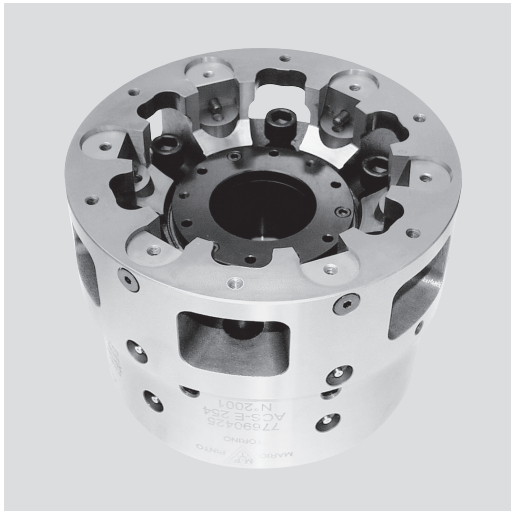


# ACS-E 6

Self centering  
column chuck

## Self-centering column chuck with pull down Ø 200 - 450 mm

- Pull down
- Power operated via standard cylinders
- O.D. clamping



### Application/customer benefits

- For small, medium and large quantities at high precision
- Pull down of the workpiece to the axial workstop during clamping
- Minimum loss of gripping force at high speed
- Standard, hardened jaw blanks available

### Technical features

- Chuck body completely case hardened
- Openings in the chuck body to evacuate chips
- Central bore for coolant / air

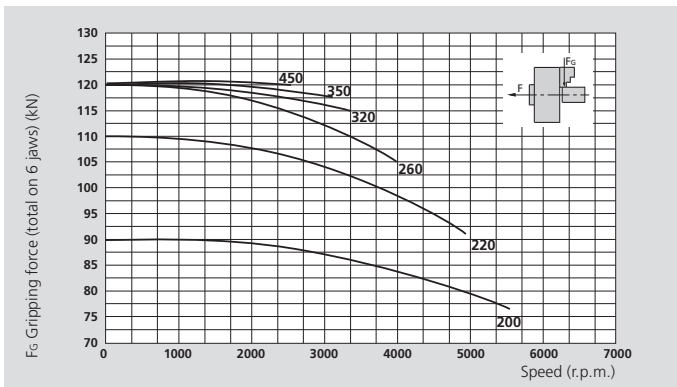
### Standard equipment

6-jaw chuck  
Mounting bolts

### Ordering example

6-jaw column chuck  
with center mounting Z170  
type ACS-E 6 220 Z170

## Actual gripping force diagram



The diagram refers to standard jaw blanks, machined to 50% of their mass.

## Technical data

SMW-AUTOBLOK Type		ACS-E 6 200	ACS-E 6 220	ACS-E 6 260	ACS-E 6 320	ACS-E 6 350	ACS-E 6 450
Jaw stroke	mm	2.6	3.2	4	6	6	6
Piston stroke	mm	10	12	15	15	15	15
Actuating force max.	kN	40	50	50	65	65	65
Grip force max.	kN	90	110	120	120	120	120
Speed max.	r.p.m.	5500	4900	4300	3400	3100	2200
Weight	kg	30	35	50	75	90	130
Moment of inertia	kg·m <sup>2</sup>	0.16	0.21	0.35	0.84	1	3
Clamping range	min.	30	50	90	90	120	210
Clamping range	max.	100	125	165	215	245	335
Rec. actuating cylinders	Type	SIN-S 100	SIN-S 125	SIN-S 125	SIN-S 125	SIN-S 125	SIN-S 125
Rec. actuating cylinders	Type	SIN-S 125	SIN-S 150	SIN-S 150	SIN-S 150	SIN-S 150	SIN-S 150
Id.-No. ACS-E 6		77690420	77690422	77690425	77690432	77690435	77690445
Id.-No. Jaw blanks		69762040	69762240			69763210	



# Self-centering column chuck with pull down

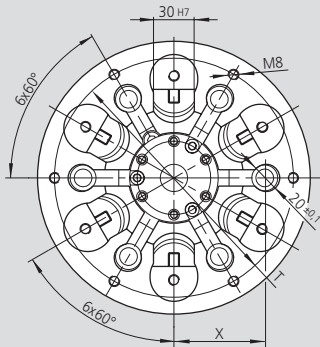
Ø 200 - 450 mm

- Pull down
- Power operated via standard cylinders
- O.D. clamping

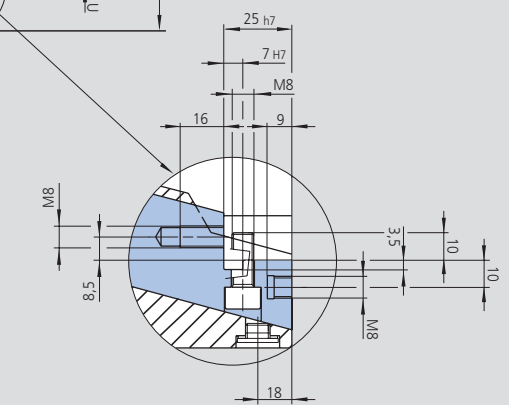
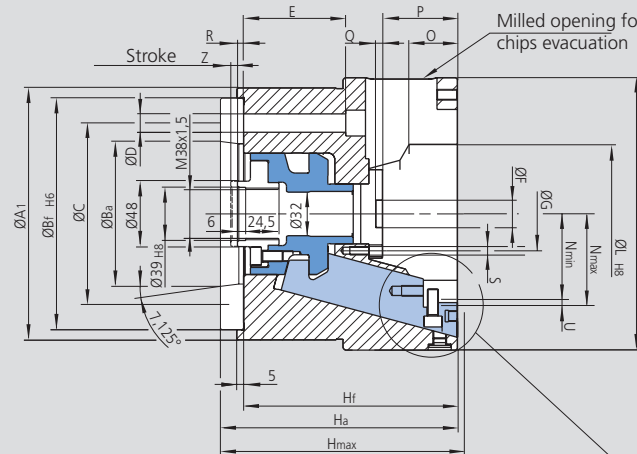
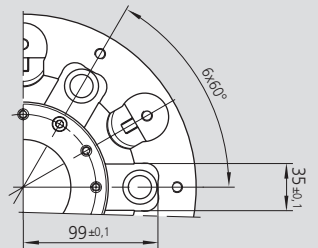
# ACS-E 6

Self centering column chuck

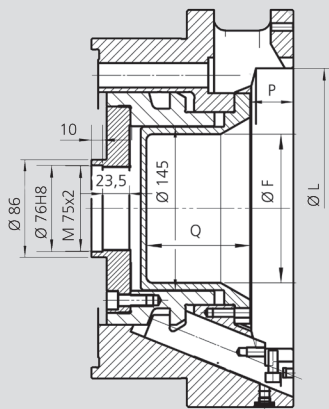
ACS-E 450



ACS-E 260



ACS-E 320-350-450

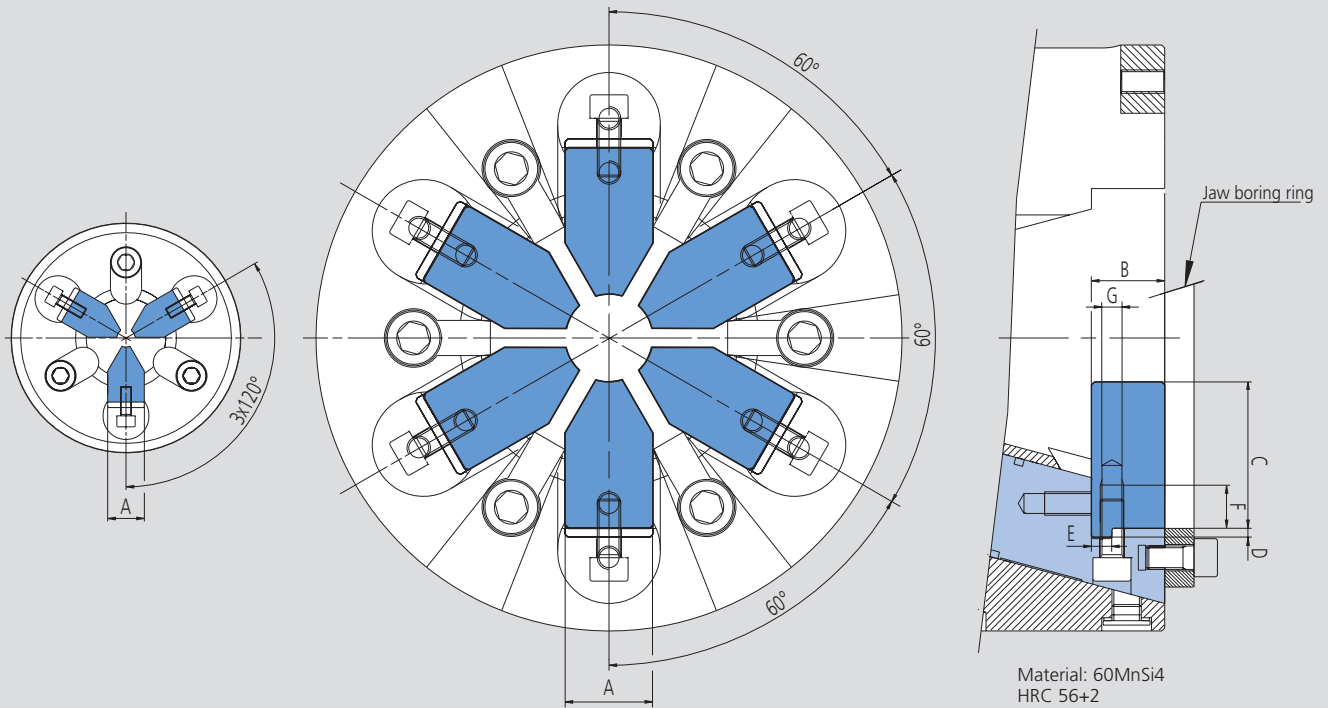


Media can be used through the chuck's bore.

Specials on request.

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

SMW-AUTOBLOK Type			ACS-E 6 200	ACS-E 6 220	ACS-E 6 260	ACS-E 6 320	ACS-E 6 350	ACS-E 6 450
Mounting			ISO-A6 Z170	ISO-A6 Z170	ISO-A8 Z220	ISO-A11 Z280	ISO-A11 Z280	ISO-A15 Z380
	A	mm	200	220	260	324	354	450
	A1	mm	185	185	235	300	300	410
	Ba	mm	106.375	106.375	139.719	196.869	196.869	285.775
	Bf	mm	170	170	220	280	280	380
	C	mm	133.4	133.4	171.4	235	235	330.2
	D	mm	13	13	17	21	21	25
	E	mm	75	75	91	97	97	97
	F	mm	20	30	70	105	131	180
	G	mm	54	68	107	154	184	270
	Hmax.	mm	179	183	198.5	200.5	200.5	200.5
	Ha	mm	174	177	191	193	193	195
	Hf	mm	157	160	172	172	172	172
	L	mm	102	126	167	217	247	336
	Nmin.	mm	66.3	76.6	97	123	138	182
	Nmax.	mm	63.7	73.4	93	117	132	176
	O	mm	32	33	34	33	33	33
	P	mm	55	50.5	40	38	38	38
	Q	mm	7	7	65.5	91.5	91.5	90
	R	mm	4.5	3.5	2	6	6	6
	S	mm	6 x M6	6 x M6	6 x M6	6 x M6	6 x M6	6 x M6
	T	mm	175	190	226	290	320	405
Stroke	U	mm	2.6	3.2	4	6	6	6
Stroke	Z	mm	10	12	15	15	15	15
	X	mm	66.7	72	-	-	-	-
	W	mm	5	5	5	6	6	6



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

SMW-AUTOBLOK Type ACS-E		110	130	145	170	200	220	260	320	350	450
<b>Number of jaws</b>		<b>3</b>	<b>3</b>	<b>3</b>	<b>3</b>	<b>3 / 6</b>	<b>3 / 6</b>	<b>3 / 6</b>	<b>3 / 6</b>	<b>3 / 6</b>	<b>3 / 6</b>
	<b>A</b> h6	18	20	20	20	30	30	30	30	30	30
	<b>B</b>	18	20	20	20	25	25	25	25	25	25
	<b>C</b>	29.5	30	35	40	50	50	50	75	75	75
	<b>D</b>	3	3	3	3	3	3	3	3	3	3
	<b>E</b> g6	5	6	6	6	7	7	7	7	7	7
	<b>F</b>	13	13	13	13	15	15	15	15	15	15
	<b>G</b>	M6	M6	M6	M6	M8	M8	M8	M8	M8	M8
<b>Rec. clamping range</b>	<b>min.</b>	4	10	20	30	30	50	90	90	120	208
<b>Rec. clamping range</b>	<b>max.</b>	45	50	70	95	100	125	165	215	245	335
Jaw blanks (1 set = 3 pcs.)	Id. No.	69761110	69761310	69761410	69761710	69762010*	69762210*	69762210*	69763210*	69763210*	-
Boring ring	Id. No.	69111110	69111310	69111410	69111710	69112040	69112240	69112540	69113240	69113540	69114540
<b>Id. No ACS-E 3 Jaws</b>		77690111	77690113	77690114	77690117	77690120	77690122	77690125	77690132	77690135	-
<b>Id. No ACS-E 6 Jaws</b>		-	-	-	-	77690420	77690422	77690425	77690432	77690435	77690445

\* For 6-jaw chucks use 2 set of 3 pcs.



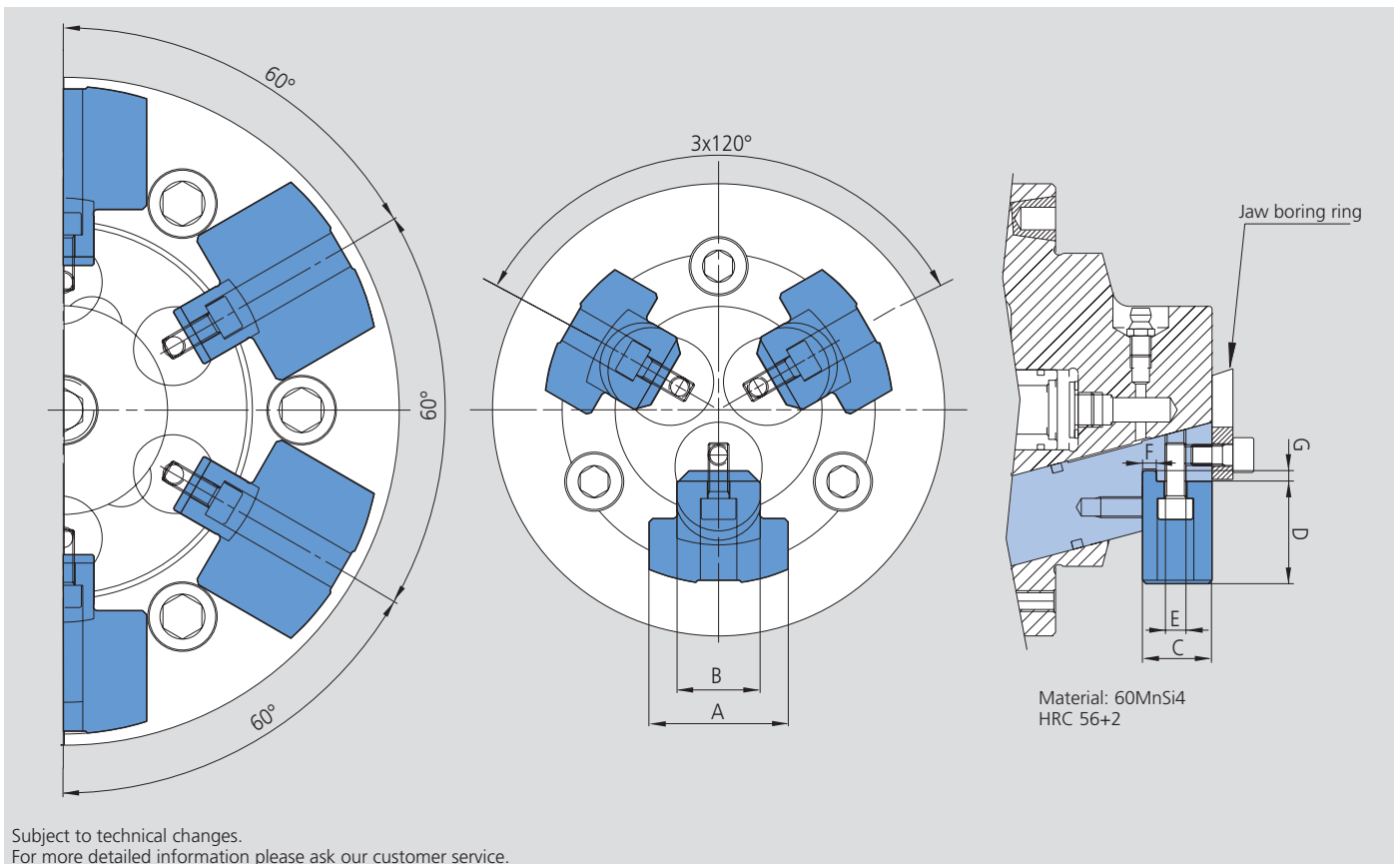
SMW-AUTOBLOK  
472

SMW-AUTOBLOK  
466

SMW-AUTOBLOK  
327

■ For 3 and 6 jaw chucks

Jaws

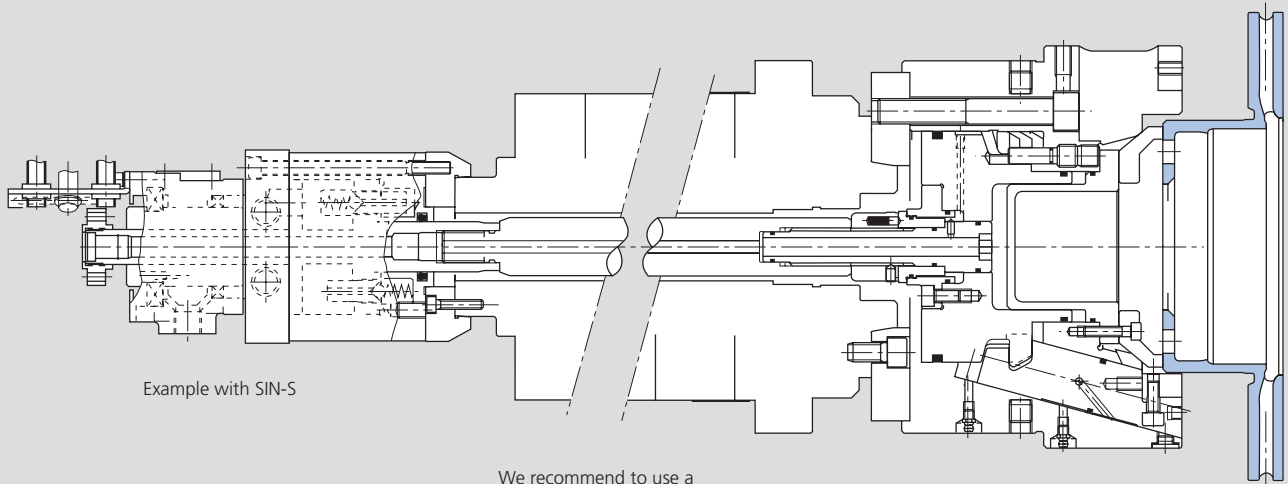


SMW-AUTOBLOK Type ACS-I		ACS-I 130	ACS-I 160	ACS-I 200	ACS-I 240	ACS-I 300
<b>Number of jaws</b>		<b>3</b>	<b>3</b>	<b>3</b>	<b>6</b>	<b>6</b>
	<b>A</b>	40	40	60	60	60
	<b>B h6</b>	24	22	22	22	22
	<b>C</b>	20	23	23	23	23
	<b>D</b>	29.5	41	61.5	61.5	53
	<b>E</b>	3 x M6	3 x M8	3 x M8	3 x M8	6 x M8
	<b>F g6</b>	4	4	4	4	4
	<b>G</b>	3	3	3	3	3
<b>Rec. clamping range</b>	<b>min.</b>	65**	92	110	144	210
<b>Rec. clamping range</b>	<b>max.</b>	100	140	200	232	280
Jaw blanks (set of 3 or 6 pieces)	Id. No.	69761360	69761660*	69762060*	69762490*	69763090*
Boring ring	Id. No.	69111360	69111660	69112060	69112490	69113090
<b>Id. No ACS-I</b>		77690613	77690616	77690620	77690924	77690930

\* Identical for size 160-200-240-300.

\*\* Min. 60 with special jaws and mounting bolts.

**ACS-E** e.g. OP10 „Machining brake disc“

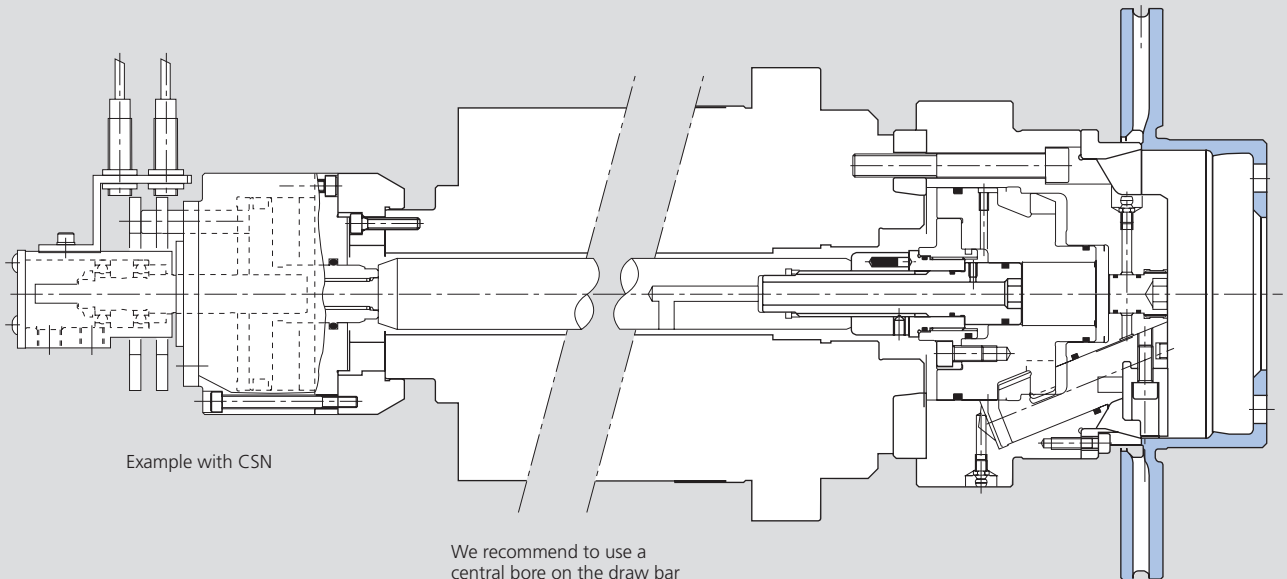


Example with SIN-S

We recommend to use a central bore on the draw bar

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

**ACS-I** e.g. OP20 „Machining brake disc“



Example with CSN

We recommend to use a central bore on the draw bar

Front workstop with air sensing or airblast

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