B-Top

A large through-bore, for a reason

Jaw chuck B-Top

Fast jaw change with quick change design and high repeatability – that is what makes the B-Top jaw chuck product line so flexible. Particularly for small lot sizes. Thus in most cases machining the chuck jaw to size is unnecessary. Also the insert bushing system is configured for small lot sizes and maximum flexibility. It enables clamping devices to be conveniently adapted to your requirement: Closed with ejector, spray nozzles, or with variable end-stop. Just the way you need it. And the innovative lubricating system ensures improved clamping force behavior of the wedge bar principle.

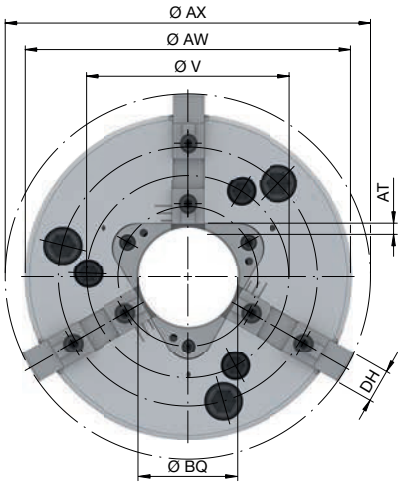
Key advantages

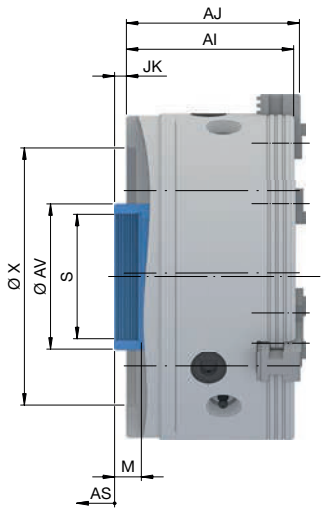
- Fast jaw change with individual unlocking
- Large through-bore with bushing inserts that can be changed from the front
- Proven wedge rod mechanism

B-Top jaw chuck in use

Jaw chuck B-Top

Jaw chuck B-Top. Technical data and order overview





Size		165	215	260	315
Variant		B-Top			
Run-out ≤ [mm]		0,020		0,025	0,030
Max. clamping force [kN]		41	74	115	160
Max. axial drawtube force [pull / push] [kN]		30	46	65	90
RPM n max. [1/min.]		6000	5400	4000	3600
Stroke per jaw [mm]	AT	5,9	7,4	8,2	8,6
Ø Capacity [mm]	BQ	43	66	81	104
Length without jaws [mm]	AI	89	104,6	123,3	132,1
Length with jaws [mm]	AJ	94,4	109,4	129,5	139,8
Jaw width [mm]	DH	20	22	26	32
Connecting thread inside	S	M54 x 1,5	M78 x 1,5	M90 x 2	M115 x 2
Piston stroke [mm]	AS	20	25	28	
Bolt hole circle	V	LK Ø 104,8 [3 x M10]	LK Ø 133,4 [3 x M12]	LK Ø 171,4 [3 x M16]	
Outer Ø [mm]	AW	165	215	260	315
Inner Ø [mm]	AV	68	96	118	148
Swing Ø	AX	191.4	265.8	315	375.4
Interface	X	Ø 140	Ø 170	Ø 220	
Depth of thread [mm]	M	15	17	20,3	22,7
Thread position in unclamped position [mm]	JK	35,2	42,2	48,5	51,2
Weight [kg]		13	24	42	66
In stock		✔	✔	✔	✔
Material no.		10002027	10002028	10002029	10002030

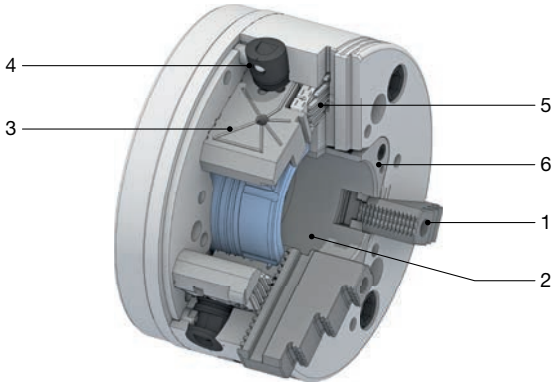
The full functional range is guaranteed only in combination with HAINBUCH universal grease Material no. 10001489 and high-pressure grease gun Material no. 10001493.
The run-out refers to soft, milled top jaws.
The clamping range depends on the jaws that are used.

		
Jaws Page 454	Flanges Page 147	Accessory overview Page 478

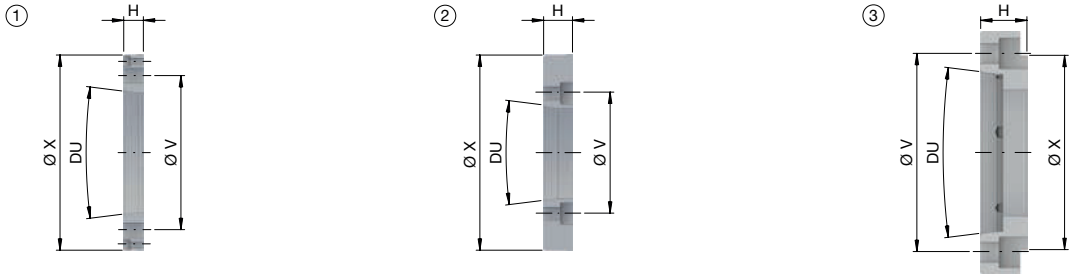
Scope of delivery

- Jaw chuck
- Master jaws
- Actuation tool
- Assembly wrench for revolving threaded ring [size 260/315]

Jaw chuck B-Top in detail

Designation	
1 Jaws with cross offset 2 Large chuck through-bore 3 Innovative lubricating system, consequently longer lubricating intervals and improved clamping force behavior 4 Operational safety when changing jaws due to ball mechanism: The actuating wrench can only be pulled off if the wedge bar is properly engaged in the master jaw 5 Locking mechanism in the wedge bar enables a secure master jaw position and thus guarantees secure mesh of the master jaw gearing in the wedge bar 6 Different insert bushings for fast adaptation to the machining requirements	

Flanges for jaw chuck B-Top

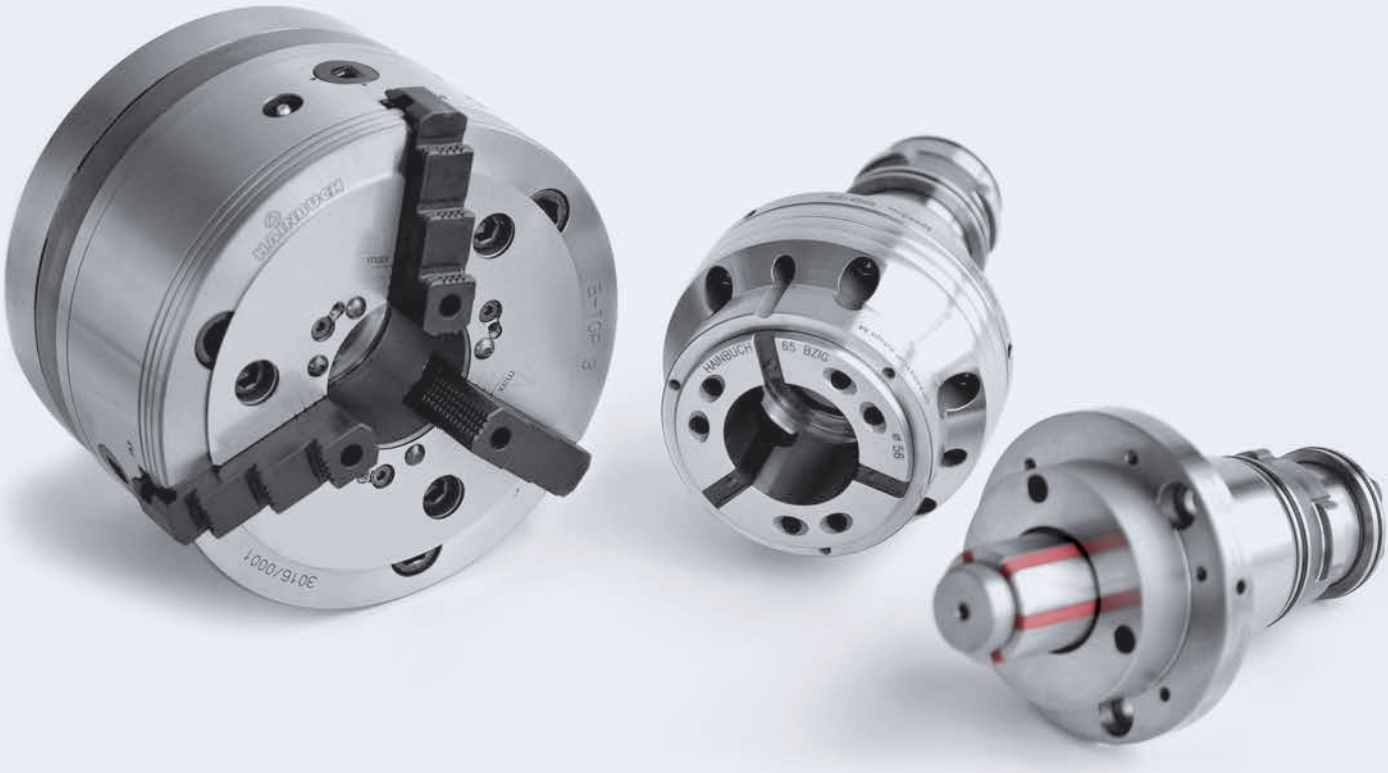


Size	Spindle nose DU	Flange type	Interface X	Length [mm] H	Bolt hole circle V	In stock	Material no.
165	A2-4	2	Ø 140	21	LK Ø 82,6 [6 x M10]	✔	10014760
	A2-5	1		16	LK Ø 104,8 [6 x M10]	✔	10014761
	A2-6	3		34	LK Ø 133,4 [6 x M12]	✔	10014762
215	A2-5	2	Ø 170	25	LK Ø 104,8 [6 x M10]	✔	10014763
	A2-6	1		17	LK Ø 133,4 [6 x M12]	✔	10014764
	A2-8	3		40	LK Ø 171,4 [6 x M16]	✔	10014765
260/315	A2-5	2	Ø 220	28	LK Ø 104,8 [6 x M10]	✔	10014766
	A2-6				LK Ø 133,4 [6 x M12]	✔	10014767
	A2-8	1		19	LK Ø 171,4 [6 x M16]	✔	10014768
	A2-11	3		50	LK Ø 235 [6 x M16]	✔	10014769

Machine spindle standard DIN 55026.

B-Top3

All fits in one another



Jaw chuck B-Top3

I.D., O.D. or jaw clamping – it's easy with the B-Top3 system. Everything fits together. With the MANDO Adapt segmented mandrel, you can change to perfect I.D. clamping in less than 2 minutes. The SPANNTOP adaptation is the right partner if you have reached your holding power and accuracy limits for O.D clamping. And all without disassembling the jaw chuck!

However, the B-Top3 basic clamping device also has its advantages: The fast change of jaws with a single-jaw unlocking mechanism and high repeatability is ideal especially for small lot sizes. Machining the chuck jaw to size is therefore unnecessary in most cases. Also, the insert bushing system is configured for small lot sizes and maximum flexibility. It enables clamping devices to be conveniently adapted to your requirements: closed, with ejector, spray nozzles or variable end-stop. Just the way you need it. And the innovative lubricating system improves clamping force behavior with the wedge bar principle.

You have never turned like this before.

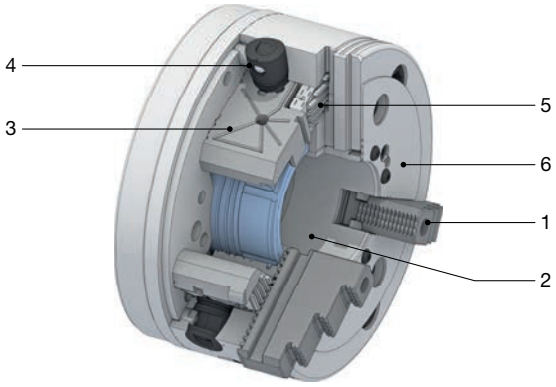
Key advantages

- Jaw chuck with quick conversion to a segmented clamping bushing [I.D. clamping] and a clamping head [O.D. clamping]
- Fast jaw change with individual unlocking
- Large through-bore with bushing inserts that can be changed from the front
- Proven wedge rod mechanism

B-Top3 in use

Jaw chuck B-Top3

Jaw chuck B-Top3 in detail

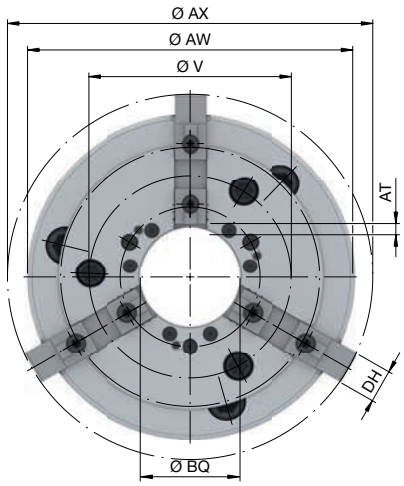
Designation	
1 Jaws with cross offset 2 Large chuck bore with CENTREX interface for ultra-precise change-over without adjustment 3 Innovative lubricating system, consequently longer lubricating intervals and improved clamping force behavior 4 Operational safety when changing jaws due to ball mechanism: The actuating wrench can only be pulled off if the wedge bar is properly engaged in the master jaw 5 Locking mechanism in the wedge bar enables a secure master jaw position and thus guarantees secure mesh of the master jaw gearing in the wedge bar 6 Different insert bushings for fast adaptation to the machining requirements	

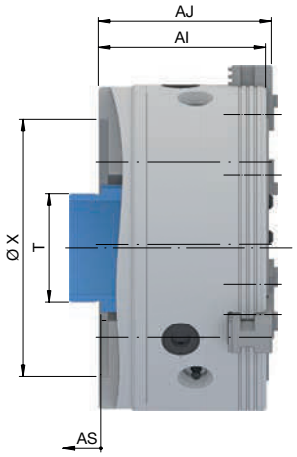
Order overview. Jaw chuck B-Top3

			Clamping elements and adaptations			
						
Size	Material no.	In stock	Jaws for jaw chuck B-Top Page 454	MANDO Adapt for jaw chuck Page 154	SPANNTOP Adapt Page 155	SPANNTOP Adapt M Page 155
215	10002031	✔	✔	✔	✔	✔

Detailed technical data follows.
The full functional range is only guaranteed if HAINBUCH universal grease, material no. 10001489, and high-pressure grease gun, material no. 10001493 are used.

Jaw chuck B-Top3. Technical data





Size		215
Variant		**B-Top3**
Run-out ≤ [mm]		0,020
Max. clamping force [kN]		74
Max. axial drawtube force [pull / push] [kN]		46
RPM n max. [1/min.]		5400
Stroke per jaw [mm]	AT	7,4
Ø Capacity [mm]	BQ	62
Length without jaws [mm]	AI	104,6
Length with jaws [mm]	AJ	109,4
Jaw width [mm]	DH	22
Connecting thread outside	T	M72 x 1,5
Piston stroke [mm]	AS	25
Bolt hole circle	V	LK Ø 133,4 [3 x M12]
Outer Ø [mm]	AW	215
Swing Ø	AX	265.8
Interface	X	Ø 170
Weight [kg]		29,5
In stock		✔
Material no.		10002031

The run-out refers to soft, milled top jaws.
The clamping range depends on the jaws that are used.

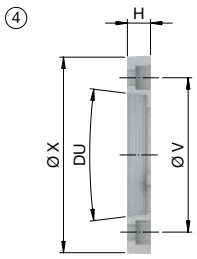
				
Jaws Page 454	Flanges Page 152	Adaptations I.D. clamping Page 154	Adaptations O.D. clamping Page 155	Accessory overview Page 478

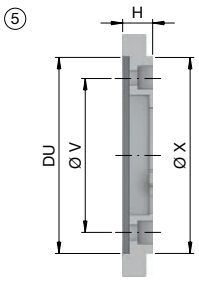
Scope of delivery

- Jaw chuck without spindle flange
- Master jaws
- Protection jaws
- Guard bushing for 22 mm wide top jaws
- Actuation tool

Jaw chuck B-Top3

Flanges for jaw chuck B-Top3

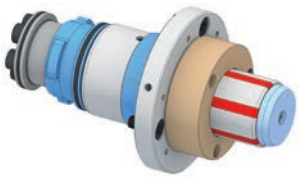




Size	Spindle nose DU	Flange type	Interface X	Length [mm] H	Bolt hole circle V	In stock	Material no.
215	A2-6	4	Ø 170	20	LK Ø 133,4 [6 x M12]	✔	10014757
	A2-8			37	LK Ø 171,4 [6 x M16]	✔	10014758
	AP170	5		20	LK Ø 133,4 [6 x M12]	✔	10014759

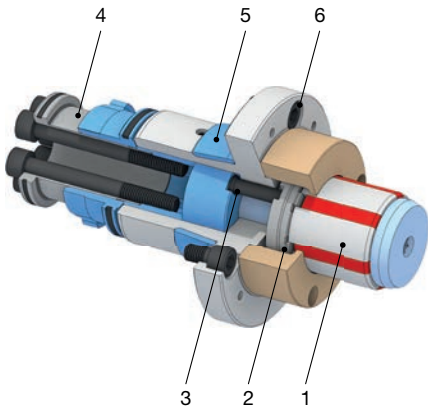
Machine spindle standard DIN 55026.

All adaptation variants at a glance

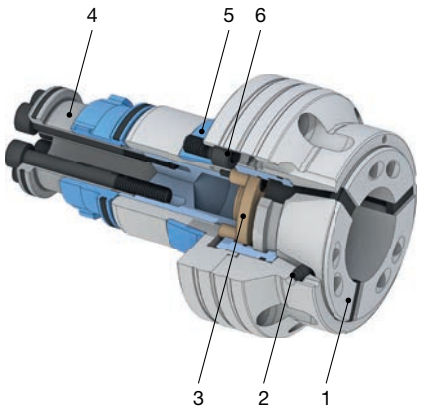
	MANDO Adapt for jaw chuck	SPANNTOP Adapt	SPANNTOP Adapt M
			
Description	Mandrel-in-jaw-chuck with draw bolt	Clamping head end-stop chuck	Clamping head through-bore chuck
Sizes	0, 1, 2, 3	65, 80, 100	65
Clamping range of all sizes [mm]	20 – 80	3 – 100	3 – 65
Ø Capacity			51,3

Attention: These adaptations are configured for a cylinder stroke of 25 mm. For shorter strokes a specially configured adaptation is required.

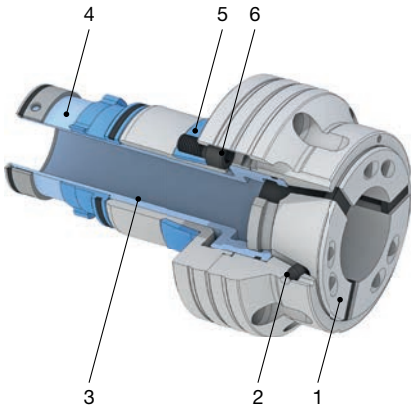
MANDO Adapt in detail

Designation	
1 Segmented clamping bushing with pull-back and hardened steel segments, joined in a vulcanization process 2 Torsional safety lock of segmented clamping bushing 3 Push-off pin 4 Integrated empty stroke. This means it is not necessary to adjust the limit switch on the clamping cylinder 5 CENTREX system for µm-precise use without adjustment 6 Mounting screws	

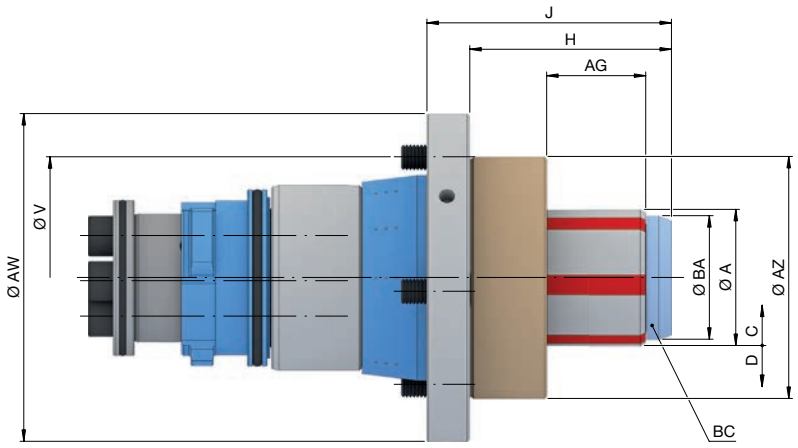
SPANNTOP Adapt in detail [end-stop chuck]

Designation	
1 Clamping head with pull-back and hardened steel segments, joined in a vulcanization process 2 Torsional safety lock of the clamping head 3 Fixed base end-stop for clamping with pull-back effect, central mounting thread for workpiece specific end-stop 4 Integrated empty stroke. This means it is not necessary to adjust the limit switch on the clamping cylinder 5 CENTREX system for µm-precise use without adjustment 6 Mounting screws	

SPANNTOP Adapt M in detail [through-bore chuck]

Designation	
1 Clamping head with pull-back and hardened steel segments, joined in a vulcanization process 2 Torsional safety lock of the clamping head 3 Through-bore Ø 51.3 mm 4 Integrated empty stroke. This means it is not necessary to adjust the limit switch on the clamping cylinder 5 CENTREX system for µm-precise use without adjustment 6 Mounting screws	

MANDO Adapt T211. Technical data and order overview



Size		0	1	2	3
Adaptation size			**215**		
Run-out ≤ [mm]			0,010		
Max. clamping length [mm]	AG	22	26	43	49
Clamping range [mm]	A	20 – 28	26 – 38	36 – 54	50 – 80
Release stroke in Ø [mm]	C		0,3		0,4
Reserve stroke in Ø [mm]	D	0,4		0,5	
Range / recommended workpiece tolerance [mm]			± 0,25		± 0,35
Max. axial drawtube force [pull / push] [kN]		10		20	25
Max. radial clamping force [kN]		42		85	105
RPM n max. [1/min.]			6000		
Length [mm]	H	40	51	71	80
Height [mm]	J	60	71	90	97
Bolt hole circle	V		LK Ø 104,8 [3 x M10]		
Outer Ø [mm]	AW		130		
Draw bolt Ø [mm]	BA	19		35	49
Max. actuating torque [Nm]	BC	10	20	25	55
End-stop outer Ø [mm]	AZ	65	69	93	96
Weight [kg]		4		5	
In stock		✔	✔	✔	✔
Material no.		10001564	10001565	10001566	10001567

In addition to the run-out of the MANDO Adapt, the run-out of the jaw chuck must also be taken into account.
Attention: These adaptations are configured for a cylinder stroke of 25 mm. For shorter strokes a specially configured adaptation is required.

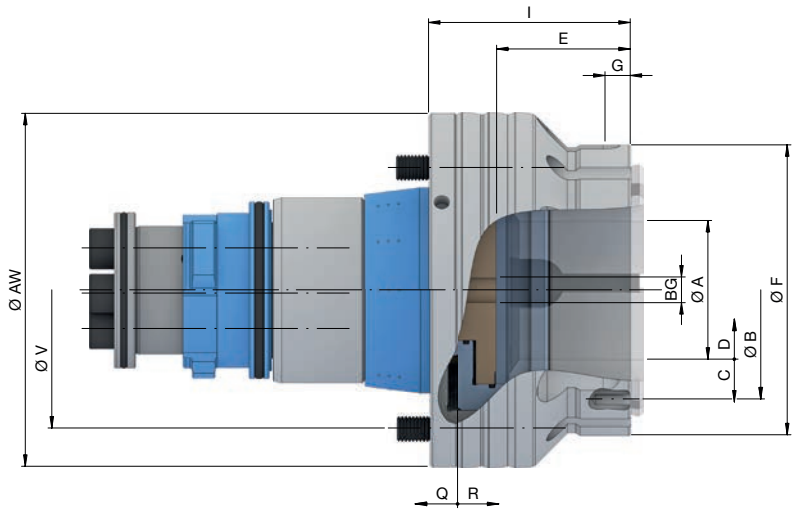

Segmented clamping bushings
Page 442


Accessory overview
Page 478

Scope of delivery

- Mandrel adaptation
- Draw bolt

SPANNTOP Adapt. Technical data and order overview



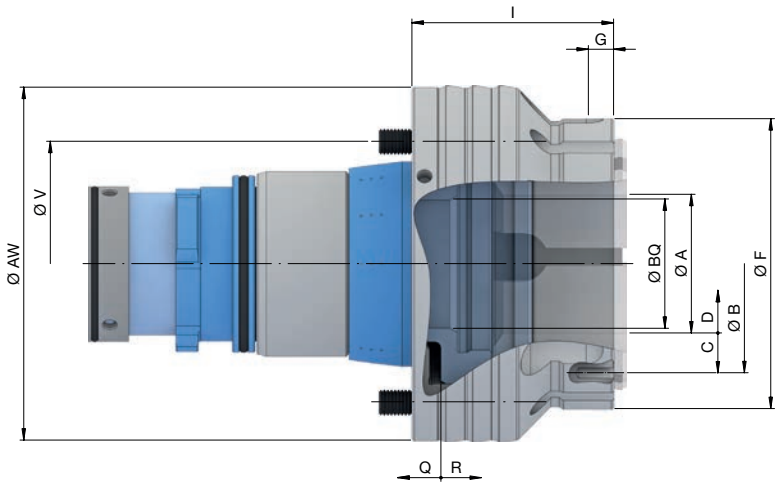
Size		65	80	100
Clamping range [mm]	A	**3 – 65**	**4 – 80**	**15 – 100**
Run-out ≤ [mm]		0,010		
Max. radial clamping force [kN]		105	115	150
Max. axial drawtube force [pull / push] [kN]		45	50	65
Reserve stroke in Ø [mm]	D	1		1,5
Release stroke in Ø [mm]	C	0,6		2
RPM n max. [1/min.]		6000	5500	5000
Reserve stroke axial [mm]	Q	2		3
Release stroke axial [mm]	R	2,5		5
Location front end-stop	F	Ø 115 f7	Ø 145 f7	Ø 191 f7
Bolt hole circle end-stop	B	LK Ø 107 [3 x M5]	LK Ø 130 [3 x M6]	LK Ø 168 [3 x M8]
Centering length [mm]	G	10		
End-stop depth [mm]	E	53	52	63,5
End-stop thread size [M]	BG	12		
Total length [mm]	I	80	85	110
Outer Ø [mm]	AW	140	182	194
Bolt hole circle	V	LK Ø 120 [3 x M10]	LK Ø 160 [3 x M10]	
Weight [kg]		8	14	20
In stock		✔	✔	✔
Material no.		10001670	10001671	10001672

In addition to the run-out of the SPANNTOP Adapt, the run-out of the jaw chuck must also be taken into consideration.
Attention: These adaptations are configured for a cylinder stroke of 25 mm. For shorter strokes a specially configured adaptation is required.


Clamping heads
Page 430


Accessory overview
Page 478

SPANNTOP Adapt M. Technical data and order overview



Size		65
Clamping range [mm]	A	**3 – 65**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		105
Max. axial drawtube force [pull / push] [kN]		45
Reserve stroke in Ø [mm]	D	1
Release stroke in Ø [mm]	C	0,6
RPM n max. [1/min.]		6000
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5
Location front end-stop	F	Ø 115 f7
Bolt hole circle end-stop	B	LK Ø 107 [3 x M5]
Centering length [mm]	G	10
Ø Capacity [mm]	BQ	51,3
Total length [mm]	I	80
Outer Ø [mm]	AW	140
Bolt hole circle	V	LK Ø 120 [3 x M10]
Weight [kg]		8
In stock		✔
Material no.		10001673

In addition to run-out of the SPANNTOP Adapt M, run-out of the jaw chuck must also be taken into consideration.
Attention: These adaptations are configured for a cylinder stroke of 25 mm. For shorter strokes a specially configured adaptation is required.


Clamping heads
Page 430


Accessory overview
Page 478

Jaw chuck B-Top3