

# IEP-D

2+2+2 movement  
MODULE 2 SERRATION

## High precision 6 jaw chucks 2+2+2 equalising Ø 1000 - 1600 mm

- Closed center
- Equalising mechanism lockable
- Centrifugal force compensation



### Application/customer benefits

- Clamping of thin walled workpieces
- Low radial deformation with 2+2+2 clamping
- Suitable for horizontal and vertical machines

### Technical features

- Adjustable to 6 jaw 2+2+2 or true 6 jaw clamping
- Possibility to regulate the equalizing stroke from full (for OP10) to very small (for OP20)
- Constant gripping force with permanent lubrication
- Master jaws with MODULE 2 SERRATION (Pitch 6.28 mm)
- Centrifugal force compensation for high spindle speed
- **proofline® chucks** = fully sealed – low maintenance

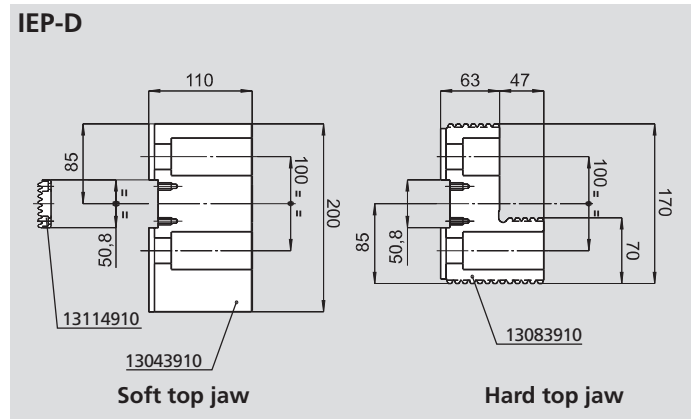
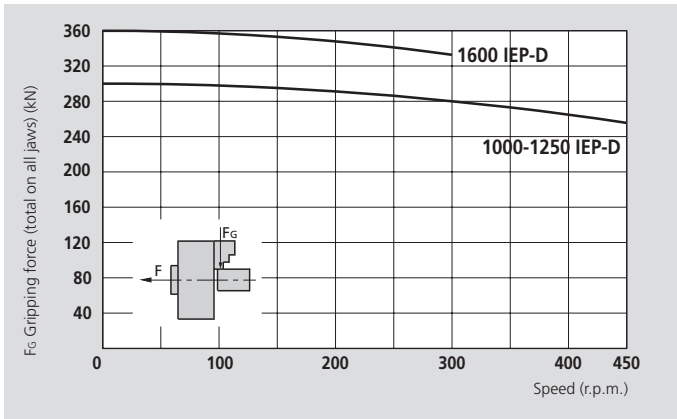
### Standard equipment

- Chuck with mounting bolts
- 1 set of soft top jaws
- 1 equalizing stroke regulating key

### Ordering example

Chuck IEP-D 1250 / Z520

## Actual gripping force diagram



The data in the diagram refer to 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.

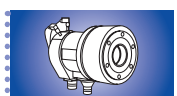
### △ Safety advice / danger of damage:

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

## Technical data

SMW-AUTOBLOK Type		IEP-D 1000 2+2+2	IEP-D 1250 2+2+2	IEP-D 1600 2+2+2
Number of jaws				
Radial jaw stroke	mm	20	20	25
Jaw compensation	mm	±5	±5	±5
Axial piston stroke	mm	40	40	50
Max. draw pull*	kN	200	200	240
Max. gripping force*	kN	300	300	360
Max. speed	r.p.m.	450	400	280
Weight (without top jaws)	kg	1100	1550	2400
Moment of inertia	kg·m <sup>2</sup>	127	273	640
Hard top jaw (piece)	Id. No.	13083910	13083910	13083910
Soft top jaw (piece)	Id. No.	13043910	13043910	13043910
Recommended actuating cylinders	Type	SIN-S 200-250	SIN-S 200-250	SIN-S 200-250

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



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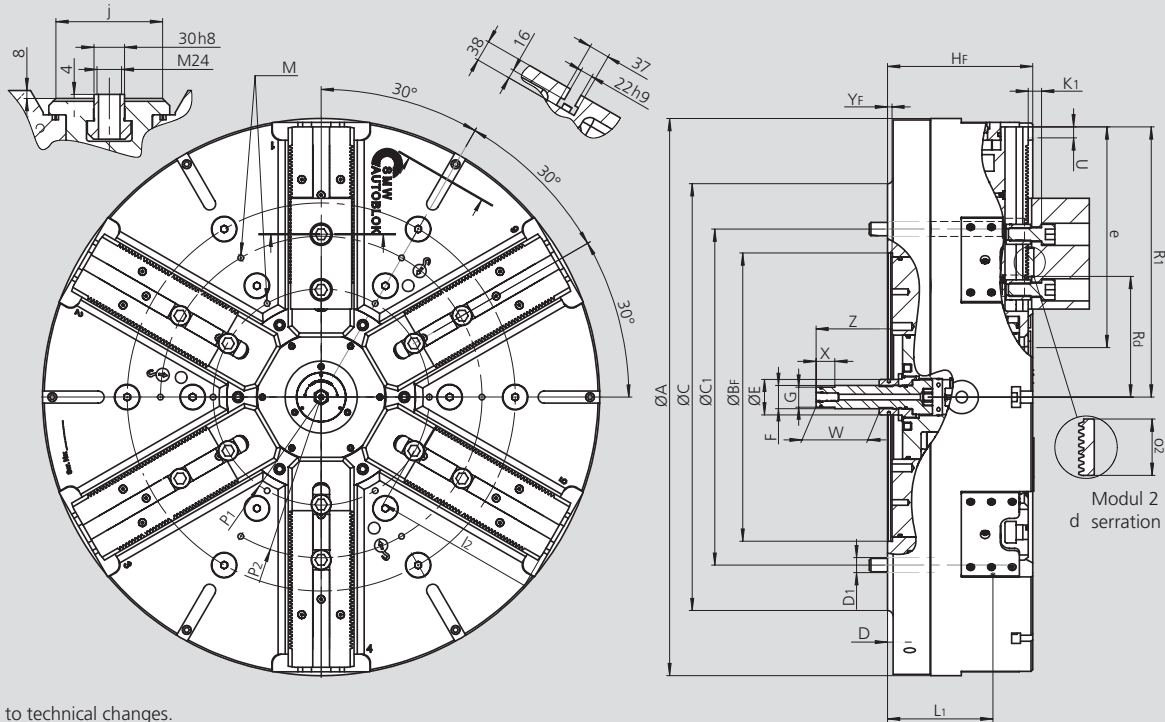
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Subject to technical changes.  
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type		IEP-D 1000		IEP-D 1250		IEP-D 1600	
	<b>A</b>	mm	1005	1250	1600		
	<b>Bf</b> H6	mm	520	520	720		
	<b>C</b>	mm	700	900	1225		
	<b>C1</b>	mm	700	700	1110		
	<b>D</b>	mm	10	10	58		
	<b>D1</b>	mm	27	27	27		
	<b>E</b>	mm	64	64	64		
	<b>F</b>	mm	M42 x 3	M42 x 3	M42 x 3		
	<b>G</b> H8	mm	36	36	36		
	<b>HF</b>	mm	254	254	272		
	<b>M</b>	mm	M12 x 22	M12 x 22	M16 x 28		
	<b>L1</b>	mm	207	207	225		
Chuck open	<b>R1</b>	mm	498	620.5	811		
Chuck open	<b>Rd</b>	mm	228	228	288.5		
Jaw stroke	<b>U</b>	mm	20	20	25		
	<b>W</b>	mm	114	114	114		
	<b>X</b>	mm	34	34	34		
	<b>Yf</b>	mm	8	8	8		
Max. / min.	<b>Z</b>	mm	156   116	156   116	156   106		
Serration	<b>d</b>	M	Module 2		Module 2		Module 2
	<b>e</b>	mm	345	465	595		
	<b>j</b>	mm	105	105	131		
	<b>k1</b>	mm	24	24	24		
Max. / min.	<b>l2</b>	mm	295   118	417   118	531   118		
	<b>o2</b>	mm	50.8	50.8	50.8		
	<b>P1</b>	mm	390	390	760		
	<b>P2</b>	mm	580	580	1000		