

IN-D

MODULE 2
SERRATION

IL-D

LONG JAW STROKE
MODULE 2
SERRATION

High precision power chuck Ø 1000 - 1600 mm

- Closed center
- Long jaw stroke
- 3 and 6 jaws (all diameters)

Application/customer benefits

- Chucking operations of very large components
- Suitable for vertical machines thanks to the front protection of the slide ways

IN-D/ IL-D: MODULE 2 serrated master jaws (pitch 6.28 mm)
(Ø 1000 - 1600 mm)

Technical features

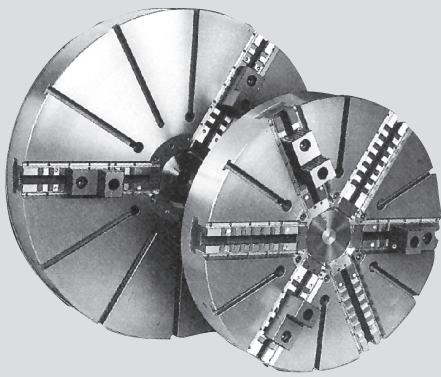
- Gripping force transmission via wedge hook
- Front protection of the slide ways against swarf and chips penetration

Standard equipment

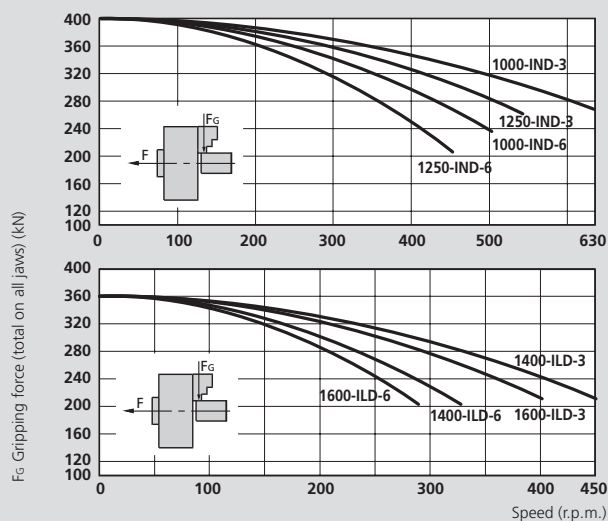
3- or 6-jaw chuck
1 set T-nuts with bolts
1 set soft top jaws with cross keys
Mounting bolts
Grease gun

Ordering example

3-jaw chuck IL-D 1600 / Z720
or
6-jaw chuck IL-D 1600 / Z720



Actual gripping force diagrams



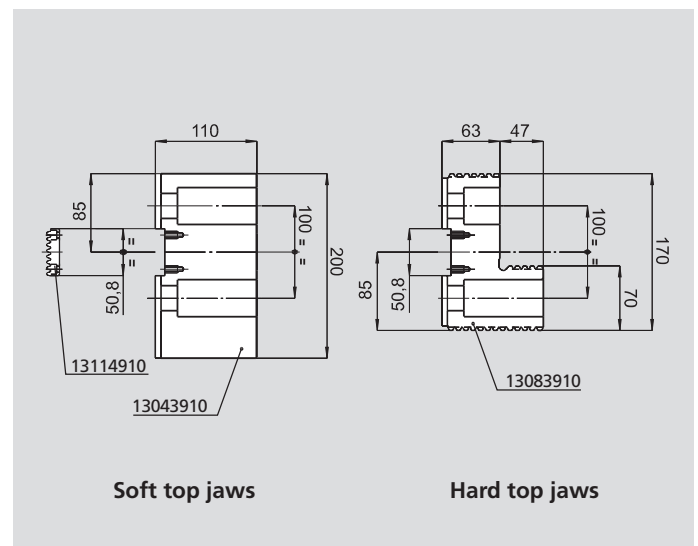
The data in the diagrams refer to 3-6 jaw chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K67 grease. The static and dynamic gripping forces have been measured using standard soft top jaws, placed in a position not exceeding the outer diameter of the chuck.

Technical data

SMW-AUTOBLOK Type		IN-D 1000		IN-D 1250		IL-D 1400		IL-D 1600	
Number of jaws		3	6	3	6	3	6	3	6
Radial jaw stroke	mm	15	15	15	15	24	24	24	24
Axial piston stroke	mm	57	57	57	57	60	60	60	60
Max. draw pull*	kN	180	180	180	180	200	200	200	200
Max. gripping force*	kN	400	400	400	400	360	360	360	360
Max. speed	r.p.m.	630	500	500	450	450	320	400	280
Weight (without top jaws)	kg	600	800	1200	1600				
Moment of inertia	kg·m ²	68	145	347	562				
Hard top jaw (piece)	Id. No.	13083910	13083910	13083910	13083910				
Soft top jaw (piece)	Id. No.	13043910	13043910	13043910	13043910				
Recommended actuating cylinders	Type	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250				
Id. No. IN-D/ IL-D 3 jaws (Center mounting)		77133339	77133349	77133755	77133763				
Id. No. IN-D/ IL-D 6 jaws (Center mounting)		77133639	77133649	77133955	77133963				

* For internal clamping reduce the draw pull by 30%

Soft and hard top jaws for IN-D and IL-D



△ Safety advice / danger of damage:

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



SMW-AUTOBLOK
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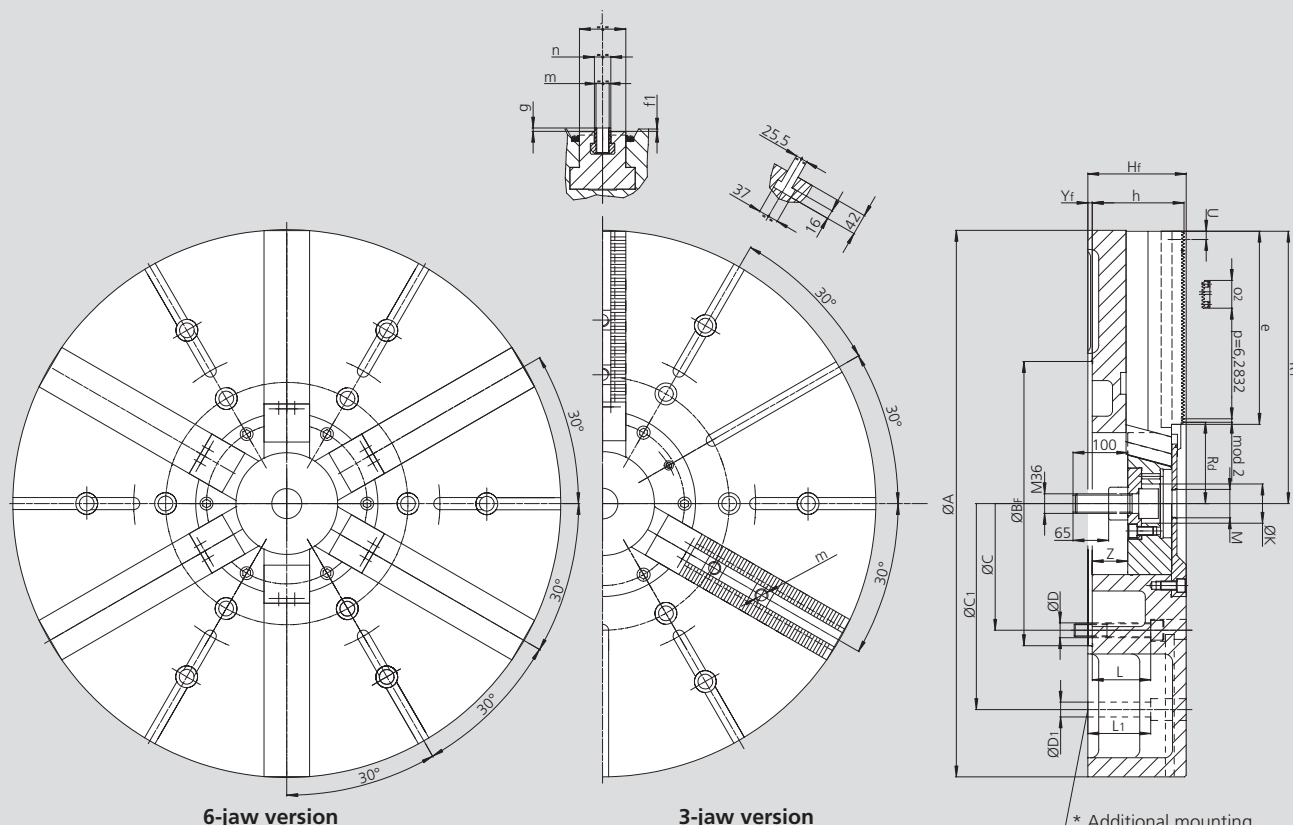
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6-jaw version

3-jaw version

* Additional mounting holes ØD1 on request

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

SMW-AUTOBLOK Type			IN-D 1000		IN-D 1250		IL-D 1400	IL-D 1600
Mounting			Z520	A20	Z520	A20	Z720	Z720
	A	mm	1005		1250		1400	1600
	Bf H6	mm	520		520		720	720
	C	mm	463.6		463.6		647.6	647.6
	C1	mm	700*		700*		1110	1110
	D	mm	27		27		33	33
	D1	mm	27*		27*		27	27
	Hf	mm	184		184		222	222
	K	mm	72		72		72	72
	L	mm	108		108		179	179
	L1	mm	116*		116*		154	154
	M	mm	M52 x 1.5		M52 x 1.5		M52 x 1.5	M52 x 1.5
Chuck open	R1	mm	498		623		696	796
Chuck open	Rd	mm	148.5		148.5		179.5	179.5
Jaw stroke	U	mm	15		15		24	24
	S	mm	100		100		100	100
	Yf	mm	8		8		8	8
Max.	Z	mm	65		65		82	82
Min.	Z	mm	8		8		22	22
	e	mm	353		478		519	619
	f	mm	8		8		8	8
	g	mm	4		4		4	4
	h	mm	168		168		206	206
	j	mm	85		85		110	110
	m	mm	M24		M24		M24	M24
	n h8	mm	30		30		30	30
	o2 h6	mm	50.8		50.8		50.8	50.8