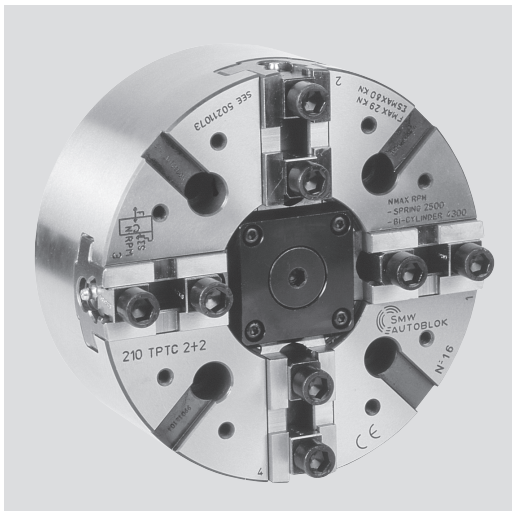


TPT-C

2+2 independent jaw movement
TONGUE & GROOVE

High precision 2+2 jaw power chuck with self-centering independent jaw movement Ø 210 - 400 mm

- Closed center
- Tongue & groove



Application/customer benefits

- Clamping of rectangular and square workpieces, self-centering in two axes

Technical features

- 2+2 jaw chuck with 2 independent self-centering jaw drives (two wedge drives)
- Jaw No. 1 + 3 (clamping jaws): power operated
- Jaw No. 2 + 4 (centering jaws): spring operated or optionally power operated
- Chuck body and internal parts are case hardened for high precision and long life

Standard equipment*

2+2 jaw chuck
Mounting bolts

Ordering example

Power chuck TPT-C 250 A8
or
Power chuck TPT-C 400-Z

A One wedge drive

- Operated by standard closed center cylinders.
- Jaws 2 and 4 are spring operated to center the component in one axis.
- Jaws 1 and 3 are power operated by the cylinder to center the component on the second axis and to apply the gripping force to drive the component.
- Only for external clamping (on request internal clamping).
- See specific draw pull, gripping force and maximum speed in the technical data table below.

***Note:** The chucks are always delivered as „one wedge drive“ version: To use them as „two independent wedge drives“ version, just remove the internal „spring assembly“ according to instruction manual

B Two independent wedge drives*

- Operated by independent double piston cylinders.
- Jaws 2 and 4 are power operated (using the small cylinder) to center the component in one axis.
- Jaws 1 and 3 are also power operated (using the large cylinder) to center the component on the second axis and to apply the gripping force to drive the component.
- Since both pair of jaws are power operated the chuck can reach higher speeds.
- See specific draw pull, gripping force and maximum speed in the technical data table below.

Technical data

SMW-AUTOBLOK Type		TPT-C 210	TPT-C 250	TPT-C 315	TPT-C 400
Number of jaws		2+2	2+2	2+2	2+2
Radial jaw stroke	mm	4	5	5	7
Wedge stroke	mm	19	24	24	33
Weight (plain back without top jaws)	kg	21	32	48	102
Moment of inertia	kg·m ²	0.12	0.27	0.64	1.95

A ONE wedge drive

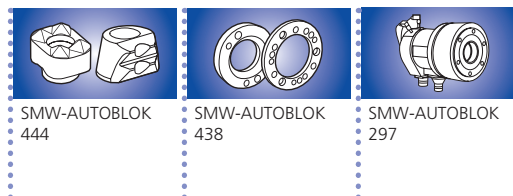
SMW-AUTOBLOK Type		TPT-C 210	TPT-C 250	TPT-C 315	TPT-C 400
Number of jaws		2+2	2+2	2+2	2+2
Max. draw pull (clamping wedge, jaw 1 + 3)	kN	29	39	45	60
Max. gripping force jaw 1 + 3** (power operated)	kN	72	98	115	150
Max. centering force jaw 2 + 4 (spring operated)	kN	11	15	15	24
Max. speed	r.p.m.	2500	2400	2000	1500
Recommended actuating cylinders	Type	SIN-S 125	SIN-S 125	SIN-S 150	SIN-S 150

B TWO independent wedge drives

SMW-AUTOBLOK Type		TPT-C 210	TPT-C 250	TPT-C 315	TPT-C 400
Number of jaws		2+2	2+2	2+2	2+2
Max. draw pull (clamping wedge, jaw 1 + 3)	kN	25	34	40	50
Max. draw pull (centering wedge, jaw 2 + 4)	kN	19	25	30	35
Max. gripping force jaw 1 + 3** (power operated)	kN	72	98	115	150
Max. centering force jaw 2 + 4 (power operated)	kN	55	72	85	100
Max. speed	r.p.m.	4300	3400	2700	2000
Recommended actuating cylinders***	Type	DCE 64 / 64	DCE 64 / 64	DCE 64 / 64	DCE 64 / 64

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

*** SMW-AUTOBLOK 310: technical details of DCE cylinders see general catalog.

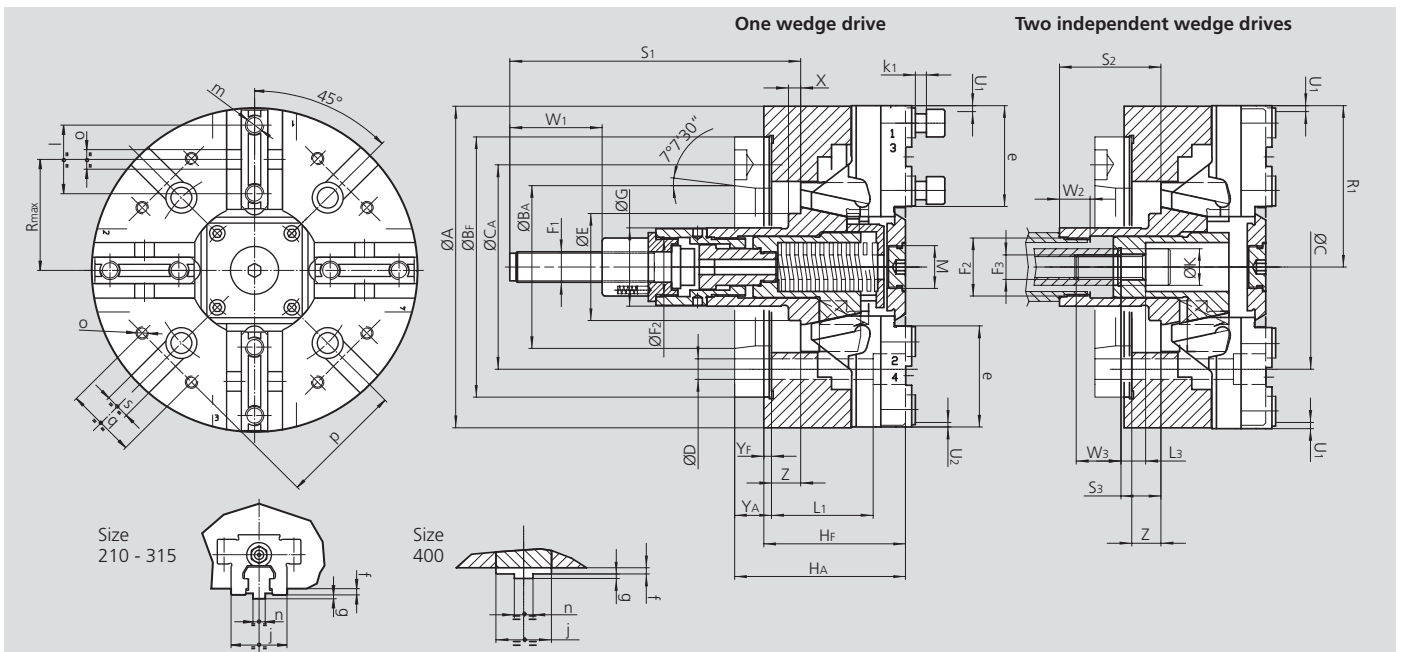


High precision 2+2 jaw power chuck with self-centering independent jaw movement \varnothing 210 - 400 mm

TPT-C

- Closed center
- Tongue & groove

2+2 independent jaw movement
TONGUE & GROOVE



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

SMW-AUTOBLOK Type			TPT-C 210		TPT-C 250			TPT-C 315			TPT-C 400	
Mounting			Z170	A6	Z220	A6*	A8	Z300	A8*	A11	Z300	A11
	A	mm	210		254			315			390	
	Bf/BA H6	mm	170	106.375	220	106.375	139.719	300	139.719	196.869	300	196.869
	C	mm	133.4		171.4		171.4		235		235	
	CA	mm	-	-	-	133.4	-	-	171.4	-	-	-
	D	mm	13.5		17		13.5		17		21	
	E	mm	70		88			110			98	
	F1	mm	M20		M24			M24			M24	
	F2	mm	M38 x 1.5		M56 x 2			M56 x 2			M56 x 2	
	F3	mm	M16		M20			M20			M20	
	G	mm	51		61			61			70	
Chuck height	Hf/HA	mm	92	111	105	124	127	111	127	136	116	140
	K H8	mm	24		30			30			35	
	L1	mm	66		59			33			54	
	L3	mm	11		9			11			11	
	M	mm	M28 x 1.5		M28 x 1.5			M28 x 1.5			M24 x 1	
	R1	mm	105.5		127.5			158			196	
	Rmax	mm	72		88			105			133.5	
	S1	mm	189		203			201			218	
	S2	mm	61		71			69			86	
	S3	mm	21		33			31			45.5	
Jaw stroke (power 1 + 3)	U1	mm	4		5			5			7	
Jaw stroke (power / spring 2 + 4)	U2	mm	3		4			4			5.4	
	W1	mm	60		60			60			60	
	W2	mm	20		20			20			20	
	W3	mm	29		31			29			29	
	X	mm	8		8			10			10	
	Yf/YA	mm	5	24	5	24	27	5	30	30	6	30
Wedge stroke	Z	mm	19		24			24			33	
	e	mm	66		77.5			93			116	
	f	mm	4		4			4			7	
	g	mm	2.5		3			3			3	
	j	mm	36		45			45			62	
	k1	mm	11		12			12			14	
	l	mm	44.4		54			54			76.2	
	m	mm	M12		M16			M16			M20	
	n h8	mm	7.94		12.7			12.7			12.7	
	o H7	mm	12.68		19.03			19.03			19.03	
	p	mm	80		102			100			150	
	q	mm	45		60			60			80	
	r	mm	M8		M10			M10			M12	
	s H8	mm	16		16			20			20	
	t	mm	5		5			5			5	

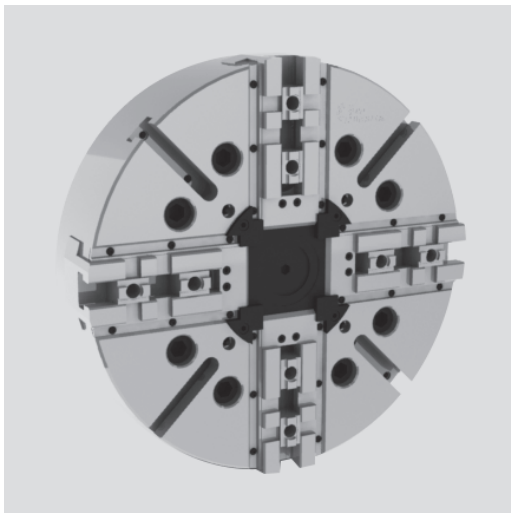
* Indirect mounting.

TPT-C

2+2 independent jaw movement
TONGUE & GROOVE

High precision 2+2 jaw power chuck with self-centering independent jaw movement Ø 500 - 800 mm

- Closed center
- Tongue & groove



Application/customer benefits

- Clamping of rectangular and square workpieces, self-centering in two axes

Technical features

- 2+2 jaw chuck with 2 independent self-centering jaw drives (two wedge drives)
- Jaw No. 1 + 3 (clamping jaws): power operated
- Jaw No. 2 + 4 (centering jaws): spring operated or optionally power operated*
- High quality cast iron body for lightweight and durability
- Protection from contamination with seals along the master jaw profiles

Standard equipment

- 2+2 jaw chuck
- 1 set of T-nuts and bolts
- 1 set of soft top jaws
- Mounting bolts

Ordering example

- Power chuck TPT-C 500 2+2 Z380
- or
- Power chuck TPT-C 800 2+2 A15

A One wedge drive

- Operated by standard closed center cylinders.
- Jaws 2 and 4 are spring operated to center the component in one axis.
- Jaws 1 and 3 are power operated by the cylinder to center the component on the second axis and to apply the gripping force to drive the component.
- For external clamping only (on request internal clamping).
- See specific draw pull, gripping force and maximum speed in the technical data table below.

B Two independent wedge drives*

- Operated by independent double piston cylinders. Jaws 2 and 4 are power operated (using the small cylinder) to center the component in one axis.
- Jaws 1 and 3 are also power operated (using the large cylinder) to center the component on the second axis and to apply the gripping force to drive the component.
- Since both pair of jaws are power operated the chuck can reach higher speeds.
- See specific draw pull, gripping force and maximum speed in the technical data table below.

***Note:** The chucks are always delivered as „one wedge drive“ version: To use them as „two independent wedge drives“ version, just remove the internal „spring assembly“ according to instruction manual.

Technical data

SMW-AUTOBLOK Type		TPT-C 500	TPT-C 630	TPT-C 800
Number of jaws		2+2	2+2	2+2
Radial jaw stroke	mm	8.5	10	10
Wedge stroke	mm	32	38	38
Weight (plain back without top jaws)	kg	180	325	550
Moment of inertia	kg·m ²	6	16	44

A ONE wedge drive

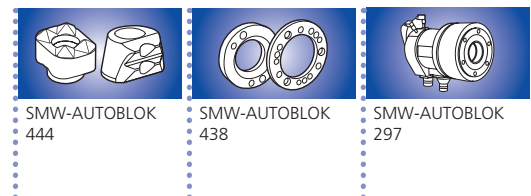
SMW-AUTOBLOK Type		TPT-C 500	TPT-C 630	TPT-C 800
Number of jaws		2+2	2+2	2+2
Max. draw pull (clamping wedge, jaw 1 + 3)	kN	80	80	80
Max. gripping force jaw 1 + 3** (power operated)	kN	160	160	160
Max. centering force jaw 2 + 4 (spring operated)	kN	30	30	30
Max. speed	r.p.m.	800	630	500
Recommended actuating cylinders	Type	SIN-S 175-200	SIN-S 175-200	SIN-S 175-200

B TWO independent wedge drives

SMW-AUTOBLOK Type		TPT-C 500	TPT-C 630	TPT-C 800
Number of jaws		2+2	2+2	2+2
Max. draw pull** (clamping wedge, jaw 1 + 3)	kN	67	67	67
Max. draw pull** (centering wedge, jaw 2 + 4)	kN	50	50	50
Max. gripping force jaw 1 + 3** (power operated)	kN	160	160	160
Max. centering force jaw 2 + 4 (power operated)	kN	120	120	120
Max. speed	r.p.m.	1200	850	700
Recommended actuating cylinders***	Type	DCE 140 / 140	DCE 140 / 140	DCE 140 / 140

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

*** SMW-AUTOBLOK 310: technical details of DCE cylinders see general catalog.



SMW-AUTOBLOK
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SMW-AUTOBLOK
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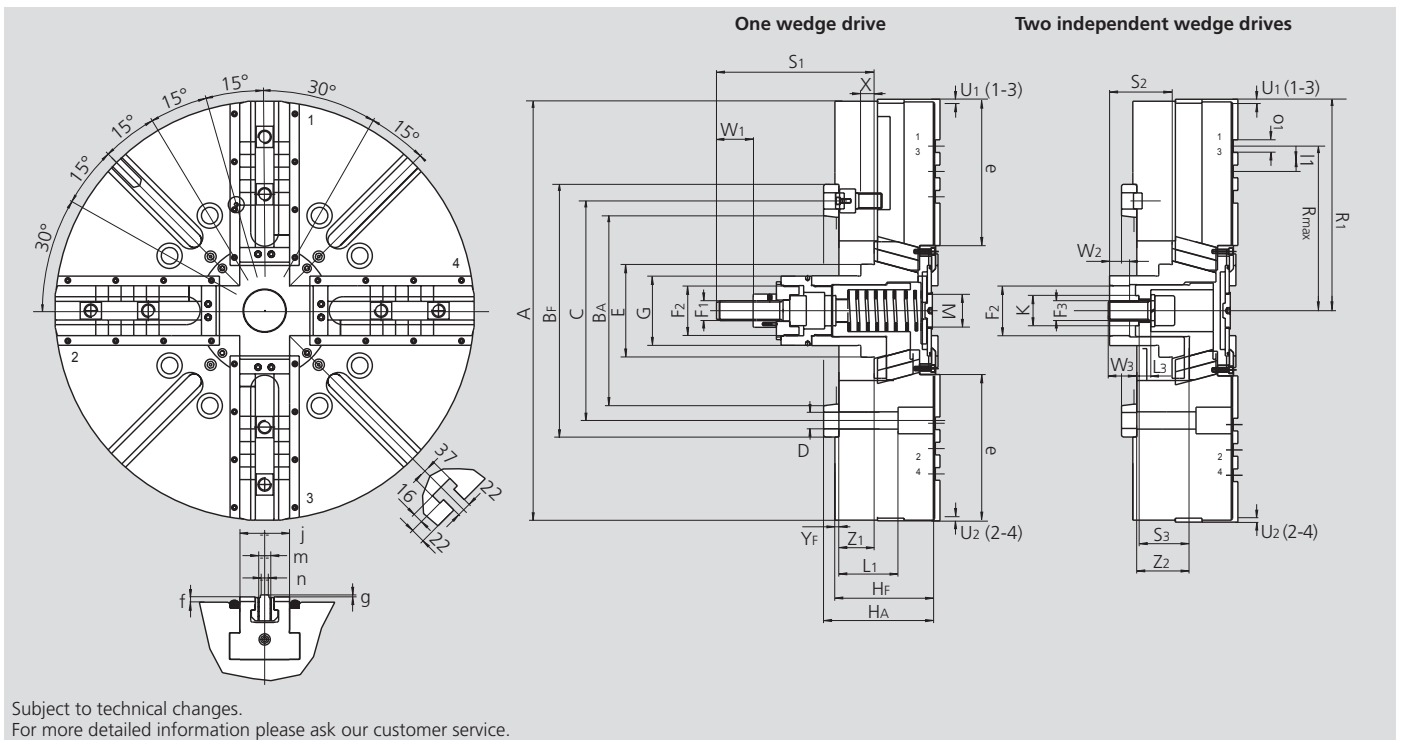
SMW-AUTOBLOK
297

High precision 2+2 jaw power chuck with self-centering independent jaw movement Ø 500 - 800 mm

TPT-C

- Closed center
- Tongue & groove

2+2 independent jaw movement
TONGUE & GROOVE



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

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SMW-AUTOBLOK Type			TPT-C 500		TPT-C 630		TPT-C 800	
Mounting			Z380	A15	Z380	A15	Z380	A15
	A	mm	510		630		800	
	Bf/BA H6	mm	380	285.775	380	285.775	380	285.775
	C	mm	330.2		330.2		330.2	
	D	mm	25		25		25	
	E	mm	140		140		140	
	F1	mm	M30		M30		M30	
	F2	mm	M75 x 2		M75 x 2		M75 x 2	
	F3	mm	M30		M30		M30	
	G	mm	104		104		104	
Chuck height	Hf/HA	mm	130	147	150	167	150	167
	K	mm	45		45		45	
	L1	mm	89		89		89	
	L3	mm	18		18		18	
	M	mm	M52 x 1.5		M52 x 1.5		M52 x 1.5	
	R1	mm	263		318		405	
	Rmax	mm	209.5		247.5		349	
	S1	mm	237		237		237	
	S2	mm	94		94		94	
	S3	mm	76		76		76	
Jaw stroke (power 1 + 3)	U1	mm	8.5		10		10	
Jaw stroke (power / spring 2 + 4)	U2	mm	6.5		8		8	
	W1	mm	55		55		55	
	W2	mm	30		30		30	
	W3	mm	46		46		46	
	X	mm	20		20		20	
	Yf/YA	mm	6 / 23		6 / 23		6 / 23	
Wedge 1 max. / min.	Z1	mm	33 / 1		53 / 15		53 / 15	
Wedge 2 max. / min.	Z2	mm	59 / 27		79 / 41		79 / 41	
	e	mm	165		220		307	
	f	mm	8		8		8	
	g	mm	3		3		3	
	j	mm	75		75		75	
	l1	mm	38.1		38.1		38.1	
	m	mm	20		20		20	
	n	mm	12.7		12.7		12.7	
	o1	mm	19.03		19.03		19.03	