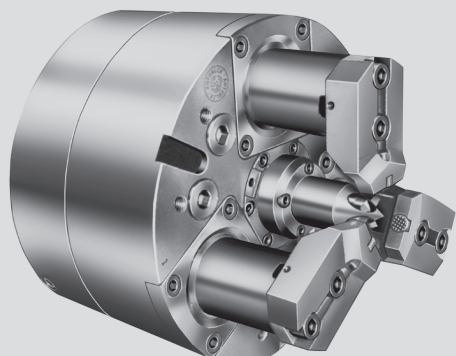


- Compensating jaw clamping
- Face driver with fixed or spring loaded center
- proofline® chucks = fully sealed - low maintenance



**proofline® series**  
fully sealed – low maintenance

### Application/customer benefits

- Complete machining of shafts in one operation
- The rough machining is done with compensating jaws clamping
- Finish machining of the complete outline with the face driver at retracted jaws

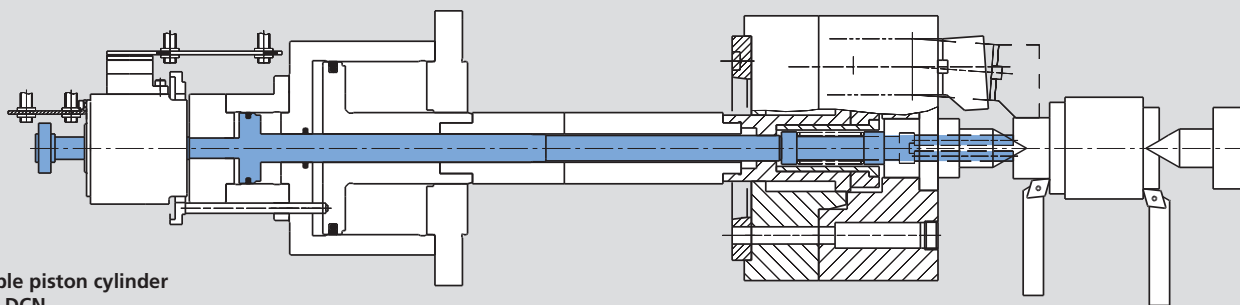
### Technical features

- Retractable jaws
- Compensating jaws clamping
- Face driver adjustable with adjusting wedges
- Center point fixed or spring loaded
- Pull down of the workpiece to the axial reference, ensures high position accuracy
- Case hardened internal parts
- Constant grease lubrication
- **proofline® chucks** = fully sealed - low maintenance

### Standard equipment

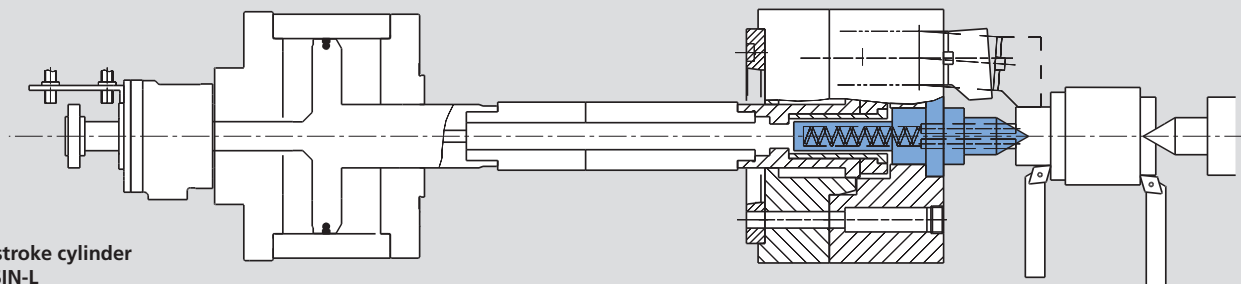
Shaft chuck without face driver  
with mounting bolts

### Axial reference in the center point - power operated face driver Actuation via double piston cylinder type ZHVD-SZ or DCN



Double piston cylinder  
Type DCN

### Axial reference on the component face - spring operated face driver Actuation via long stroke cylinder type SIN-L



Long stroke cylinder  
Type SIN-L

### Technical data

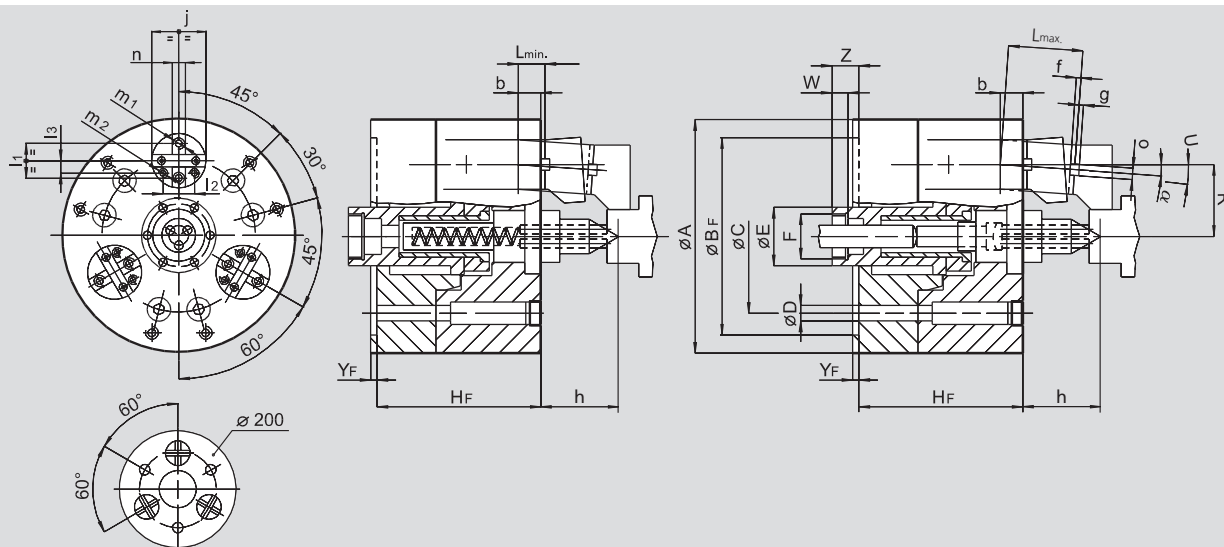
| SMW-AUTOBLOK Type                       |                   | GSA 200              | GSA 260              | GSA 320                                      | GSA 480        |
|-----------------------------------------|-------------------|----------------------|----------------------|----------------------------------------------|----------------|
| Number of jaws                          |                   | 3                    | 3                    | 3                                            | 3              |
| Angular jaw stroke U°                   | deg.              | 5°                   | 5°                   | 5°                                           | 5°             |
| Radial jaw stroke at distance h         | mm                | 9                    | 10                   | 11.5                                         | 15             |
| Compensation at distance h              | mm                | ±0.8                 | ±1                   | ±1                                           | ±4.5           |
| Wedge stroke (total)                    | mm                | 57.5                 | 66.5                 | 77.6                                         | 103.9          |
| Max. draw-push                          | kN                | 40                   | 60                   | 80                                           | 200            |
| Max. gripping force at distance h       | kN                | 40                   | 65                   | 100                                          | 240            |
| Max. speed                              | r.p.m.            | 4500                 | 4000                 | 3200                                         | 1600           |
| Weight (without top jaws)               | kg                | 30                   | 55                   | 100                                          | 420            |
| Moment of inertia                       | kg·m <sup>2</sup> | 0.15                 | 0.46                 | 1.28                                         | 11             |
| Recommended actuating cylinders:        |                   |                      |                      |                                              |                |
| - Axial reference in the center bore    |                   | DCN 125 / 30 70 / 25 | DCN 125 / 30 70 / 25 | DCN 125 / 30 87 / 40<br>DCN 170 / 40 95 / 50 | ZHVD-SZ 240-40 |
| - Axial reference on the component face |                   | SIN-L 125            | SIN-L 150            | SIN-L 150                                    | SIN-L 250      |
| Id. No. GSA                             |                   | 77210320             | 77210326             | 77210332                                     | 77211548       |

# Shaft turning chuck Ø 200 - 480 mm

# GSA

- Compensating jaw clamping
- Face driver with fixed or spring loaded center
- proofline® chucks = fully sealed – low maintenance

Shaft chuck with retractable jaw  
Face driver



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

| SMW-AUTOBLOK Type  |              |      | GSA 200   | GSA 260   | GSA 320 | GSA 480 |
|--------------------|--------------|------|-----------|-----------|---------|---------|
|                    | <b>A</b>     | mm   | 200       | 260       | 320     | 480     |
|                    | <b>BF H6</b> | mm   | 170       | 220       | 280     | 380     |
|                    | <b>C</b>     | mm   | 146       | 171.4     | 235     | 330.2   |
|                    | <b>D</b>     | mm   | 17        | 17        | 21      | 25      |
|                    | <b>E</b>     | mm   | 50        | 61        | 75      | 105     |
|                    | <b>F</b>     | mm   | M38 x 1.5 | M50 x 1.5 | M56 x 2 | M75 x 2 |
|                    | <b>HF</b>    | mm   | 160       | 183       | 215     | 356     |
|                    | <b>Lmin.</b> | mm   | 24        | 25        | 33      | 55      |
|                    | <b>max.</b>  | mm   | 74        | 83        | 98      | 135     |
|                    | <b>R</b>     | mm   | 60        | 75        | 102.5   | 153     |
| Jaw pivoting       | <b>U</b>     | deg. | 5°        | 5°        | 5°      | 5°      |
|                    | <b>W</b>     | mm   | 18        | 18        | 18      | 30      |
|                    | <b>YF</b>    | mm   | 6         | 6         | 6       | 18      |
| Min.               | <b>Z</b>     | mm   | 25        | 27        | 15.4    | 27      |
| Max.               | <b>b</b>     | mm   | 82.5      | 93.5      | 93      | 131     |
|                    | <b>f</b>     | mm   | 24        | 25        | 32      | 58      |
|                    | <b>g</b>     | mm   | 4         | 5         | 5       | 7       |
|                    | <b>h</b>     | mm   | 3         | 3.5       | 3       | 6       |
| Reference distance | <b>j</b>     | mm   | 80        | 90        | 105     | 115     |
|                    | <b>l1</b>    | mm   | 48        | 55        | 65      | 95      |
|                    | <b>l2</b>    | mm   | 32        | 35        | 42      | 66      |
|                    | <b>l3</b>    | mm   | 27        | 32        | 35      | 53      |
|                    | <b>m1</b>    | mm   | 12        | 12.5      | 16      | 25      |
|                    | <b>m2</b>    | mm   | M10       | M12       | M16     | M16     |
|                    | <b>n H7</b>  | mm   | M8        | M10       | M12     | M16     |
|                    | <b>o h7</b>  | mm   | 12.68     | 12.68     | 12.68   | 19.03   |
|                    | <b>α</b>     | deg. | 12.68     | 12.68     | 12.68   | 19.03   |
|                    |              |      | 3°        | 3°        | 3°      | 3°      |

## ISO-A flanges for GSA chucks

| FF 1<br>Direct<br>ISO-A mounting | FF 2<br>Reduction<br>ISO-A mounting | FF 3<br>Increase<br>ISO-A mounting | GSA chuck | Spindle | Type | Id. No.  | A   | BF  | BA      | C     | C1    | T  |
|----------------------------------|-------------------------------------|------------------------------------|-----------|---------|------|----------|-----|-----|---------|-------|-------|----|
|                                  |                                     |                                    | 200       | A5      | 2    | 24152050 | -   | 170 | 82.563  | 104.8 | 146   | 24 |
|                                  |                                     |                                    | 200       | A6      | 2    | 24162050 | -   | 170 | 106.375 | 133.4 | 146   | 24 |
|                                  |                                     |                                    | 200       | A8      | 3    | 24182050 | 210 | 170 | 139.719 | 171.4 | 146   | 40 |
|                                  |                                     |                                    | 260       | A6      | 2    | 24162530 | -   | 220 | 106.375 | 133.4 | 171.4 | 24 |
|                                  |                                     |                                    | 260       | A8      | 1    | 24182500 | -   | 220 | 139.719 | 171.4 | -     | 19 |
|                                  |                                     |                                    | 260       | A11     | 3    | 24112510 | 280 | 220 | 196.869 | 235   | 171.4 | 45 |
|                                  |                                     |                                    | 320       | A8      | 2    | 24183500 | -   | 280 | 139.719 | 171.4 | 235   | 30 |
|                                  |                                     |                                    | 320       | A11     | 1    | 24113500 | -   | 280 | 196.869 | 235   | -     | 21 |
|                                  |                                     |                                    | 480       | A11     | 2    | 24115000 | -   | 380 | 196.869 | 235   | 330.2 | 40 |
|                                  |                                     |                                    | 480       | A15     | 1    | 24125000 | -   | 380 | 285.775 | 330.2 | -     | 23 |



SMW-AUTOBLOK  
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