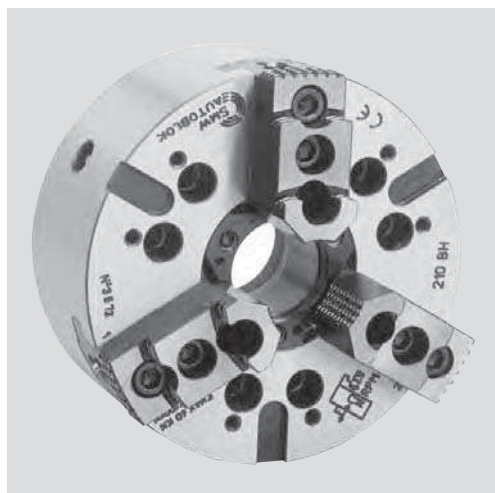


# BH-M

METRIC serration

## High precision power chucks Ø 130 - 450 mm

- LARGE THROUGH HOLE
- 2, 3 and 4 jaws



### Application/customer benefits

- For open center or partial open center clamping
- Large through-hole

**BH-M:** Master jaws with METRIC serration (1.5 mm x 60°)  
(Suitable for Japanese chucks top jaws)

### Technical features

- Gripping force transmission via wedge hook
- Case hardened body to assure greatest precision and long chuck life
- 2 jaw version from diameter 130 to 315
- 3 jaw version available in all diameters
- 4 jaw chuck available starting from diameter 165 mm

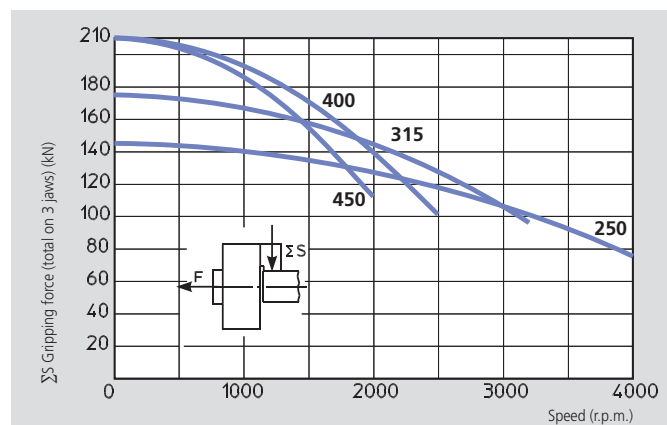
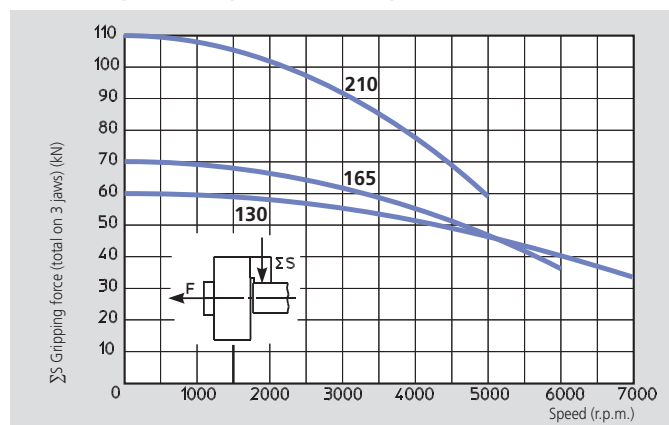
### Standard equipment

2, 3 or 4 jaw chuck  
1 set T-nuts with bolts  
1 set soft top jaws  
Mounting bolts  
Grease gun

### Ordering example

2 jaw chuck BH-M 210/A6  
or  
3 jaw chuck BH-M 250/A8

## Actual gripping force diagrams



The data in the diagrams refer to 3-jaw-chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K05 grease. The static and dynamic gripping forces have been measured using standard soft top jaws, placed in a position not exceeding the outer diameter of the chuck.

### △ Safety advice/danger of damage:

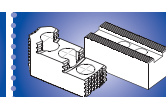
When using taller/heavier jaws and/or clamping on a bigger diameter reduce draw pull/rotating speed accordingly.

## Technical data

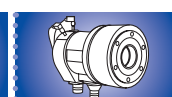
SMW-AUTOBLOK Type		BH-M 130			BH-M 165			BH-M 210			BH-M 250			BH-M 315			BH-M 400		BH-M 450	
Number of jaws		2	3		2	3	4	2	3	4	2	3	4	2	3	4	3	4	3	4
Through-hole	mm	32			46			52			66			95			118		118	
Radial jaw stroke	mm	3.2			3.2			4			5			5			6.5		6.5	
Axial piston stroke	mm	15			15			19			24			24			31		31	
Max. draw pull	kN	15	22		17	25	25	25	38	38	34	50	50	40	60	60	70	70	70	70
Max. gripping force	kN	42	60		48	70	70	72	110	110	98	145	145	115	175	175	210	210	210	210
Max. speed	r.p.m.	7000	7000		6000	6000	5000	5000	5000	4300	4000	4000	3400	3200	3200	2700	2500	2000	2000	1700
Mass (without top jaws)	kg	5			9.5			19			30			46			86		135	
Moment of inertia	kg·m <sup>2</sup>	0.012			0.036			0.12			0.27			0.62			2		3.5	
Recommended actuating cylinders		SIN-S 85/100 VNK 70-37			SIN-S 100 VNK 102-46			SIN-S 100/125 VNK 130-52			SIN-S 125/150 VNK 150-67			SIN-S 125/150 VNK 225-95			SIN-S 150/175 VNK 320-127		SIN-S 150/175 VNK 320-127	



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