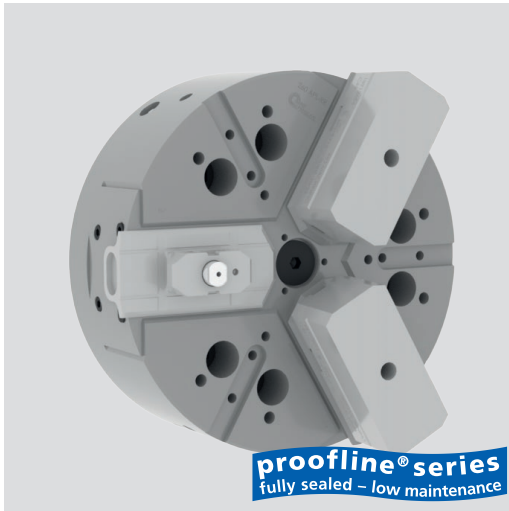


APL-RR

LONG STROKE

High precision power chuck Ø 215 - 400 mm

- quick jaw change
- proofline® chucks = fully sealed - low maintenance



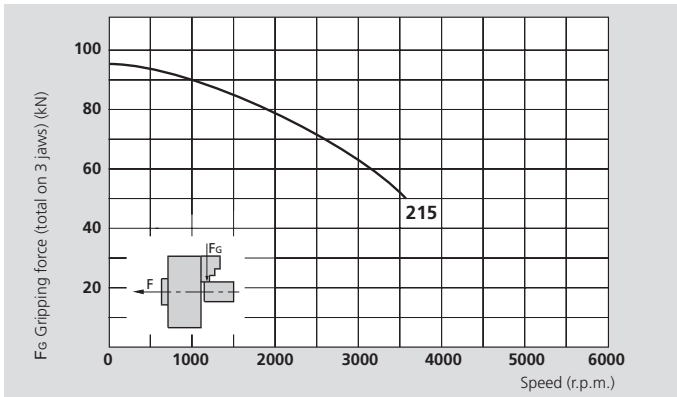
Application

- Sealed chuck with quick jaws change system
- Easy coupling and uncoupling with spring loaded button
- For mid to large batch production
- Safety against accidental release
- Suitable for manual and/or robotic use
- Fully sealed, ideal for dry machining of castings and forgings, or if high pressure coolant is used
- Extra long jaw stroke of clamping and wide range of workpieces clamping with the same serie of jaws
- Available sizes Ø 215-400 and ready for robotized change
- Semifinished pallet and top jaws kit

Technical features

- EXTRA long jaw stroke
- Costant gripping force with permanent grease lubrication
- Center bore for coolant and/or air
- Chuck body and internal parts case hardened
- proofline® chucks = fully sealed - low maintenance

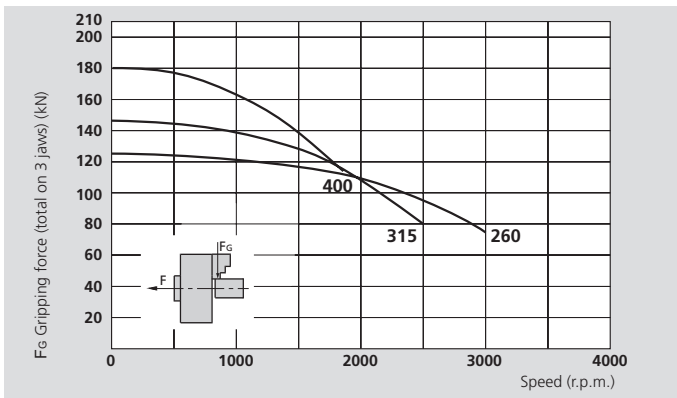
Actual gripping force diagrams



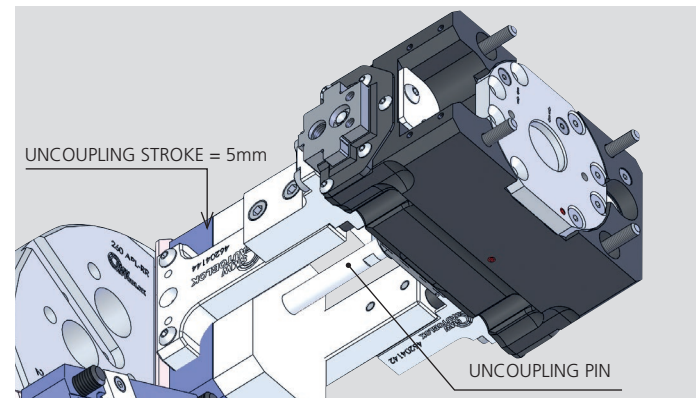
The data in the diagrams refer to 3-jaw chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K67 grease. The static and dynamic gripping forces have been measured using standard soft top jaws.

⚠ Safety advice / danger of damage:

When using taller / heavier jaws and / or clamping on a bigger diameter reduce draw pull / rotating speed accordingly.



Easy jaw change example



Technical data

SMW-AUTOBLOK Type		APL-RR 215	APL-RR 260	APL-RR 315	APL-RR 400
Id.No. APL-RR		77189521	77189526	77189531	77189540
Number of jaws		3	3	3	3
Radial jaw stroke	mm	8.5	9.7	12.1	13.3
Axial piston stroke	mm	21	24	30	33
Max. draw pull*	kN	53	68	80	100
Max. gripping force*	kN	95	125	145	180
Max. speed	r.p.m.	3600	3000	2500	1900
Weight (without top jaws)	kg	20	34	55,3	89
Moment of inertia	kg·m ²	0.12	0.31	0.73	1.77
Recommended actuating cylinders	Type	SIN-S 100 / 125	SIN-S 125 / 150	SIN-S 125 / 150	SIN-S 150 / 175

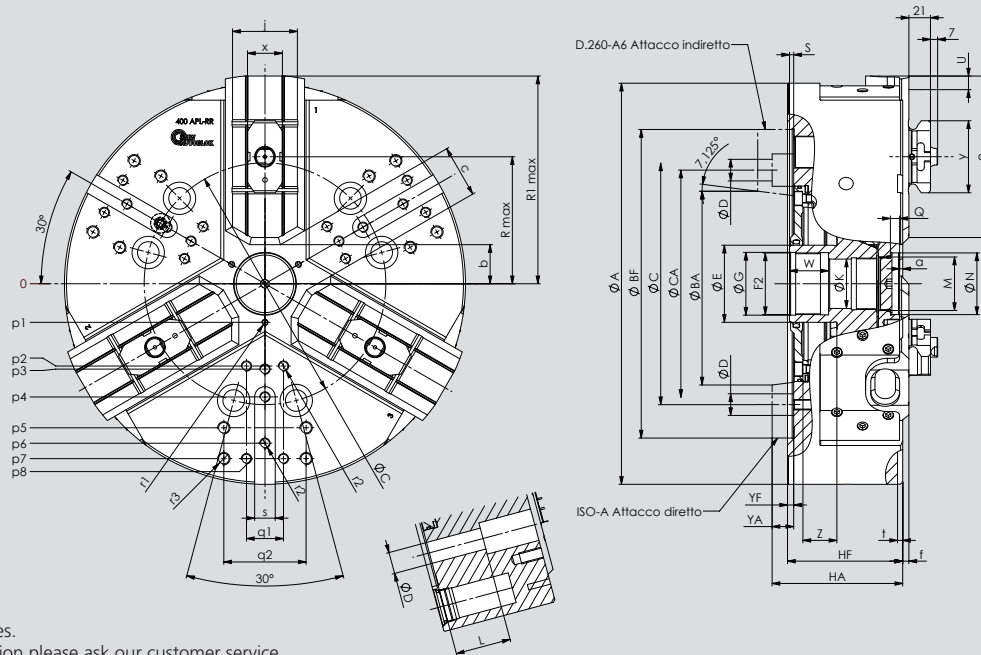
* For internal clamping reduce the draw pull by 30%.

High precision power chuck Ø 215 - 400 mm

APL-RR

- quick jaw change
- proofline® chucks = fully sealed - low maintenance

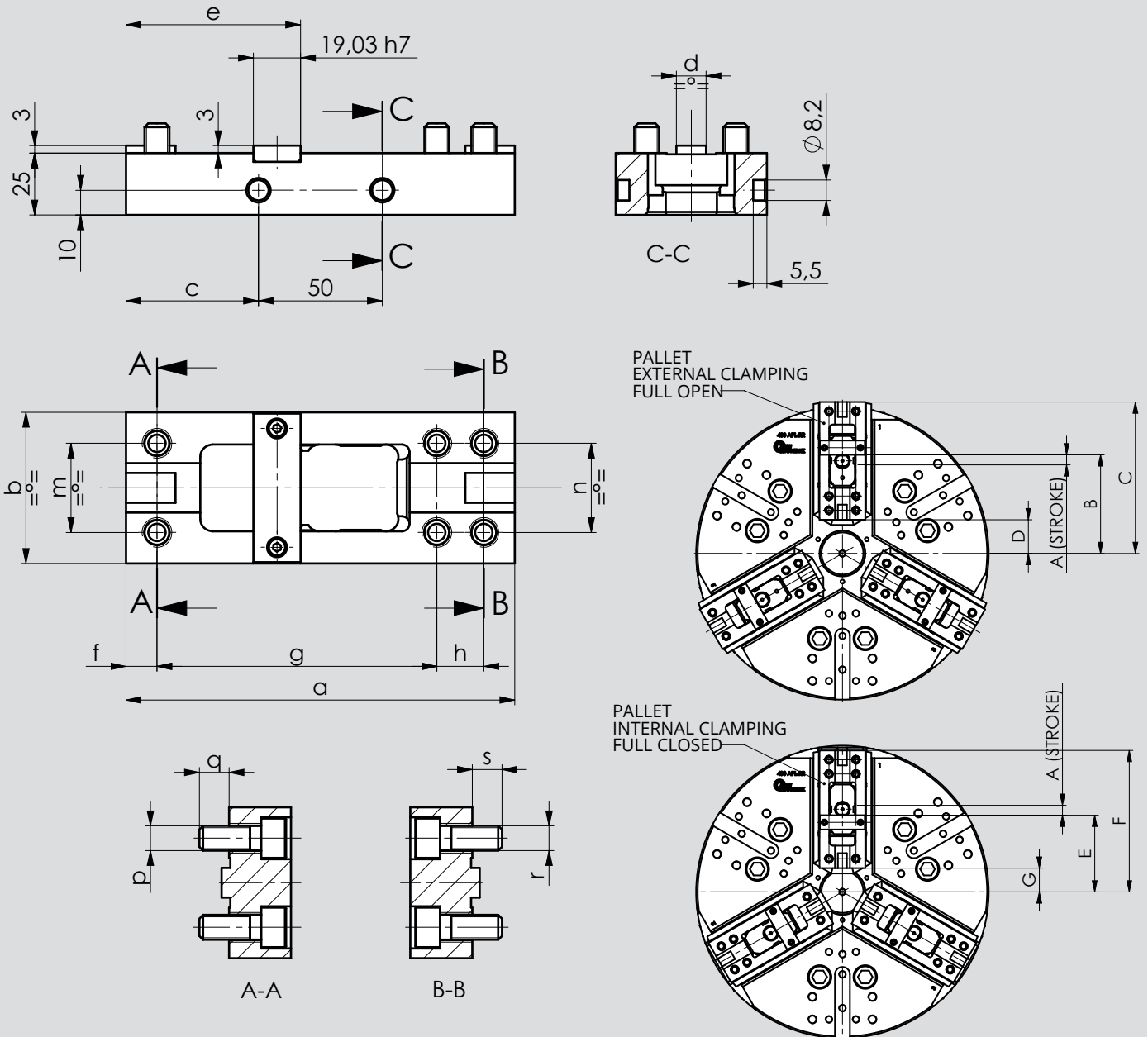
LONG STROKE



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

SMW-AUTOBLOK Type			APL-RR 215	APL-RR 260	APL-RR 315	APL-RR 400
ID.No.			77189521	77189526	77189531	77189540
Mounting			Z170*	Z220*	Z220*	Z300*
	A	mm	216	262	315	390
	Bf/BA H6	mm	170	220	220	300
	C	mm	133.4	171.4	171.4	235
	CA	mm	-	-	-	-
	D	mm	13.5	17	17	21
	E	mm	42	48	48	75
	F2	mm	M32 x 1.5	M38 x 1.5	M38 x 1.5	M60 x 1.5
	G H8	mm	33	39	39	61
	Hf/HA	mm	81	92	101	112
	K	mm	20	25	25	48
	L	mm	32	38	38	54
	M	mm	M22 x 1.5	M28 x 1.5	M28 x 1.5	M52 x 1.5
	N H9	mm	24	34	34	60
	Q	mm	5.5	5.5	5.5	9
Chuck open	R1	mm	112.5	136	163.5	202
Max.	R	mm	67	79.5	95.5	123.5
Max. / min.	S	mm	25 / 4	28 / 4	34 / 4	37 / 4
Radial jaw stroke	U	mm	8.5	9.7	12.1	13.3
	W	mm	26	26	26	38
Max. / min.	Yf/YA	mm	5	5	5	6
	Z	mm	21 / 0	24 / 0	30 / 0	33 / 0
	a	mm	3	3	3	3
Min.	b	mm	8.5	9	11	24.5
Min.	c	mm	6.2	6	6	28
	e	mm	91,5	113	136,5	157
	f	mm	3	3	3	6
	j	mm	46	48	58	63
	x	mm	24	28	28	34
	y	mm	50	58	64	70
	p1	mm	16	21	21	37.5
	p2	mm	-	-	60	80
	p3	mm	49	55	62.5	83
	p4	mm	80	70	80	110
	p5	mm	80	102	102	140
	p6	mm	-	102	120	155
	p7	mm	-	-	135	170
	p8	mm	-	-	-	170
	q1	mm	-	-	30	36
	q2	mm	45	60	60	80
	r1	mm	M5 / 8	M6 / 10	M6 / 10	M6 / 12
	r2	mm	M8 / 17	M8 / 17	M8 / 17	M10 / 19
	r3	mm	M8 / 17	M10 / 19	M10 / 19	M12 / 22
	s	mm	16	16	16	20
	t	mm	5	5	5	5

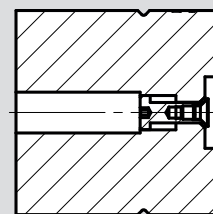
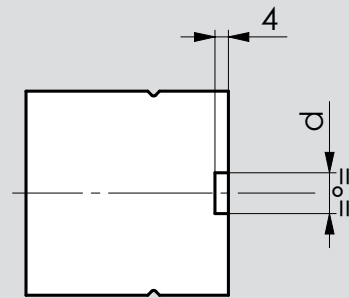
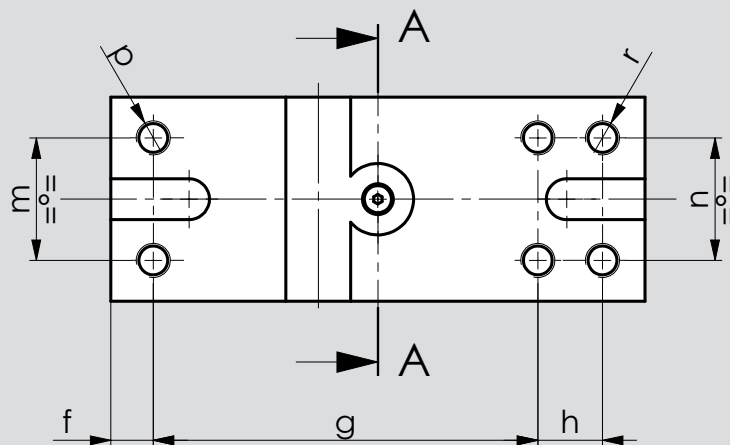
* see the chuck flanges explained on chapter 12



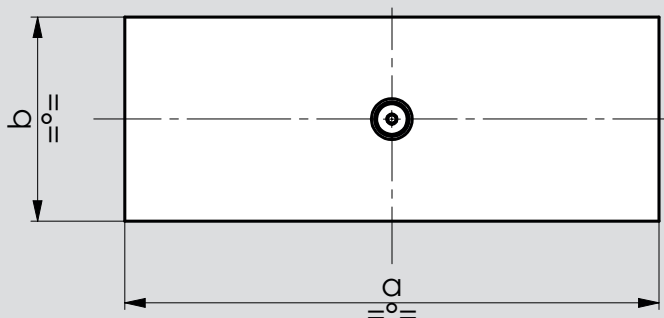
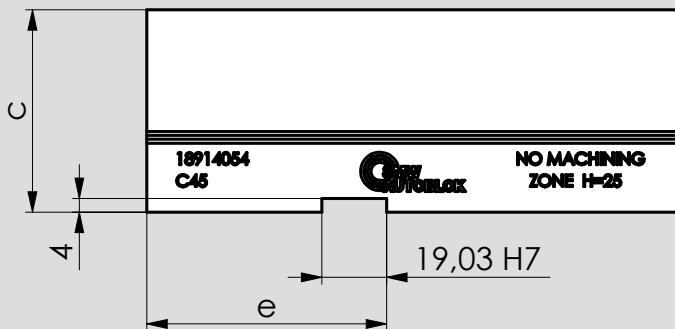
Subject to technical changes.
For more detailed information please ask our customer service.

Model		215	260	315	400		A	B	C	D	E	F	G
ID.No.		18762154	18762654	18763154	18764054	215 APL-RR	8,5	71,7	112,4	21,4	53,7	104	13
a	mm	91	113	136	157	260 APL-RR	9,7	86	136	23	63,3	126,3	13,3
b	mm	46	51	54	61	315 APL-RR	12,1	102	163,5	27,5	76,9	151,4	15,4
c	mm	20,5	31,5	43	53,5	400 APL-RR	13,3	131,5	202	45	102,2	188,7	31,7
d (H7)	mm	8	12	12	12								
e	mm	40,7	50	61,5	70,5								
f	mm	8,5	10,5	14	12,5								
g	mm	72	90	108	113								
h	mm	x	x	x	19								
m	mm	26	30	30	36								
n	mm	26	30	30	36								
p	mm	M6	M10	M10	M10								
q	mm	12	12	12	12								
r	mm	M8	M10	M10	M10								
s	mm	14	12	12	12								
							A	B	C	D	E	F	G
						260 NTL-RR	9	86	136	23	64	127	14
						315 NTL-RR	11	102	163,5	27,5	78	152,5	16,5
						400 NTL-RR	12	131,5	202	45	103,4	189,9	32,9

TOP JAWS



A-A



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

SMW-AUTOBLOK Model		APL-RR 215	APL-RR 260	APL-RR 315	APL-RR 400
C45		18912154	18912654	18913154	18914054
a	mm	91	113	136	157
b	mm	45	50	50	60
c	mm	44,5	49,5	49,5	59,5
d (H7)	mm	8	12	12	12
e	mm	40,7	50	61,5	70,5
f	mm	8,5	10,5	14	12,5
g	mm	72	90	108	113
h	mm	x	x	x	19
m	mm	26	30	30	36
n	mm	26	30	30	36
p	mm	M6x14	M10x14	M10x14	M10x14
r	mm	M8x16	M10x14	M10x14	M10x14