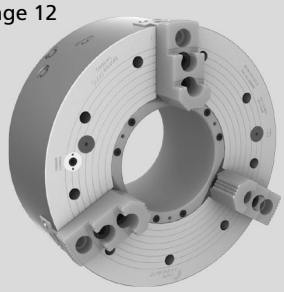
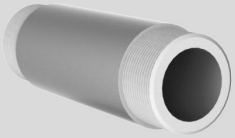
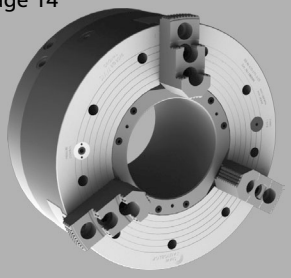
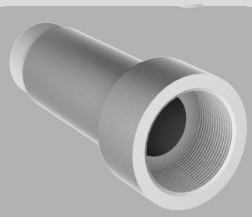
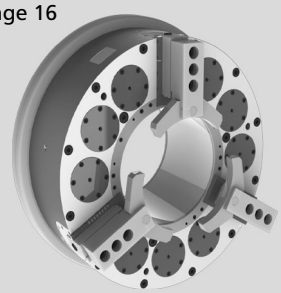
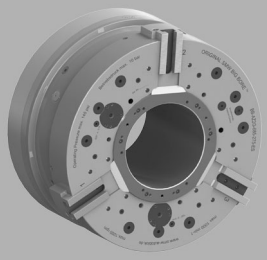
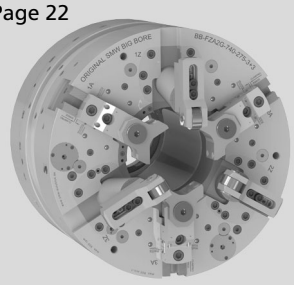
Overview Pipe

Customer´s OCTG product:

- **Straight pipe**
- **Bent pipe**

CHUCK	APPLICATION	OCTG PRODUCT	CUSTOMER BENEFITS
BB-N Page 12 	Threading of straight pipe with the original SMW Big Bore Type BB-N.		▪ **Quick jaw movement** more pipe per hour ▪ Can be used for other work pieces besides piping ▪ O.D. and I.D. clamping
BB-N-ES Page 14 	Threading of straight pipe with upset ends with the original SMW Big Bore Type BB-N-ES.		▪ **Quick jaw movement** more pipe per hour ▪ Large jaw stroke for easy loading of pipe and less danger of damaging threads when unloading
BB-SC Page 16 	High production **spring clamp** chuck for threading of straight pipe with or without upset ends with the original SMW Big Bore Type BB-SC.		▪ **Full jaw stroke in 2 seconds** for highest productivity ▪ Fully sealed/low maintenance for highest availabitlity of the machine ▪ Safe clamping of pipe even in longer machining processes with spring clamp technology
BB-AZ2G Page 18 	Threading of straight and bent pipe with the original SMW Big Bore Type BB-AZ2G.		▪ **Self centering or compensating clamping** for universal use ▪ Quick jaw movement ▪ External centering device needed when used in compensating mode ▪ O.D. clamping only
BB-FZA2G Page 22 	Threading of straight and bent pipe with integrated centering jaws with the original SMW Big Bore Type BB-FZA2G.		▪ **Integrated centering jaws for the pipe** = no external centering device needed ▪ Quick jaw movement ▪ Fully automatic programable cycle

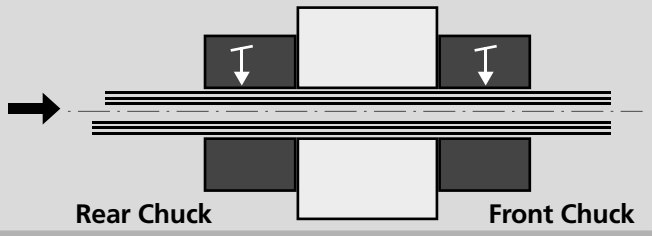
Pipe Clamping

Recommended Combinations

Self centering clamping | Self centering or compensating clamping | 3+3-Combination

Combination A

Pipe
Loading



Note:
This combination can be only used for straight pipe!

Combination B

Pipe
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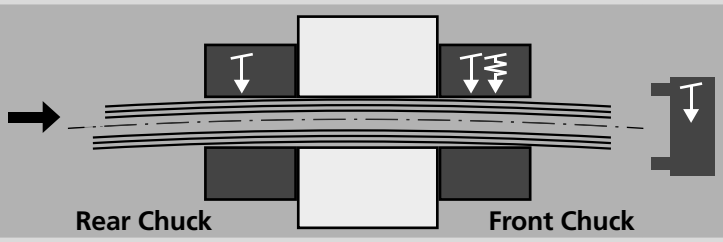

Centering

Combination C

Pipe
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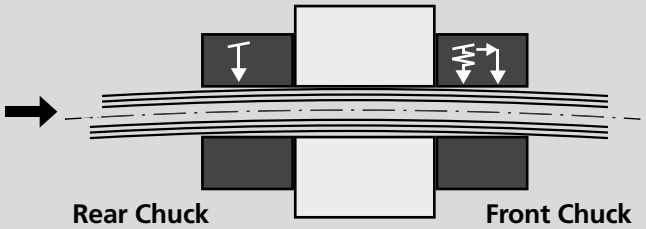
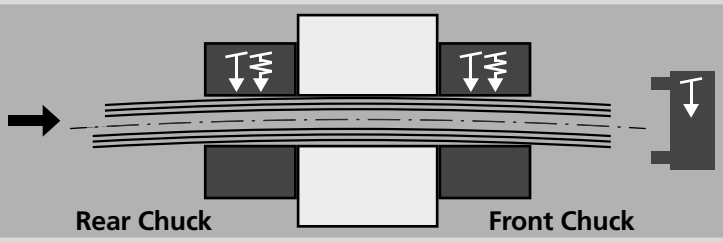


Note:
No centering necessary!

Combination D

Pipe
Loading



Centering

Combination E

Pipe
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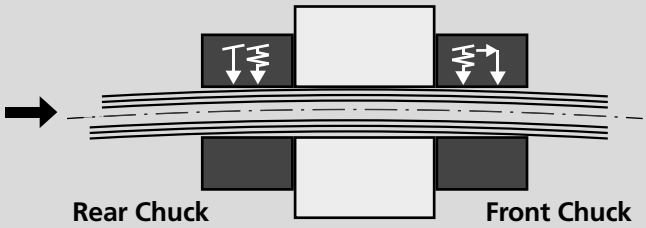
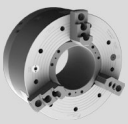
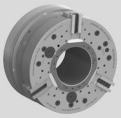
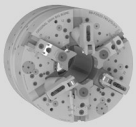
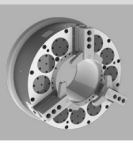


Note:
No centering necessary!

Respective chuck matrix:

Self centering clamping	Self centering or compensating clamping	3 jaw + 3 jaw combination
 **BB-N/ BB-N-ES** Page 12/14	 **BB-AZ2G** Page 18	 **BB-FZA2G** Page 22
 **BB-SC** Page 16		

Centering options:

Chuck CC
Page 20

Turret
by customer

BIG BORE®
BB-SC

Dentatura in POLLICI

Autocentranti con cilindro incorporato con PASSAGGIO BARRA EXTRA GRANDE Ø 275 - 565 mm

- **Ø mandrini 600 - 1020**
- **Serraggio tramite pacchi di molle**
- **Con corsa rapida e corsa di bloccaggio**

Applicazioni

- Lavorazione delle estremità di tubi lunghi/serraggio autocentrante
- Corsa lunga delle griffe per bloccaggio di tubi con collarino
- Massima produttività grazie a tempi di apertura e chiusura < 3 sec.
- Lunghi intervalli di manutenzione = elevata disponibilità della macchina
- Lavorazione di tubi storti, regolati in centro con spessori manuali
- È possibile utilizzare il passaggio barra completo della macchina

Caratteristiche tecniche

- Serraggio autocentrante tramite 9/6/3 pacchi di molle a scelta
- Pacchi di molle racchiuse in cartucce
- Apertura tramite cilindro pneumatico a singolo effetto incorporato
- Forza di serraggio costante grazie alla continua lubrificazione a grasso
- Comando a impulsi in apertura/chiusura per la regolazione della centratura del tubo
- Corsa lunga delle griffe suddivisa in CORSA RAPIDA E CORSA DI BLOCCAGGIO
- Ridotto consumo di aria
- Controllo corsa
- **proofline®** = mandrini ermetici - bassa manutenzione

Dotazione standard

Mandrino con viti di fissaggio
1 Serie di morsetti teneri
1 Serie di Tasselli a T con viti

Esempio di ordine

Big Bore SC 850-395
Cod. 053350

Accessori

Unità di controllo AC-SC

Il principio affidabile:
Serraggio tramite pacchi di molle / apertura tramite cilindro pneumatico

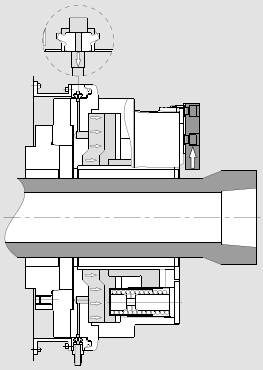


Fig. 1
Apertura mandrino (solo con mandrino fermo). Le guarnizioni a profilo si deformano con la pressione dell'aria e aderiscono al corpo del mandrino, permettendo il riempimento del cilindro su un lato. Il pistone comprime i pacchi di molle e le griffe si aprono.

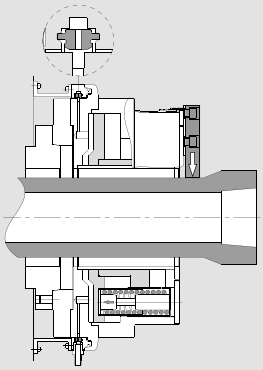


Fig. 2
Serraggio mandrino (possibile anche con mandrino in rotazione). L'aria compressa viene disinserita. Le guarnizioni a profilo SMW tornano in posizione espansa e le molle trasmettono alle griffe la forza di bloccaggio.

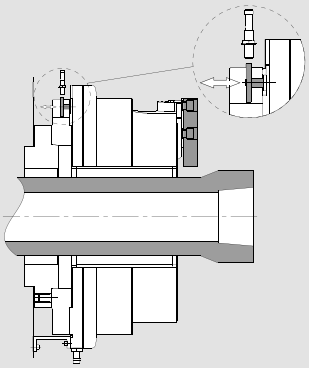
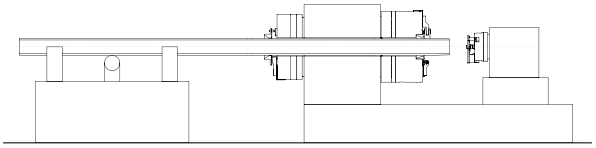
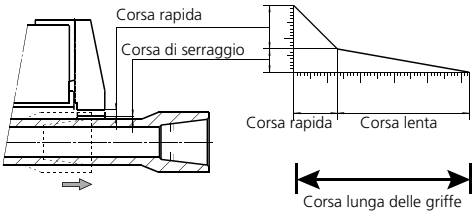


Fig. 3
Controllo della corsa
La corsa di bloccaggio delle griffe viene controllata meccanicamente. La misurazione di posizione/il controllo finale avvengono tramite sensore di prossimità.



Lavorazione delle estremità di tubi con due mandrini per tornio.

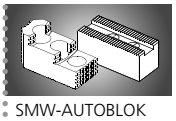


Dati tecnici

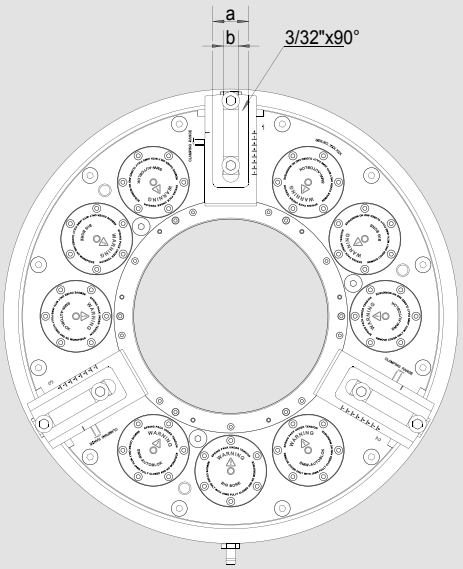
Modello SMW-AUTOBLOK		BB-SC 600-275			BB-SC 850-395			BB-SC 1020-565		
Cod.		**053540**			**053350**			**053570**		
Passaggio barra	mm (poll.)	275 (10.83")			395 (15.55")			565 (22.24")		
Corsa totale per griffa	mm (poll.)	25.4 (1")			27 (1.06")			27 (1.06")		
Corsa rapida per griffa*	mm (poll.)	16.9 (0.67")			15 (0.59")			15 (0.59")		
Corsa di serraggio per griffa	mm (poll.)	8.5 (0.33")			12 (0.47")			12 (0.47")		
Pressione di apertura con 9 molle	bar (psi)	5 (73)			5 (73)			5 (73)		
Forza di serraggio max a 3/6/9 molle	kN (lbf)	50 (11240)	100 (22480)	150 (33721)	57 (12814)	113 (25403)	170 (38218)	57 (12814)	113 (25403)	170 (38218)
Velocità massima	giri/min.	1000			700			420		
Consumo d'aria per apertura a 5 bar (73 psi)	litri	60			115			139		
Massa (senza morsetti)	kg (lbs)	510 (1124)			930 (2050)			1260 (2779)		
Momento d'inerzia	kg·m²	34			101			223		

* da NON utilizzare per il bloccaggio

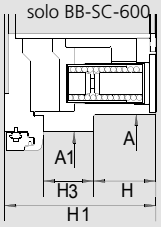
SMW-AUTOBLOK 295

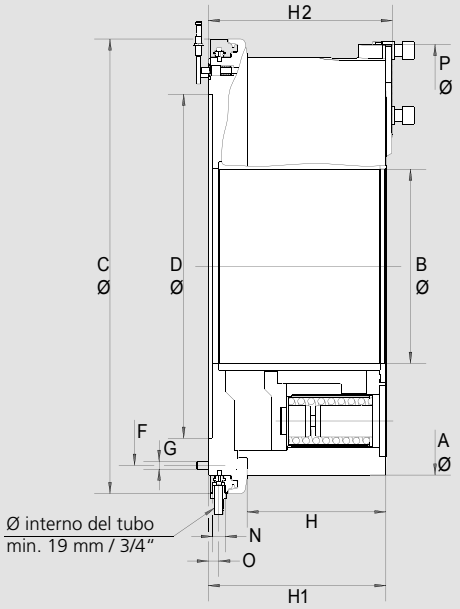


SMW-AUTOBLOK 292



Pressione di apertura con tutte le molle montate
min. 5 bar (73 psi), max. 8 bar (116 psi)



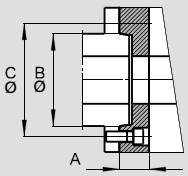


Con riserva di modifiche tecniche.
Per maggiori informazioni contattare l'ufficio tecnico SMW-AUTOBLOK.

Modello SMW-AUTOBLOK			BB-SC 600-275	BB-SC 850-395	BB-SC 1020-565
Attacco			**Z520**	**Z700**	**Z870**
	A	mm	605	850	1020
(BB-SC-600-275)	**A1**	mm	675	-	-
Passaggio barra	**B**	mm	275	395	565
	C	mm	750	925	1095
	D H6	mm	520	700	870
	F	mm	640	810	980
	G		M12 (12x)	M16 (12x)	M16 (12x)
	H		126.7	282.5	282.5
	H1		307.5	361.5	361.5
	H2		320.5	374.5	374.5
(BB-SC-600-275)	**H3**		102	-	-
	N		G 3/4"	G 3/4"	G 3/4"
	O		21.5	21.5	21.5
Interferenza max.	**P**		655.8	902.8	1074
	a		58	73	73
	b		25.5	30	30
Corsa rapida		mm	16.9	15	15
Corsa di bloccaggio		mm	8.5	12	12
Corsa totale delle griffe		mm	25.4	27	27

Flange di adattamento

Attacco
ISO-A DIN 55026



BB-SC	600-275			850-395		1020-565		
Naso macchina	A11	A15	A20	A15	A20	A15	A20	A28
Cod.	su richiesta	053590	053591	053362	053358	su richiesta	053595	053596