

# NEW GENERATION

## The sealed quick jaw change manual chuck

### HG-2G

>> ALL EXISTING TOP JAWS CAN BE USED

#### Customer Benefits

	HG-N	HG-2G
Minimized set up times due to the quick jaw change system	■	■
Highest accuracy of the jaw change	■	■
Universal	■	■
Case hardened parts	■	■
Wedge bar drive	■	■
Jaw safety interlock	■	■
Ideal for vertical mounting of chuck		■
Sealed wedge bars and base jaws		■
Optimized lubrication in the jaw guides		■
Low maintenance		■

#### Economic and Efficiency

Example: Maintenance costs at high accumulation of dirt / coolant

	HG-N	HG-2G
Lubrication interval	every shift	every 3rd shift
Required time for lubricating	10 Min.	10 Min.
Working days / year	230	230
Required time / year	2.300 Min.	767 Min.
Machine costs / hour	€ 60.–	€ 60.–
Total costs / year	€ 2.300.–	€ 767.–
<b>Profit / year *</b>	<b>at 1-shift operation</b>	<b>€ 1.533.–</b>
	<b>at 2-shift operation</b>	<b>€ 3.066.–</b>
	<b>at 3-shift operation</b>	<b>€ 4.599.–</b>

\* Additionally the profit is increased by reducing the down time of the machine, as the 2G-chucks also need less disassembling for cleaning.

# Clamping glossary

**HG-2G:** Evolution of the quick jaw change power chuck HG-N. The HG-2G features additional seals and an improved lubrication system for low maintenance. **The chuck still offers all the same advantages as the HG-N.**

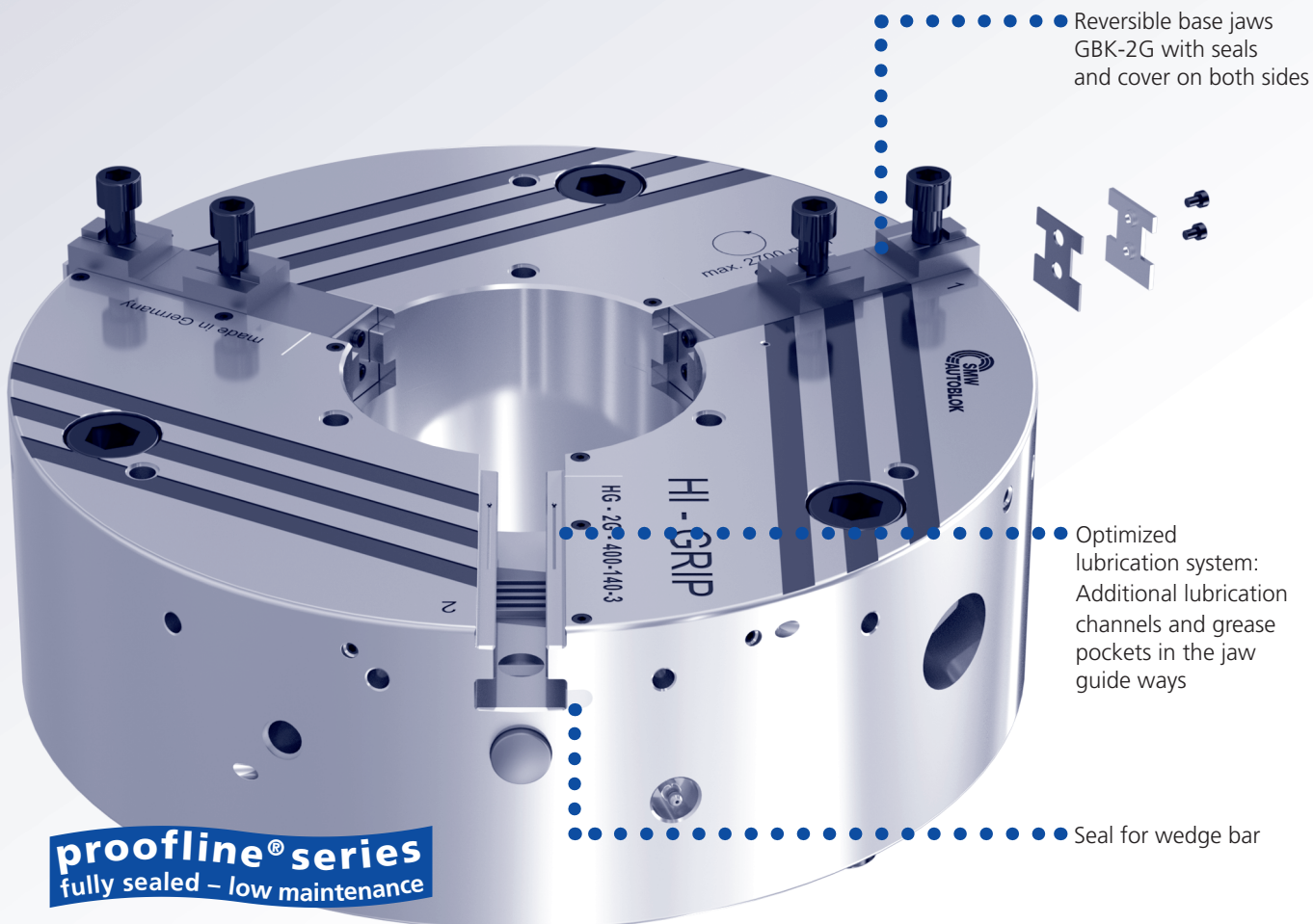
The proven wedge bar drive guarantees unmatched accuracy and rigidity. A low loss of grip force due to centrifugal force makes the chuck ideal for high speed applications.

**Sealing:** The HG-2G is sealed by seals attached to both faces of the base jaws. Also the wedge bars are protected by mechanical seals. The seals **protect the chuck** against penetration of dirt and swarf.

**Low Maintenance:** The **lubrication system of the HG-2G is optimized.** Additional lubrication channels and grease pockets integrated in the jaw guide ways ensure constant clamping force. The lubrication intervals are significantly longer reducing down times and cost for maintenance.

**Mass production:** The sealing and the new lubrication system make the HG-2G also suitable for use on machining centers or turning and milling centers in vertical operation.

**Compatibility:** The HG-2G is interchangeable with the standard series of quick jaw change chucks HG-N. Existing master jaws still can be used without sealing. A small modification made to the master jaws and a **mounting kit** can upgrade existing master jaws to become 2G master jaws.

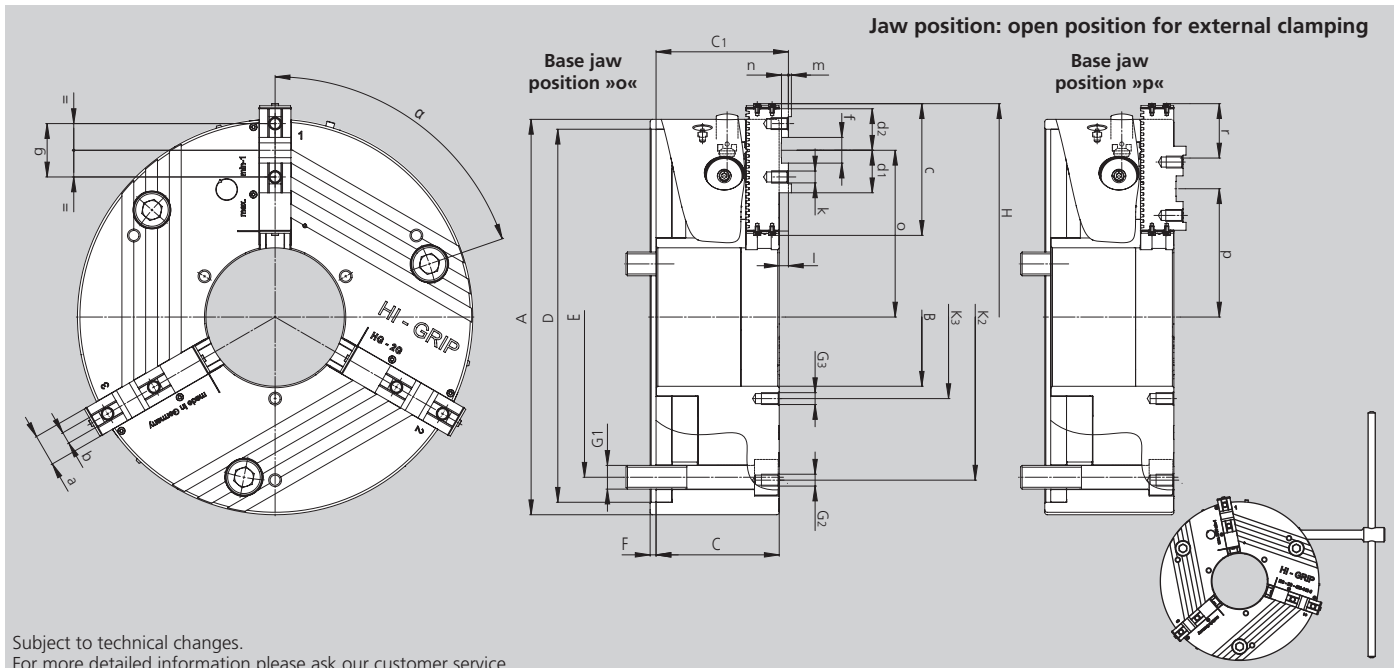


# HG-2G

## Manual chucks Ø 400 - 630 mm

QUICK JAW CHANGE  
Jaw system original SMW

### Main dimensions and technical data



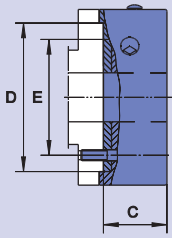
Subject to technical changes.  
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type HG-2G		400-140	500-165	630-254
Mounting	Size	Z380	Z380	Z380
	A	400	500	630
	B	140	165	254
	C	124.6	136	143
	C1	133.9	146	153
H6	D	380	380	380
	E	330.2	330.2	330.2
	F	6	8	8
	G1	M24	M24	M24
	G2	M12 / 3 x 120°	M16 / 9 x 40°	M16 / 6 x 60°
	G3	M12 / 3 x 120°	M12 / 3 x 120°	M12 / 3 x 120°
Swing dia.	H	432	on request	on request
	K2	330	420	550
	K3	165	195	290
	α°	71	71	74
Master jaw		GBK-2G 400	GBK-2G 500	GBK-2G 630
	a	32	45	45
f7	b	12	18	18
	c	133.2	167.7	209.7
	d1	43	53	53
	d2	42	48.25	49.7
H7	f	26	30	30
	g	54	60	60
Thread / thread depth	k	M12 / 17	M16 / 34	M16 / 34
	l	9.3	10	10
	m	3	4	4
	n	7	9	9
Max. / min.	o	168.8 / 113.8	211 / 141	291.5 / 200.5
Max. / min.	p	129.8 / 74.8	150 / 80	191.5 / 100.5
Base jaw tooth pitch	-	5.5	7	7
Master jaw offset	r	55	70	91
Master jaw offset	teeth	10	10	13
<b>Usable jaw stroke</b>	mm	8.5	11.5	13
<b>Max. total gripping force</b>	kN	220	250	250
<b>At max. torque Md</b>	Nm	250	260	260
<b>Speed</b>	r.p.m.	2700	1500	1000
<b>Weight without jaws</b>	kg	99	161	270
<b>Moment of inertia</b>	kg·m²	1.9	4.5	12

Further sizes on request.

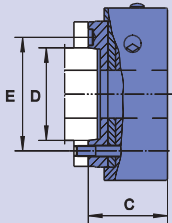
Ordering review

**Chuck with center mounting DIN 6350**



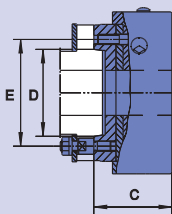
HG-2G	400-140		500-165		630-254	
Mounting	Z380		Z380		Z380	
C	125		136		136	
D	380		380		380	
E	330.2		330.2		330.2	
<b>Chuck with GBK-2G + WAK</b>						
Id. No.	161729		161813		161827	
<b>Chuck with GBK-2G + GUA</b>						
Id. No.	161800		161814		161828	

**Chuck with ISO-A mounting DIN 55026**



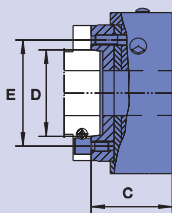
HG-2G	400-140		500-165		630-254	
Mounting	A11	A15	A11	A15	A11	A15
C	165	161	176	172	176	172
D	196.88	285.77	196.88	285.77	196.88	285.77
E	235.0	330.2	235.0	330.2	235.0	330.2
<b>Chuck with GBK-2G + WAK</b>						
Id. No.	161801	161807	161815	161821	161829	161835
<b>Chuck with GBK-2G + GUA</b>						
Id. No.	161802	161808	161816	161822	161830	161836

**Chuck with bayonet mounting DIN 55027 Type C**



HG-2G	400-140		500-165		630-254	
Mounting	C11	C15	C11	C15	C11	C15
C	161	161	172	172	172	172
D	196.88	285.77	196.88	285.77	196.88	285.77
E	235.0	330.2	235.0	330.2	235.0	330.2
<b>Chuck with GBK-2G + WAK</b>						
Id. No.	161803	161809	161817	161823	161831	161837
<b>Chuck with GBK-2G + GUA</b>						
Id. No.	161804	161810	161818	161824	161832	161838

**Chuck with Camlock mounting DIN 55029 Type S**



HG-2G	400-140		500-165		630-254	
Mounting	S11	S15	S11	S15	S11	S15
C	175	175	186	186	186	186
D	196.88	285.77	196.88	285.77	196.88	285.77
E	235.0	330.2	235.0	330.2	235.0	330.2
<b>Chuck with GBK-2G + WAK</b>						
Id. No.	161805	161811	161819	161825	161833	161839
<b>Chuck with GBK-2G + GUA</b>						
Id. No.	161806	161812	161820	161826	161834	161840

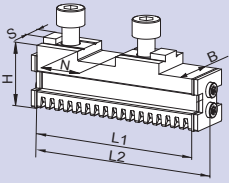
Parts included: Fixing elements (screws resp. studs resp. camlock bolts).  
Further sizes on request.

# HG-2G

## Jaws

### QUICK JAW CHANGE

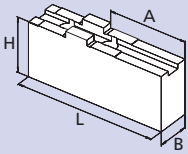
#### GBK-2G Hardened base jaws



Chuck	HG-2G 400	HG-2G 500	HG-2G 630
Jaw type	GBK-2G 400	GBK-2G 500	GBK-2G 630
Id. No.	161605	161843	161846
B	32	45	45
H	43	57	57
L1	123	158	198
L2 *	133.2	168.2	208.2
N	26	30	30
S	12	18	18
kg / set	3.0	7.1	9.0

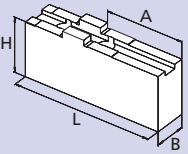
\* Dimension incl. seals, cover and screws

#### WAK Soft top jaws



Chuck	HG-2G 400	HG-2G 500	HG-2G 630
Jaw type	WAK 400-10	WAK 500-10	WAK 500-10
Id. No.	012494	012495	012495
B	35	50	50
H	54	73	73
L	145	180	180
A	74	100	100
kg / set	5.8	13.7	13.7

#### WAKS Wide soft top jaws

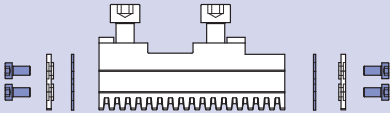


Chuck	HG-2G 400	HG-2G 500	HG-2G 630
Jaw type	WAKS 400-30	WAKS 500-30	WAKS 500-30
Id. No.	012500	012501	012501
B	80	90	90
H	64	73	73
L	100	130	130
A	44	65	65
kg / set	11.0	16.4	16.4

### Seal Kit

#### for hardened base jaws GBK-2G

Consisting of seals (6 pcs.)  
and mounting screws (12 pcs.)

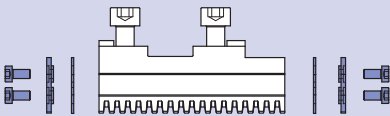


HG-2G	400	500	630
Seal kit type	GBK-2G 400	GBK-2G 500	GBK-2G 630
Id. No.	205385	206915	206915

### Mounting Kit

#### for hardened base jaws GBK-2G

Consisting of seals (6 pcs.), covers (6 pcs.)  
and mounting screws (12 pcs.)



HG-2G	400	500	630
Mounting kit type	GBK-2G 400	GBK-2G 500	GBK-2G 630
Id. No.	205389	206916	206916

#### Advice:

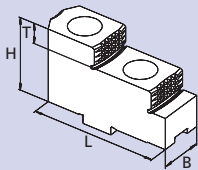
Existing master jaws still can be used without seals. A small modification made to the master jaws and a mounting kit can upgrade existing master jaws to become 2G master jaws (instruction for the rework on request).

JAWS-CATALOG  
Request or  
download:  
[www.smw-autoblok.de](http://www.smw-autoblok.de)

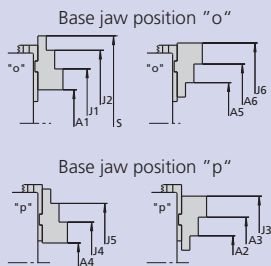


QUICK JAW CHANGE

**GUA**  
Hardened reversible  
stepped top jaws



**Clamping ranges**



Chuck	HG-2G 400	HG-2G 500	HG-2G 630
Jaw type	GUA 400	GUA 500	GUA 500
Id. No.	012487	012488	012488
B	36	45	45
H	56	70	70
L	105	130	130
T	15	20	20
kg / set	3.2	10.8	10.8
A1	138-258	150-308	265-469
A2	78-188	37-181	58-262
A3	186-298	144-302	179-383
A4	60-183	33-191	65-269
A5	143-268	143-301	258-462
A6	253-378	264-422	379-583
J1	218-338	259-417	374-578
J2	328-448	380-538	495-699
J3	263-380	253-411	288-492
J4	138-263	139-297	174-378
J5	248-373	260-418	295-499
J6	333-458	373-531	488-692
S	-	570	732

JAWS-CATALOG

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**Important for maintenance and safe operation,  
to be ordered with the chuck**

**Grease KO5®**

Special grease for  
manual and power chucks



Cartridge 14 Oz. (DIN 1284)  
Grease content 500 g  
Id. No. 016440

Can 1000 g  
Id. No. 011881



- High adhesion
- High resistance against coolant
- High load bearing capacity
- High gripping force
- Low friction coefficient
- Avoids tribocorrosion

**Grease gun**

Grease gun (DIN 1283) for  
cartridges 14 Oz. (DIN 1284)

■ Also refillable from grease can 1000 g



**Lubrication set Id. No. 083726**

Supply range

- Grease gun
- 1 Adapter flexible for high pressure grease nipple
- 1 Adapter for cone grease nipple