

- Radial setting of jaws
- Closed center
- 4 jaws (all diameters)

### Application/customer benefits

- Clamping of large square and irregular parts using 2 or 4 jaws self centering
- Suitable for vertical machines thanks to the front protection of the slide ways
- Manual radial setting of master jaws
- TONGUE & GROOVE (type "American Standard")

### Technical features

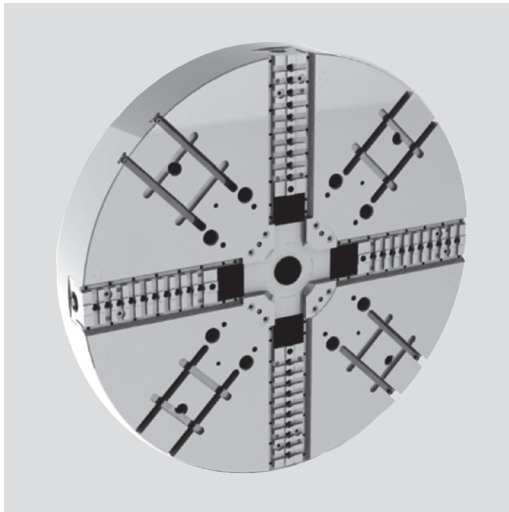
- Gripping force transmission via wedge hook
- Manual radial setting of master jaws for workpiece centering
- Protection from contamination with seals along the master jaw profiles
- Possibility to use jaw boxes for manual clamping mounted on the T-slots between the master jaws

### Standard equipment

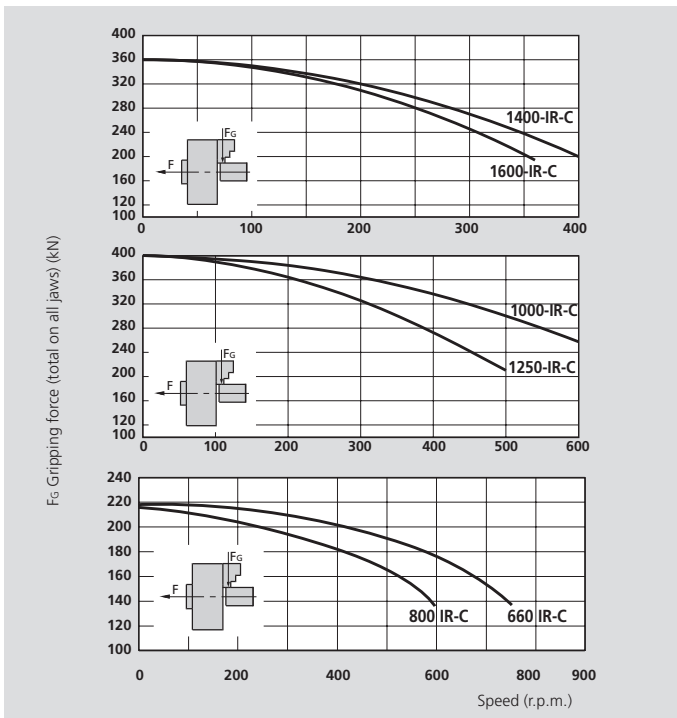
- 4-jaw chuck
- 1 set of soft top jaws
- Mounting bolts
- Grease gun

### Ordering example

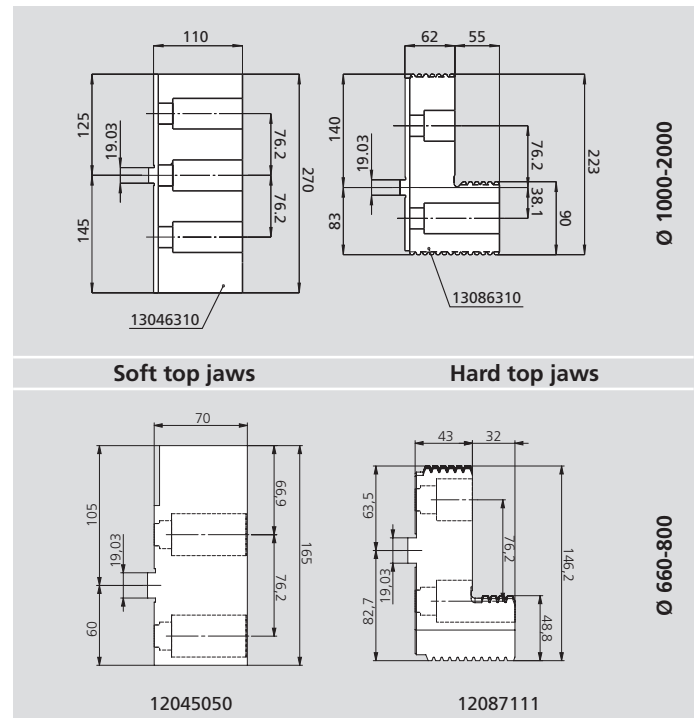
4-jaw chuck IR-C 1600 / Z720



### Actual gripping force diagrams



### Soft and hard top jaws for IR-C



The data in the diagram refer to 4-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		IR-C 660	IR-C 800	IR-C 1000	IR-C 1250	IR-C 1400	IR-C 1600	IR-C 2000
<b>Number of jaws</b>		<b>4</b>	<b>4</b>	<b>4</b>	<b>4</b>	<b>4</b>	<b>4</b>	<b>4</b>
<b>Radial jaw stroke (+ manual setting)</b>	mm	20 + (20)	20 + (20)	23 + (30)	23 + (30)	24 + (40)	24 + (40)	24 + (40)
<b>Axial piston stroke</b>	mm	50	50	57	57	60	60	60
<b>Max. draw pull*</b>	kN	120	120	180	180	200	200	200
<b>Max. gripping force*</b>	kN	215	215	320	320	360	360	360
<b>Max. speed</b>	r.p.m.	750	600	550	450	380	340	280
<b>Weight (without top jaws)</b>	kg	390	490	660	900	1425	1765	2730
<b>Moment of inertia</b>	kg·m <sup>2</sup>	16	40	84	178	347	562	1360
<b>Hard, reversible top jaw (piece)</b>	Id. No.	12087111	12087111	13086310	13086310	13086310	13086310	13086310
<b>Soft top jaw (piece)</b>	Id. No.	12045050	12045050	13046310	13046310	13046310	13046310	13046310
<b>Recommended actuating cylinders</b>	Type	SIN-S 150-175-200	SIN-S 150-175-200	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250
<b>Id. No. IR-C (Center mounting)</b>		77996601	77998024	77137439	77137449	77137455	77137463	77137479

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

# High precision power chuck Ø 660 - 2000 mm

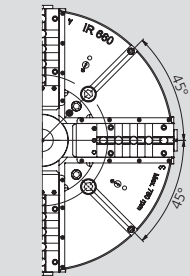
# IR-C

- Radial setting of jaws
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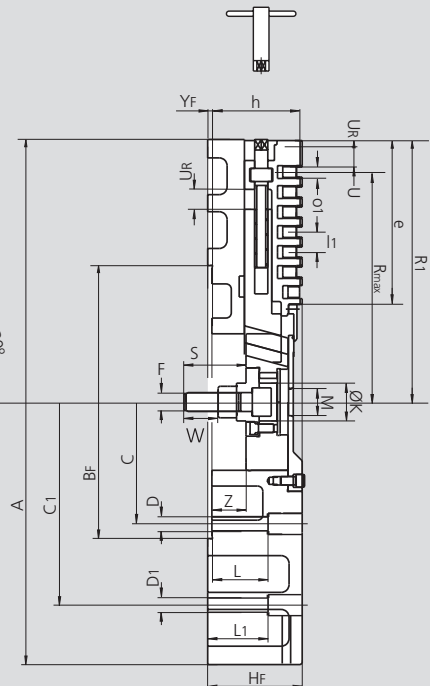
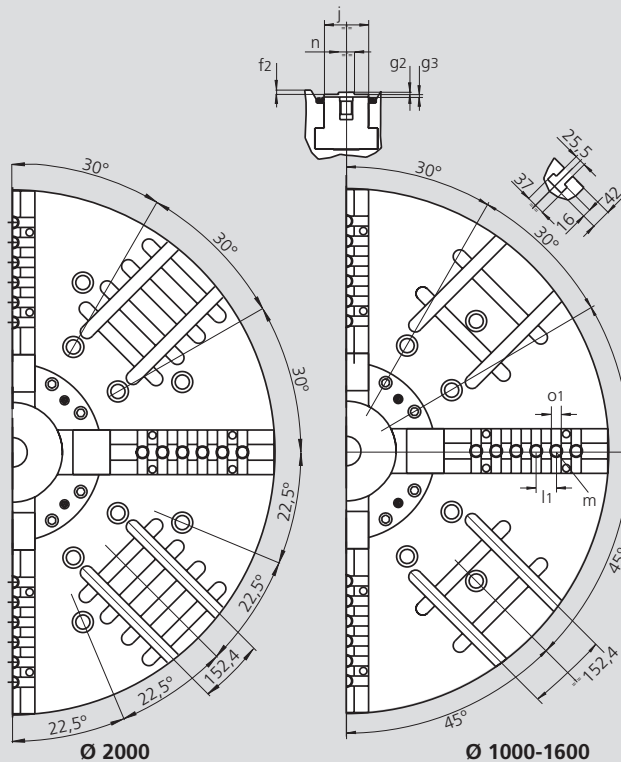
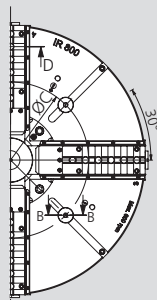
TONGUE & GROOVE

1

Ø 660



Ø 800



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

SMW-AUTOBLOK Type			IR-C 660		IR-C 800		IR-C 1000		IR-C 1250		IR-C 1400		IR-C 1600		IR-C 2000	
Mounting			Z380	A15	Z520	A20	Z520	A20	Z520	A20	Z720	Z720	Z720	Z720	Z720	
	<b>A</b>	mm	660		800		1005		1250		1400		1600		2000	
	<b>B<sub>F</sub> H6</b>	mm	380	285.775	520	417.775	520	520	520	520	720	720	720	720	720	
	<b>C</b>	mm	330.2		463.6		463.6		463.6		647.6		647.6		647.6	
	<b>C<sub>1</sub></b>	mm	-		-		700		700		1110		1110		1110	
	<b>D</b>	mm	27		27		27		27		33		33		33	
	<b>D<sub>1</sub></b>	mm	-		-		27		27		27		27		27	
	<b>F</b>	mm	M30		M30		M36		M36		M36		M36		M36	
	<b>H<sub>F</sub></b>	mm	154		150		200		200		240		240		260	
	<b>K</b>	mm	50		105		72.5		72.5		72.5		72.5		72.5	
	<b>L</b>	mm	75		55		137		137		177		177		197	
	<b>L<sub>1</sub></b>	mm	-		-		145		145		177		177		205	
	<b>M</b>	mm	M52 x 1.5		M52 x 1.5		M52 x 1.5		M52 x 1.5		M52 x 1.5		M52 x 1.5		M52 x 1.5	
Chuck open	<b>R<sub>1</sub></b>	mm	340.5		400		502		623		696		796		996	
Chuck open	<b>R<sub>max</sub></b>	mm	307		375		457		563		651		738		914	
Radial stroke	<b>U</b>	mm	20		20		23		23		24		24		24	
Setting stroke	<b>U<sub>R</sub></b>	mm	20		20		30		30		40		40		40	
	<b>W</b>	mm	57,5		60		65		65		65		65		65	
	<b>S</b>	mm	97		95		118		118		118		118		118	
	<b>Y<sub>F</sub></b>	mm	8		8		8		8		8		8		8	
Max.	<b>Z</b>	mm	56		66		75		75		100		100		120	
Min.	<b>Z</b>	mm	6		16		18		18		40		40		40	
	<b>e</b>	mm	194		246		295		416		446		539		739	
	<b>f<sub>1</sub></b>	mm	-		-		-		-		-		-		-	
	<b>f<sub>2</sub></b>	mm	7		13		8		8		8		8		8	
	<b>g<sub>2</sub></b>	mm	3		3		4		4		4		4		4	
	<b>g<sub>3</sub></b>	mm	7		7		7		7		7		7		7	
	<b>h</b>	mm	156		158		184		184		224		224		244	
	<b>j</b>	mm	85		85		85		85		110		110		110	
	<b>l<sub>1</sub></b>	mm	38.1		38.1		38.1		38.1		38.1		38.1		38.1	
	<b>m</b>	mm	M20		50		M24		M24		M24		M24		M24	
	<b>n h8</b>	mm	12.7		50		30		30		30		30		30	
	<b>o<sub>1</sub> H7</b>	mm	19.03		19.03		19.03		19.03		19.03		19.03		19.03	
Number of „o <sub>1</sub> “ cross grooves			3		5		6		9		10		12		16	
Number of „m“ threads			5		6		7		9		11		13		17	