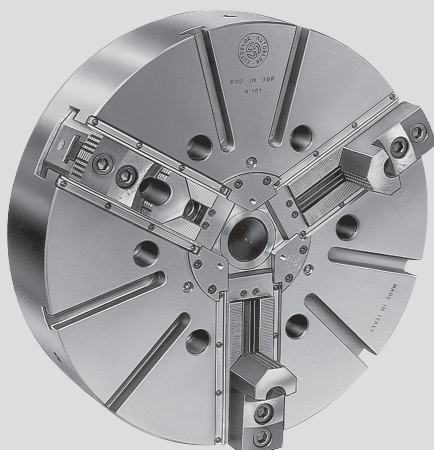


IL-D**INCH
SERRATION****IL-C****TONGUE & GROOVE****High precision power chuck Ø 500 - 800 mm**

- Closed center
- Long stroke
- 3 and 4 jaws

**Application/customer benefits**

- For large parts
- Suitable for vertical machines
- Extra long clamping stroke
(possibility to clamp 1st and 2nd operation with the same jaws)

IL-D: Master jaws with INCH SERRATION (3/32" x 90°)**IL-C:** Master jaws with TONGUE & GROOVE**Technical features**

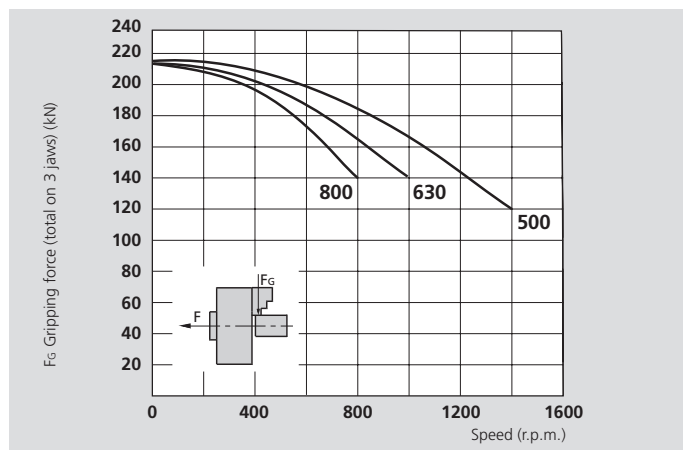
- EXTRA long jaw stroke
- Gripping force transmission via wedge hook
- Sealed against swarf and chips

Standard equipment

3- or 4-jaws chuck
 1 set T-nuts with bolts
 1 set soft top jaws (not in IL-C)
 Mounting bolts

Ordering example

3-jaw chuck IL-D 500 / A15
 or
 4-jaw chuck IL-C 630 / Z380

Actual gripping force diagram

The data in the diagram 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.

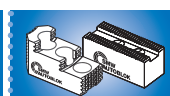
Technical data

SMW-AUTOBLOK Type		IL-D 500 IL-C 500		IL-D 630 IL-C 630		IL-D 800 IL-C 800	
Number of jaws		3	4	3	4	3	4
Radial jaw stroke	mm	13	13	15	15	15	15
Axial piston stroke	mm	33	33	38	38	38	38
Max. draw pull*	kN	120	120	120	120	120	120
Max. gripping force*	kN	215	215	215	215	215	215
Max. speed	r.p.m.	1400	1100	1000	800	800	650
Weight (without top jaws)	kg	130	180	220	325	320	550
Moment of inertia	kg·m ²	4.2	5.9	10.8	16	23.8	44
Recommended actuating cylinders		SIN-S 150 / 175 / 200		SIN-S 150 / 175 / 200		SIN-S 150 / 175 / 200	
Type							
Id. No. IL-D (Center mounting)		77762150	77762550	77762163	77762563	77762180	77762580
Id. No. IL-C (Center mounting)		77768250	77768650	77768263	77768663	77768280	77768680

* For internal clamping reduce the draw pull by 30%.



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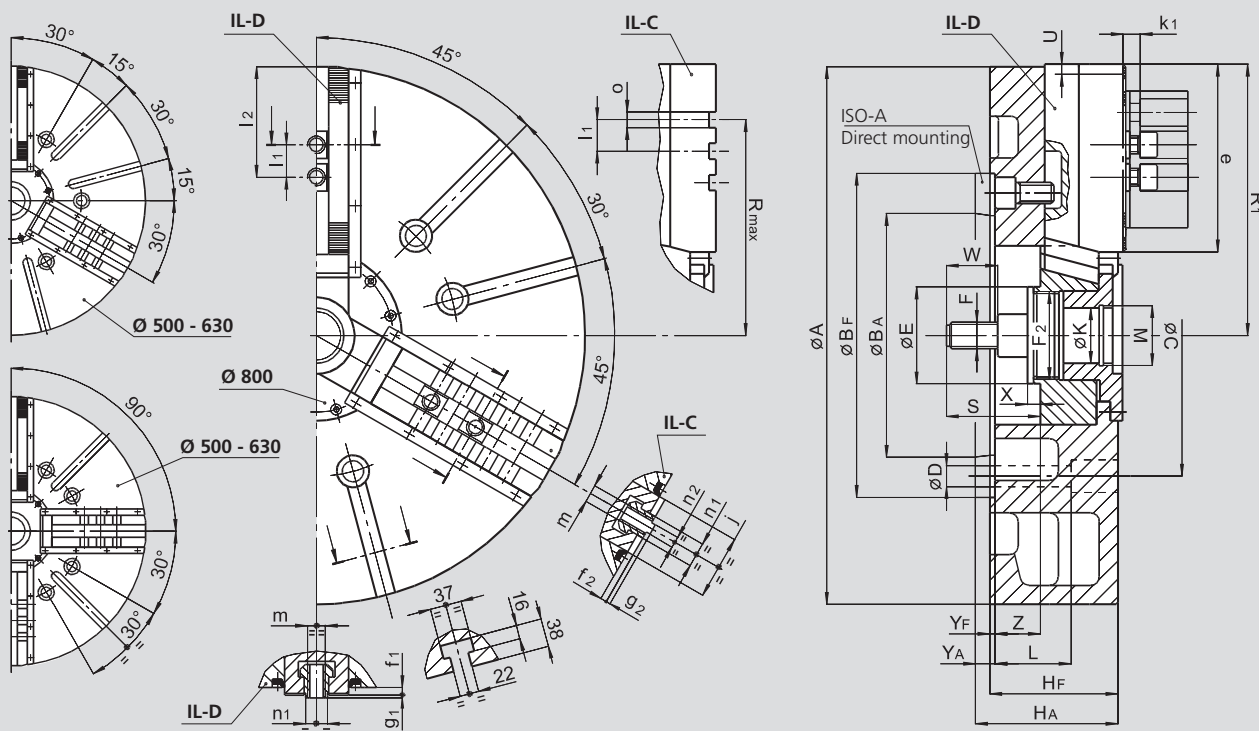
SMW-AUTOBLOK
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SMW-AUTOBLOK
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IL-C

- TONGUE & GROOVE**



SMW-AUTOBLOK Type			IL-D 500 IL-C 500		IL-D 630 IL-C 630		IL-D 800 IL-C 800	
Mounting			Z380	A15	Z380	A15	Z380	A15
	A	mm	510		630		800	
	Bf/BA H6	mm	380	285.775	380	285.775	380	285.775
	C	mm	330.2		330.2		330.2	
	D	mm	25		25		25	
	E	mm	114		114		114	
	F	mm	M30		M30		M30	
	F2	mm	M102 x 2		M102 x 2		M102 x 2	
	Hf/HA	mm	130	147	150	167	150	167
	K	mm	65		65		65	
	L	mm	89		89		89	
	M	mm	M68 x 2		M68 x 2		M68 x 2	
Chuck open	R1	mm	265		321		408	
	Rmax.	mm	212		250		352	
	S	mm	110		110		110	
Jaw stroke	U	mm	13		15		15	
	W	mm	60		60		60	
	X	mm	15		15		15	
	Yf/YA	mm	6	23	6	23	6	23
Max. / min.	Z	mm	33 / 0		53 / 15		53 / 15	
	e	mm	164		220		307	
	f1	mm	9		9		9	
	f2	mm	8		8		8	
	g1	mm	4		4		4	
	g2	mm	3		3		3	
	j	mm	75		75		75	
	k1	mm	16		16		16	
	l1	mm	38.1		38.1		38.1	
Max. / min.	l2	mm	135 / 48		190 / 48		277 / 48	
	m	mm	M20		M20		M20	
	n1 h8	mm	25.5		25.5		25.5	
	n2 h8	mm	12.7		12.7		12.7	
	o H7	mm	19.03		19.03		19.03	