SMW AUTOBLOK

NEW

KNCS-matic

3 JAWS

Automatic Quick Jaw Change

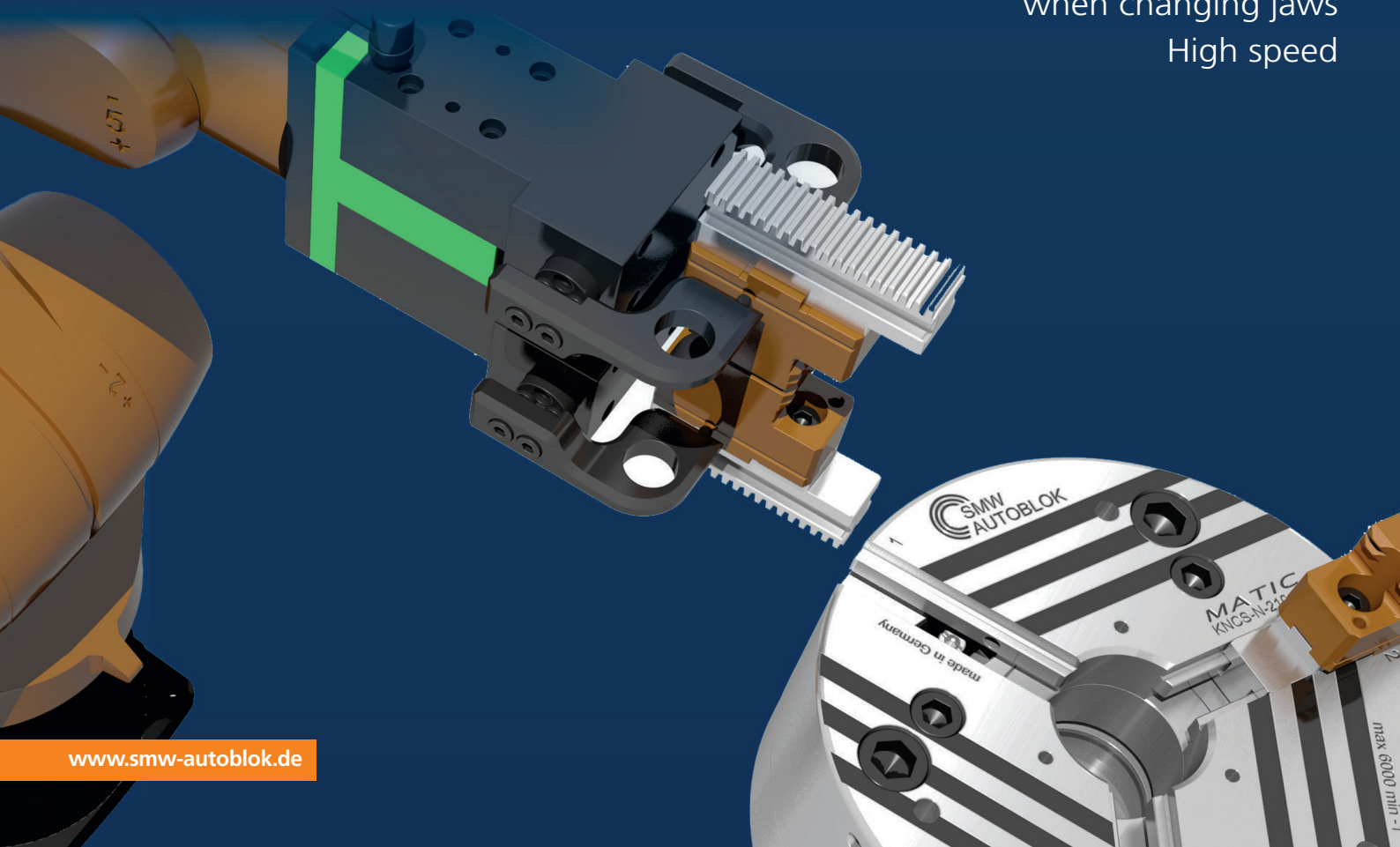
FLEXIBLE

Automatic quick jaw change
utilizing the machines
loading robot

PRECISE

High repeatability
when changing jaws

High speed



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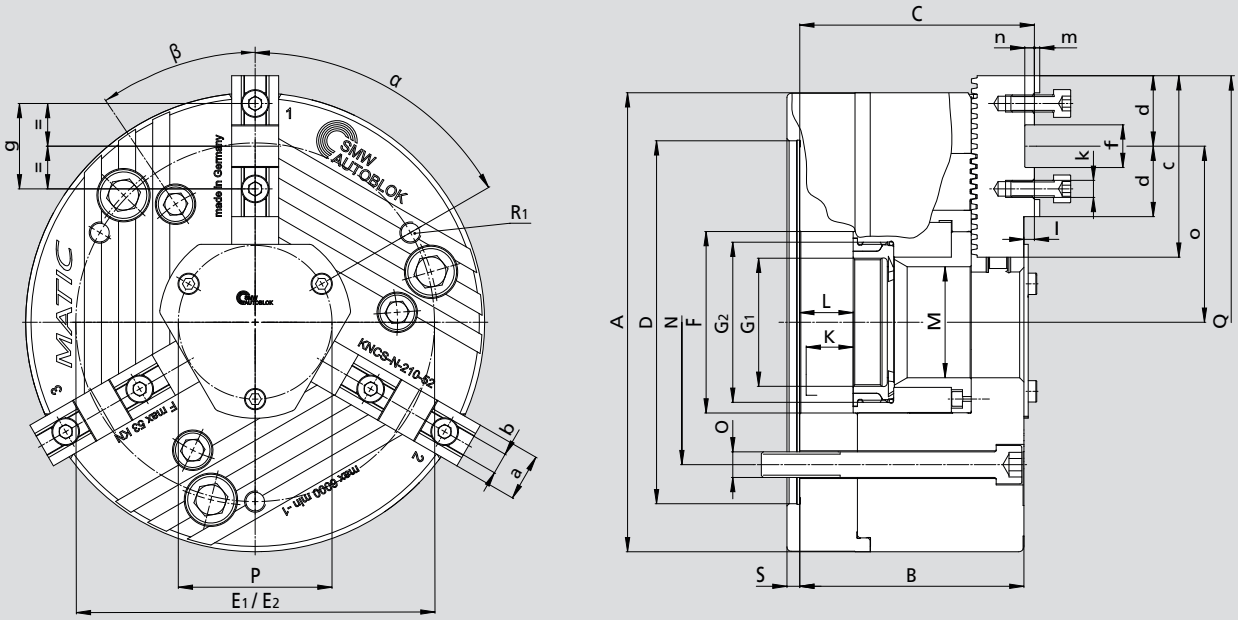
KNCS-*matic*

QUICK JAW CHANGE

Main dimensions and technical data

* ATTENTION!
Use base jaws always together with the chuck cover plates!

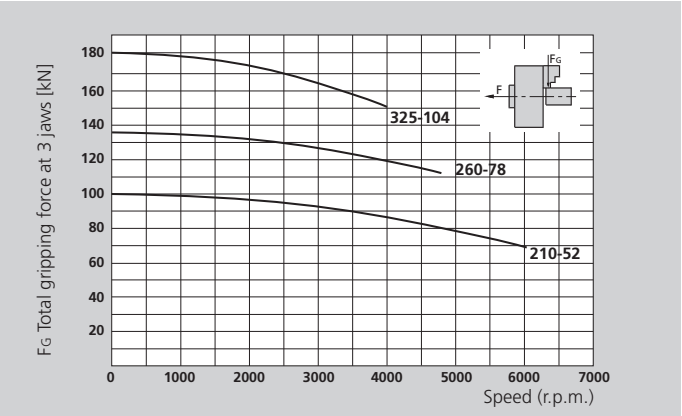
Jaw position: open position for external clamping
Base jaw position „o"

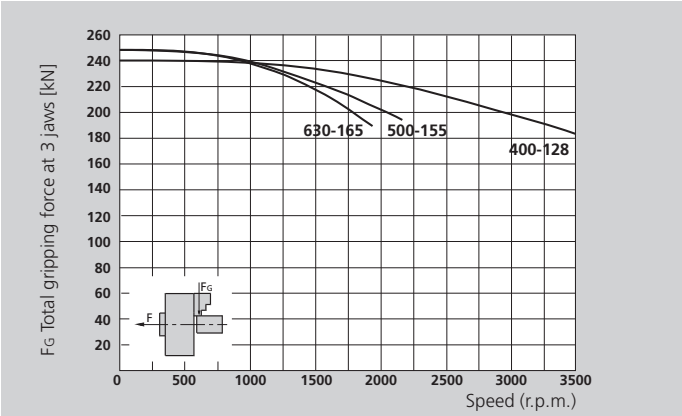


Subject to technical changes.
For more detailed information please ask for customer drawing.

SMW-AUTOBLOK Type KNCS-*matic*		210-52	260-78		325-104	400-128	500-155	630-165
Mounting	**Size**	**Z170**	**Z170**	**Z220**	**Z300**	**Z380**	**Z380**	**Z380**
	A	215	260		324	400	500	630
	B	105	120		129.9	140	174	174
	C	109.9	128.3		139.2	149.2	184	184
	D H6	170	170	220	300	380	380	380
Circle for fixtures etc.	**E1**	168	210		268	330	420	420
Circle for fixtures etc.	**E2**	-	-		-	-	-	585
	F	85	111		144	180	207	217
Rotating ring nut / depth	**G1**	M60 x 1.5 / 16	M90 x 2.0 / 20		M115 x 2.0 / 22	M138 x 2.0 / 22	M165 x 2.0 / 25	M175 x 2.0 / 25
Piston thread / depth	**G2**	M75 x 2.0 / 19	M102 x 2.0 / 23		M132 x 2.0 / 25	M160 x 2.0 / 25	M185 x 2.0 / 28	M195 x 2.0 / 28
Piston stroke	**K**	25	28		28	32	42	42
max.	**L**	25	28		28	32	42	42
	M	52	78		104	128	155	165
Mounting screw circle	**N**	133.4	133.4	171.4	235	330.2	330.2	330.2
Mounting screw	**O**	M12	M12	M16	M20	M24	M24	M24
Circle for coverplates	**P**	72	95		130	152	180	195
	Q	261	307		385	452	552	643
Thread / Thread depth	**R**	M10 / 12 (3x)	M10 / 18 (3x)		M10 / 16 (6x)	M12 / 18 (9x)	M16 / 25 (9x)	M16 / 25 (18x)
	S	6	6		6	8	8	8
	a	22	26		32	32	45	45
	b f7	10	12		12	12	18	18
	c	85	104		115	125	160	200
	d	33	36		36	43	50	50
	f H7	20	20		20	26	30	30
	g	40	40		40	54	60	60
Thread / Thread depth	**k**	M8 / 13	M12 / 17		M12 / 17	M12 / 17	M16 / 34	M16 / 34
	l	4.9	8.3		9.3	9.3	10	10
	m	2.5	3		3	3	4	4
	n	4.5	5.5		6	7	9	9
max. / min.	**o**	96.6 / 68.3	116.6 / 83.6		155.7 / 106.2	182.3 / 121.8	225 / 141	270.5 / 179.5
Base jaw tooth pitch	**-**	4.7	5.5		5.5	5.5	164 / 80	7
Base jaw offset	teeth	6	6		9	11	12	13
α	deg.	60	60		60 / 85	20 / 60 / 100	20 / 60 / 100	20 / 60 / 100
β Mounting screw circle	deg.	34	55		40	40	40	40
Stroke per jaw at piston stroke **K** max.	mm	7.0 / 25	8.0 / 28		8.0 / 28	8.0 / 32	10.0 / 42	10.0 / 42
max. actuating force	kN	53	70		95	115	120	120
max. total gripping force	kN	100	135		180	240	250	250
max. speed	r.p.m.	6000	4700		4000	3500	2200	1700
Weight without jaws	kg	24	43		65	115	225	390
Moment of inertia	kg·m²	0.11	0.38		1.20	2.50	6.50	18.0
Recommended closed center cylinder	**Type**	**SIN-S 125/150**	**SIN-S 150/175**		**SIN-S 150/175/200**	**SIN-S 175/200**	**SIN-S 175/200**	**SIN-S 175/200**
Recommended open center cylinder	**Type**	**VNK-T2 130-52**	**VNK-T2 170-77**		**VNK-T2 250-110**	**VNK-T2 320-127**	**VSG 450-165**	**VSG 450-165**

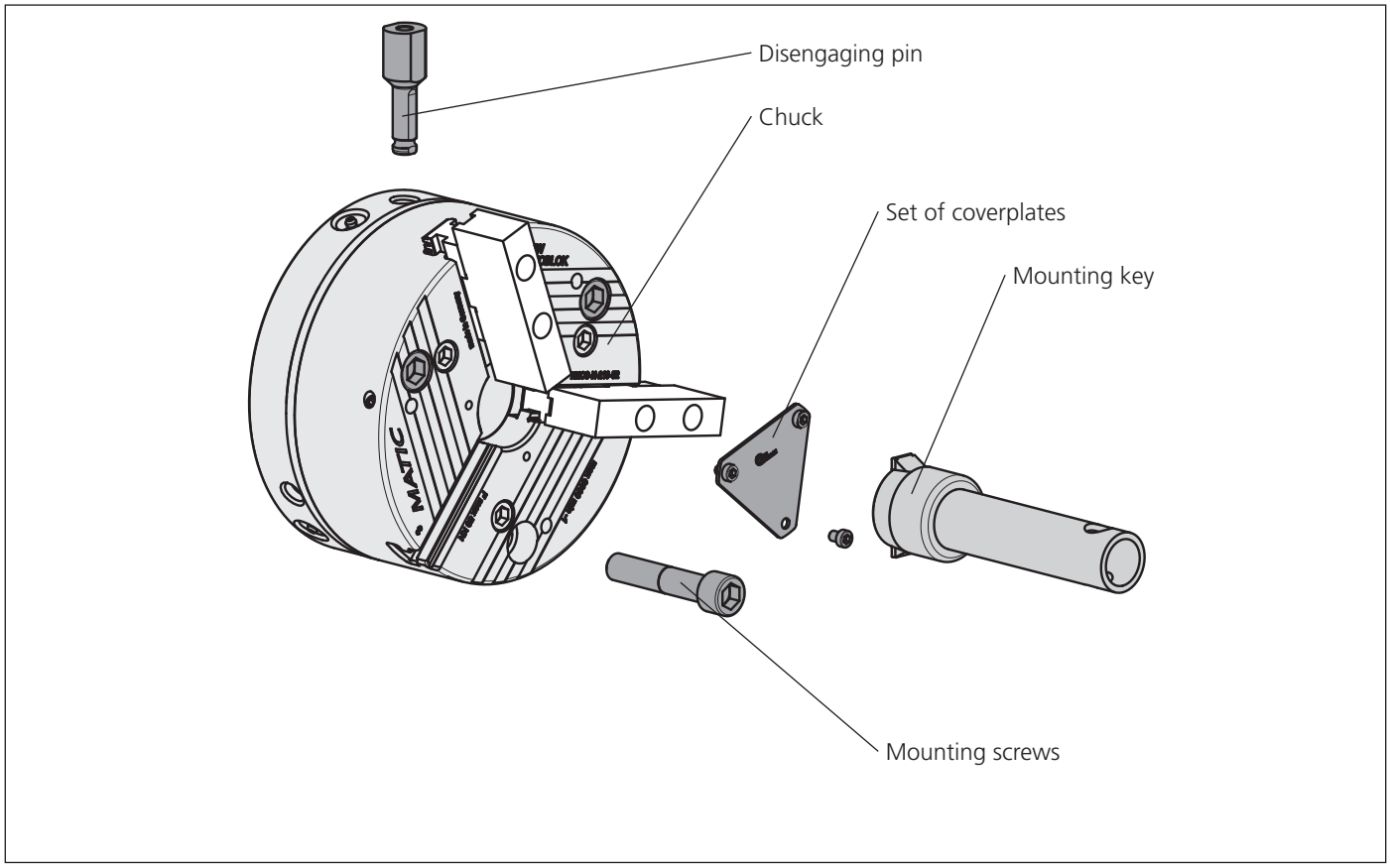
Gripping force / speed diagram KNCS-*matic*





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.



Supply range:

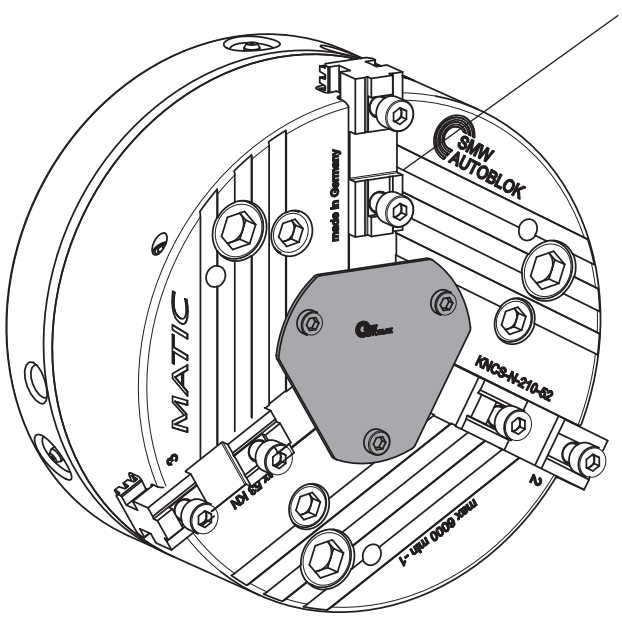
Chuck + disengaging pin + mounting screws + mounting key + 1 set of coverplates

Size / Spindle mounting	KNCS-*matic* 210-52 - Z170	KNCS-*matic* 260-78 - Z170	KNCS-*matic* 260-78 - Z220	KNCS-*matic* 325-104 - Z300	KNCS-*matic* 400-128 - Z380	KNCS-*matic* 500-155 - Z380	KNCS-*matic* 630-165 - Z380
Ident No.	162080	162242	162255	162183	162155	162355	162200

Operate KNCS-*matic* chuck only with chuck cover plate set!

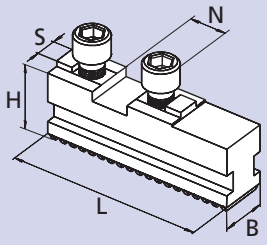
ATTENTION!

Danger of contamination of the master jaw serration, and thus jamming of the master jaws and malfunction of the chuck!



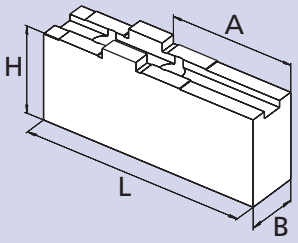
GBK
Hardened base jaws

KNCS-*matic*	210	260	325	400	500	630
Jaw type	GBK 200	GBK 250	GBK 315	GBK 400	GBK 500	GBK 630
Id. No.	012440	012441	012442	012443	012444	012445
B	22	26	32	32	45	45
H	29.5	37	43	43	57	57
L	85	104	115	125	160	200
N	20	20	20	26	30	300
S	10	12	12	12	18	18
kg/set	1.0	1.8	2.7	3.0	7.1	9.0



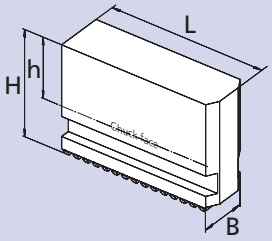
WAK
Soft top jaws

KNCS-*matic*	210	260	325	400	500	630
Jaw type	WAK 200-10	WAK 250-10	WAK 250-10	WAK 400-10	WAK 500-10	WAK 500-10
Id. No.	012492	012493	012493	012494	012495	012495
B	22	30	30	35	50	50
H	42	50	50	54	75.5	75.5
L	105	125	125	145	180	180
A	50	70	70	74	100	100
kg/set	2.0	3.6	3.6	5.8	13.7	13.7



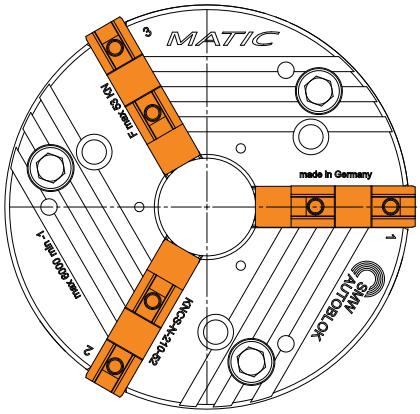
UVB
Soft monoblock jaws

KNCS-*matic*	210	260	325	400	500	630
Jaw type	UVB 200	UVB 250	UVB 315	UVB 400	UVB 500	UVB 630
Id. No.	012448	012449	012450	012451	012452	012453
B	22	26	32	32	45	45
H	70	90	100	100	134	134
h	45	61	66	66	87	87
L	83	108	119	146.5	175	230
kg/set	2.7	5.5	8.2	10.1	23	30.4



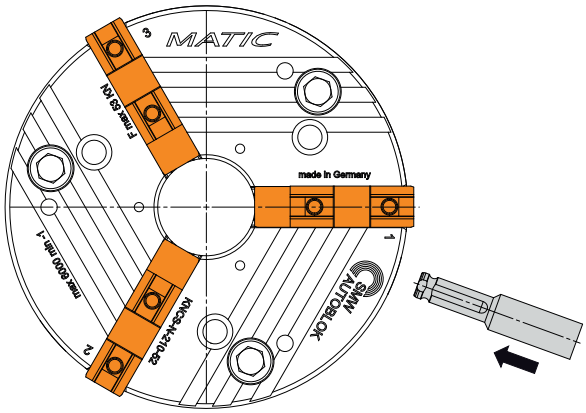
Attention!
Modify soft monoblock jaws type UVB for the use of the chuck cover plates!

Step 1



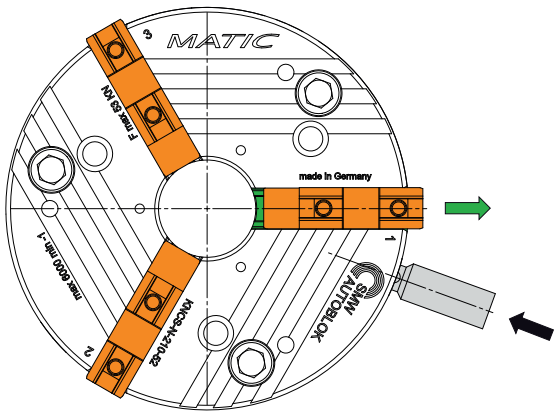
Stop the machine spindle with one guideway orientated horizontal. (In vertical use is no specific orientation necessary)

Step 2



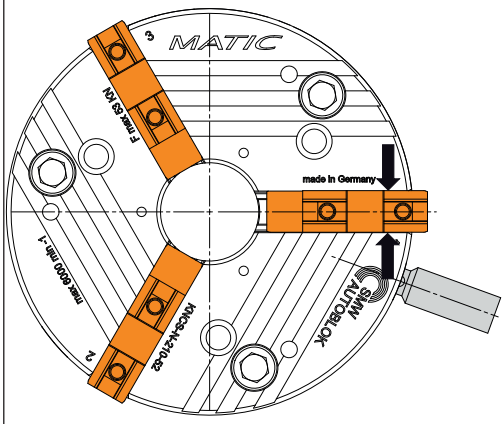
Bring in the disengaging pin.

Step 3



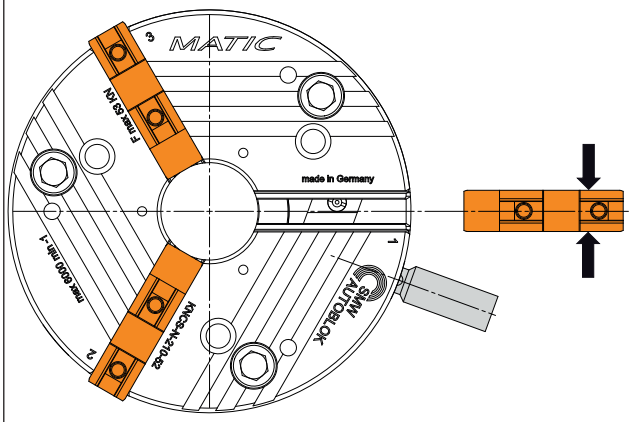
Disengage the first jaw. The jaw will make a radial relative movement outwards.

Step 4



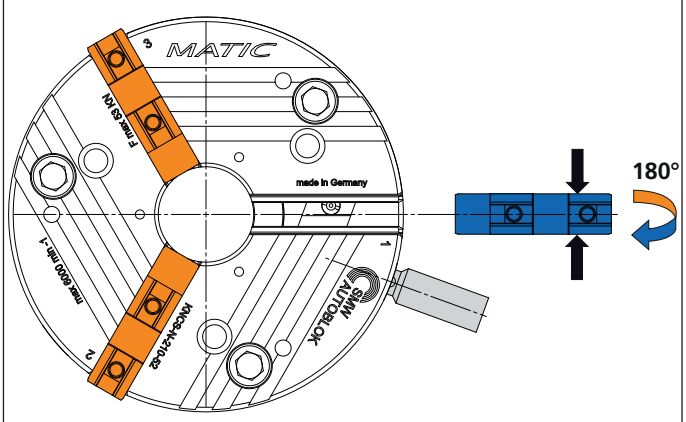
Bring in the robot hand and grip the jaw.

Step 5



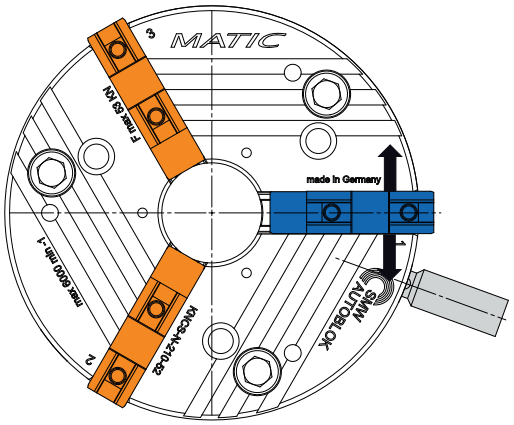
Pull the jaw out of the chuck.

Step 6



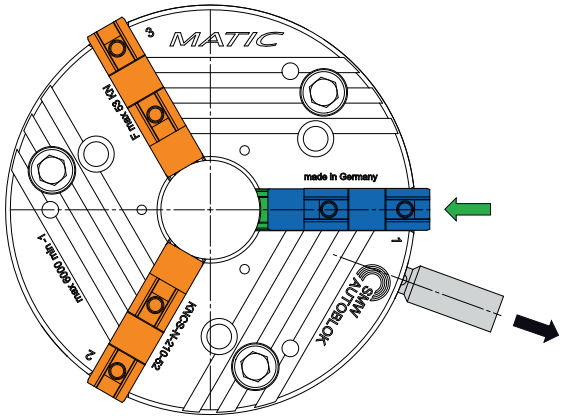
Insert the new jaw.

Step 7



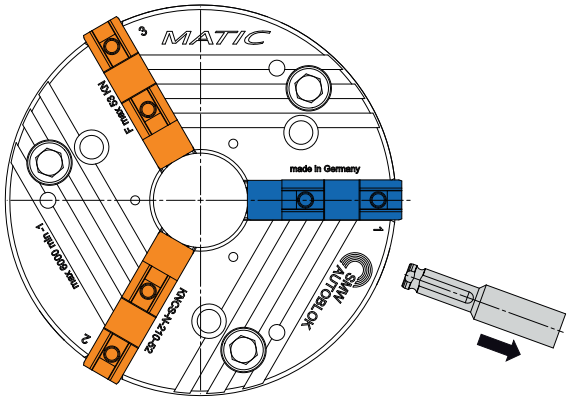
Open the robot hand and release the new jaw.

Step 8



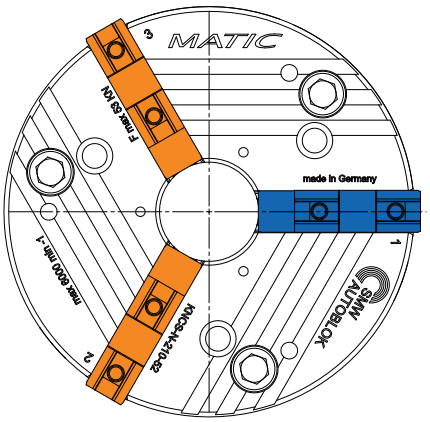
Pull out the disengaging pin. The jaw will make a radial relative movement inwards.

Step 9



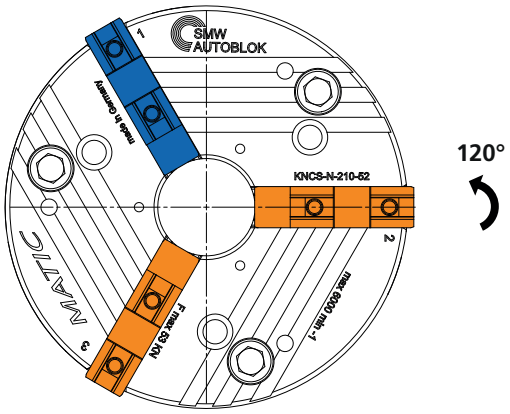
Retract the disengaging pin.

Step 10



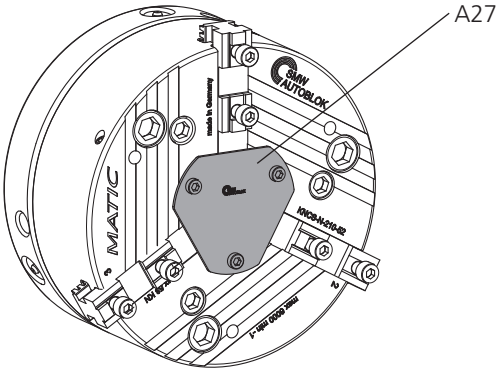
Prepare to change the next jaw.

Step 11



Index the chuck to have the next jaw guideway in the horizontal position for the jaw change and repeat the procedure.

Operate KNCS-*matic* chuck only with chuck cover plate set (A27)!

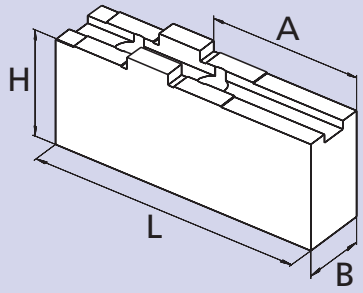


KNCS-*matic*

QUICK JAW CHANGE

■ SOFT TOP JAWS wide version
■ Accessories

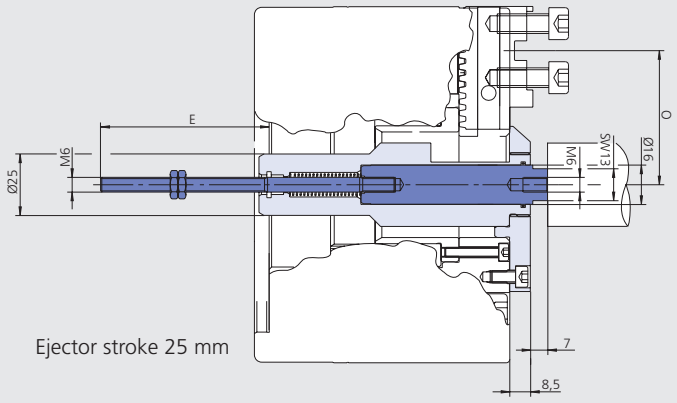
WAKS
Soft top jaws wide version



Type	Id. No.	B	H	L	A	kg/ set	SMW-AUTOBLOK Chuck type
WAKS 200-10	**080934**	30	51	100	57	2.9	KNCS-*matic* 210-52
WAKS 200-20	**080935**	30	66	100	45	3.4	
WAKS 200-30	**012497**	40	36	70	27	1.9	
WAKS 200-31	**080936**	40	56	90	43	3.9	
WAKS 200-32	**036733**	40	76	95	52	5.8	
WAKS 250-10	**080937**	40	55	125	70	3.9	KNCS-*matic* 260-78 325-104
WAKS 250-11	**080938**	40	75	125	70	7.5	
WAKS 250-12	**080939**	40	95	125	70	9.6	
WAKS 250-13	**080940**	40	115	125	70	11.5	
WAKS 250-20	**012498**	60	55	90	44	6.2	
WAKS 250-21	**080942**	60	55	110	60	7.6	
WAKS 250-22	**080943**	60	75	90	44	9.4	
WAKS 250-23	**080944**	60	75	110	60	11.5	
WAKS 250-30	**012499**	80	55	90	44	8.5	
WAKS 250-31	**080945**	80	75	110	60	14.1	
WAKS 400-10	**080946**	40	54	110	54	4.9	KNCS-*matic* 400-128
WAKS 400-11	**080947**	40	54	145	89	6.7	
WAKS 400-12	**080948**	40	94	145	89	11.1	
WAKS 400-13	**080949**	40	114	145	89	13.5	
WAKS 400-14	**080950**	40	146	145	89	16.9	
WAKS 400-20	**080951**	60	54	110	54	7.6	
WAKS 400-21	**080952**	60	74	110	54	10.3	
WAKS 400-22	**080953**	60	94	110	54	14.1	
WAKS 400-30	**012500**	80	64	100	44	11.0	
WAKS 500-10	**080954**	60	73	155	90	13.8	KNCS-*matic* 500-155 630-165
WAKS 500-12	**080956**	60	113	155	90	19.5	
WAKS 500-20	**080957**	80	73	155	90	15.5	
WAKS 500-21	**080958**	80	93	155	90	26.3	
WAKS 500-30	**012501**	90	73	130	65	16.4	
WAKS 500-31	**012502**	100	73	150	85	20.0	

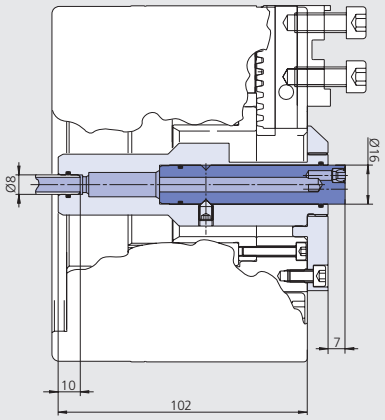
Accessories for KNCS-*matic* chucks

Ejector / axial stop



Ejector stroke 25 mm

Coolant flush



Technische Daten

SMW-AUTOBLOK Type				KNCS-*matic* 210-52	KNCS-*matic* 260-78	KNCS-*matic* 325-104	KNCS-*matic* 400-128	KNCS-*matic* 500-155	KNCS-*matic* 630-165
Ejector		**E**	mm	61.5	46.5	-	-	-	-
Ejector	min./max.	**O**	mm	68.3 / 77.8	88.6 / 105.1	-	-	-	-
Ejector / axial flush			Id. No.	174142	274140	-	-	-	-
Coolant flush basic kit	min./max.	**O**	mm	68.3 / 77.8	88.6 / 105.1	-	-	-	-
Coolant flush basic kit			Id. No.	175002	274141	-	-	-	-
Coolant flush premium kit	min./max.	**O**	mm	68.3 / 96.6	89.1 / 116.6	-	-	-	-
Coolant flush premium kit			Id. No.	176022	274142	-	-	-	-

Notes

Notes



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