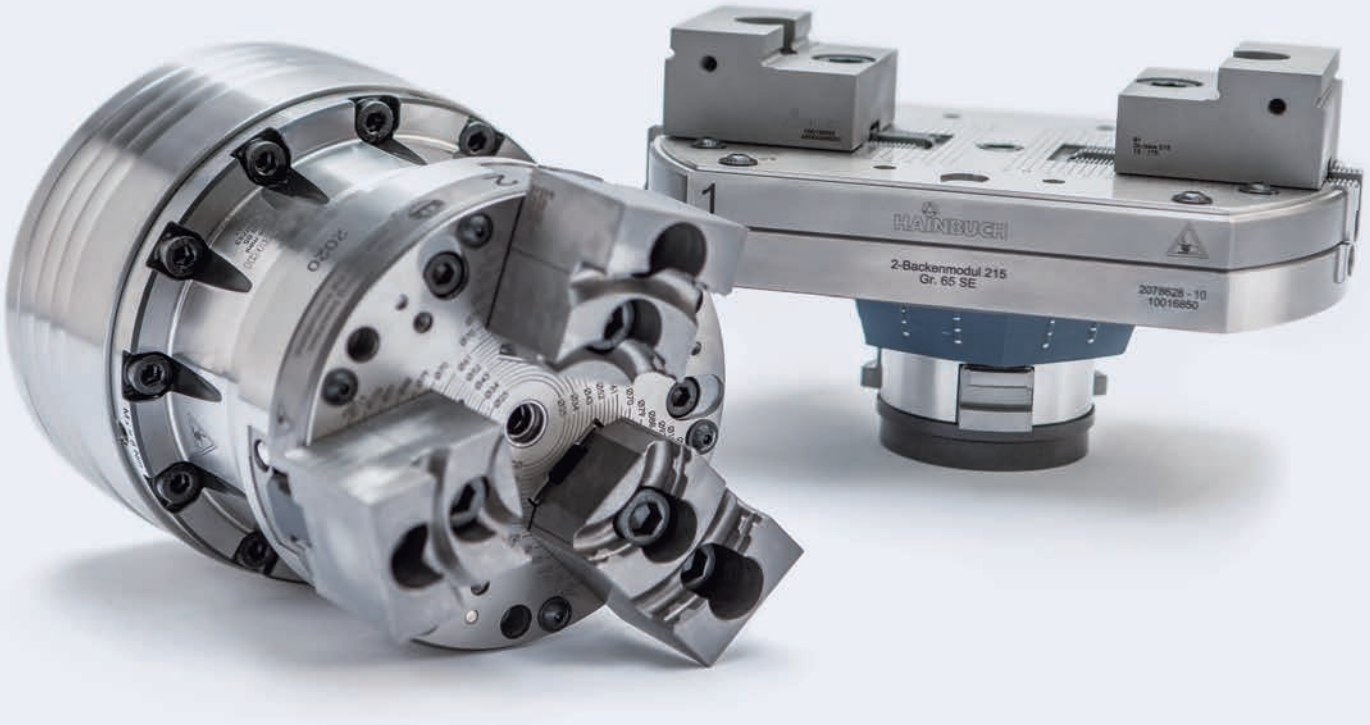
Jaw modules

Perfect for a large parts spectrum

HAINBUCH SYSTEM



Change over from O.D. clamping to jaw clamping or centric clamping in 2 minutes – without clamping device change-over and without having to align? No problem, with the jaw modules. The basic unit, into which the jaw module is inserted, is a HAINBUCH chuck or stationary chuck. If at times the clamping head reaches its limits because it must clamp a larger area, then use one of the jaw modules.

The 3-jaw module is best suited for round workpieces, and if you have cubic workpieces, then rely on the 2-jaw module. This means that for a large parts spectrum you are completely flexible and always have the solution that is ideally suited for the respective clamping situation.

Both are small, lightweight, and can be quickly changed over – an ingenious solution for small-series production.

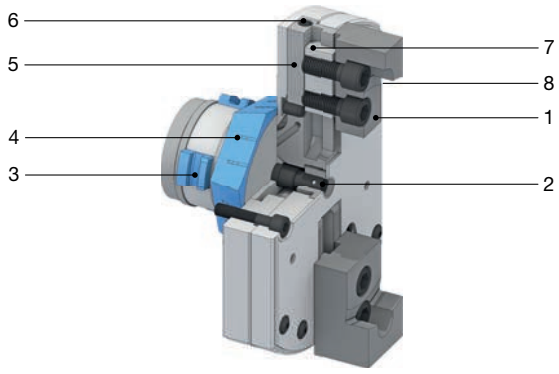
Key advantages

- Jaw clamping in the HAINBUCH chuck or stationary chuck
- Extremely fast conversion without detachment of the base clamping device [2 min.]
- Self-centering on the basic clamping device
- Enlarges clamping range of the basic clamping device
- Deadlength clamping without pull-back effect
- Optimal lubrication and resistant to contamination thanks to the lubricating system

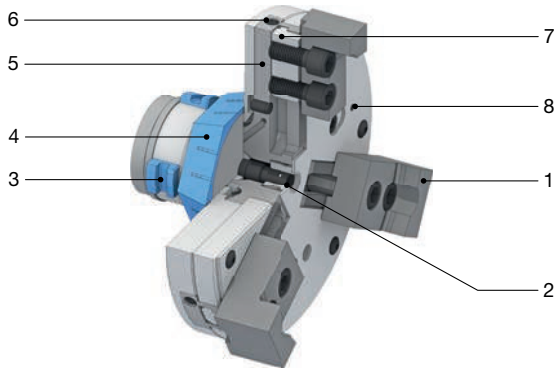
Jaw modules at a glance

	3-jaw module	2-jaw module
		
Description	Adaptation for jaw clamping [O.D. clamping]	Adaptation for centric clamping [O.D. clamping]
Sizes	145, 215	215
Clamping range of all sizes [mm]	25 – 209	15 – 209
Variant	SE [hexagonal], RD [round]	SE [hexagonal], RD [round]
Advantages	■ Machining between the jaws is possible [milling or drilling] ■ Handy and lightweight compared to 3-jaw chucks ■ Run-out ≤ 0.020 mm for re-machined soft jaws	■ Can also be used rotating up to 1,500 rpm ■ Handy and lightweight compared to centric clamping vises ■ Clamping repeatability ≤ 0.010 for hard reversible stepped jaws

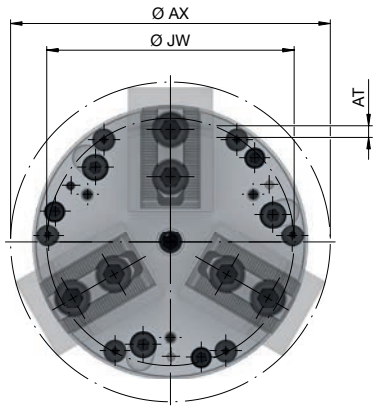
2-jaw module SE in detail

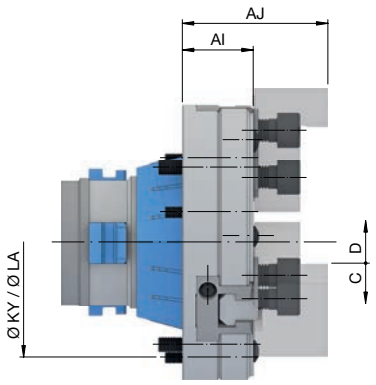
Designation	
1 Adjustable top jaws with fine serration 2 Assembly and locking mechanism 3 Coupling 4 CENTREX system for µm-precise use without adjustment 5 Master jaw 6 Grease nipple 7 T-slot nut 8 Indicator for the clamping reserve	

3-jaw module SE in detail

Designation	
1 Adjustable top jaws with fine serration 2 Assembly and locking mechanism 3 Coupling 4 CENTREX system for µm-precise use without adjustment 5 Master jaw 6 Grease nipple 7 T-slot nut 8 Indicator for the clamping reserve	

3-jaw module SE. Technical data and order overview

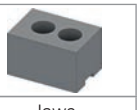




Product line		**SE**		
Adaptation size		**65**		**100**
Size		145	215	
Run-out ≤ [mm]		0,020		
Clamping range [mm]	JW	see overview top jaws		
RPM n max. [1/min.]		5000	3000	
Max. actuating force when boring the jaws [kN]		45		
Max. axial drawtube force [pull / push] [kN]		45		
Max. radial clamping force [kN]		60		
Release stroke in Ø [mm]	C	2,2		5
Reserve stroke in Ø [mm]	D	1,6		2,5
Stroke per jaw [mm]	AT	1,9		3,8
Gear cutting type		1,5 x 60° [serration]		
Swing Ø	AX	~149	~220	
Length without jaws [mm]	AI	37,5		
Length with jaws [mm]	AJ	77		
Bolt hole circle TOPlus mini / premium	KY	LK Ø 112 [3 x M8]		LK Ø 160 [3 x M8]
Bolt hole circle all except TOPlus mini / premium	LA	LK Ø 126 [3 x M6]		LK Ø 180 [3 x M8]
Weight [kg]		6,3	11,3	14,5
In stock		✔	✔	✔
Material no.		10000711	10000712	10000713

Run-out of ≤ 0.020 mm is only ensured with re-machined soft jaws.

Mounting precision for rotating clamping devices: Run-out of 0.005 mm can be achieved between chuck and the adaptation clamping device. Run-out errors on the chuck must be taken into consideration. Mounting repeatability of stationary clamping devices is 0.003 mm on the adaptation clamping device.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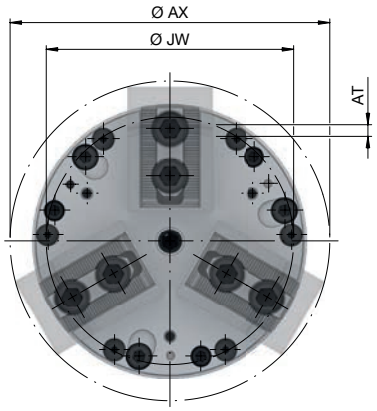
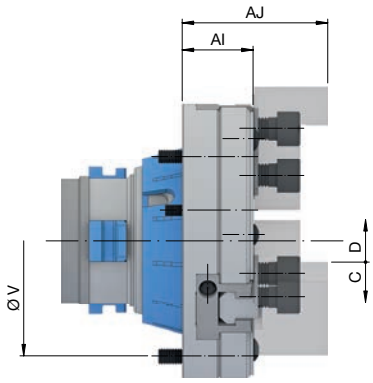
Scope of delivery

- 3-jaw module
- T-slot nuts
- Storage box

3-jaw module RD. Technical data and order overview





Product line		**RD**			
Adaptation size		**65**		**80**	**100**
Size		145	215		
Run-out ≤ [mm]		0,020			
Clamping range [mm]	JW	see overview top jaws			
RPM n max. [1/min.]		5000	3000		
Max. actuating force when boring the jaws [kN]		45			
Max. axial drawtube force [pull / push] [kN]		45			
Max. radial clamping force [kN]		60			
Release stroke in Ø [mm]	C	2,2			5
Reserve stroke in Ø [mm]	D	1,6			2,5
Stroke per jaw [mm]	AT	1,9			3,8
Gear cutting type		1,5 x 60° [serration]			
Swing Ø	AX	~149	~220		
Length without jaws [mm]	AI	37,5		40	37,5
Length with jaws [mm]	AJ	77		80	77
Bolt hole circle	V	LK Ø 126 [3 x M8]		LK Ø 139 [3 x M8]	LK Ø 180 [3 x M8]
Weight [kg]		6,3	11,3	12,6	14,5
In stock		✔	✔	✔	✔
Material no.		10000718	10000719	10000720	10000721

Run-out ≤ 0.020 mm only applies for re-machined soft jaws.

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: The adaptation ring is required for use of the jaw module on a SPANNTOP mini chuck.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Adaptation ring
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Scope of delivery

- 3-jaw module
- T-slot nuts
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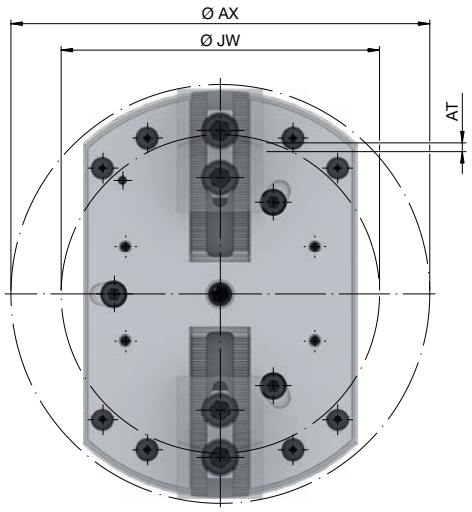
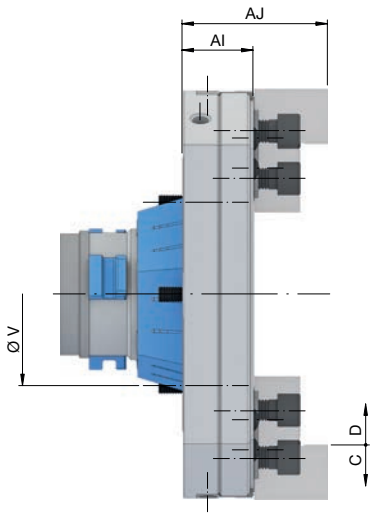
2-jaw module SE. Technical data and order overview

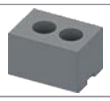




Product line		SE			
Adaptation size		**65**		**100**	
Size		215			
Suitable for		TOPlus mini / premium	all except TOPlus mini / premium		TOPlus mini / premium
Run-out ≤ [mm]		0,020			
Repeatability ≤ [mm]		0,010			
Clamping range [mm]	JW	see overview top jaws			
RPM n max. [1/min.]		1500			
Max. actuating force when boring the jaws [kN]		40			
Max. axial drawtube force [pull / push] [kN]		40			
Max. radial clamping force [kN]		50			
Release stroke in Ø [mm]	C	2,2		5	
Reserve stroke in Ø [mm]	D	1,6		2,5	
Stroke per jaw [mm]	AT	1,9		3,75	
Gear cutting type		1,5 x 60° [serration]			
Swing Ø	AX	220			
Length without jaws [mm]	AI	37,5			
Length with jaws [mm]	AJ	77			
Bolt hole circle	V	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 180 [3 x M8]	LK Ø 160 [3 x M8]
Weight [kg]		10,1	10,2	15,5	
In stock		✔	✔	✔	✔
Material no.		10016842	10016850	10016847	10016848

Run-out ≤ 0.020 mm only applies for re-machined and re-milled jaws.
Clamping repeatability ≤ 0.010 mm for hard reversible stepped jaws:

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



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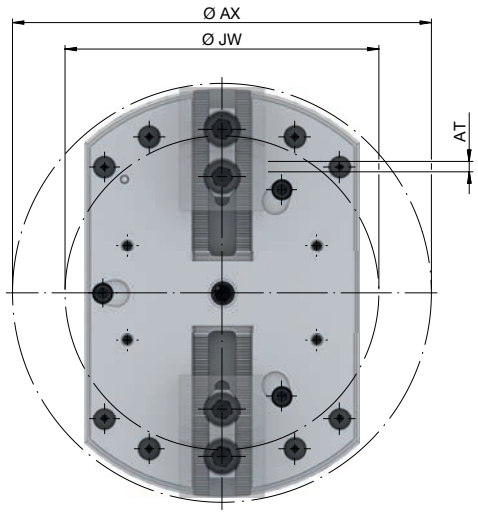
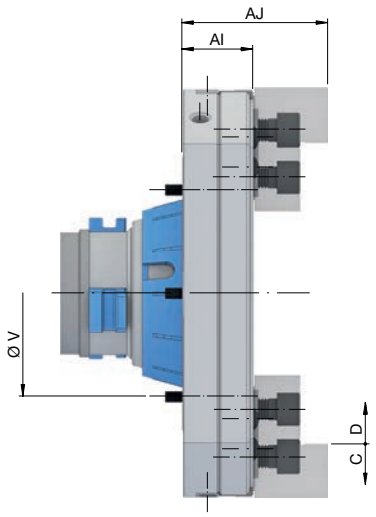
Scope of delivery

- 2-jaw module
- T-slot nuts
- Storage box

2-jaw module RD. Technical data and order overview



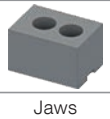


Product line		RD		
Adaptation size		**65**	**80**	**100**
Size		215		
Run-out ≤ [mm]		0,020		
Repeatability ≤ [mm]		0,010		
Clamping range [mm]	JW	see overview top jaws		
RPM n max. [1/min.]		1500		
Max. actuating force when boring the jaws [kN]		40		
Max. axial drawtube force [pull / push] [kN]		40		
Max. radial clamping force [kN]		50		
Release stroke in Ø [mm]	C	2,2		5
Reserve stroke in Ø [mm]	D	1,6		2,5
Stroke per jaw [mm]	AT	1,9		3,75
Gear cutting type		1,5 x 60° [serration]		
Swing Ø	AX	220		
Length without jaws [mm]	AI	37,5		
Length with jaws [mm]	AJ	77		
Bolt hole circle	V	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Weight [kg]		10,2	11,5	15,6
In stock		✔	✔	✔
Material no.		10016849	10016843	10016846

Run-out ≤ 0.020 mm only applies for re-machined and re-milled jaws.
Clamping repeatability ≤ 0.010 mm for hard reversible stepped jaws:

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: The adaptation ring is required for use of the jaw module on a SPANNTOP mini chuck.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