-190	295-380
GGK 4002	012479								91	3,5	F 315	140-225	110-185	220-305	
GGK 4003	012480								147	3,6	F+315		90-215		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	3 KTNC 500	70-190	245-400	150-310	370-520
GGK 5002	012482								108	6,7	F+400	150-310	130-275	280-430	244-400
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2	F 500 L		110-220		
											F+500 L				
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	3 KTNC 630	70-300	225-510	150-420	360-630
GGK 5002	012482								108	6,7		150-430	140-390	270-550	244-520
GGK 5003	012483	50	63	25					130	6,2			100-220		

clamping range



Base jaw position "**P**" Base jaw position "**O**"



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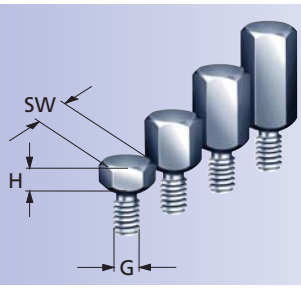


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stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	

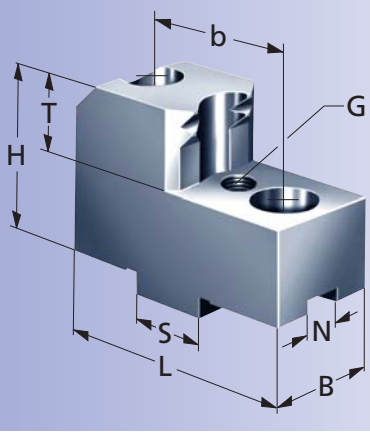


hard roughing jaws

GGK for quick jaw change

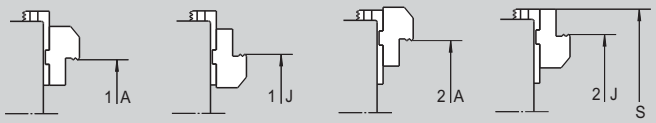
tongue & groove

for Forkardt-chucks



Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Forkardt	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	KTNCV 175	30-80			
GGK 1752	012465								68	1,0	FNC 175		126-190	48-110	160-220
GGK 1753	012466								60	1,0				80-140	142-202
GGK 1754	012467								56	0,9			84-148	104-166	118-180
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	KTNCV 200	44-106			
GGK 2002	012470								66	1,3	FNC 200	58-120	120-180	100-162	172-234
GGK 2003	012471								66	1,3		96-158	90-152	142-204	136-198
GGK 2004	012472			15					85	1,7			55-95		65-95
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KTNCV 250	40-90	200-285	80-170	272-360
GGK 2502	012474								72	2,3	FNC 250	75-163	128-216	150-238	220-308
GGK 2503	012475								78	2,6		95-183	102-190	172-260	172-260
GGK 2504	012476								108	3,2			75-100		88-176
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	KTNCV 315	40-118	200-320	80-200	275-395
GGK 2502	012474								78	2,6	FNC 315	65-185	125-245	150-270	202-322
GGK 2505	012477			15					84	2,8	KTNC 315		73-190	180-300	170-290
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	KTNCV 400	50-180	220-340	100-265	315-425
GGK 4002	012479								91	3,5	FNC 400	140-260	120-220	220-340	185-305
GGK 4003	012480								147	3,6	KTNC 400		95-215		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KTNCV 500	60-235	255-440	160-350	375-560
GGK 5002	012482								108	6,7	FNC 500			280-470	255-445
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2			110-280		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	KTNCV 630	60-335	225-525	160-460	375-675
GGK 5002	012482								108	6,7	FNC 630			280-580	255-555
GGK 5003	012483	50	63	25					130	6,2			110-380		

clamping ranges

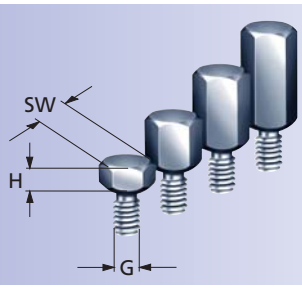


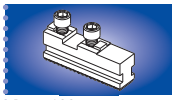
Base jaw position "**P**" Base jaw position "**O**"

stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	





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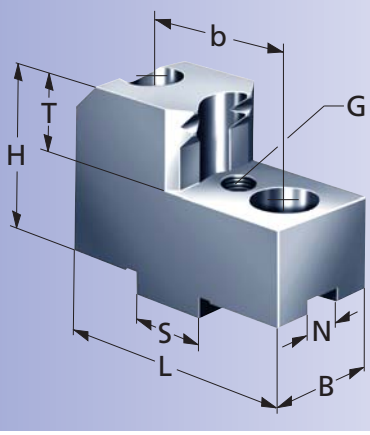
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hard roughing jaws

GGK for quick jaw change

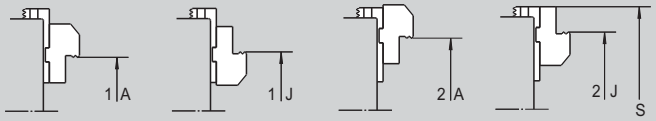
tongue & groove

for Kitagawa-chucks

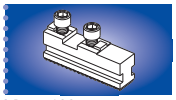


Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Kitagawa	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 2001	**012469**	28	45	20	M5	10	20	40	87	1,9	**QJ 8"**	30-62		61-110	
GGK 2002	**012470**								66	1,3	**(QJ 210-43)**	68-117	134-183	116-165	182-230
GGK 2003	**012471**								66	1,3		105-154		153-280	
GGK 2004	**012472**			15					85	1,7			60-89		88-135
GGK 2501	**012473**	40	50	22	M6	12	20	40	94	3,0	**QJ 10"**	40-78	197-270	82-154	
GGK 2502	**012474**								72	2,3	**(QJ 254-65)**	76-148	127-200	152-224	
GGK 2503	**012475**								78	2,6		98-170		174-246	
GGK 2504	**012476**								108	3,2			67-135		142-215
GGK 2501	**012473**	40	50	22	M6	12	20	40	94	3,0	**QJ 12"**	40-96		101-174	
GGK 2502	**012474**								72	2,3	**(QJ 315-78)**	82-166	138-236	170-244	238-316
GGK 2503	**012475**								78	2,6		104-188		192-266	208-286
GGK 2505	**012477**			15					84	2,8			80-175		

clamping ranges



Base jaw position "**P**" Base jaw position "**O**"



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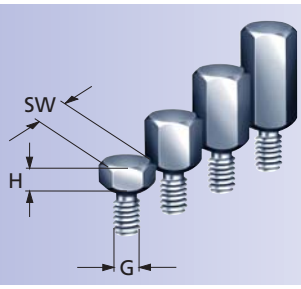


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Page 143

stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	**016510**	M5	5	10
ALB 510	**016508**		10	
ALB 515	**016509**		15	
ALB 605	**016513**	M6	5	10
ALB 610	**016511**		10	
ALB 615	**016512**		15	
ALB 620	**017602**		20	
ALB 805	**017603**	M8	5	13
ALB 810	**016514**		10	
ALB 815	**016515**		15	
ALB 820	**016516**		20	
ALB 825	**081191**		25	

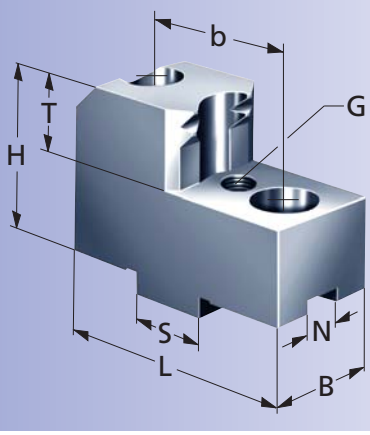


hard roughing jaws

GGK for quick jaw change

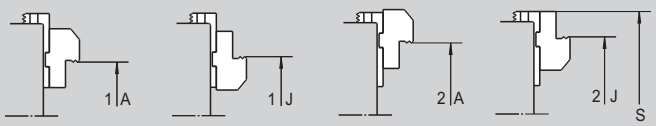
tongue & groove

for Röhm-chucks



Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Röhm	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	Duro-NC 160	28-70	-		
GGK 1752	012465								68	1,0	Duro-NCE 160		138-180	50-100	
GGK 1753	012466								60	1,0	Duro 160		110-150	85-135	
GGK 1754	012467								56	0,9			85-120	110-160	
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	Duro-NC 175	36-78			
GGK 1752	012465								68	1,0			146-188	58-108	
GGK 1753	012466								60	1,0			118-158	93-143	
GGK 1754	012467								56	0,9			93-128	118-168	
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	Duro-NC 200			28-75	
GGK 2002	012470								66	1,3	Duro-NCE 200	55-130	125-195	100-180	170-240
GGK 2003	012471								66	1,3	Duro 200		90-160	140-210	
GGK 2004	012472			15					85	1,7			55-100		
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	Duro-NC 250	38-95	195-280	80-160	270-300
GGK 2502	012474								72	2,3	Duro-NCE 250		125-205	145-225	
GGK 2503	012475								78	2,6	Duro 250		110-180	180-260	
GGK 2504	012476								108	3,2					80-170
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	Duro-NCE 315	66-139	223-324	108-204	298-344
GGK 2502	012474								72	2,3			153-249	173-269	
GGK 2503	012475								78	2,6			138-224	208-304	
GGK 2504	012476								108	3,2					108-214
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	Duro-NC 315	50-150	220-330	120-220	
GGK 4002	012479								91	3,5	Duro 315		110-220	220-320	
GGK 4003	012480								147	3,6			85-200		
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	Duro-NCE 400	128-206	298-386	198-276	
GGK 4002	012479								91	3,5			188-276	298-376	
GGK 4003	012480								147	3,6			163-256		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	Duro-NC 400	65-175	260-380	165-285	380-430
GGK 5002	012482								108	6,7	Duro 400		140-260	285-400	
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2			105-200		
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	Duro-NCE 500	101-289			436-604
GGK 5002	012482								108	6,7			296-494	221-404	
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2			176-374	346-534	
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	Duro-NC 500	65-235	260-440	185-350	400-550
GGK 5002	012482								108	6,7	Duro 500		140-320	310-480	

clamping ranges

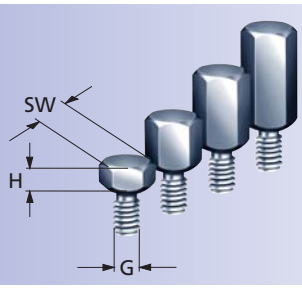


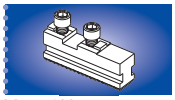
Base jaw position "**P**" Base jaw position "**O**"

stop pins

ALB

Type	Id-No.	G	H	SW
ALB 505	016510	M5	5	10
ALB 510	016508		10	
ALB 515	016509		15	
ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	





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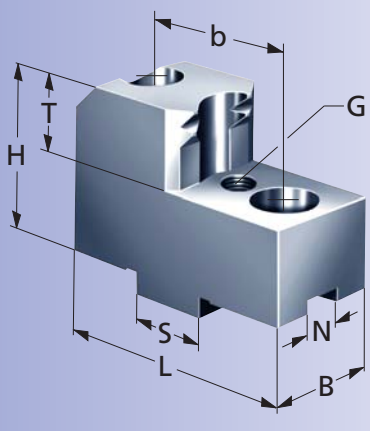
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hard roughing jaws

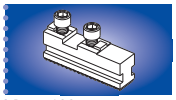
GGK for quick jaw change

tongue & groove

for Schunk-chucks



Type	Id.-No.	B	H	T	G	N	S	b	L	kg/ set	Schunk	clamping ranges Ø external-A_1	clamping ranges Ø internal-J_1	clamping ranges Ø external-A_2	clamping ranges Ø internal-J_2
GGK 1751	012464	25	40	16	M5	8	18	32	64	0,9	ROTA-S 160	25-50	-	-	-
GGK 1752	012465								68	1,0	ROTA-S PLUS 160		133-160	38-67	
GGK 1753	012466								60	1,0			105-134	66-95	
GGK 1754	012467								56	0,9			78-106	95-125	
GGK 2001	012469	28	45	20	M5	10	20	40	87	1,9	ROTA-S 200	30-55	185-230	45-94	-
GGK 2002	012470								66	1,3	THW 210-F	60-110	130-178	100-145	165-215
GGK 2003	012471								66	1,3	ROTA-S PLUS 200	100-150	90-135	140-185	130-175
GGK 2004	012472			15					85	1,7	ROTA-NC-WF 210	-	55-84	-	70-120
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	ROTA-S 250	35-70	200-265	65-138	265-330
GGK 2502	012474								72	2,3	THW 250-F	80-145	130-195	143-205	190-260
GGK 2503	012475								78	2,6	THW 265-F	110-175	100-165	174-237	165-230
GGK 2504	012476								108	3,2	ROTA NC-WF 250 ROTA-S PLUS 250	-	-	-	80-145
GGK 2501	012473	40	50	22	M6	12	20	40	94	3,0	ROTA NC-WF 315	40-92	205-280	94-179	294-370
GGK 2502	012474								72	3,0		85-161	135-210	170-249	219-300
GGK 2503	012475								78	2,6		115-190	105-180	203-278	194-270
GGK 2505	012477			15					84	2,8		-	85-150	-	-
GGK 4001	012478	50	55	25	M8	12	26	54	104	4,8	ROTA-S 315	50-162	230-350	118-240	305-430
GGK 4002	012479								91	3,5	THW 315-F	162-283	110-230	240-360	190-308
GGK 4003	012480								147	3,6	THW 400-F ROTA-S PLUS 315	-	100-220	-	-
GGK 5001	012481	60	74	35	M8	18	30	60	125	8,8	ROTA-S 400	80-190	260-400	170-310	380-520
GGK 5002	012482								108	6,7	ROTA-S 500	170-310	140-280	265-405	260-400
GGK 5003	012483	50	63	25	M8	18	30	60	130	6,2	THW 500-F ROTA-S PLUS 400/500	-	100-210	-	



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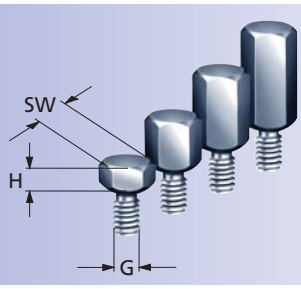


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stop pins

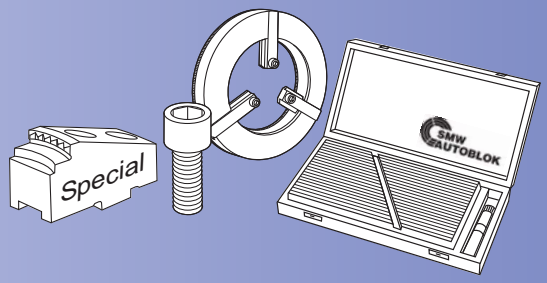
ALB

Type	Id-No.	G	H	SW
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ALB 510	016508		10	
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ALB 605	016513	M6	5	10
ALB 610	016511		10	
ALB 615	016512		15	
ALB 620	017602		20	
ALB 805	017603	M8	5	13
ALB 810	016514		10	
ALB 815	016515		15	
ALB 820	016516		20	
ALB 825	081191		25	



Accessories

Accessories



	special jaws (to customer request)		Page 143
AD	Conversion jaws • serration • tongue & groove		Page 144
GM GF	Jaw mounting bolts DIN 912 class 12.9		Page 145
ADS	boring rings		Page 146
ADVL ADVS	boring fixture boring fixture	light version heavy version	Page 147
RPS	Dress and cleaning plate serration INCH / METRIC		Page 148
	hardening instruction material 16MnCr5 material C45		Page 149
	calculation basis • grip force • deformation		Page 150
	Repair service		Page 152

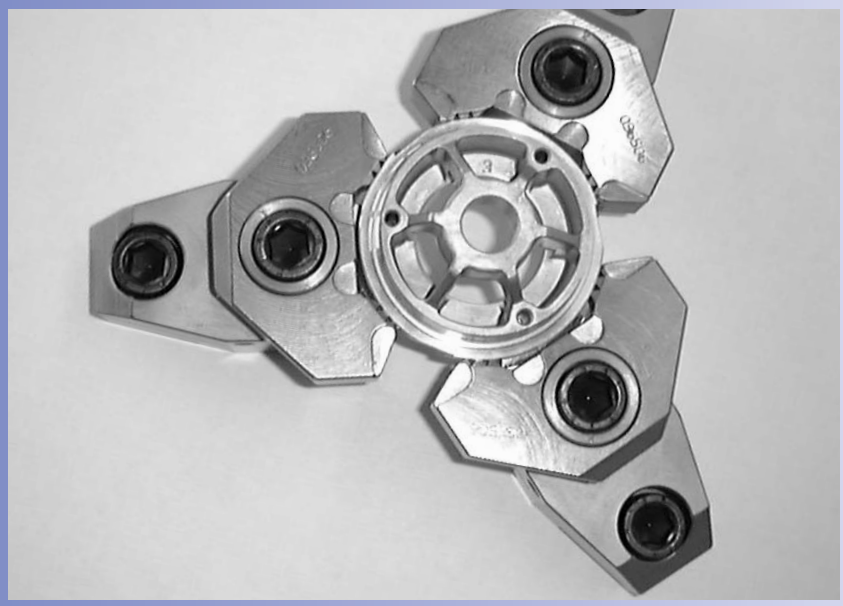
Monoblock jaws with grippers

for heavy duty machining



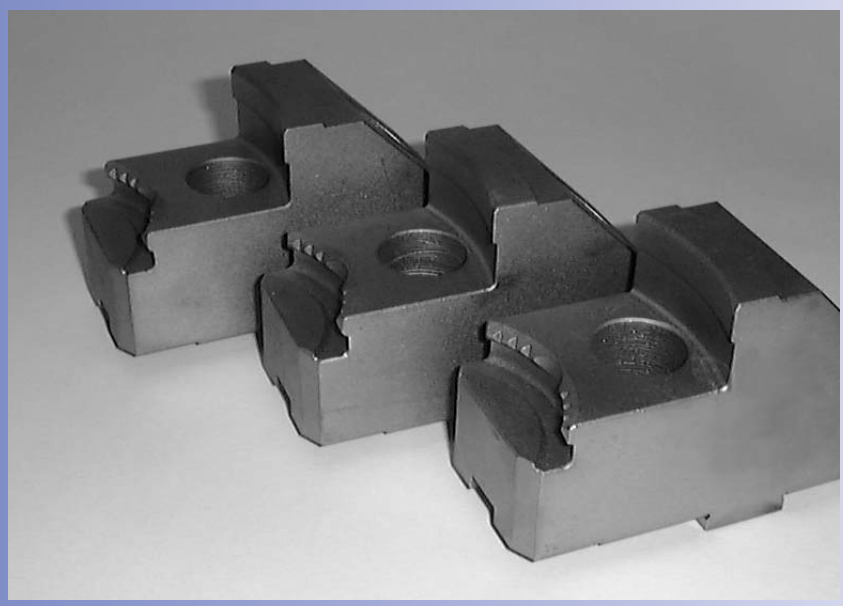
floating jaws

for easy deformed work pieces



Cost effective

Op.1. and op. 2. with one jaw set



Datasheet for special hard or soft top jaws

Customer address

company

department | specialist

street | zip code/village

telephone | fax

Work-piece

⚠ Mark the clamping and locating area of the . **work piece in your drawing.**

Work piece type

Material | KS-factor

Clamping area ☐ raw ☐ pre machined ☐ finish machined

Marks from gripping allowed ☐ yes ☐ no

Deformation allowed ☐ yes, ____ mm ☐ no

Processing

☐ turning ☐ milling ☐ drilling ☐ roughing

☐ finishing ☐ grinding ☐ with coolant ☐ dry machining

☐ other

max. machining speed ____ rpm | max. machine speed ____ rpm

feed per rev. ____ mm/rev. | cutting depth ____ mm

Jaw version

☐ 1. OP ☐ gripper jaws ☐ see datasheet (fine serration page 24+35, tongue + groove page 82+97)

☐ 2. OP ☐ soft jaws ☐ non serrated clamping area ☐ diamond serration

☐ Slot and serration milled

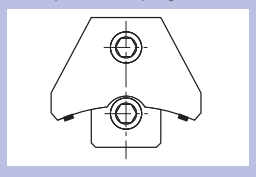
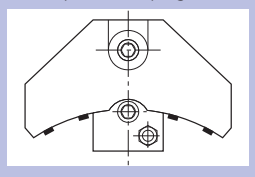
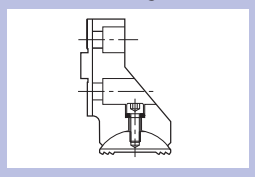
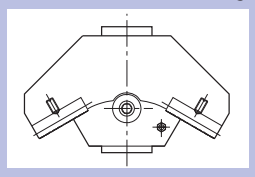
☐ Slot and serration ground

☐ Clamping and location surface pre machined for finishing on the machine at the customer

☐ Clamping and location surface ground or turned on a fixture

☐ Turn over clamping = both ops. in one jaw set

☐ 6 point clamping radial ☐ 12 point clamping radial ☐ axial swivelling ☐ axial und radial swivelling

Power chuck

Manufacturer | Type and size | jaws/number

Jaw mounting ☐ Slot and serration (If it is a special chuck please send a drawing!)

☐ Slot width ____ mm

serration ☐ 1/16" x 90° ☐ 3/32" x 90° ☐ 1,5 x 60° ☐ 3 x 60° ☐ Modul 2 ☐ ____

☐ Tongue and groove (If it is a special chuck please send a drawing!)

machine

Max. swing ____ mm ☐ Dynamic balancing with work piece

Machine spindle ☐ horizontal ☐ vertical ☐ inverted

Loading ☐ manual ☐ automatic (send information about interference with loader!)

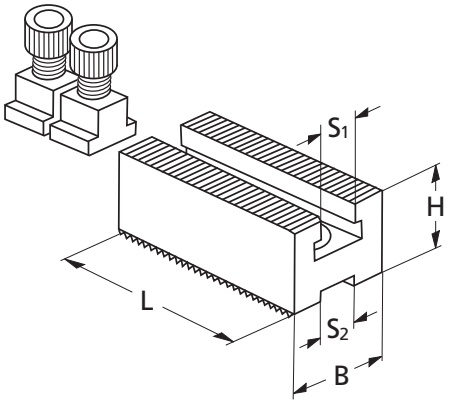
Other

date | advisor

Hard connecting jaws serration/tongue & groove ground

To mount top jaws to chucks with different master jaw dimensions

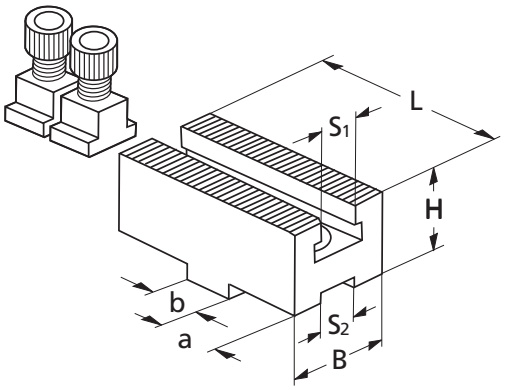
Conversion jaw type AD 10



Fine serration on both sides.
T-nuts and bolts are special according to the existing top jaws.

serration chuck side
S_2
serration jaw side
S_1
H
B
L
chuck type

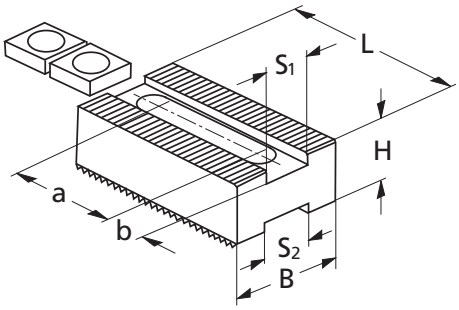
Conversion jaw type AD 50



Tongue and groove on the chuck and fine serration on the jaws.
T-nuts and bolts are special according to the existing top jaws.

serration jaw side
S_1
H
B
L
S_2
a
b
chuck type

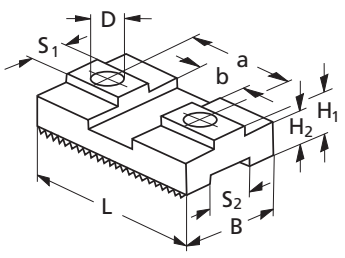
Conversion jaw type AD 30



Fine serration on both sides.
The conversion jaw has a slot so that it can match different bolts patterns.

serration chuck side
S_2
serration jaw side
S_1
H
B
L
a
b
chuck type

Conversion jaw type AD 80



Tongue and groove on the jaw and fine serration the chuck.
The size and position of the holed D are depending on the existing T-nuts.

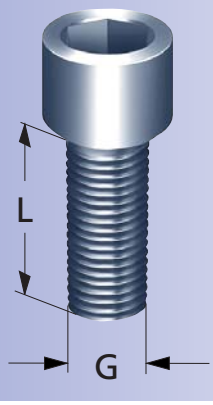
serration chuck side
S_2
H1
H2
B
L
S_1
a
b
chuck type

jaw mounting bolts

GM + GF

for base jaws type GBK, GBKS, GBK-B, MFG

screw DIN 912, class 12.9

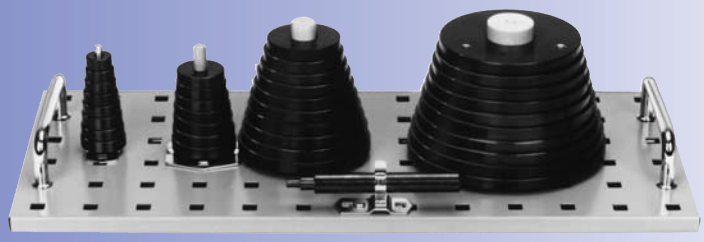


Type	Id.-No.	G x length	SMW-AUTOBLOK base jaws
GM 820	**010182**	M8 x 20	GBK 140 GBK 160 GBK 200 GBKS 200 GBKB 210
GM 1225	**015524**	M12 x 25	GBK 250 GBKS 250 GBK 260 GBK 315 GBKS 315 GBKB 315
GM 1230	**010207**	M12 x 30	GBK 400 GBKS 400 GBKB 400
GM 1645	**010448**	M16 x 45	GBK 500 GBK 630 GBKB 500 GBKB 630 GBKB 800
GM 2045	**082498**	M20 x 45	MFG 630
GF 820	**084331**	M8 x 1 x 20	MFG 160 MFG 200
GF 1230	**087603**	M12 x 1,5 x 30	MFG 250
GF 1235	**087733**	M12 x 1,5 x 35	MFG 315
GF 1640	**086405**	M16 x 1,5 x 40	MFG 400

boring rings

ADS

to bore jaws on the chuck

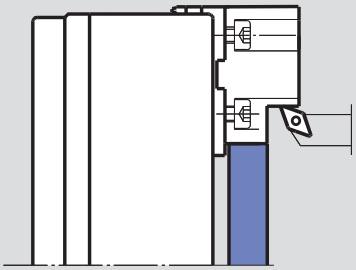


Type	Id.-No.	set
ADS	082689	set 36 pcs. as shown

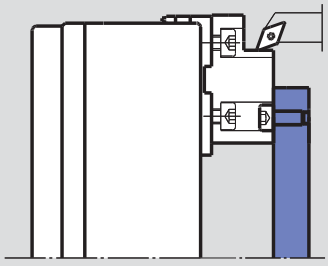
The advantages of the SMW-AUTOBLOK boring rings for jaws:

- Complete set to bore all dia. from 20 to 150 mm.
- Set consisting of 36 rings Ø 20 - 50 mm eachstepped 2 mm. From Ø 50 - 150 mm stepped in 5 mm increments.
- Clearly organized on base plate.
- Rings from Ø 105 mm and up have 3 tapped holes for clamping bolts to machine jaws for internal gripping.
- Rigid design. Rings are 10 mm thick, quenched for greater durability.
- Mounting handle is used for the safe insertion of the smaller rings without danger of injuries.

Applications



external clamping



internal clamping

Recommendations:

For highest repeatability and accuracy please follow these instructions:

- Always tighten mounting bolts in the top jaws with a torque wrench.
- Always position boring rings as close as possible to the clamping area.
- Always bore top jaws at machining pressure.

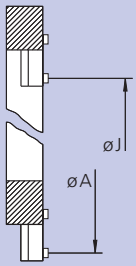
Boring fixture
ADVL + ADVS

to bore jaws
on the chuck



Boring fixture ADVL

light duty version

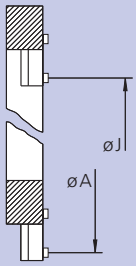


- For low grip forces up to 3000 daN.
- To bore soft or quenched jaws on manual chucks.
- Adjustment of the clamping dia. by turning the scroll or reversing the inserts.
- The fixture can cover a large range.

Type	Id.-No.	external-Ø mm	internal-Ø mm	clamping range A	clamping range J	max. grip force	weight kg/piece
ADVL 150	081903	153	110	from 150 to 215	from 50 to 115	1500 daN	1,5
ADVL 180	081904	176	110	from 170 to 260	from 35 to 125	3000 daN	3,3
ADVL 220	081905	215	135	from 215 to 285	from 70 to 140	3000 daN	5,2
ADVL 250	081906	244	162	from 240 to 315	from 100 to 175	3000 daN	5,6
ADVL 290	081907	290	208	from 290 to 360	from 145 to 215	3000 daN	6,8

Boring fixture ADVS

heavy duty version

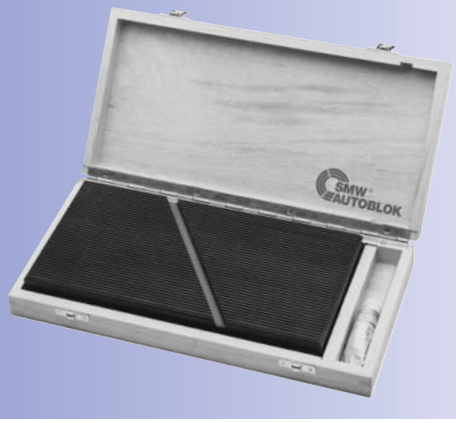


- For higher grip forces up to 7500 daN.
- To bore soft or quenched jaws on manual or power chucks.
- To grind hard jaws on manual or power chucks.
- Mainly used on power chucks.
- Adjustment of the clamping dia. by turning the scroll or reversing the inserts.
- The fixture can cover a large range.

Type	Id.-No.	external-Ø mm	internal-Ø mm	clamping range A	clamping range J	max. grip force	weight kg/piece
ADVS 230	081910	225	135	from 229 to 305	from 81 to 157	4500 daN	7,0
ADVS 290	081909	288	184	from 292 to 368	from 128 to 204	6000 daN	11,5
ADVS 370	081911	370	250	from 388 to 464	from 208 to 284	7500 daN	21,0

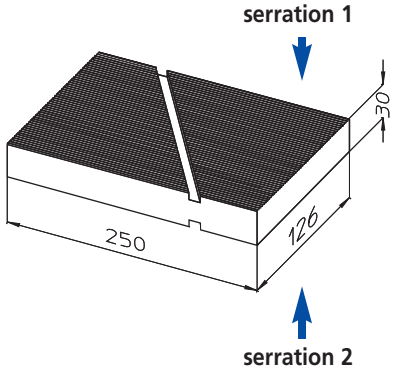
Dress and cleaning plate
RPS
With 2 different fine serrations

to clean and dress top jaws
with fine serration inch/metric



SMW-AUTOBLOK Type	Id.-No.	serration		kg/piece
		upper side	lower side	
RPS-D	081912	1/16" x 90°	3/32" x 90°	7,0
RPS-M	081914	1,5 x 60°	3 x 60°	7,0
RPS-MD	081913	1,5 x 60°	1/16" x 90°	7,0

- **Dress and cleaning plate, hardened, precision ground serrations.**
- **2 different serrations, on the upper and lower side of the plate. Just turn it over!**
- **Quick cleaning of the top jaws serration. Swarf and dirt is accumulated in the diagonal groove.**
- **Dressing of light damage on the serration by using the grinding compound.**



Standard equipment:

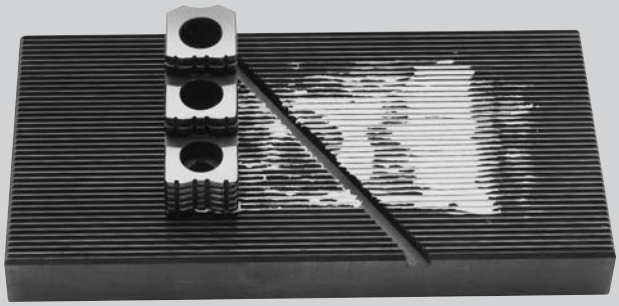
cleaning plate
1 tube of grinding paste
wooden box

Extra grinding paste
Id.-No. 037133

Dressing and cleaning of serration

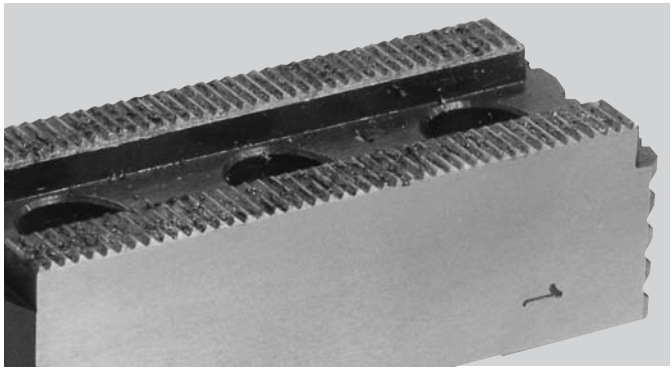


Apply grinding compound (corn 320) near the outer edge

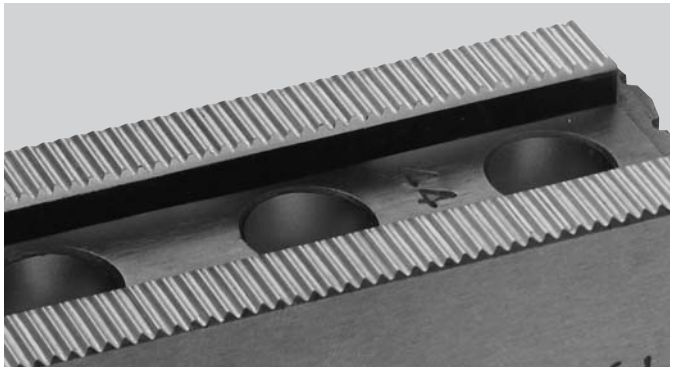


Put the jaw on the grinding compound and move it back and forth, with a light pressure.

Dirty/damaged serration



Serration after dressing and cleaning



Hardening instruction for soft jaws

Material 16MnCr5 (1.7131)



1. Preheat to 500° Celsius.
2. Carburise at 930° Celsius.
   Carburising depth is appr. 0,1 mm per hour.
3. Harden at 850° Celsius an quench in oil at 100° Celsius.
4. Wash and clean from oil.
5. Temper at 150 - 180° Celsius according to request hardness.
   about 2 hours.
6. Regrind the serration in case of distortion.

Material C45 (1.0503)



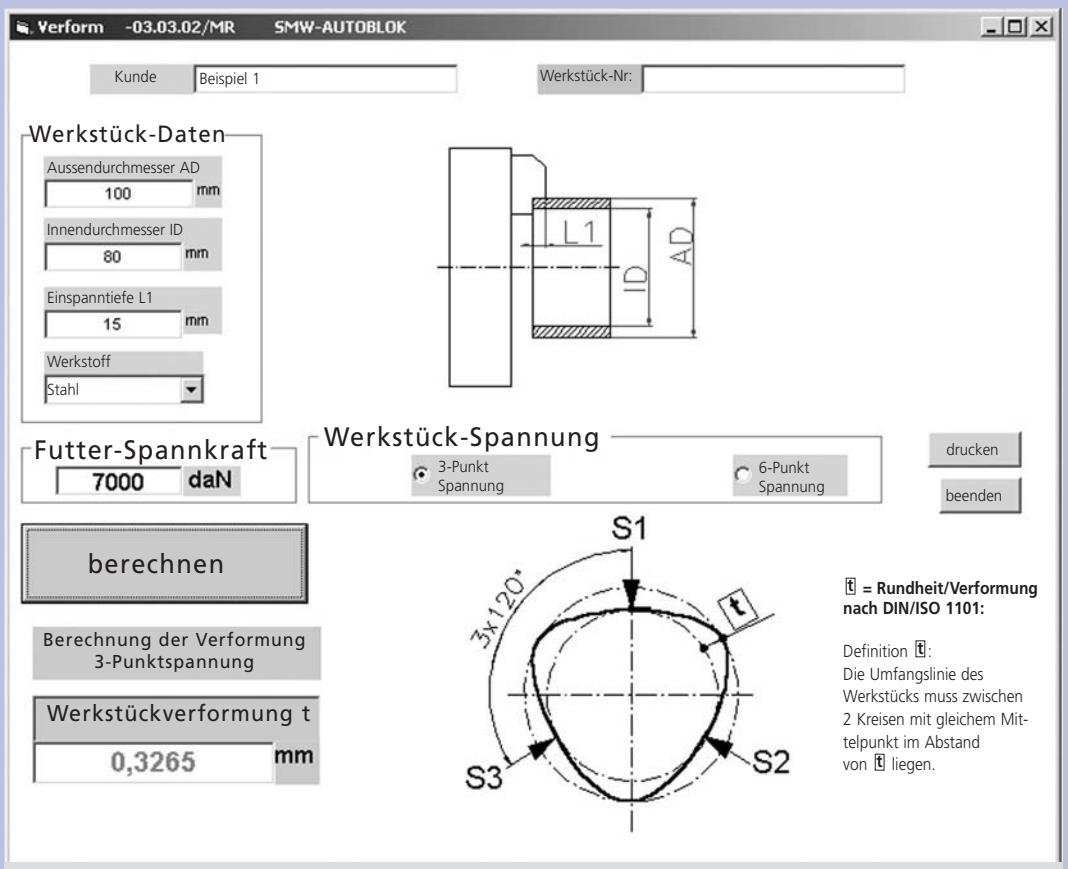
The carbon necessary for hardening is already in the material.
Partial hardening (such as clamping area) is possible by induction hardening.
A distortion of the contact surface can be eliminated or reduced in most cases

1. Partial preheating to 870 - 930° Celsius (1 - 3 mm deep).
2. Quench harden in emulsion.
3. Temper at 150 - 180° Celsius according to requested hardness about 2 hours.

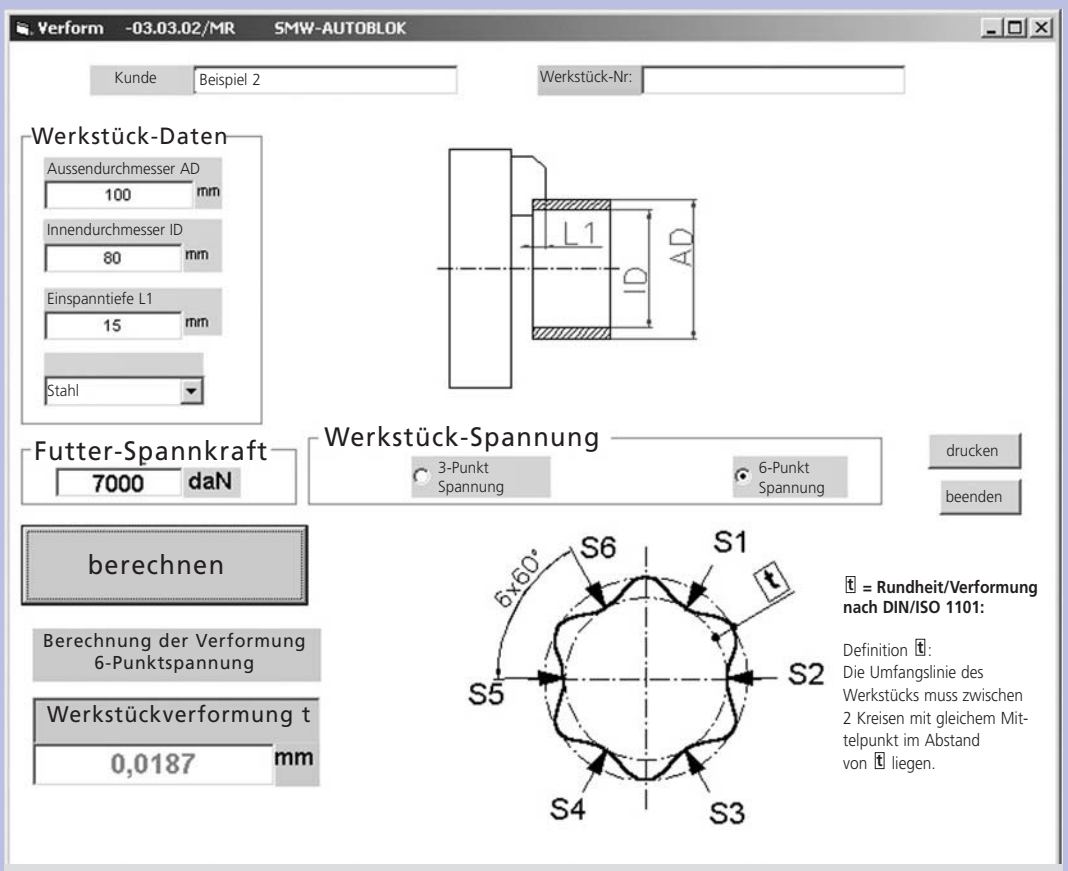
Jaws from Material C45 must be inspected for cracks after induction hardening.

CALCULATION-SERVICE

We can provide a calculation of deformation for thin walled components when clamping with the chuck



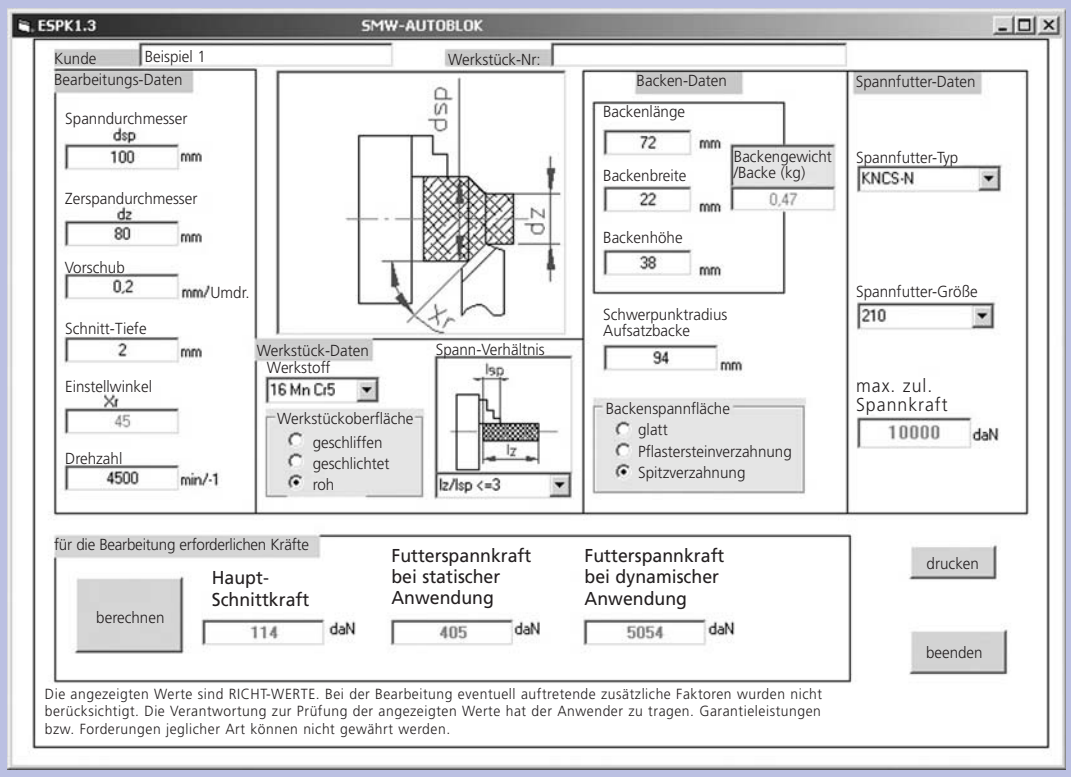
Bitte beachten: Die Rundheit des Werkstücks wird durch die Verformung beim Spannen und zusätzlich durch die Maschinenspindel, das Werkzeug und die Werkstückcharakteristik beeinflusst.



Bitte beachten: Die Rundheit des Werkstücks wird durch die Verformung beim Spannen und zusätzlich durch die Maschinenspindel, das Werkzeug und die Werkstückcharakteristik beeinflusst.

CALCULATION-SERVICE

We can calculate the necessary gripforce for SMW-AUTOBLOK chucks for your machining process.

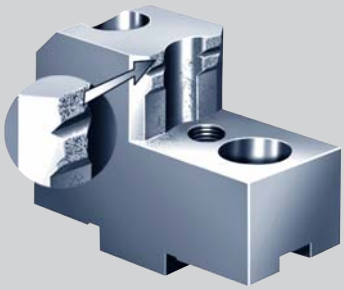


Repair Service

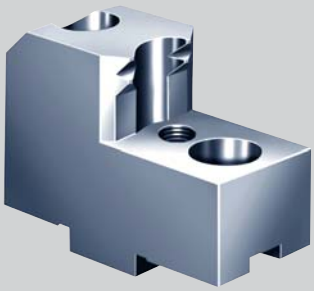
Refurbishing of the clamping area and / or the serration of worn out jaws

example roughing jaws

worn out/damaged

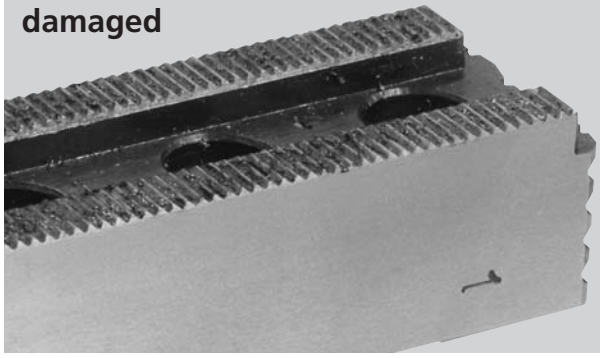


refurbished

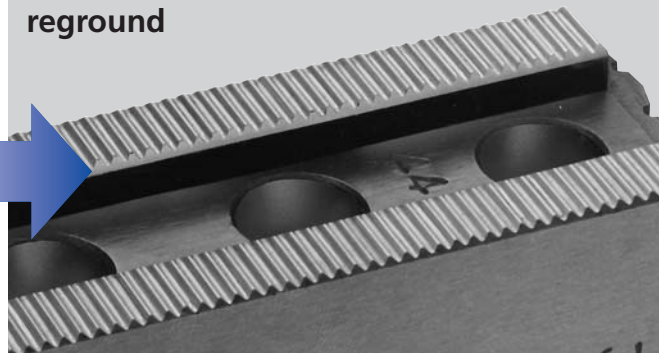


example serration

damaged



reground



Repairs are done quickly and economic.

For quotation please send in your jaws as a complete set.