

# IEP-D

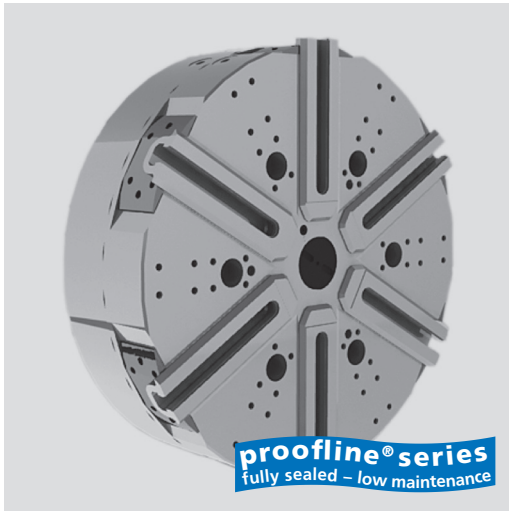
2+2+2 movement  
INCH SERRATION

# IEP-C

2+2+2 movement  
TONGUE & GROOVE

## High precision 6-jaw chuck 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 equalising 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

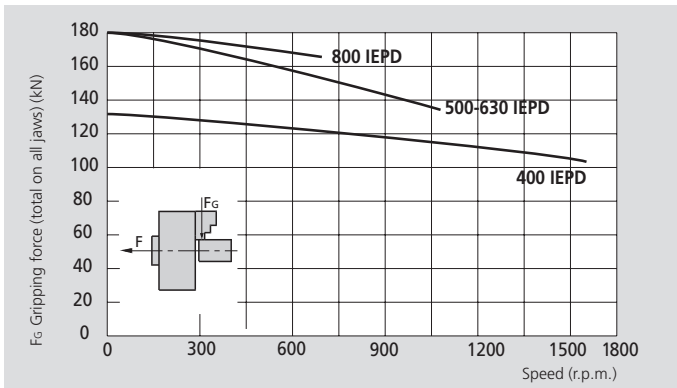
1 set of soft top jaws

1 equalising stroke regulating key

### Ordering example

Chuck IEP-D 500 / Z380

## Actual gripping force diagram



The data in the diagram refers 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 <sup>2</sup>	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	
Id. No. IEP-D		77994220		77995030		77996332		77998030	
Id. No. IEP-C		77994221		77995020		77996331		77998029	

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

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



SMW-AUTOBLOK  
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# High precision 6-jaw chuck 2+2+2 equalising

Ø 400 - 800 mm

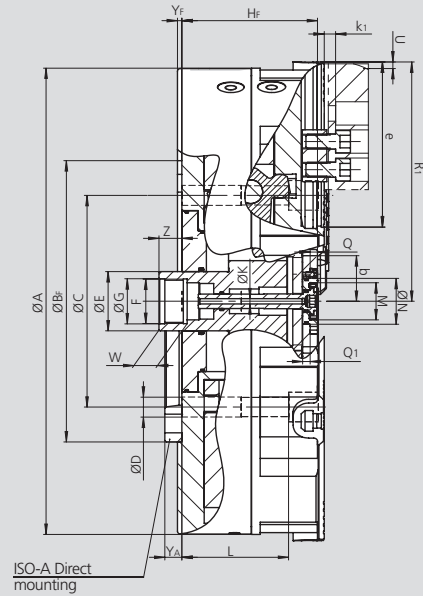
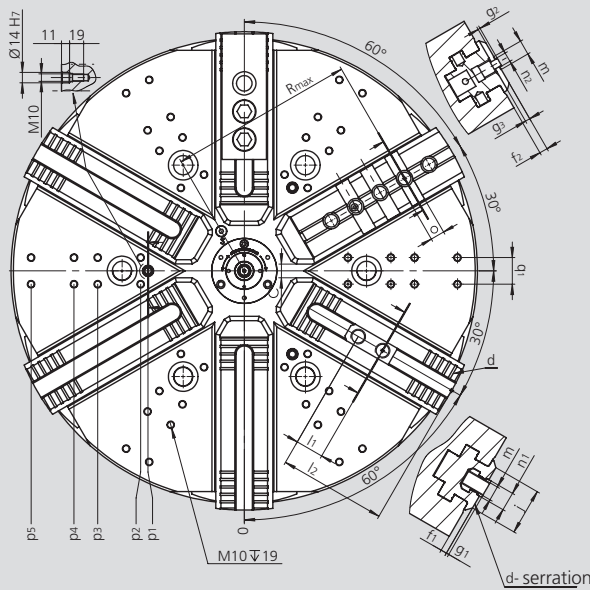
- Closed center
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## IEP-D

2+2+2 movement  
INCH SERRATION

## IEP-C

2+2+2 movement  
TONGUE & GROOVE



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