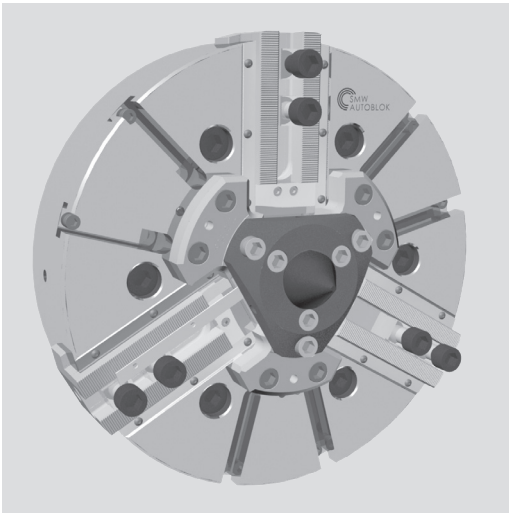


IND-CP

INCH SERRATION
AND MODULE 2

High precision self centering and compensating power chucks Ø 500 - 1000 mm

- Closed center
- 3 jaws



Application/customer benefits

- Clamping of large parts
- Self centering clamping of workpieces that need to be centered by the jaws
- Compensating clamping of shafts held between centers or centered by other means like collet, mandrel or self centering chucks

IND-CP Ø 500-800: Master jaws with INCH SERRATION (3/32" x 90°)

IND-CP Ø 1000: Master jaws with MODULE 2
TONGUE & GROOVE master jaws on request

Technical features

- Gripping force transmission via wedge hook
- Sealed against swarf and chips
- Conversion self centering / compensating with an easy rotation of internal ring
- Rotation of the conversion ring with chuck mounted on machine

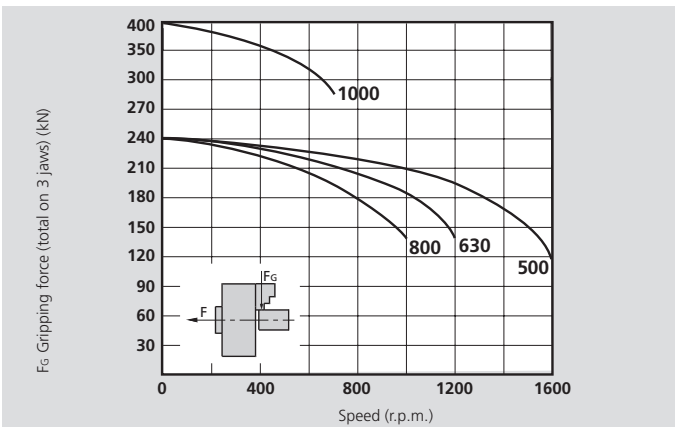
Standard equipment

3 jaw chuck / 1 set T-nuts with screws
1 set soft top jaws with bolts
Center point on request

Ordering example

3 jaw chuck IND-CP 630 / A15

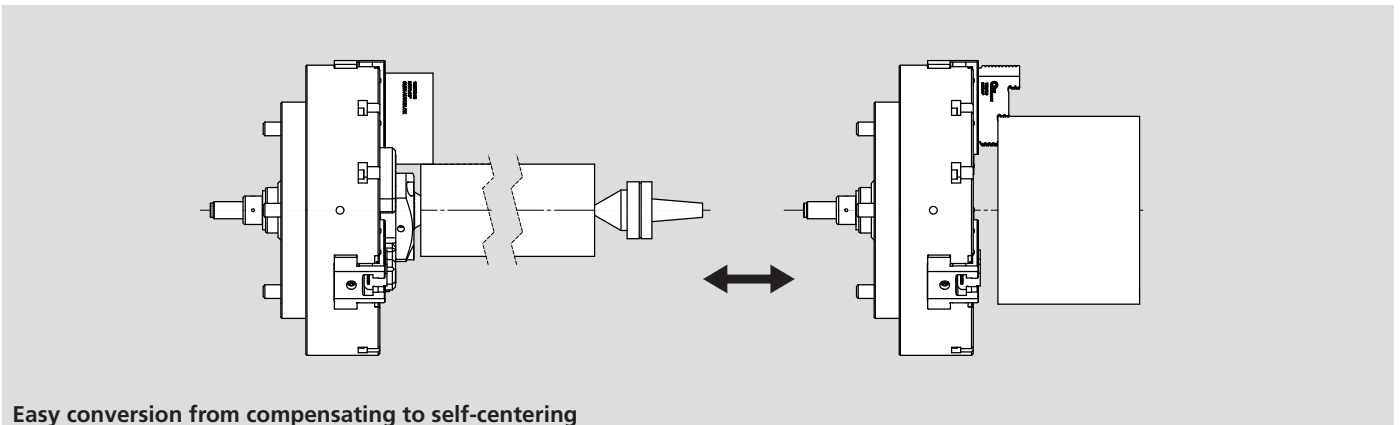
Actual gripping force diagram



The data in the diagram refer to 3 jaw chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K67 grease. The static and dynamic gripping forces have been measured using standard soft top jaws, placed in a position not exceeding the outer diameter of the chuck.

⚠ Safety advice / danger of damage:

When using taller / heavier jaws and / or clamping on a bigger diameter reduce draw pull / rotating speed accordingly.



Easy conversion from compensating to self-centering

Technical data

SMW-AUTOBLOK Type		500	630	800	1000
Number of jaws		3	3	3	3
Radial jaw stroke	mm	7.5	10	10	15
Axial piston stroke	mm	28	38	38	57
Compensation	mm	2.5	2.5	2.5	3
Max. draw pull*	kN	100	100	100	150
Max. gripping force*	kN	240	240	240	320
Max. speed	r.p.m.	1500	1000	900	630
Weight (without top jaws)	kg	130	240	320	710
Moment of inertia	kg·m ²	4.5	11	24	50
Recommended actuating cylinders	Type	SIN-S 150 / 175 / 200			

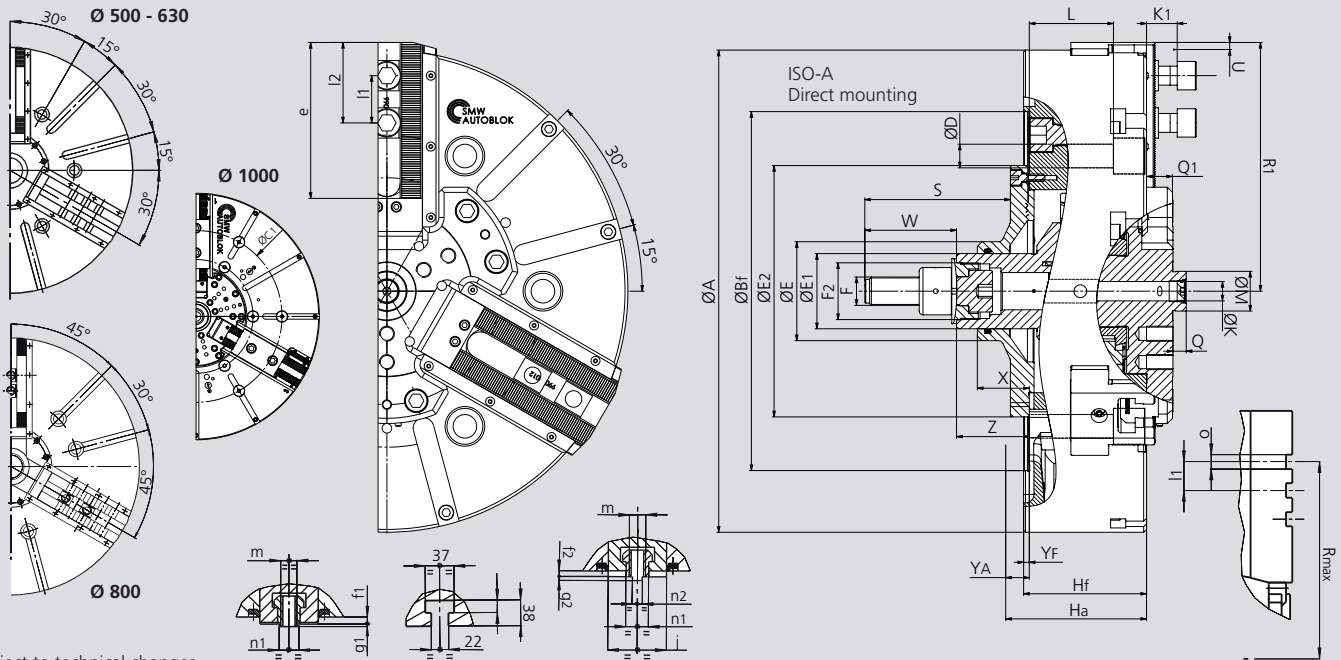
* For internal clamping reduce the draw pull by 30%.

High precision self centering and compensating power chucks \varnothing 500 - 1000 mm

- Closed center
- 3 jaws

IND-CP

INCH SERRATION
AND MODULE 2



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

SMW-AUTOBLOK Type			IND-CP 500		IND-CP 630		IND-CP 800		IND-CP 1000
Mounting			Z380	A15	Z380	A15	Z380	A15	Z520
	A	mm	510		630		800		1005
	Bf/BAH6	mm	380	285.775	380	285.775	380	285.775	520
	C	mm	330.2		330.2		330.2		463.6
	C1	mm	-		-		-		700
	D	mm	25		25		25		25
	E	mm	105		105		105		115
	E1	mm	80		80		80		90
	E2	mm	266		266		266		325
	F	mm	M30		M30		M30		M36
	F2	mm	M60 x 1,5		M60 x 1,5		M60 x 1,5		M78x2
	Hf/HA	mm	130	174	150	194	150	194	184
	K	mm	20.5		20.5		20.5		34.5
	L	mm	89		89		89		108
	M	mm	42		42		42		100
	M1	mm	280		280		280		405
	Q	mm	14		14		14		20
	Q1	mm	32		32		32		30
Chuck open	R1	mm	263		318		405		498
	Rmax	mm	209.5		247.5		349		-
Max. / min.	S	mm	154 / 182		134 / 172		134 / 172		143 / 200
Stroke per jaw	U	mm	7.5		10		10		15
	W	mm	97		97		97		105
	X	mm	55		55		55		60
	Yf/YA	mm	6	50	6	50	6	50	8
Max. / min.	Z	mm	77 / 105		57 / 95		57 / 95		65 / 122
	e	mm	165		220		307		353
	f1	mm	9		9		9		8
	f2	mm	8		8		8		-
	g1	mm	4		4		4		4
	g2	mm	3		3		3		-
	j	mm	75		75		75		-
	k1	mm	16		16		16		16
	l1	mm	38.1		38.1		38.1		100
Max. / min.	l2	mm	135 / 48		190 / 48		277 / 48		320 / 36
	m	mm	M20		M20		M20		M24
	n1 h8	mm	25.5		25.5		25.5		30
	n2 h8	mm	12.7		12.7		12.7		-
	o H7	mm	19.03		19.03		19.03		-