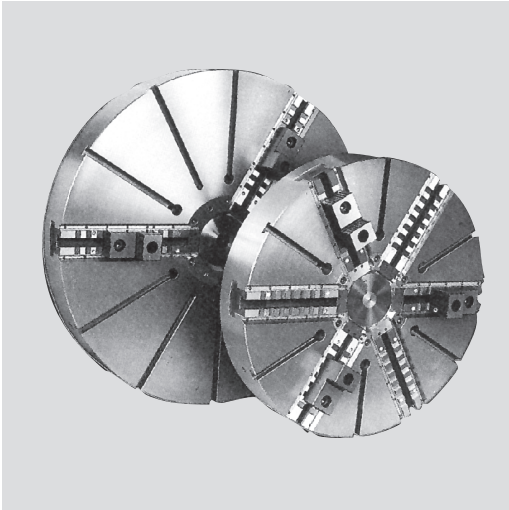


- Radial setting of jaws
- Closed center
- 3 and 6 jaws (660 – 800: 3 jaws / 1000 – 2500: 3 and 6 jaws)



Application/customer benefits

- Chucking operations of very large components
- Suitable for vertical machines thanks to the front protection of the slide ways

IR-C: Manual radial setting of master jaws, TONGUE & GROOVE (type "American Standard") (all diameters)

Technical features

- Gripping force transmission via wedge hook
- Front protection of the slide ways against swarf and chips penetration
- IR-C chucks with manual radial setting of master jaws for the workpiece centering

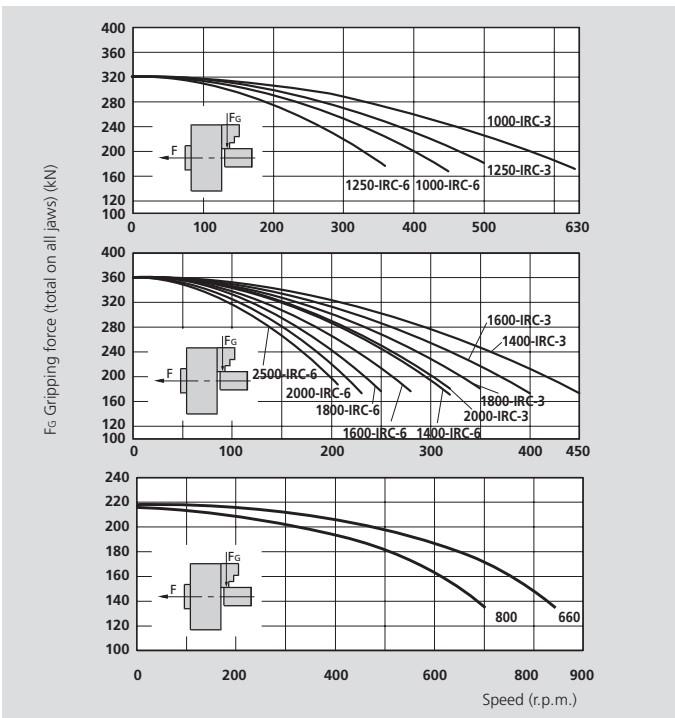
Standard equipment

- 3 or 6 jaw chuck
- 1 set soft top jaws
- Mounting bolts and grease gun

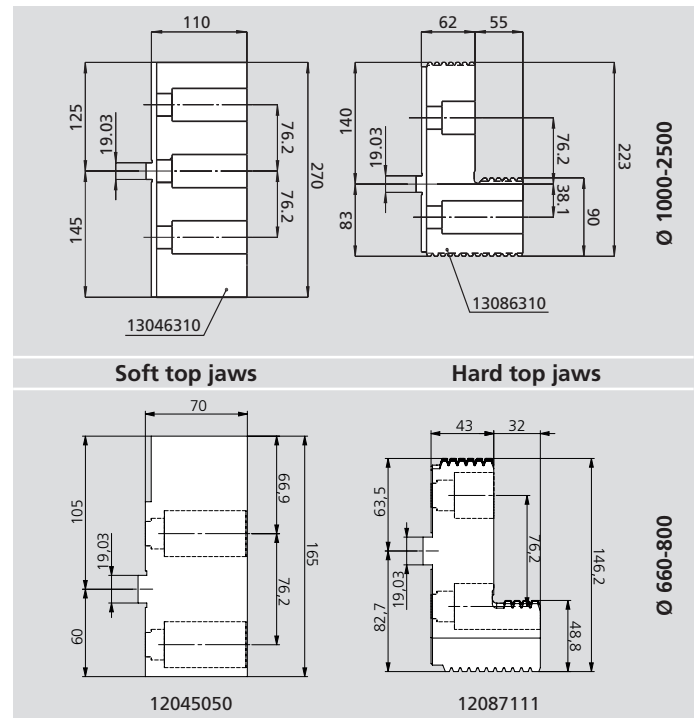
Ordering example

6 jaw chuck IR-C 1600 / Z720

Actual gripping force diagrams



Soft and hard top jaws for IR-C



The data in the diagram refer to 3-6 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.

Technical data

SMW-AUTOBLOK Type	IR-C 660	IR-C 800	IR-C 1000	IR-C 1250	IR-C 1400	IR-C 1600	IR-C 1800	IR-C 2000	IR-C 2500
Number of jaws	3	3	3 6	3 6	3 6	3 6	3 6	3 6	6
Radial jaw stroke + (manual setting)	mm 20 + (20)	mm 20 + (30)	mm 23 + (30)	mm 23 + (30)	mm 24 + (40)	mm 24 + (40)	mm 24 + (40)	mm 24 + (40)	mm 30 + (40)
Axial piston stroke	mm 50	mm 50	mm 57	mm 57	mm 60	mm 60	mm 60	mm 60	mm 60
Max. draw pull*	kN 120	kN 120	kN 180	kN 180	kN 200	kN 200	kN 200	kN 200	kN 270
Max. gripping force*	kN 215	kN 215	kN 320	kN 320	kN 360	kN 360	kN 360	kN 360	kN 380
Max. speed	r.p.m. 850	r.p.m. 700	r.p.m. 630 450	r.p.m. 500 360	r.p.m. 450 320	r.p.m. 400 280	r.p.m. 350 250	r.p.m. 320 230	r.p.m. 200
Weight (without top jaws)	kg 390	kg 520	kg 600	kg 800	kg 1200	kg 1600	kg 1800	kg 2500	kg 5100
Moment of inertia	kg·m ² 15.5	kg·m ² 25	kg·m ² 68	kg·m ² 145	kg·m ² 280	kg·m ² 500	kg·m ² 750	kg·m ² 1250	kg·m ² 3860
Hard top jaw (piece)	Id. No. 12087111	Id. No. 12087111	Id. No. 13086310	Id. No. 13086310	Id. No. 13086310	Id. No. 13086310	Id. No. 13086310	Id. No. 13086310	Id. No. 13086310
Soft top jaw (piece)	Id. No. 12045050	Id. No. 12045050	Id. No. 13046310	Id. No. 13046310	Id. No. 13046310	Id. No. 13046310	Id. No. 13046310	Id. No. 13046310	Id. No. 13046310
Recommended actuating cylinders	Type SIN-S 150-175-200	Type SIN-S 150-175-200	Type SIN-S 250	Type SIN-S 250	Type SIN-S 250	Type SIN-S 250	Type SIN-S 250	Type SIN-S 250	Type SIN-S 250

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

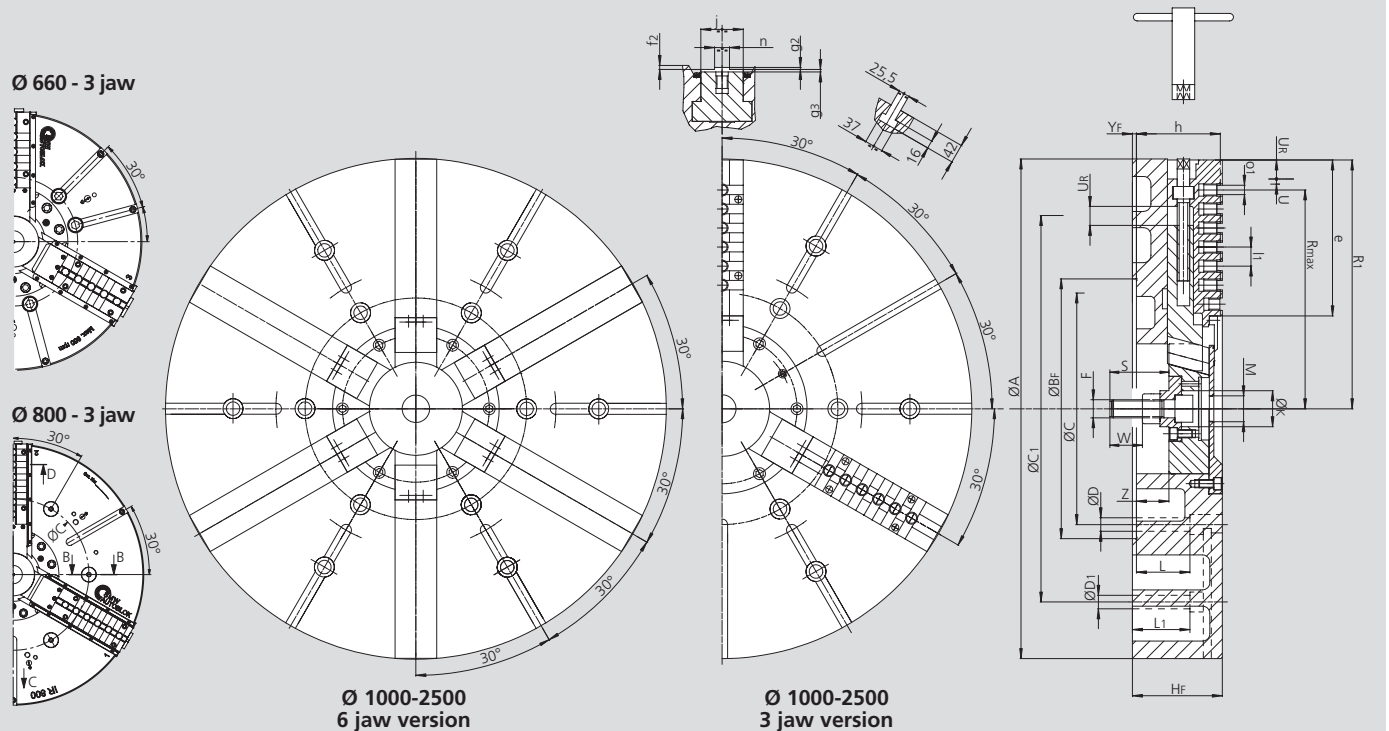
High precision power chucks \varnothing 660 - 2500 mm

IR-C

- Radial setting of jaws
- Closed center
- 3 and 6 jaws (660 – 800: 3 jaws / 1000 – 2500: 3 and 6 jaws)

TONGUE & GROOVE

1



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

SMW-AUTOBLOK Type		IR-C 660		IR-C 800		IR-C 1000		IR-C 1250		IR-C 1400		IR-C 1600		IR-C 1800		IR-C 2000		IR-C 2500	
Mounting		Z380	A15	Z520	A20	Z520	A20	Z520	A20	Z720	Z720	Z720	Z720	Z720	Z720	Z720	Z720	Z720	Z720
	A	mm	660	800		1005		1250		1400		1600		1800		2000		2500	
	Bf H6	mm	380	285.775	520	412.775	520	520	720	720	720	720	720	720	720	720	720	720	720
	C	mm	330.2	463.6		463.6		463.6		647.6		647.6		647.6		647.6		647.6	
	C1	mm	-	-		700		700		1110		1110		1110		1110		1640	
	D	mm	27	27		27		27		33		33		33		33		33	
	D1	mm	-	-		27		27		27		27		27		27		27	
	F	mm	M30	M30		M36		M36		M36		M36		M36		M36		M42	
	Hf	mm	154	150		184		184		222		222		222		240		280	
	K	mm	50	105		72		72		72		72		72		72		72	
	L	mm	75	87		121		121		159		159		159		177		182	
	L1	mm	-	-		97		97		130		130		130		148		205	
	M	mm	M52 x 1.5	M52 x 1.5		M52 x 1.5		M52 x 1.5		M52 x 1.5		M52 x 1.5		M52 x 1.5		M52 x 1.5		-	
Chuck open	R1	mm	340.5	400		502		623		696		796		896		996		1248	
Chuck open	Rmax	mm	307	375		457		563		657		738		838		914		1176	
	S	mm	97	95		100		100		100		100		100		100		30	
Radial stroke	U	mm	20	20		23		23		24		24		24		24		40	
Setting stroke	UR	mm	20	30		30		30		40		40		40		40		15	
	W	mm	57,5	60		65		65		65		65		65		65		54	
	Yf	mm	8	8		8		8		8		8		8		8		8	
Max.	Z	mm	56	66		59		59		82		82		82		100		-	
Min.	Z	mm	6	16		2		2		22		22		22		40		-	
	e	mm	194	246		295		416		446		546		639		739		959	
	f2	mm	7	13		8		8		8		8		8		8		8	
	g2	mm	3	3		4		4		4		4		4		4		4	
	g3	mm	7	7		7		7		7		7		7		7		7	
	h	mm	156	158		168		168		206		206		206		224		261	
	j	mm	85	85		85		85		110		110		110		110		110	
	l1	mm	38.1	38.1		38.1		38.1		38.1		38.1		38.1		38.1		38.1	
	m	mm	M20	M20		M24		M24		M24		M24		M24		M24		M24	
	n h8	mm	12.7	12.7		30		30		30		30		30		30		30	
	o1 H7	mm	19.03	19.03		19.03		19.03		19.03		19.03		19.03		19.03		19.03	
Number of „o1“ cross grooves			3	5		6		9		10		12		14		16		21	
Number of „m“ threads			5	6		7		10		11		13		15		17		21	