



Jaw modules

Perfect for a large variety of parts

Jaw modules



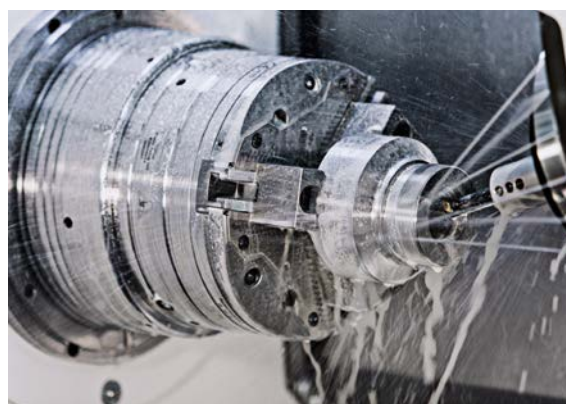
Change over from O.D. clamping to jaw clamping or centric clamping in 2 minutes – without clamping device change-over and without having to align? No problem, with the jaw modules. Because the basic unit, into which the jaw module is inserted, is a HAINBUCH chuck or stationary chuck. If at times the 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 from O.D. to I.D. without detachment of the base clamping device [2 min.]
- Self-centering on the basic clamping device
- Enlarged 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 module on the machine

Jaw modules at a glance

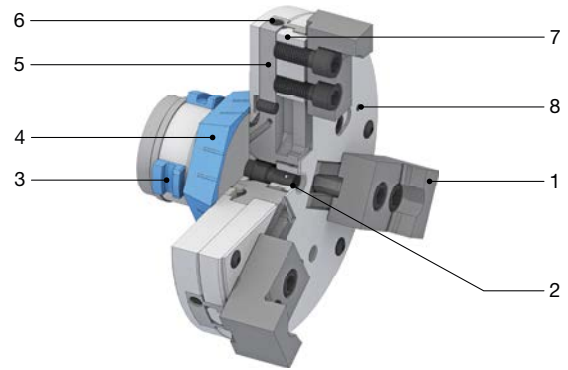
	3-jaw module	2-jaw module
		
Description	Adaptation for jaw clamping [O.D. clamping]	Adaptation for centric clamping [O.D. clamping]
Sizes	145, 215	215
Clamping range of all sizes [mm]	25 – 209	15 – 209
Variant	SE [hexagonal], RD [round]	SE [hexagonal], RD [round]
Advantages	<ul style="list-style-type: none"> ■ 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 	<ul style="list-style-type: none"> ■ 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



3-jaw module SE in detail

Designation

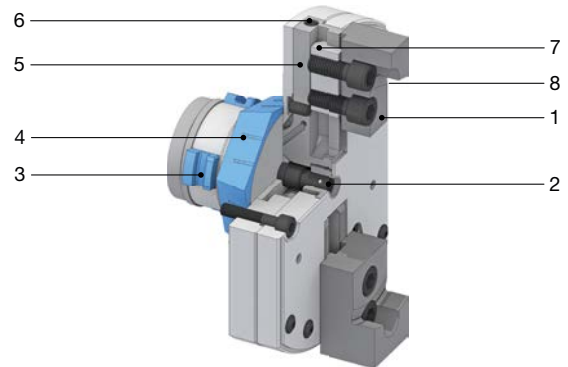
- 1 Adjustable top jaws with fine serration
- 2 Assembly and locking mechanism
- 3 Coupling
- 4 CENTREX system for μm -precise used without adjustment
- 5 Master jaw
- 6 Grease nipple
- 7 T-slot nut
- 8 Indicator for the clamping reserve



2-jaw module SE in detail

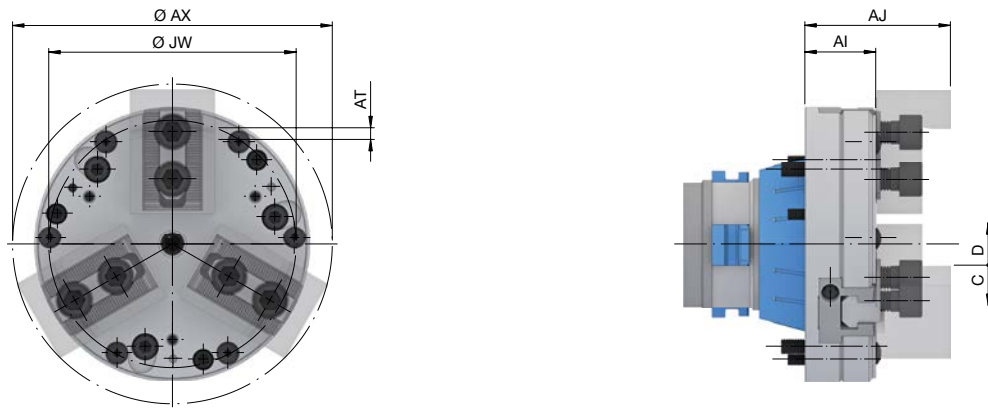
Designation

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





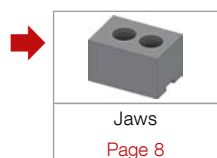
3-jaw module SE. Technical data and order overview



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	
Weight [kg]		6,3	14,5
In stock		✓	✓
Material	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 jaw module. Run-out errors on the chuck must be taken into consideration. Mounting repeatability of stationary clamping devices is 0.003 mm on the jaw module.

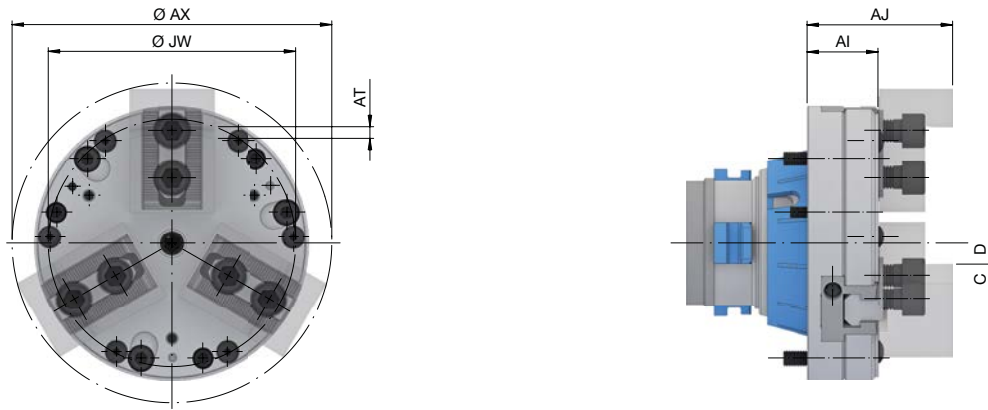


Scope of delivery

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



3-jaw module RD. Technical data and order overview

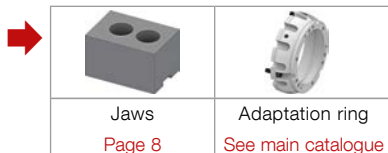


Product line	RD			
Adaptation size	65		80	100
Size	145		215	
Run-out ≤ [mm]	0,020			
Clamping range [mm]	JW	see overview top jaws		
RPM n max. [1/min.]	5000		3000	
Max. actuating force when boring the jaws [kN]	45			
Max. axial drawtube force [pull / push] [kN]	45			
Max. radial clamping force [kN]	60			
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
Weight [kg]		6,3	11,3	12,6
In stock		✓	✓	✓
Material		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 jaw module. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the jaw module.

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



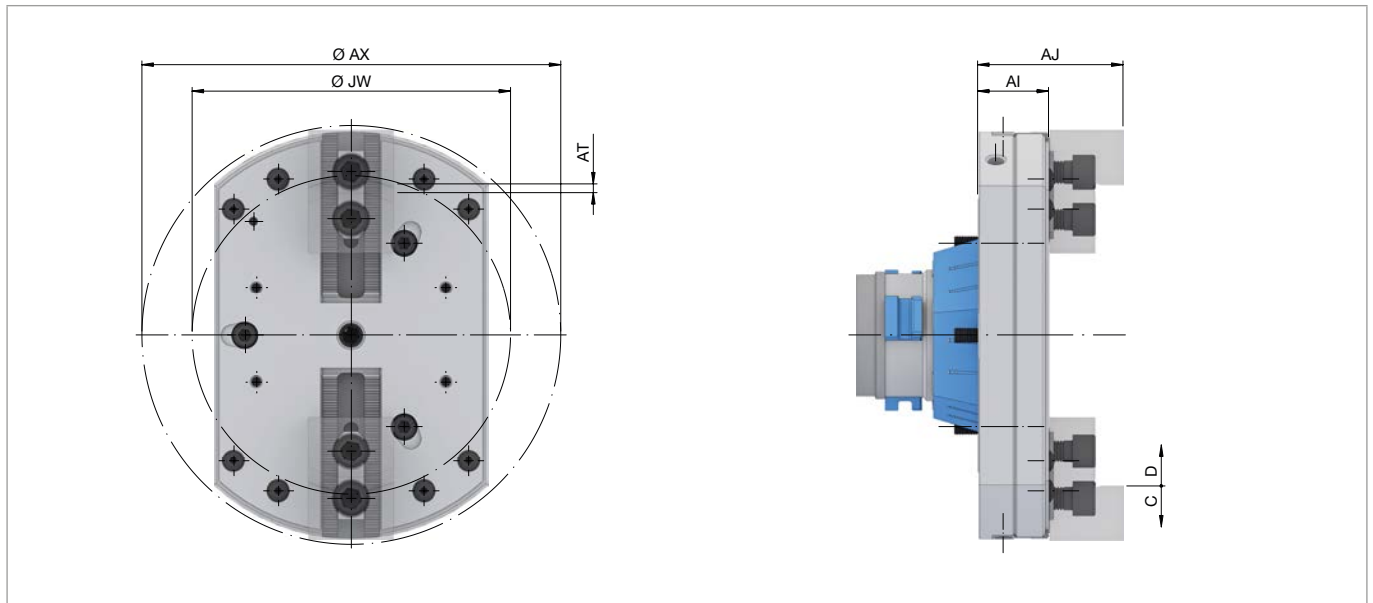
Scope of delivery

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

Jaw modules



2-jaw module SE. Technical data and order overview

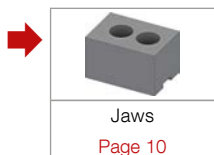


Product line	SE			
Adaptation size	65		100	
Size			215	
Suitable for	TOPlus mini		all except TOPlus mini	
Run-out ≤ [mm]			0,020	
Repeatability ≤ [mm]			0,010	
Clamping range [mm]	JW		see overview top jaws	
RPM n max. [1/min.]			1500	
Max. actuating force when boring the jaws [kN]			40	
Max. axial drawtube 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		
Weight [kg]	10,1	10,2	15,5	
In stock	✓	✓	✓	✓
Material	10016842	10016850	10016847	10016848

Run-out ≤ 0.020 mm only applies for re-machined and milled-out 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 jaw module. Run-out errors on the chuck must be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the jaw module.

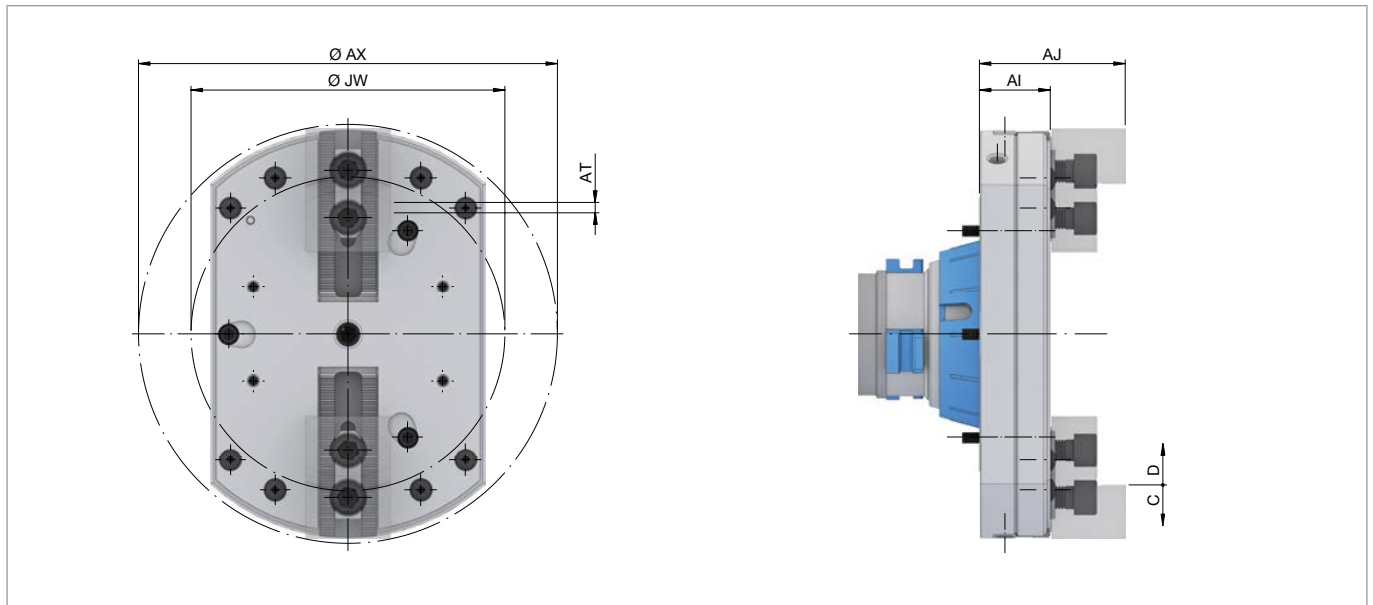


Scope of delivery

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



2-jaw module RD. Technical data and order overview



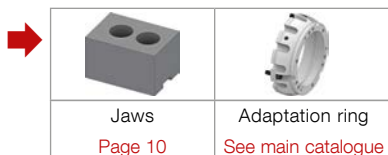
Product line	RD		
Adaptation size	65	80	100
Size		215	
Run-out ≤ [mm]		0,020	
Repeatability ≤ [mm]		0,010	
Clamping range [mm]	JW	see overview top jaws	
RPM n max. [1/min.]		1500	
Max. actuating force when boring the jaws [kN]		40	
Max. axial drawtube force [pull / push] [kN]		40	
Max. radial clamping 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	
Weight [kg]		10,2	11,5
In stock		✓	✓
Material		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 jaw module. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the jaw module.

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





Scope of delivery

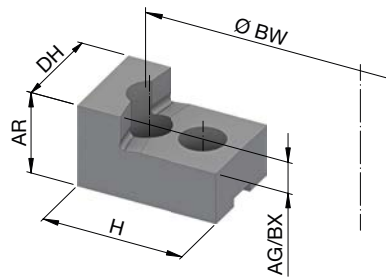
- 2-jaw module
- T-slot nuts
- Storage box

JAWS

Jaws for jaw modules

Overview jaws for 3-jaw module

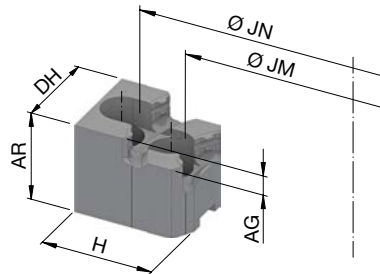
	Top jaws, soft	Radial grooved jaws
		
Description	Soft top jaws for in-house machining and in-house milling	Hard radial grooved jaws with max. clamping range
Sizes	145, 215	145, 215
Workpiece condition	Finished part	Blank
Clamping possibilities	O.D. clamping	O.D. clamping
In-house machining	Yes	No
Workpiece geometry	Round	Round



Product	Top jaws, soft	
Size	145/215	
Gear cutting type	1,5 x 60° [serration]	
Length [mm]	H	65
Jaw width [mm]	DH	45
Jaw height [mm]	AR	40
Clamping range for size 145 [mm]	25 - 140	
Clamping range for size 215 [mm]	25 - 209	
Max. clamping length [mm]	AG	15
Max. permissible turning Ø	BW	140 / 209
Max. permissible turning depth [mm]	BX	15
In stock	✓	
Material	10000734	

JAWS

Jaws for jaw modules





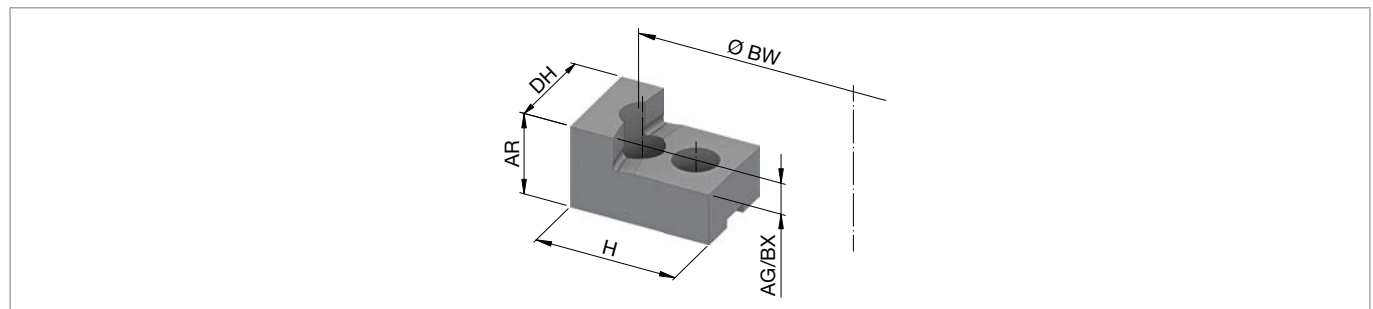
Product	Radial grooved jaws					
Size	145/215					
Gear cutting type	1,5 x 60° [serration]					
Length [mm]	H	63		55		
Jaw width [mm]	DH	45				
Jaw height [mm]	AR	46				
Clamping range at counter bore 1 size 145 [mm]	JM	25 - 34	35 - 43	43 - 52	52 - 60	62 - 71
Clamping range at counter bore 2 size 145 [mm]	JN	70 - 79	79 - 89	89 - 99	97 - 107	106 - 116
Clamping range at counter bore 1 size 215 [mm]	JM	25 - 103	35 - 111	43 - 119	52 - 126	62 - 137
Clamping range at counter bore 2 size 215 [mm]	JN	70 - 148	79 - 158	89 - 168	97 - 177	106 - 187
Ø Counter bore 1 side 1 [mm]	JM	25	35	43	52	62
Ø Counter bore 2 side 1 [mm]	JN	70	79	89	97	106
Max. clamping length [mm]	AG	10				
In stock		✓	✓	✓	✓	✓
Material		10000725	10000730	10000731	10000728	10000732

JAWS

Jaws for jaw modules

Overview jaws for 2-jaw module

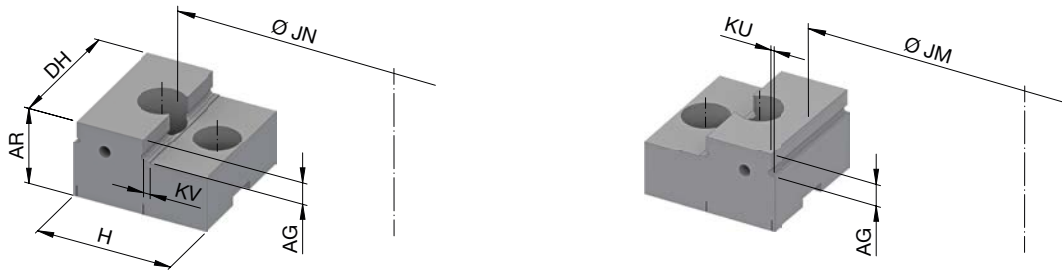
	Top jaws, soft	Reversible stepped jaws, hard
		
Description	Soft top jaws for in-house machining and in-house milling	Hard reversible stepped jaws with large clamping range
Sizes	215	215
Workpiece condition	Finished part	Blank
Clamping possibilities	O.D. clamping	O.D. clamping
In-house machining	Yes	No
Workpiece geometry	As desired	As desired



Product	Top jaws, soft	
Size	215	
Gear cutting type	1,5 x 60° [serration]	
Length [mm]	H	65
Jaw width [mm]	DH	45
Jaw height [mm]	AR	40
Clamping range [mm]	25 - 209	
Max. clamping length [mm]	AG	15
Max. permissible turning Ø	BW	209
Max. permissible turning depth [mm]	BX	15
In stock	✓	
Material	10016853	

JAWS

Jaws for jaw modules



Product	Reversible stepped jaws, hard	
Size	215	
Gear cutting type	1,5 x 60° [serration]	
Length [mm]	H	60
Jaw width [mm]	DH	60
Jaw height [mm]	AR	36
Clamping range at counter bore 1 size 215 [mm]	JM	15 - 96
Clamping range at counter bore 2 size 215 [mm]	JN	95 - 176
Ø Counter bore 1 side 1 [mm]	JM	15
Ø Counter bore 2 side 1 [mm]	JN	95
Support surface for counter bore 1 [mm]	KU	1,5
Support surface for counter bore 2 [mm]	KV	3
Max. clamping length [mm]	AG	10
In stock	✓	
Material	10016852	