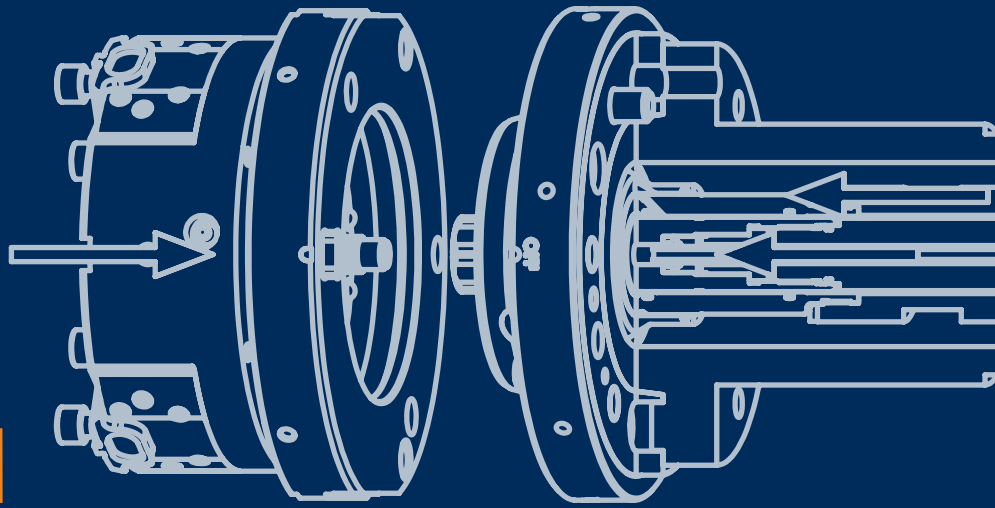


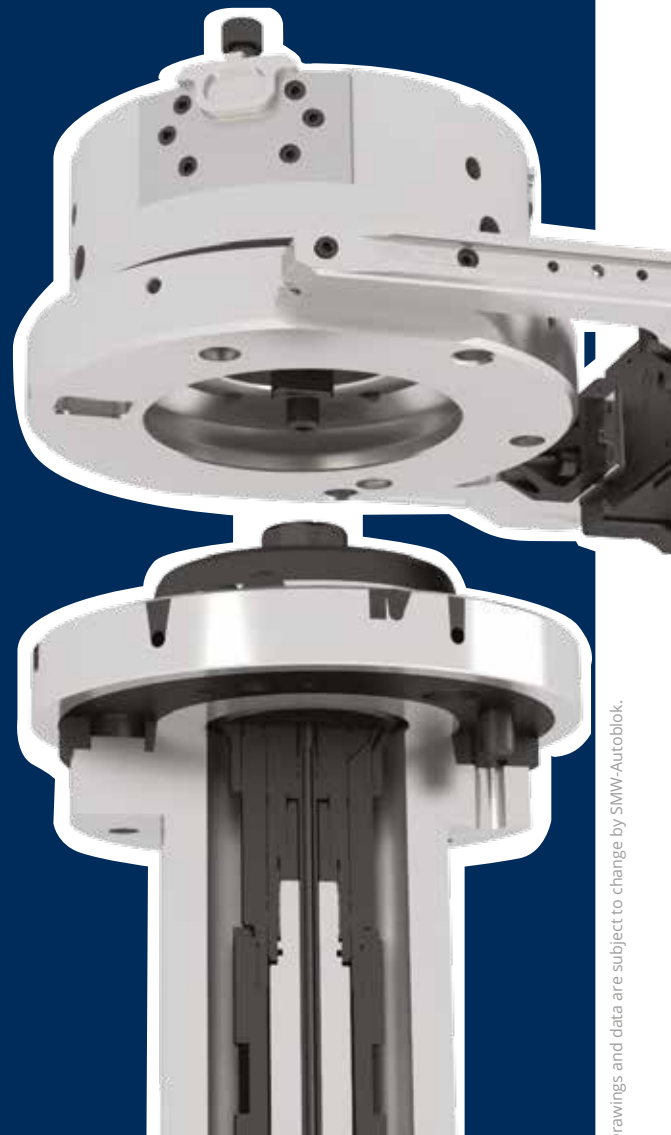
AT-PM



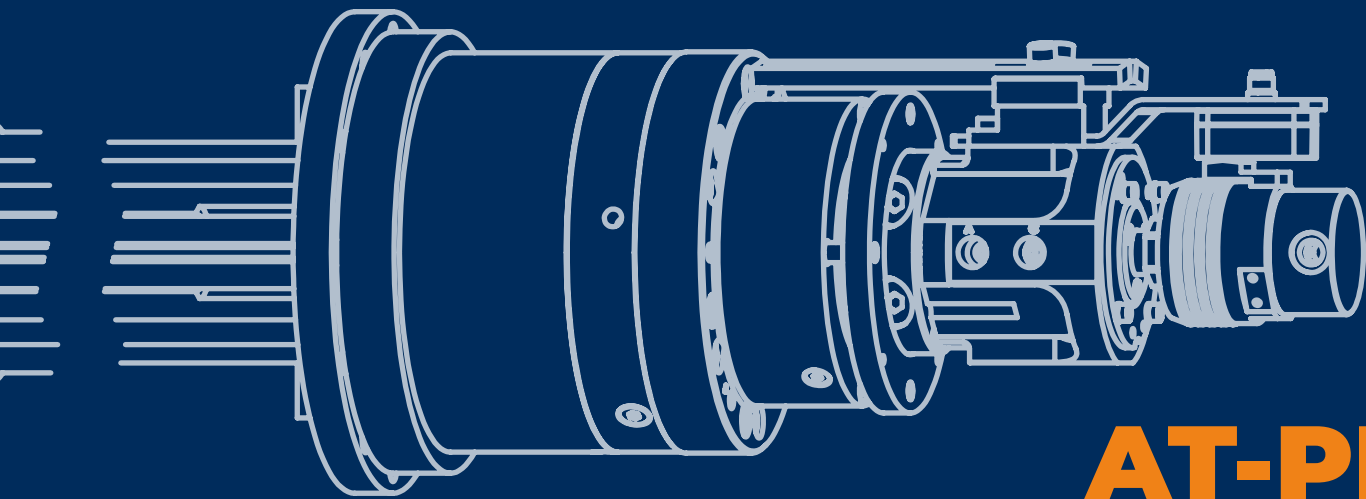
All SMW-Autoblok quick chucks change systems are designed to permit a fast and quick change of chucks on the lathe using a special double cylinder.

CUSTOMER BENEFITS

- ▶ QUICK CHUCKS CHANGE ON LATHE
- ▶ QUICK CHUCKS CHANGE AVAILABLE DIAMETER ON LATHE
- ▶ QUICK CONNECTION TO DOUBLE CYLINDER BETWEEN AUTOMATIC FEEDING
- ▶ PALLET POSITIONING ACCURACY
PALLET < 0,005 mm



Drawings and data are subject to change by SMW-Autoblok.



AT-PM

Product type	Size			AT-PM Id. n.	pallets and chucks usable on rotary plate		Air sensing	external draw-bar/operation AT-PM		internal draw-bar/operation CHUCK OR COLLECT	
	200/170	240/220	320/330		∅ pallets /chucks	rpm		max pull-down cylinder	max holding force pallet	max pull-down force cylinder	max pushing force cylinder
ATPM	200/170			65002009	170	5000		30 kN	120 kN	68 kN	40 kN
					210	4000					
					260	3000					
		240/220		65002405	210	4500		30 kN	120 kN	68 kN	40 kN
					260	3500					
					315	2500					
			320/330	65003205	315	2500		40 kN	160 kN	112 kN	65 kN
					400	1600					
					530	900					


DOUBLE PISTON CYLINDERS with 4 safety valves AT-PM control


CUSTOMER BENEFITS

AT-PM actuation +TS and AP chucks

AT-PM actuation + collets

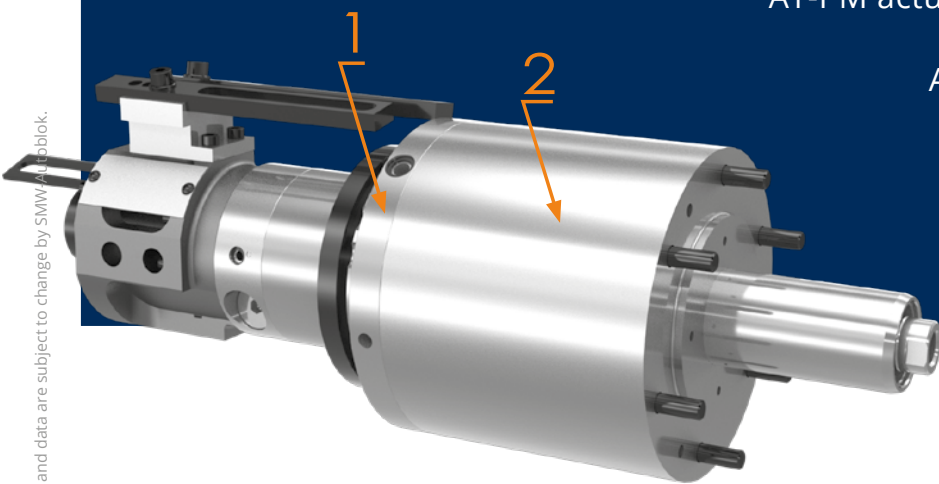
Pallet positioning accuracy < 0,005 mm

PISTON 1

 AT-PM actuation

PISTON 2

 Chuck actuation



Drawings and data are subject to change by SMW-AUTOBLOK.



DOUBLE PISTON CYLINDERS

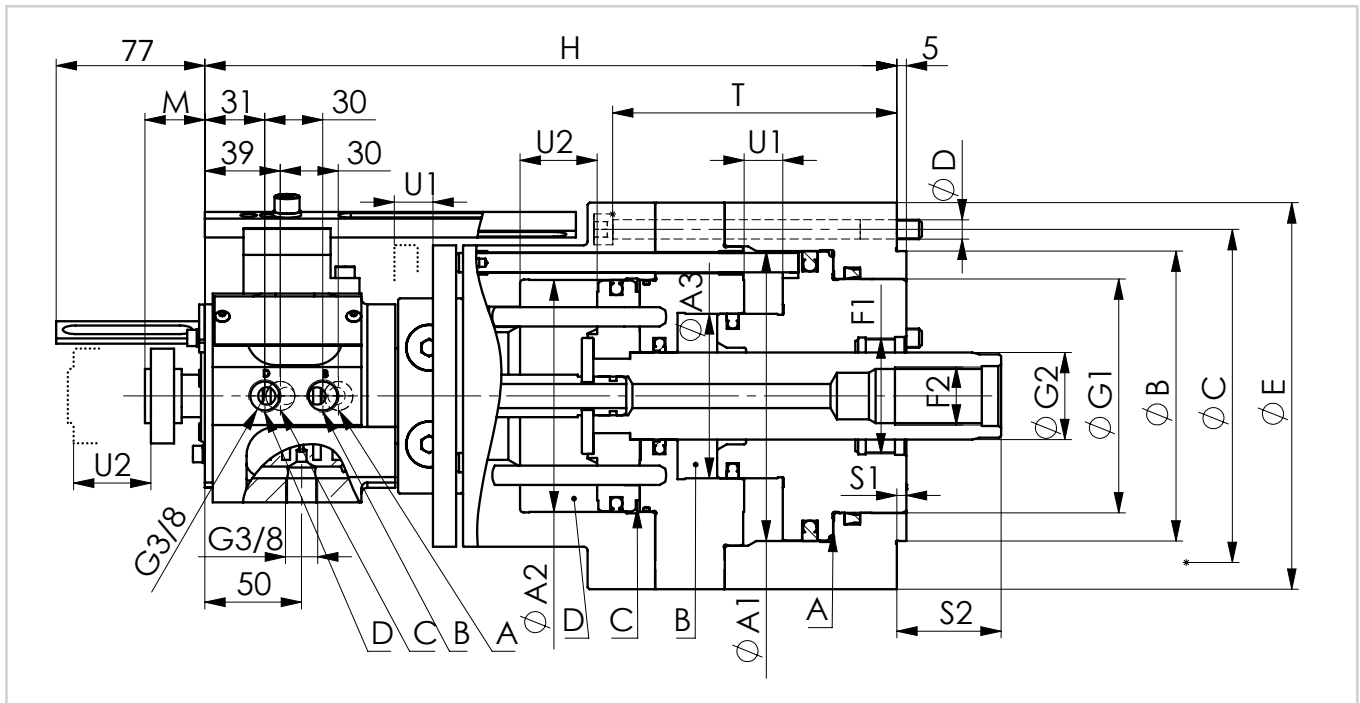
WITH 4 SAFETY VALVES FOR AT-PM CONTROL

Applications/Customer benefits

- AT-PM actuation +TS and AP chucks
- AT-PM actuation + collets
- Pallet positioning accuracy < 0,005 mm

Technical features

- Double piston cylinder with 4 way oil manifold for separate actuation of the 2 cylinders
- Pressure range 8 - 70 bar
- Horizontal or vertical installation
- Safety valves on the biggest cylinders and stroke control on each cylinder
- Central bore for air, coolant or oil with thread for rotary union
- Mounting from the rear side with bolts
- A 10 µm filter in pressure line is requested
- Use oil HM32 ISO 3448
- Air sensing function for pallet positioning
- Balancing 6.3

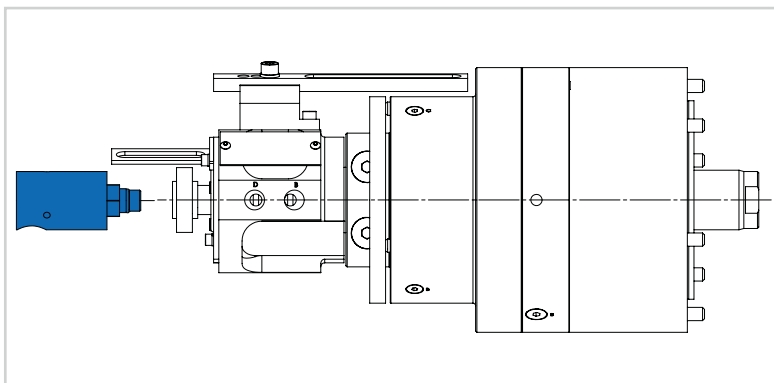
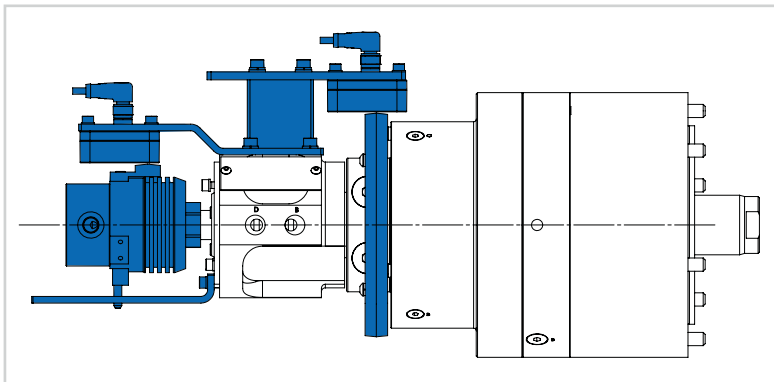
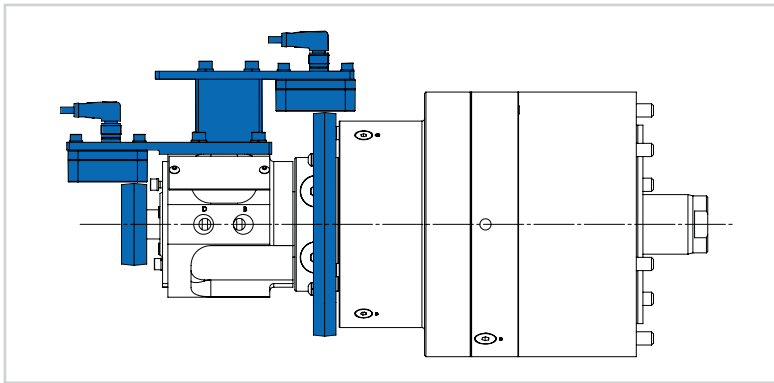
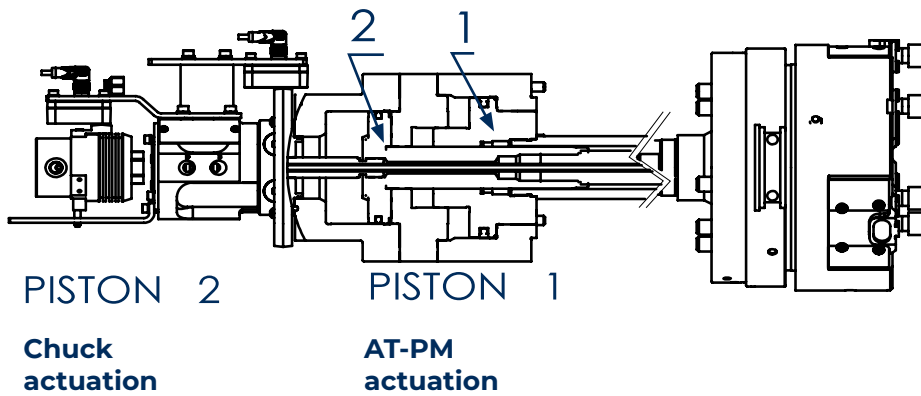


ID.No.	DOUBLE PISTON CYLINDER TYPE	Piston Area A (cm ²)	Piston Area B (cm ²)	Piston Area C (cm ²)	Piston Area D (cm ²)	A Piston force max/min (kN)	B Piston force max/min (kN)	C Piston force max/min (kN)	D Piston force max/min (kN)	Max speed (rpm)	Weight (kg)	Moment of inertia (kgm ²)	Pressure max/min (bar)
33981009	DCE-4V 64-64/30-40	66	63	63	66	46/5	44/5	44/5	46/5	5000	28,6	0,074	70/8
33981206	DCR-4V 60-100/20-40	61	41	97	109	43/5	29/3,3	68/7,7	76/8,7	5000	36	0,127	70/8
33981510	DCR-4V 90-160/20-40	90	41	160	173	63/7	29/3,3	112/13	121/14	4000	47,5	0,24	70/8

Total oil drainage 3 dm³/min at 30 bar /50°C

ID.No.	DOUBLE PISTON CYLINDER TYPE	A1	A2	A3	B	C	D 6x60°	E	F1	F2	G1	G2	H	M	S1 (max)	S2 (max)	T	U1	U2
33981009	DCE-4V 64-64/30-40	125	95	/	105	145	M10	174	M45x1,5	M20x1,5	85	30	362	31	40	76	151	30	40
33981206	DCR-4V 60-100/20-40	150	120	85	150	175	M10	200	M60x1,5	M30	121	45	358	31	5	54	147	20	40
33981510	DCR-4V 90-160/20-40	180	150	85	180	206	M12	234	M72x1,5	M30	145	45	360	31	5	52	144	20	40

AT-PM: Double piston cylinders and LPS 4.0 kit



LPS 4.0 Kit - OPTIONAL

- kit for DCE-4V 64/64 ID.No. 60558306
- kit for DCR-4V 60/100 ID.No. 60558406
- kit for DCR-4V 90/160 ID.No. 60558407

Not included in the kit:

- sensor LPS 4.0 ID.No. 208108
- cable+connector ID.No. 208247

LPS 4.0 Kit - RU-2-22 - OPTIONAL

- kit for DCE-4V 64/64 ID.No. 60558336
- kit for DCR-4V 60/100 ID.No. 60558436
- kit for DCR-4V 90/160 ID.No. 60558437

Not included in the kit:

- sensor LPS 4.0 ID.No. 208108
- cable+connector ID.No. 208247
- rotary union for 2 media type RU-2-22 ID.No. 044970

Rotary union RU-1-16 - OPTIONAL

- rotary union for 1 medium RU-1-16 ID.No. 043271