CHUCK

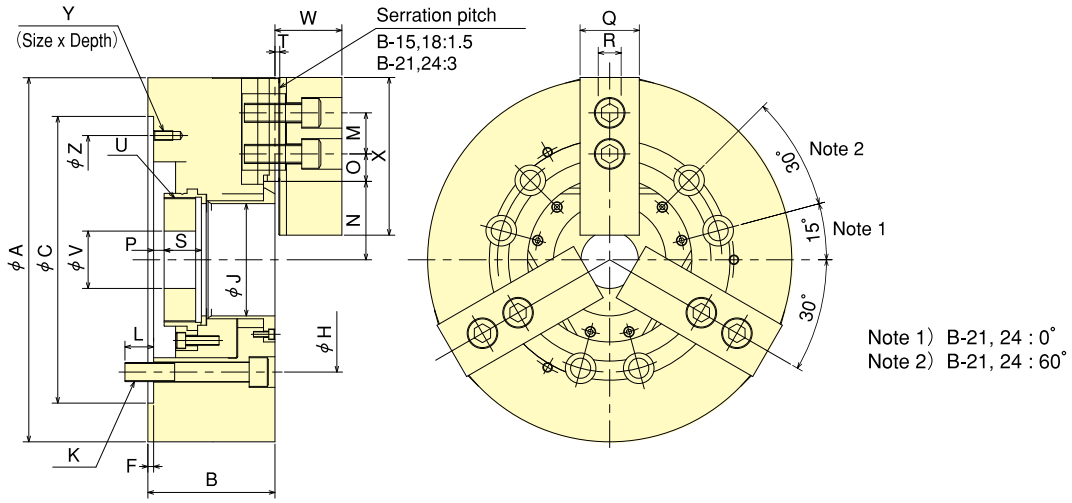
# Large Thru-Hole Power Chuck
# B series

## Stable Machining for Large Work Pieces
## Universally recognised standard chuck

●Through-hole
15inch φ117.5 · 18inch φ117.5
21inch φ140.0 · 24inch φ165.0

＊CE correspondence

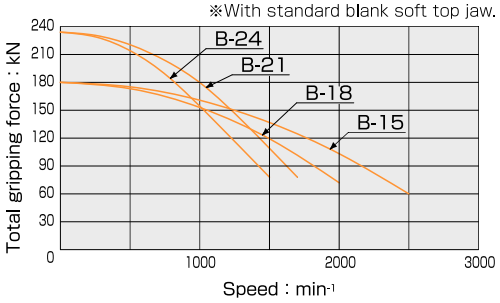
### ■ Dimensional Drawings




Note 1） B-21, 24 : 0°
Note 2） B-21, 24 : 60°

### Gripping Characteristic Graphs

※With standard blank soft top jaw.




### ■ Dimensions ※Blank draw nut equipped.

| Model \ Dimensions | A | B | C (H6) | F | H | J | K | L | M | N max. | N min. | O max. | O min. | P max. | P min. | Q | R | S | T | U max. | V | W | X | Y | Z |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| B-15 | 381 | 133 | 300 | 6 | 235.0 | 117.5 | 6-M20 | 30 | 43 | 82 | 76.7 | 43.75 | 18.25 | 11 | −12 | 62 | 22 | 39 | 5 | M130×2.0 | 60 | 70 | 165 | M10×20 | 260 |
| B-18 | 450 | 133 | 380 | 6 | 235.0 | 117.5 | 6-M20 | 30 | 43 | 82 | 76.7 | 78.25 | 18.25 | 11 | −12 | 62 | 22 | 39 | 5 | M130×2.0 | 60 | 70 | 165 | M10×20 | 320 |
| B-21 | 530 | 140 | 380 | 6 | 330.2 | 140 | 6-M22 | 31 | 60 | 98.5 | 93.2 | 87.5 | 21.5 | 11 | −12 | 65 | 25 | 39 | 5 | M155×3.0 | 80 | 73 | 180 | M12×30 | 330.2 |
| B-24 | 610 | 149 | 380 | 6 | 330.2 | 165 | 6-M22 | 32 | 60 | 108 | 102.7 | 117.5 | 21.5 | 20 | − 3 | 65 | 25 | 40.5 | 5 | M175×3.0 | 80 | 73 | 180 | M12×25 | 330.2 |

### ■Specifications

| Model \ Specifications | Thru-Hole mm | Gripping range mm Max. | Gripping range mm Min. | Jaw Stroke (diameter) mm | Plunger Stroke mm | Max. Draw Bar Pull Force kN (kgf) | Max. Gripping Force kN (kgf) | Max. Speed min-1 | Net Weight with Soft top jaws kg | Moment of inertia kg·m² | Matching Cylinder | Max. pressure MPa(kgf/cm²) | Matching Hard top jaw | Matching Soft top jaw |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| B-15 | 117.5 | 381 | 30 | 10.6 | 23 | 71.0 (7240) | 180.0 (18355) | 2500 | 120.0 | 2.273 | F2511H | 2.30 (23.5) | HB15A1 | SB15C1 |
| B-18 | 117.5 | 450 | 30 | 10.6 | 23 | 71.0 (7240) | 180.0 (18355) | 2000 | 164.0 | 4.451 | F2511H | 2.30 (23.5) | HB15A1 | SB15C1 |
| B-21 | 140 | 530 | 87 | 10.6 | 23 | 90.0 (9177) | 234.0 (23861) | 1700 | 235.0 | 8.950 | F2511H | 3.00 (30.6) | HB18B2 | SB18A2 |
| B-24 | 165 | 610 | 109 | 10.6 | 23 | 90.0 (9177) | 234.0 (23861) | 1400 | 293.0 | 16.600 | F2511H | 3.00 (30.6) | HB18B2 | SB18A2 |

# Large Thru-Hole Power Chuck (Direct Mount)
# B-A series

## Equipped with Chuck Adaptor to suit Spindle Nose
## Universally recognised standard chuck

＊CE correspondence



## Dimensional Drawings

Fig. 2

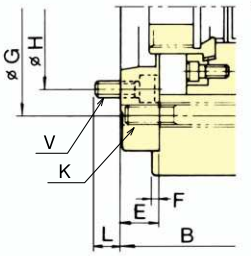
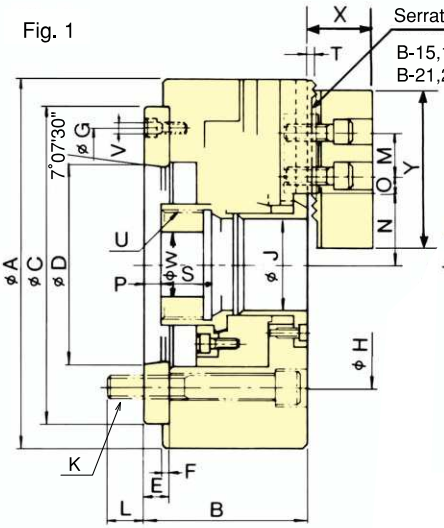
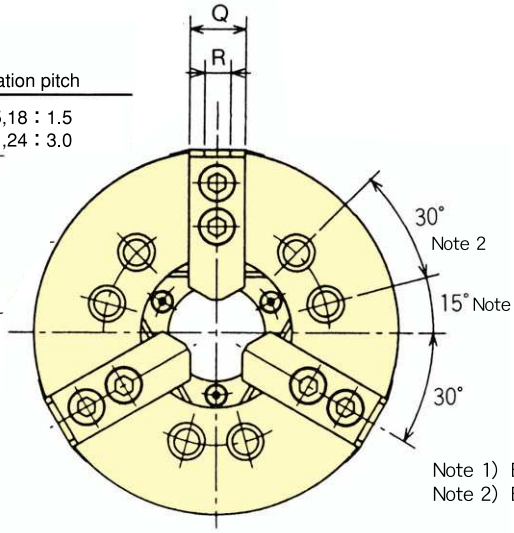



Fig. 1

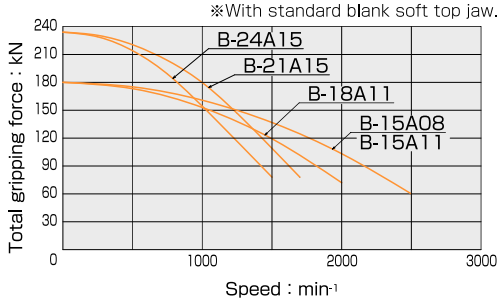



Note 1) B-21, 24 : 0°
Note 2) B-21, 24 : 60°

## Gripping Characteristic Graphs

※With standard blank soft top jaw.




## Dimensions ※B-15A08 is reffered to in Fig.2. ※Blank draw nut equipped.

| Model \ Dimensions | A | B | C | D | E | F | G | H | J | K | L | M | N max. | N min. | O max. | O min. | P max. | P min. | Q | R | S | T | U max. | V | W | X | Y |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| B-15A08 | 381 | 160 | 300 | 139.719 | 33 | 6 | 235 | 171.4 | 117.5 | 6-M20 | 24 | 43 | 82 | 76.7 | 43.75 | 18.25 | 44 | 21 | 62 | 22 | 39 | 5 | M130×2.0 | 6-M16 | 60 | 70 | 165 |
| B-15A11 | 381 | 149 | 300 | 196.869 | 22 | 6 | 260 | 235.0 | 117.5 | 6-M20 | 28 | 43 | 82 | 76.7 | 43.75 | 18.25 | 33 | 10 | 62 | 22 | 39 | 5 | M130×2.0 | 3-M10 | 60 | 70 | 165 |
| B-18A11 | 450 | 149 | 380 | 196.869 | 22 | 6 | 320 | 235.0 | 117.5 | 6-M20 | 28 | 43 | 82 | 76.7 | 78.25 | 18.25 | 33 | 10 | 62 | 22 | 39 | 5 | M130×2.0 | 3-M10 | 60 | 70 | 165 |
| B-21A15 | 530 | 161 | 380 | 285.775 | 27 | 6 | 330.2 | 330.2 | 140 | 6-M22 | 34 | 60 | 98.5 | 93.2 | 87.5 | 21.5 | 38 | 15 | 65 | 25 | 39 | 5 | M155×3.0 | 3-M12 | 80 | 73 | 180 |
| B-24A15 | 610 | 170 | 380 | 285.775 | 27 | 6 | 330.2 | 330.2 | 165 | 6-M22 | 35 | 60 | 108 | 102.7 | 117.5 | 21.5 | 47 | 24 | 65 | 25 | 40.5 | 5 | M175×3.0 | 3-M12 | 80 | 73 | 180 |

## Specifications

| Model \ Specifications | Thru-Hole mm | Gripping range mm Max. | Gripping range mm Min. | Jaw Stroke (diameter) mm | Plunger Stroke mm | Max. Draw Bar Pull Force kN (kgf) | Max. Gripping Force kN (kgf) | Max. Speed min-1 | Net Weight with Soft top jaws kg | Moment of inertia kg·m² | Matching Cylinder | Max. pressure MPa(kgf/cm²) | Matching Hard top jaw | Matching Soft top jaw | Spindle nose size |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| B-15A08 | 117.5 | 381 | 30 | 10.6 | 23 | 71.0 (7240) | 180.0(18355) | 2500 | 134.0 | 2.470 | F2511H | 2.30 (23.5) | HB15A1 | SB15C1 | A2-8 |
| B-15A11 | 117.5 | 381 | 30 | 10.6 | 23 | 71.0 (7240) | 180.0(18355) | 2500 | 127.0 | 2.385 | F2511H | 2.30 (23.5) | HB15A1 | SB15C1 | A2-11 |
| B-18A11 | 117.5 | 450 | 30 | 10.6 | 23 | 71.0 (7240) | 180.0(18355) | 2000 | 178.0 | 4.775 | F2511H | 2.30 (23.5) | HB15A1 | SB15C1 | A2-11 |
| B-21A15 | 140 | 530 | 87 | 10.6 | 23 | 90.0 (9177) | 234.0(23861) | 1700 | 246.0 | 9.250 | F2511H | 3.00 (30.6) | HB18B2 | SB18A2 | A2-15 |
| B-24A15 | 165 | 610 | 109 | 10.6 | 23 | 90.0 (9177) | 234.0(23861) | 1400 | 304.0 | 16.850 | F2511H | 3.00 (30.6) | HB18B2 | SB18A2 | A2-15 |