

IN-D

MODULE 2
SERRATION

IL-D

LONG JAW STROKE
MODULE 2
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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

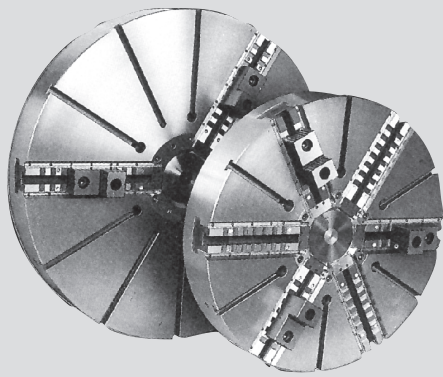
- Gripping force transmission via wedge hook
- Front protection of the slide ways against swarf and chips penetration

Standard equipment

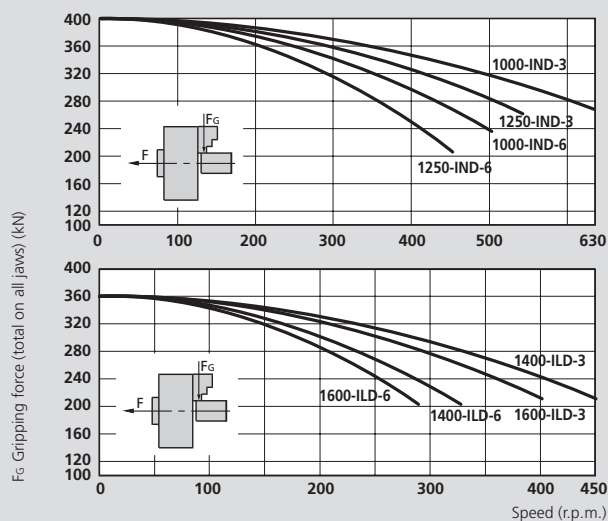
3- or 6-jaw chuck
1 set T-nuts with bolts
1 set soft top jaws with cross keys
Mounting bolts
Grease gun

Ordering example

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



Actual gripping force diagrams



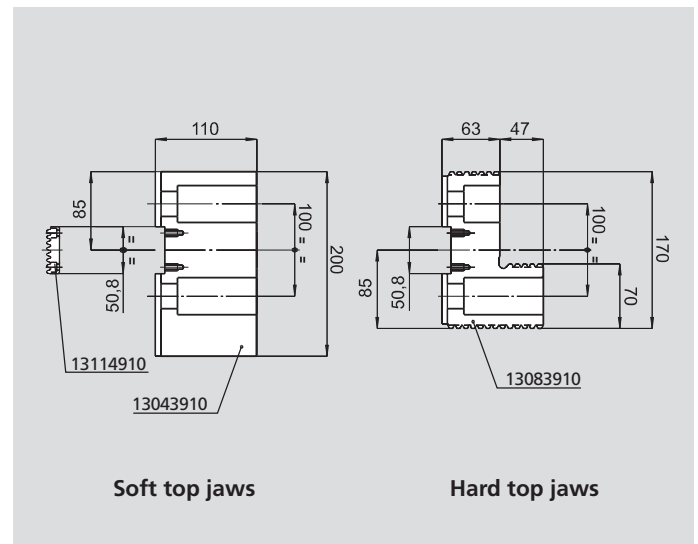
The data in the diagrams refer to 3-6 jaw chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K67 grease. The static and dynamic gripping forces have been measured using standard soft top jaws, placed in a position not exceeding the outer diameter of the chuck.

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		24		24	
Axial piston stroke	mm	57		57		60		60	
Max. draw pull*	kN	180		180		200		200	
Max. gripping force*	kN	400		400		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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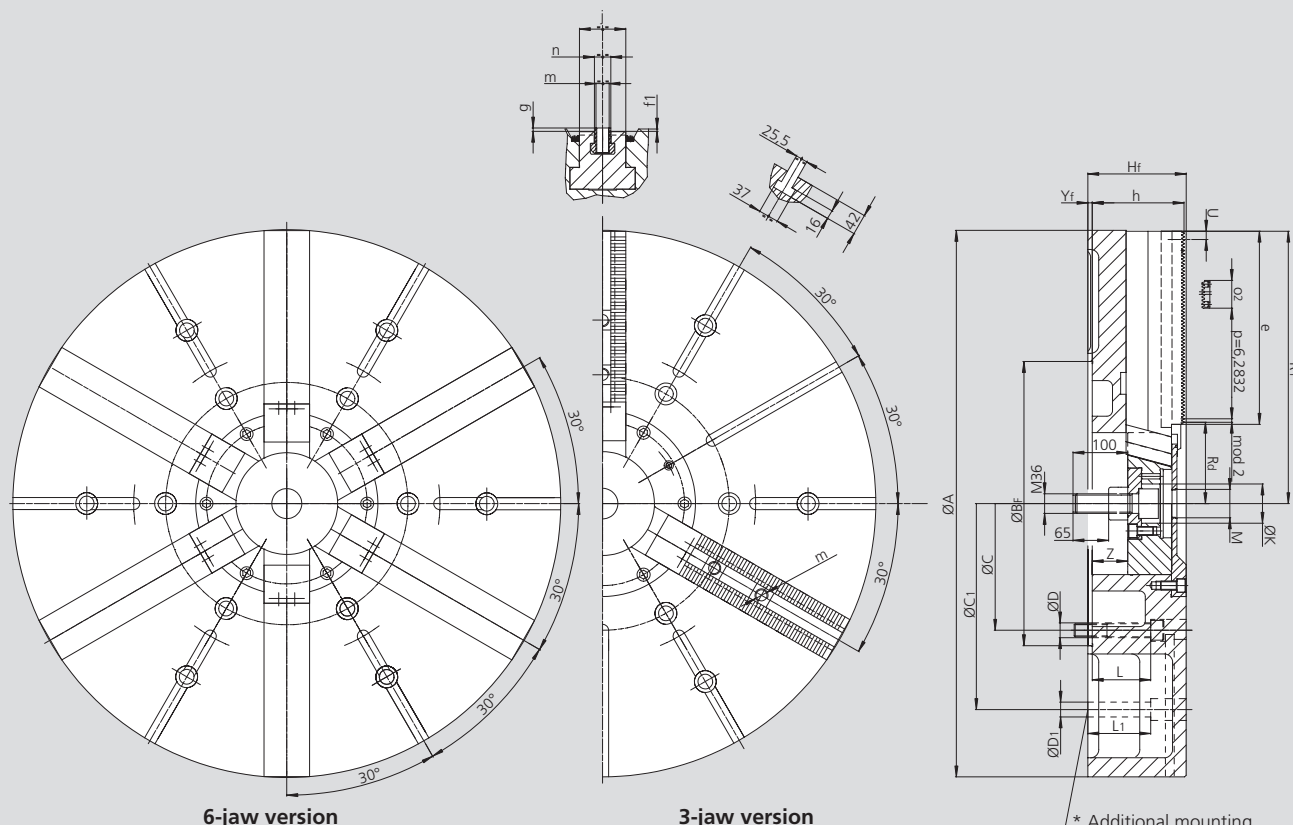
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6-jaw version

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
	B _F H6	mm	520		520		720	720
	C	mm	463.6		463.6		647.6	647.6
	C ₁	mm	700*		700*		1110	1110
	D	mm	27		27		33	33
	D ₁	mm	27*		27*		27	27
	H _F	mm	184		184		222	222
	K	mm	72		72		72	72
	L	mm	108		108		179	179
	L ₁	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	R ₁	mm	498		623		696	796
Chuck open	R _d	mm	148.5		148.5		179.5	179.5
Jaw stroke	U	mm	15		15		24	24
	S	mm	100		100		100	100
	Y _F	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
	o ₂ h6	mm	50.8		50.8		50.8	50.8