

IEP-D

2+2+2 movement
INCH SERRATION

IEP-C

2+2+2 movement
TONGUE & GROOVE

High precision 6 jaw chucks 2+2+2 equalising Ø 400 - 800 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

IEP-D: Master jaws with INCH SERRATION
(3/32" x 90° sizes 500-630-800, 1/16" x 90° size 400)

IEP-C: Master jaws with TONGUE & GROOVE

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
- Centrifugal force compensation for high spindle speed
- **proofline® chucks** = fully sealed – low maintenance

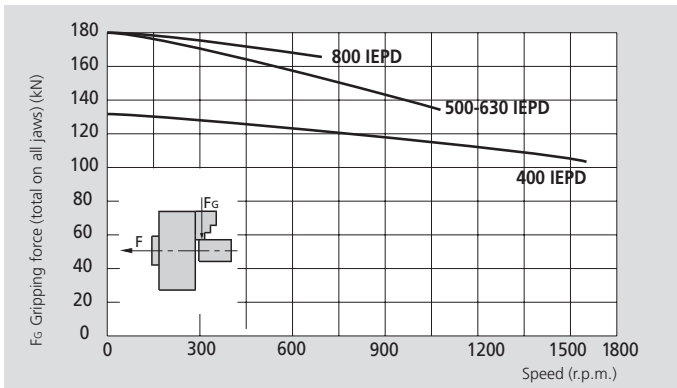
Standard equipment

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

Ordering example

Chuck IEP-D 500 / Z380

Actual gripping force diagram



The data in the diagram refer to 6-jaw-chucks, newly maintained according to their service manuals using the original lubricant. 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 400 | IEP-C 400 | IEP-D 500 | IEP-C 500 | IEP-D 630 | IEP-C 630 | IEP-D 800 | IEP-C 800 |
|-------------------------------------------|-------------------|-----------------------|-----------|-----------------------|-----------|-----------------------|-----------|-----------------------|-----------|
| Number of jaws | | 2+2+2 | | 2+2+2 | | 2+2+2 | | 2+2+2 | |
| Radial jaw stroke | mm | 10 | | 15 | | 15 | | 15 | |
| Jaw compensation | mm | ±2.5 | | ±4 | | ±4 | | ±4 | |
| Axial piston stroke | mm | 20 | | 30 | | 30 | | 30 | |
| Max. draw pull** | kN | 90 | | 120 | | 120 | | 120 | |
| Max. gripping force** | kN | 130 | | 180 | | 180 | | 180 | |
| Max. speed | r.p.m. | 1600 | | 1100 | | 800 | | 650 | |
| Weight (without top jaws) | kg | 145 | | 260 | | 410 | | 670 | |
| Moment of inertia | kg·m ² | 2.9 | | 8.5 | | 20 | | 55 | |
| Hard top jaw (set of 3*) for IEP-D | Id. No. | 12083036 | | 12084546 | | 12084546 | | 12084546 | |
| Soft top jaw (piece) for IEP-D | Id. No. | 12073000 | | 12074040 | | 12075050 | | 12075050 | |
| Soft top jaw (piece) for IEP-C | Id. No. | 12043060 | | 12044050 | | 12045050 | | 12045050 | |
| Recommended actuating cylinders | Type | SIN-S 100 / 125 / 150 | | SIN-S 150 / 175 / 200 | | SIN-S 150 / 175 / 200 | | SIN-S 150 / 175 / 200 | |

* 2 sets (= 6 pieces) per chuck are required.

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



SMW-AUTOBLOK
297

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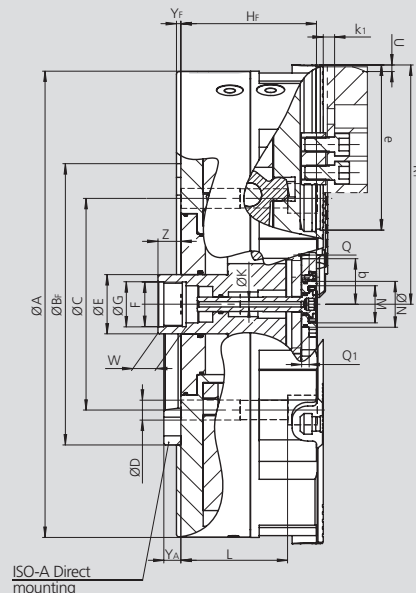
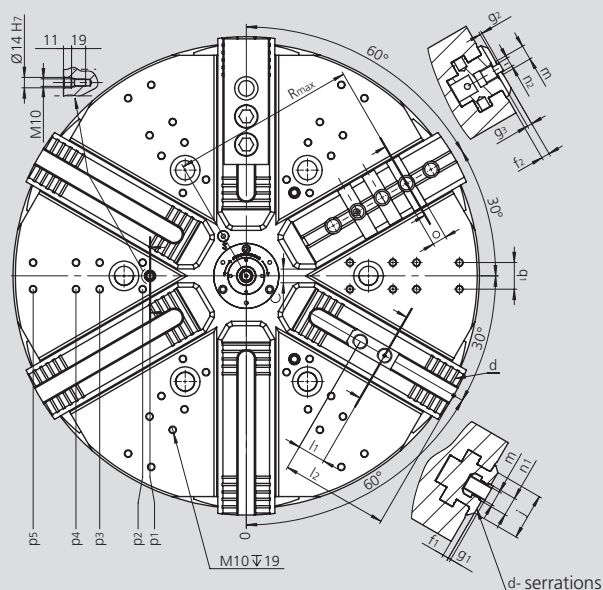
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Subject to technical changes.
For more detailed information please ask our customer service.

| SMW-AUTOBLOK Type | | IEP-D 400 | IEP-C 400 | IEP-D 500 | IEP-C 500 | IEP-D 630 | IEP-C 630 | IEP-D 800 | IEP-C 800 | |
|----------------------------------------|--------------|-----------|-------------|-----------|-------------|-----------|-------------|-----------|-------------|-----------|
| | A | mm | 419 | 419 | 510 | 510 | 630 | 630 | 800 | 800 |
| | BF H6 | mm | 300 | 300 | 380 | 380 | 380 | 380 | 520 | 520 |
| | C | mm | 235 | 235 | 330.2 | 330.2 | 330.2 | 330.2 | 463.6 | 463.6 |
| | D | mm | 21 | 21 | 25.5 | 25.5 | 25.5 | 25.5 | 25.5 | 25.5 |
| | E | mm | 75 | 75 | 80 | 80 | 80 | 80 | 80 | 80 |
| | F | mm | M60 x 1.5 | M60 x 1.5 | M60 x 1.5 | M60 x 1.5 | M60 x 1.5 | M60 x 1.5 | M60 x 1.5 | M60 x 1.5 |
| | G H8 | mm | 61 | 61 | 61 | 61 | 61 | 61 | 61 | 61 |
| | HF | mm | 154 | 154 | 184 | 184 | 184 | 184 | 184 | 184 |
| Through hole | K | mm | 7 | 7 | 7 | 7 | 7 | 7 | 7 | 7 |
| | L | mm | 130 | 130 | 144 | 144 | 144 | 144 | 144 | 144 |
| | M | mm | M50 x 1.5 | M50 x 1.5 | M50 x 1.5 | M50 x 1.5 | M50 x 1.5 | M50 x 1.5 | M50 x 1.5 | M50 x 1.5 |
| | N H8 | mm | 62 | 62 | 62 | 62 | 62 | 62 | 62 | 62 |
| | Q | mm | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 |
| | Q1 | mm | 10 | 10 | 10 | 10 | 10 | 10 | 10 | 10 |
| Chuck open | R1 | mm | 212 | 212 | 263.5 | 263.5 | 323.5 | 323.5 | 408.5 | 408.5 |
| Jaw stroke | U | mm | 10 | 10 | 15 | 15 | 15 | 15 | 15 | 15 |
| | W | mm | 38 | 38 | 38 | 38 | 38 | 38 | 38 | 38 |
| Max / min. | Z | mm | 16 / -4 | 16 / -4 | 61 / 31 | 61 / 31 | 61 / 31 | 61 / 31 | 61 / 31 | 61 / 31 |
| Min. | b | mm | 45 | 45 | 46.5 | 46.5 | 46.5 | 46.5 | 46.5 | 46.5 |
| Min. | c | mm | 2.9 | 2.9 | 3.5 | 3.5 | 3.5 | 3.5 | 3.5 | 3.5 |
| | d | inch | 1/16" x 90° | - | 3/32" x 90° | - | 3/32" x 90° | - | 3/32" x 90° | - |
| | e | mm | 150 | 150 | 174 | 174 | 234 | 234 | 319 | 319 |
| | f1 | mm | 8 | - | 8 | - | 8 | - | 8 | - |
| | f2 | mm | - | 8 | - | 11 | - | 11 | - | 11 |
| | g1 | mm | 3.5 | - | 3.5 | - | 3.5 | - | 3.5 | - |
| | g2 | mm | - | 3 | - | 3 | - | 3 | - | 3 |
| | g3 | mm | - | 3.5 | - | 6.5 | - | 6.5 | - | 6.5 |
| | j | mm | 58 | 58 | 63 | 63 | 63 | 63 | 63 | 63 |
| | k1 | mm | 9 | 9 | 15.5 | 15.5 | 15.5 | 15.5 | 15.5 | 15.5 |
| | l1 | mm | 30 | 38.1 | 38 | 38.1 | 38 | 38.1 | 38 | 38.1 |
| Max. / min. | l2 | mm | 108 / 43 | - | 138 / 54 | - | 198 / 54 | - | 283 / 54 | - |
| | m | mm | M16 | M16 | M20 | M20 | M20 | M20 | M20 | M20 |
| | n1 h8 | mm | 21 | - | 25.5 | - | 25.5 | - | 25.5 | - |
| | n2 | mm | - | 12.7 | - | 12.7 | - | 12.7 | - | 12.7 |
| | o | mm | - | 19.03 | - | 19.03 | - | 19.03 | - | 19.03 |
| Radial position | p1 | mm | 150 | 150 | 130 | 130 | 130 | 130 | 130 | 130 |
| Radial position | p2 | mm | 140 | 140 | 140 | 140 | 140 | 140 | 165 | 165 |
| Radial position | p3 | mm | 195 | 195 | - | - | 198 | 198 | 200 | 200 |
| Radial position | p4 | mm | - | - | 230 | 230 | 230 | 230 | 255 | 255 |
| Radial position | p5 | mm | - | - | - | - | 288 | 288 | 290 | 290 |
| | q1 | mm | 36 | 36 | 36 | 36 | 36 | 36 | 36 | 36 |
| | Rmax | mm | - | 139 | - | 198 | - | 250 | - | 351 |
| | YF/YA | mm | 6 23 | 6 23 | 6 23 | 6 23 | 6 23 | 6 23 | 6 23 | 6 23 |
| Number of cross grooves (IEP-C) | | | - | 1 | - | 2 | - | 3 | - | 6 |