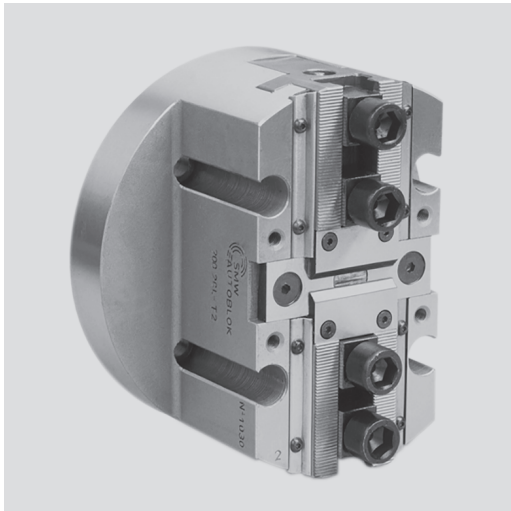


**CL-C**

TONGUE &amp; GROOVE

**CL-D**INCH  
SERRATION**High precision power chuck  $\varnothing$  80 - 315 mm**

- Long stroke
- Closed center
- 2 jaws

**Application/customer benefits**

- Gripping or handling of irregular shaped pieces, for example on special machines
- Suitable for vertical machines

**CL-C:** Master jaws with TONGUE & GROOVE ( $\varnothing$  80 - 160 mm)**CL-D:** Master jaws with INCH SERRATION (1/16" x 90°) ( $\varnothing$  200 - 315 mm)**Technical features**

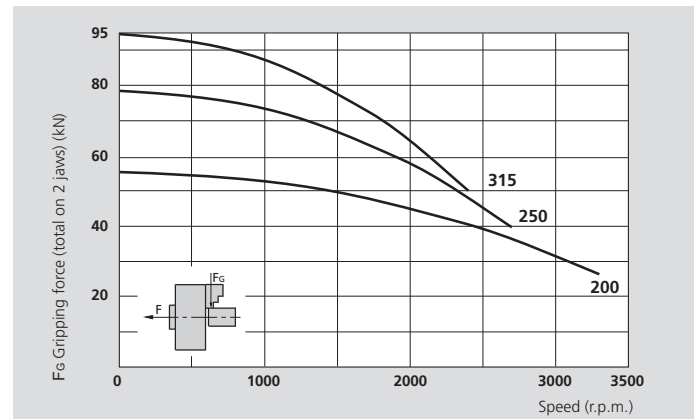
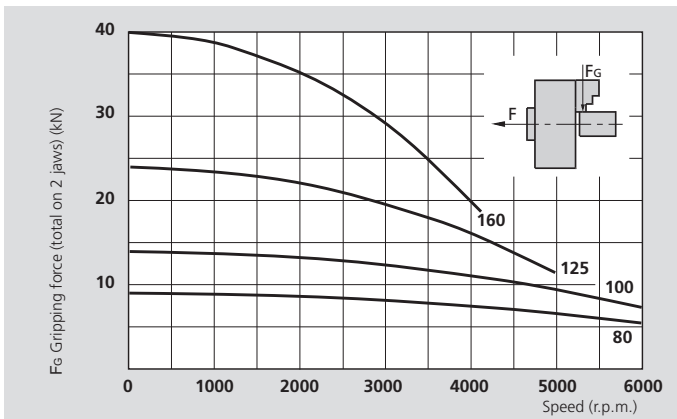
- EXTRA long stroke per jaw
- Gripping force transmission via wedge hook
- Sealed against swarf and chips

**Standard equipment**

2-jaw chuck  
4 T-nuts with bolts ( $\varnothing$  200 - 315 mm)  
Without top jaws

**Ordering example**

2-jaw chuck CL-D 250 / A8  
or  
2-jaw chuck CL-C 100 / Z92

**Actual gripping force diagrams**

The data in the diagrams refer to 2-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.

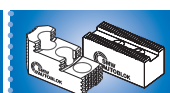
**Technical data**

SMW-AUTOBLOK Type		CL-C 80	CL-C 100	CL-C 125	CL-C 160	CL-D 200	CL-D 250	CL-D 315
<b>Number of jaws</b>		<b>2</b>	<b>2</b>	<b>2</b>	<b>2</b>	<b>2</b>	<b>2</b>	<b>2</b>
<b>Radial jaw stroke</b>	mm	4.4	5.5	8	10	12	13	14
<b>Axial piston stroke</b>	mm	11	14	20	25	30	32	35
<b>Max. draw pull*</b>	kN	6	9	15	25	35	50	60
<b>Max. gripping force*</b>	kN	9	14	24	40	55	78	95
<b>Max. speed</b>	r.p.m.	6000	6000	5000	4100	3300	2700	2400
<b>Weight (without top jaws)</b>	kg	1.5	2.5	5	10	14	24	38
<b>Moment of inertia</b>	kg·m <sup>2</sup>	0.0012	0.003	0.010	0.03	0.065	0.18	0.41
<b>Id. No. CL-C/CL-D (Center mounting)</b>		77907108	77907110	77907113	77907116	77900720	77900725	77900731

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



SMW-AUTOBLOK  
466



SMW-AUTOBLOK  
468



SMW-AUTOBLOK  
327

# High precision power chuck $\varnothing$ 80 - 315 mm

- Long stroke
- Closed center
- 2 jaws

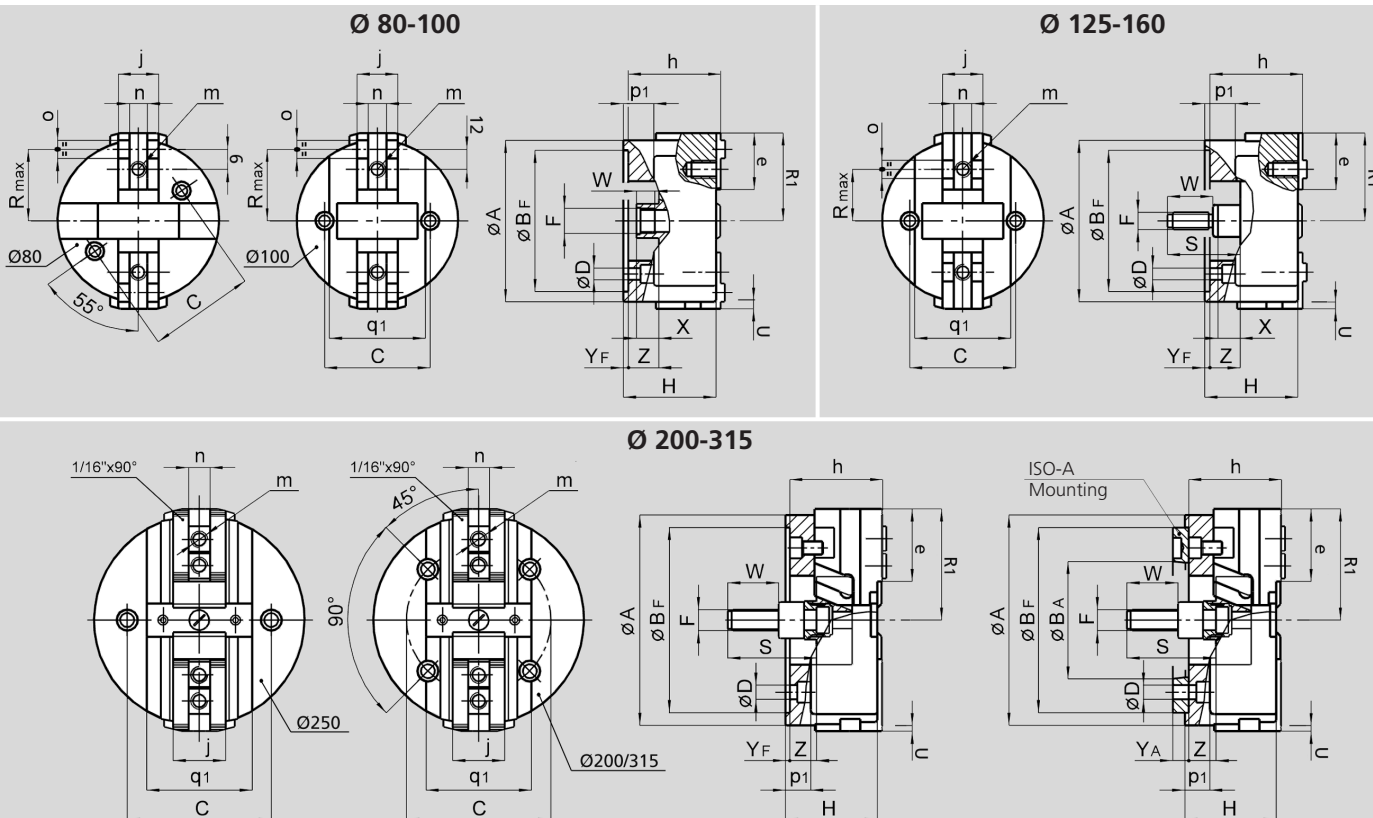
## CL-C

TONGUE & GROOVE

## CL-D

INCH  
SERRATION

1



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

SMW-AUTOBLOK Type			CL-C 80		CL-C 100		CL-C 125		CL-C 160		CL-D 200		CL-D 250		CL-D 315		
			TONGUE & GROOVE														INCH SERRATION
Mounting			Z74	-	Z92	-	Z115	-	Z140	A5	Z170	A6	Z220	A8	Z220	A8	
	<b>A</b>	mm	80		100		125		160		200		250		315		
	<b>BF H6</b>	mm	74	-	92	-	115	-	140		170		220		220		
	<b>BA</b>	mm	-	-	-	-	-	-	82.563		-	106.375	-	139.719	-	139.719	
	<b>C</b>	mm	60		75		92		104.8		133.4		171.4		171.4		
	<b>D</b>	mm	9	-	11	-	13.5	-	12	12	13.5	13.5	17	17	17	17	
	<b>F</b>	mm	M16 x 1.5		M18 x 1.5		M16		M16		M20		M24		M24		
	<b>HF/HA</b>	mm	45	-	54	-	76	-	92	102	103	115	109	123	114	128	
Chuck open	<b>R1</b>	mm	40		50		68		87		108		132		165		
	<b>Rmax</b>	mm	32.4		43		38		51		-		-		-		
	<b>S</b>	mm	-		-		49		109		97		105		105		
Jaw stroke	<b>U</b>	mm	4.4		5.5		8		10		12		13		14		
	<b>W</b>	mm	12		16		40		52		55		60		60		
	<b>X</b>	mm	14		11		6		22		8		10		10		
	<b>YF/YA</b>	mm	4	-	4	-	4	-	5	15	5	17	5	19	5	19	
Min. / max.	<b>Z</b>	mm	11 / 0		14 / 0		26 / 6		30 / 5		30 / 0		32 / 0		37 / 2		
	<b>e</b>	mm	24.5		32		46		56		70		86		120		
	<b>h</b>	mm	45		54		76		91		104		110		115		
	<b>j</b>	mm	20		22		30		40		50		62		62		
	<b>m</b>	mm	M8		M10		M12		M16		M16		M20		M20		
	<b>n h8</b>	mm	8		8		14		18		21		25.5		25.5		
	<b>o</b>	mm	8		8		16		18		-		-		-		
	<b>p1</b>	mm	-		22		30		30		31		33		36		
	<b>q1</b>	mm	-		60		75		95		110		125		140		