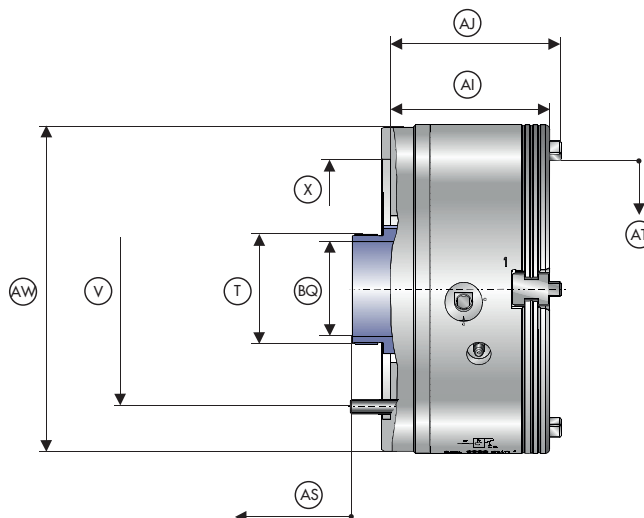
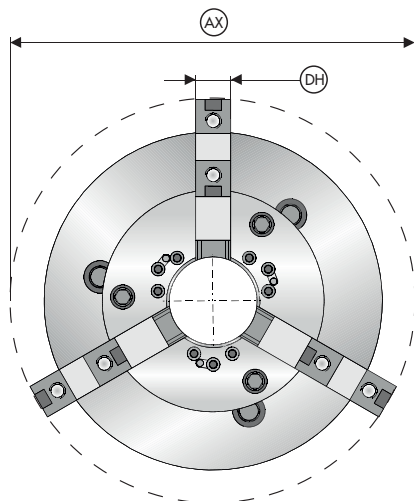


STANDARD CHUCKS

Jaw chuck B-Top3

Jaw chuck B-Top3. Technical data



Size	215	
Variant	B-Top3	
Concentricity [mm]		0,020
Max. clamping force [kN]		74
Max. axial drawtube force [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		✓
Order no.		3016/0001

The runout is related to the already machined top jaws.

					
Flanges	Jaws	Bushing inserts	Adaptations I.D. clamping	Adaptations O.D. clamping	Grease
Page 159	Page 386	Page 164	Page 161	Page 162	Page 165

STANDARD CHUCKS

Jaw chuck B-Top3

Flanges for jaw chuck B-Top3

4

Technical drawing 4 shows a side view of a flange. It features a central spindle nose with diameter DU and a flange with thickness H. The total height of the assembly is X, and the height of the spindle nose is V.




5

Technical drawing 5 shows an end view of the flange. It features a central spindle nose with diameter DU and a flange with thickness H. The total height of the assembly is X, and the height of the spindle nose is V.

Size	Spindle nose DU	Flange type	Interface X	Length [mm] H	Bolt hole circle V	In stock	Order no.
215	AP170	5Ø 170	20	LK Ø 133,4 [6 x M12]	✓	2083/0003	
	A2-6	4	37	LK Ø 171,4 [6 x M16]	✓	2083/0001	
	A2-8				✓	2083/0002	

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	4 – 100	4 – 65
Ø Capacity			51,3

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

STANDARD CHUCKS

Jaw chuck B-Top3

MANDO Adapt in detail

Designation	
<ol style="list-style-type: none"> 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 used without adjustment 6 Mounting screws 	

SPANNTOP Adapt in detail [end-stop chuck]

Designation	
<ol style="list-style-type: none"> 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 used without adjustment 6 Mounting screws 	

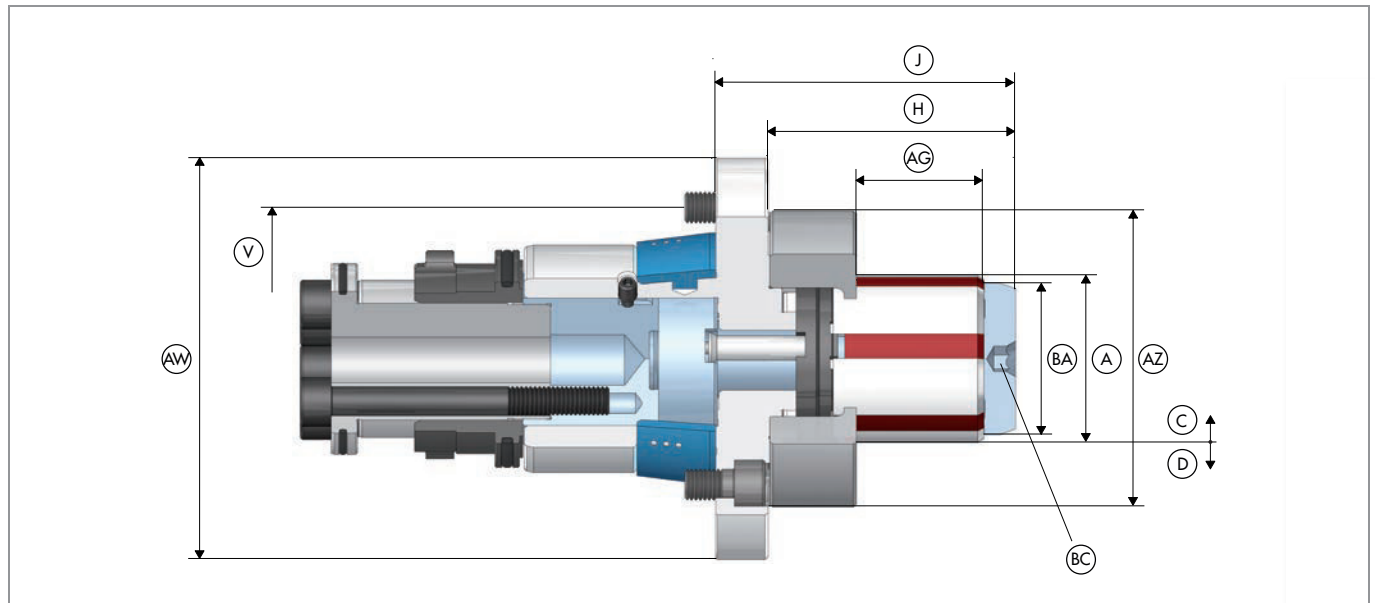
SPANNTOP Adapt M in detail [through-bore chuck]

Designation	
<ol style="list-style-type: none"> 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 $\varnothing 51.3 \text{ mm}$ 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 used without adjustment 6 Mounting screws 	

STANDARD CHUCKS

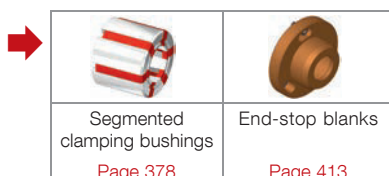
Jaw chuck B-Top3

MANDO Adapt T211. Technical data and order overview



Size		0	1	2	3
Adaptation size		215			
Concentricity [mm]		0,010			
Max. clamping length [mm]	AG	22,00	26,00	43,00	49,00
Clamping range [mm]	A	20 – 28	26 – 38	36 – 54	50 – 80
Release stroke in Ø [mm]	C	0,3			
Reserve stroke in Ø [mm]	D	0,4			
Range / recommended workpiece tolerance [mm]		± 0,25			
Max. axial drawtube force [kN]		10			
Max. radial clamping force [kN]		42			
RPM n max. [1/min.]		6000			
Length [mm]	H	40	51	71	78
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			
Max. actuating torque [Nm]	BC	10	20	25	55
End-stop outer Ø [mm]	AZ	65	69	93	96
Weight [kg]		4			
In stock		✓	✓	✓	✓
Order no.		2522/0001	2522/0002	2522/0003	2522/0004

In addition to the concentricity of the MANDO Adapt, the concentricity 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.



Scope of delivery

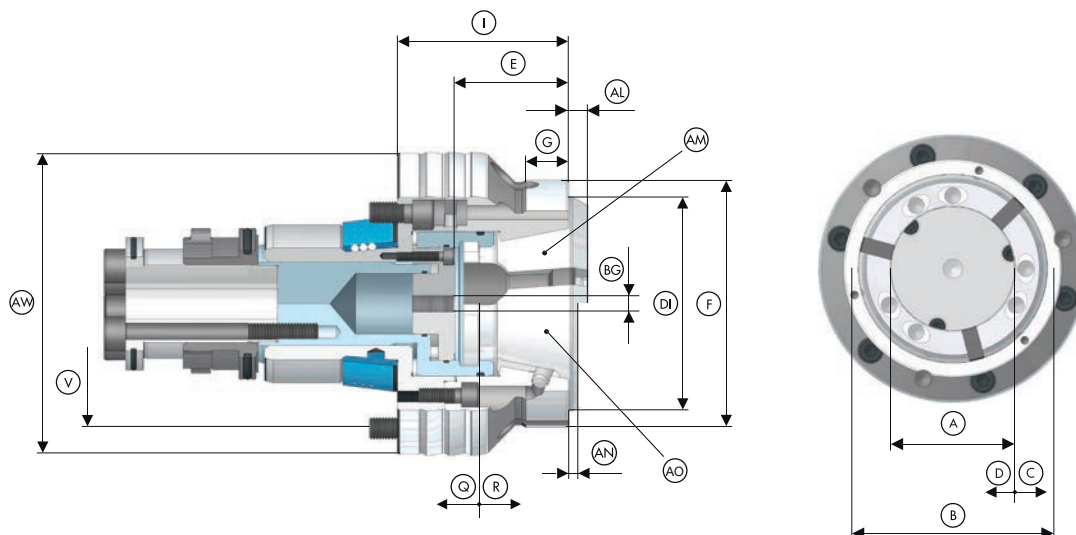
- Mandrel adaptation
- Draw bolt

STANDARD CHUCKS

Jaw chuck B-Top3



SPANTOP Adapt. Technical data and order overview



Size		65	80	100
Clamping range [mm]	A	4 – 65	5 – 80	16 – 100
Concentricity [mm]			0,010	
Max. radial clamping force [kN]		105	115	150
Max. axial drawtube force [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]	
Clamping head serrated	AM	SK 65 BZI	SK 80 BZI	SK 100 BZ
Clamping head protrusion length serrated [mm]	AL	9	4	
Clamping head smooth	AO	SK 65 BZIG	SK 80 BZIG	SK 100 BZG
Clamping head protrusion length smooth [mm]	AN		4	
Head Ø [mm]	DI	99,5	115	144
Weight [kg]		8	14	20
In stock		✓	✓	✓
Order no.		2604/0001	2604/0002	2604/0003

In addition to the concentricity of the SPANTOP Adapt, the concentricity of the jaw chuck must also be taken into consideration.

Attention: These adaptation elements are configured for a cylinder stroke of 25 mm. For shorter strokes customized configured adaptation element is required.



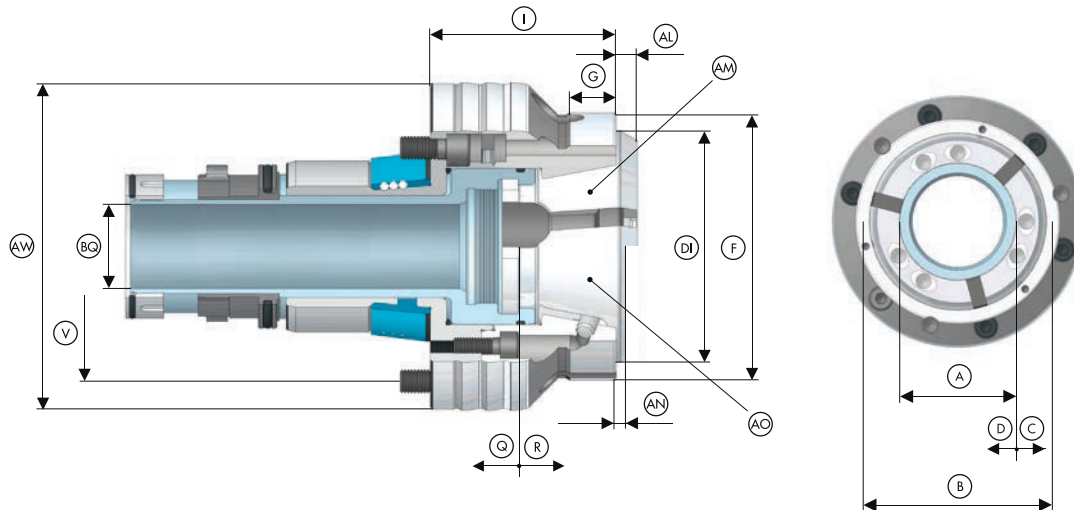
	
Clamping heads	Changing fixtures
Page 368	Page 419



STANDARD CHUCKS

Jaw chuck B-Top3

SPANNTOP Adapt M. Technical data and order overview



Size	65		
Clamping range [mm]	A	5 – 65	
Concentricity [mm]		0,010	
Max. radial clamping force [kN]		105	
Max. axial drawtube force [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]	
Clamping head serrated	AM	SK 65 BZI	
Clamping head protrusion length serrated [mm]	AL	9	
Clamping head smooth	AO	SK 65 BZIG	
Clamping head protrusion length smooth [mm]	AN	4	
Head Ø [mm]	DI	99,5	
Weight [kg]		8	
In stock		✓	
Order no.		2604/0004	


In addition to concentricity of the SPANNTOP Adapt M, concentricity of the jaw chuck must also be taken into consideration.
 Attention: These adaptation elements are configured for a cylinder stroke of 25 mm. For shorter strokes customized configured adaptation element is required.

	
Clamping heads Page 368	Changing fixtures Page 419

STANDARD CHUCKS

Jaw chuck B-Top3

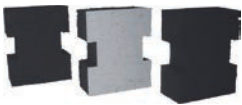



Bushing inserts for jaw chucks B-Top3

Product	Figure	Jaw width [mm]	In stock	Order no.
Bushing insert, closed		22	✓	3019/0009
		40	✓	3019/0012
Bushing insert with ejector		22	✓	3022/0005
		40	✓	3022/0006
Bushing insert with through-bore		22	✓	3019/0010
		40	✓	3019/0011
Bushing insert with spray nozzles		22	✓	3020/0005
		40	✓	3020/0006
Bushing insert with adjustable end-stop		22	✓	3021/0005
		40	✓	3021/0006

STANDARD CHUCKS

Jaw chuck B-Top3

Accessories

Product	Figure	In stock	Order no.
Chip protection		✓	3018/0001
Ejector wrench		✓	3018/0004
High-pressure grease gun		✓	2086/0005
Universal grease		✓	2085/0004

Chucks

Mandrels

Stationary
clamping devices

Adaptation
clamping devices

Quick change-
over systems

Clamping heads,
Bushings, Jaws

Accessories

Multi spindles