

IEP-D

2+2+2 movement
MODULE 2 SERRATION

High precision 6-jaw chuck 2+2+2 equalising Ø 1000 - 1600 mm

- Closed center
- Equalising mechanism lockable
- Centrifugal force compensation



Application/customer benefits

- Clamping of thin walled workpieces
- Low radial deformation with 2+2+2 clamping
- Suitable for horizontal and vertical machines

Technical features

- Adjustable to 6 jaw 2+2+2 or true 6 jaw clamping
- Possibility to regulate the equalising stroke from full (for OP10) to very small (for OP20)
- Constant gripping force with permanent lubrication
- Master jaws with MODULE 2 SERRATION (pitch 6.28 mm)
- Centrifugal force compensation for high spindle speed
- **proofline® chucks** = fully sealed - low maintenance

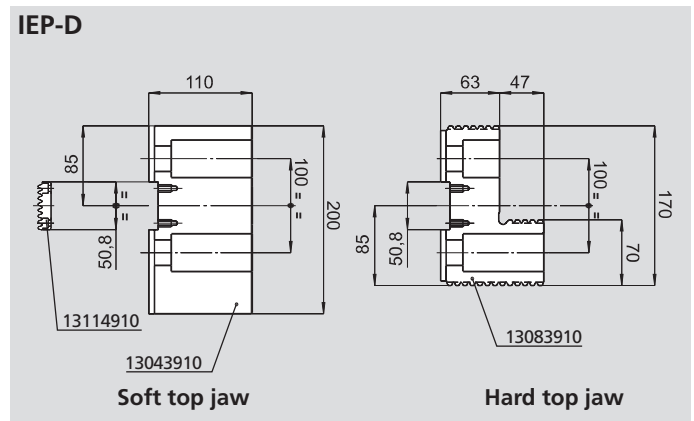
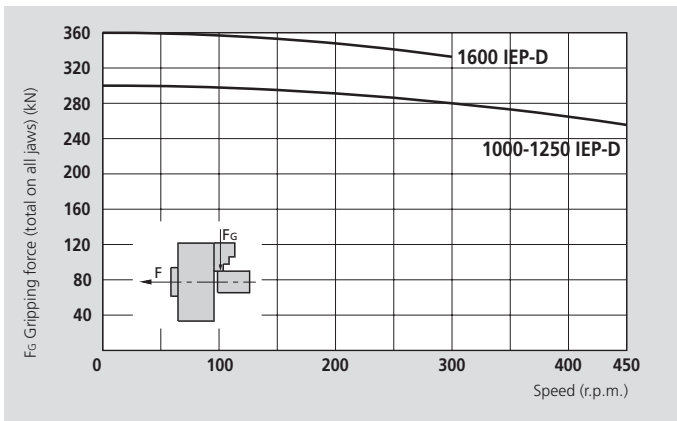
Standard equipment

- Chuck with mounting bolts
- 1 set of soft top jaws
- 1 equalising stroke regulating key

Ordering example

Chuck IEP-D 1250 / Z520

Actual gripping force diagram



The data in the diagram refers to 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.

⚠ **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		IEP-D 1000	IEP-D 1250	IEP-D 1400	IEP-D 1600
Number of jaws		2+2+2	2+2+2	2+2+2	2+2+2
Radial jaw stroke	mm	20	20	25	25
Jaw compensation	mm	±5	±5	±5	±5
Axial piston stroke	mm	40	40	50	50
Max. draw pull*	kN	200	200	240	240
Max. gripping force*	kN	300	300	360	360
Max. speed	r.p.m.	450	400	320	280
Weight (without top jaws)	kg	1100	1550	2260	2400
Moment of inertia	kg·m ²	127	273	535	640
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 200-250	SIN-S 200-250	SIN-S 200-250	SIN-S 200-250
Id. No. IEP-D		77134239	77134249	77134255	77134263

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



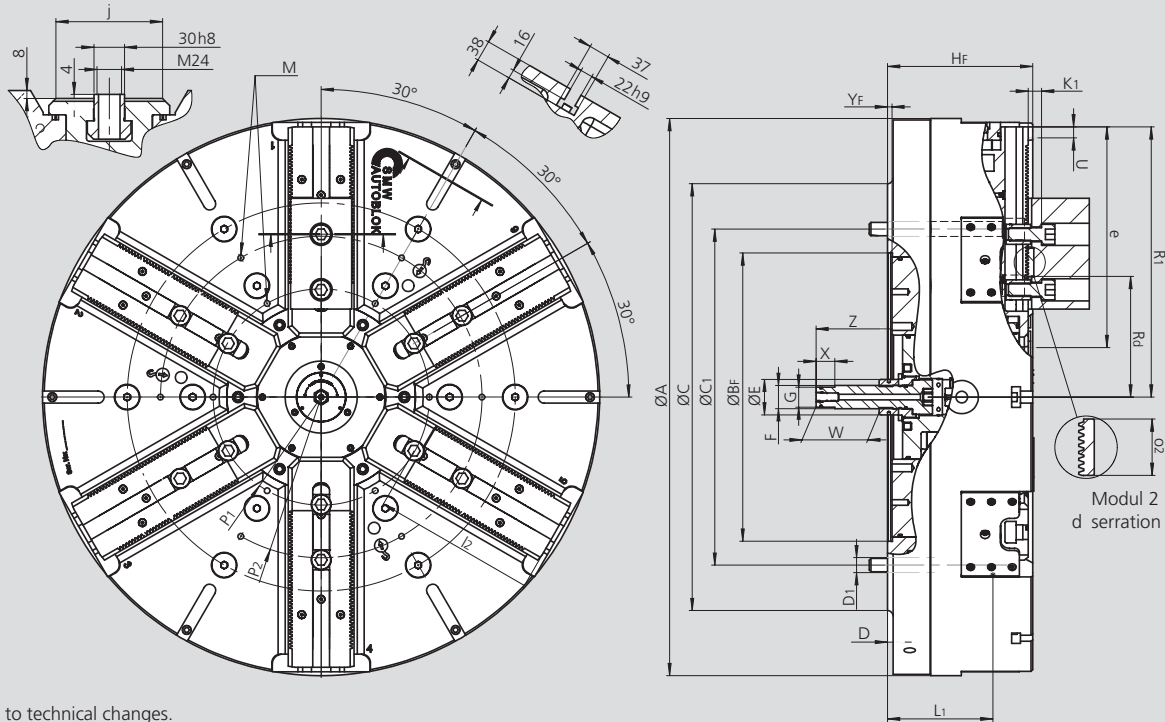
SMW-AUTOBLOK
327

High precision 6-jaw chuck 2+2+2 equalising Ø 1000 - 1600 mm

- Closed center
- Equalising mechanism lockable
- Centrifugal force compensation

IEP-D

2+2+2 movement
MODULE 2 SERRATION



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

SMW-AUTOBLOK Type			IEP-D 1000		IEP-D 1250		IEP-D 1400		IEP-D 1600	
	A	mm	1005		1250		1400		1600	
	Bf H6	mm	520		520		720		720	
	C	mm	700		900		-		1225	
	C1	mm	700		700		1110		1110	
	D	mm	10		10		-		58	
	D1	mm	27		27		27		27	
	E	mm	64		64		64		64	
	F	mm	M42 x 3		M42 x 3		M42 x 3		M42 x 3	
	G H8	mm	36		36		36		36	
	Hf	mm	254		254		280		272	
	M	mm	M12 x 22		M12 x 22		M16 x 20		M16 x 28	
	L1	mm	207		207		225		225	
Chuck open	R1	mm	498		620.5		686		811	
Chuck open	Rd	mm	228		228		278		288.5	
Jaw stroke	U	mm	20		20		25		25	
	W	mm	114		114		114		114	
	X	mm	34		34		34		34	
	Yf	mm	8		8		8		8	
Max. / min.	Z	mm	156	116	156	116	156	106	156	106
Serration	d	M	Module 2		Module 2		Module 2		Module 2	
	e	mm	345		465		533		595	
	j	mm	105		105		131		131	
	k1	mm	24		24		24		24	
Max. / min.	l2	mm	295	118	417	118	460	118	531	118
	o2	mm	50.8		50.8		50.8		50.8	
	P1	mm	390		390		380		760	
	P2	mm	580		580		500		1000	