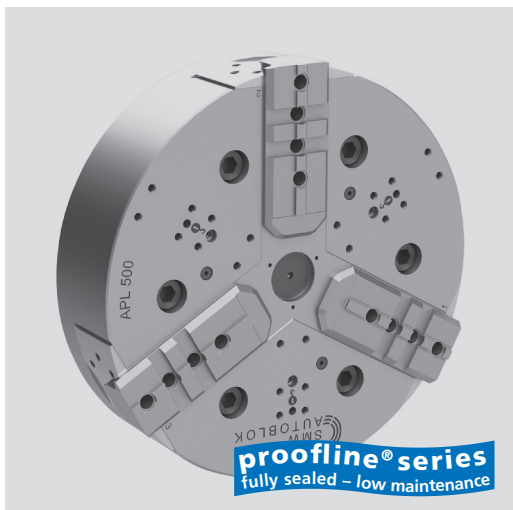


APL-DINCH
SERRATION**APL-C**

TONGUE & GROOVE

High precision power chuck Ø 500 - 1000 mm

- Closed center
- Long stroke
- 3 jaws
- proofline® chucks = fully sealed - low maintenance

**Application/customer benefits**

- For large batch production
- Fully sealed, ideal for dry machining of castings and forgings or if high pressure coolant is used
- Large clamping range

APL-D: INCH SERRATION master jaws**APL-C:** TONGUE & GROOVE master jaws (American Standard)**Technical features**

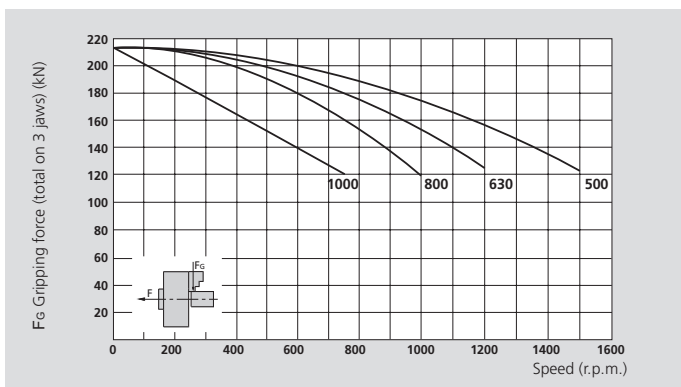
- EXTRA long jaw stroke
- Constant gripping force with permanent grease lubrication
- Center bore for coolant and / or air
- Chuck body and internal parts case hardened
- **proofline® chucks** = fully sealed - low maintenance

Standard equipment

- 3-jaw chuck
- 1 set T-nuts and bolts (no APL-C)
- 1 set soft top jaws (no APL-C)
- Mounting bolts

Ordering example

3-jaw chuck APL-C 630 Z380

Actual gripping force diagram

The data in the diagrams 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.

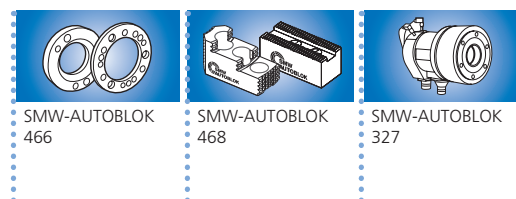
△ Safety advice / danger of damage:

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

Technical data

SMW-AUTOBLOK Type		APL-D 500 APL-C 500	APL-D 630 APL-C 630	APL-D 800 APL-C 800	APL-D 1000 APL-C 1000
Radial jaw stroke	mm	13.3	13.3	13.3	13.3
Axial piston stroke	mm	33	33	33	33
Max. draw pull*	kN	120	120	120	120
Max. gripping force*	kN	215	215	215	215
Max. speed	r.p.m.	1400	1000	800	750
Weight (without top jaws)	kg	170	297	535	840
Moment of inertia	kg·m ²	5.5	14.6	44	105
Recommended actuating cylinders	Type	SIN-S 175 / 200	SIN-S 175 / 200	SIN-S 175 / 200	SIN-S 175 / 200
Id. No. APL-D (Center mounting)		77184050	77184063	77184080	77184090
Id. No. APL-C (Center mounting)		77187850	77187863	77187880	77187890

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



High precision power chuck Ø 500 - 1000 mm

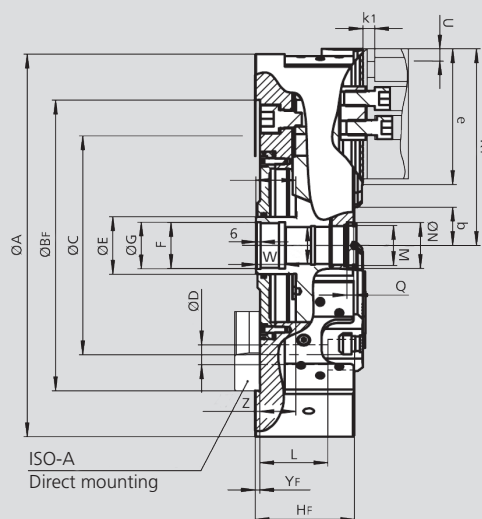
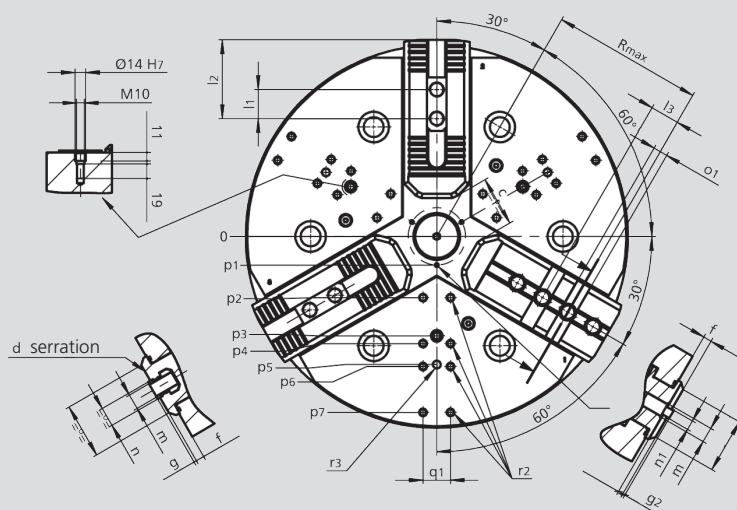
- Closed center
- Long stroke
- 3 jaws
- proofline® chucks = fully sealed - low maintenance

APL-D

INCH
SERRATION

APL-C

TONGUE & GROOVE



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

SMW-AUTOBLOK Type			APL-D 500 APL-C 500	APL-D 630 APL-C 630	APL-D 800 APL-C 800	APL-D 1000 APL-C 1000
Mounting			Z380	Z380	Z520	Z520
	A	mm	500	630	800	1000
	Bf H6	mm	380	380	520	520
	C	mm	330.2	330.2	463.6	463.6
	D	mm	26	26	26	26
	E	mm	75	75	75	75
	F	mm	M60 x 1.5	M60 x 1.5	M60 x 1.5	M60 x 1.5
	G H8	mm	61	61	61	61
	Hf	mm	130	140	150	150
	K	mm	48	48	48	48
	L	mm	89	89	89	89
	M	mm	M52 x 1.5	M52 x 1.5	M52 x 1.5	M52 x 1.5
	N H8	mm	60	60	60	60
	Q	mm	7.5	7.5	7.5	7.5
Chuck open	R1	mm	257	322	407	507
Max.	R	mm	198	250	351	465
	S	mm	52	52	52	52
Jaw stroke	U	mm	13.3	13.3	13.3	13.3
	W	mm	38	38	38	38
Max. / min.	Z	mm	47 / 14	57 / 24	57 / 24	67 / 34
Min.	b	mm	36.5	36.5	36.5	36.5
Min.	c	mm	42	42	42	42
	d	Inch	3 / 32 x 90°	3 / 32 x 90°	3 / 32 x 90°	3 / 32 x 90°
	e	mm	177	242	327	457
	f	mm	11	11	11	11
	g	mm	3.5	3.5	3.5	3.5
	g2	mm	3	3	3	3
	g3	mm	6.5	6.5	6.5	6.5
	j	mm	72	72	72	72
	k1	mm	16	16	16	16
	l1	mm	38	38	38	38
Max. / min.	l2	mm	145 / 54	210 / 54	295 / 54	393 / 54
	l3	mm	38.1	38.1	38.1	38.1
	m	mm	M20	M20	M20	M20
	n H8	mm	25.5	25.5	25.5	25.5
	n1 H8	mm	12.7	12.7	12.7	12.7
	o1	mm	19.03	19.03	19.03	19.03
	p1	mm	37.5	37.5	37.5	37.5
	p2	mm	80	80	-	80
	p3	mm	130	130	130	130
	p4	mm	140	170	200	170
	p5	mm	167.5	280	280	280
	p6	mm	170	-	290	260
	p7	mm	230	260	380	350
	q1	mm	36	36	36	36
	r1	mm	M6	M6	M6	M6
	r2	mm	M10	M10	M10	M10
	r3	mm	M12	M16	M16	M16
	Yf	mm	6	6	6	6
Number of „o1“ cross grooves (only for APL-C)			2	3	6	9
Number of „m“ threads (only for APL-C)			4	5	8	10