

- Radial setting of jaws
- Closed center
- 3 and 6 jaws (660 - 800: 3 jaws / 1000 - 2500: 3 and 6 jaws)



Application/customer benefits

- Chucking operations of very large components
- Suitable for vertical machines thanks to the front protection of the slide ways

IR-C: Manual radial setting of master jaws, TONGUE & GROOVE (type "American Standard") (all diameters)

Technical features

- Gripping force transmission via wedge hook
- Front protection of the slide ways against swarf and chips penetration
- IR-C chucks with manual radial setting of master jaws for the workpiece centering

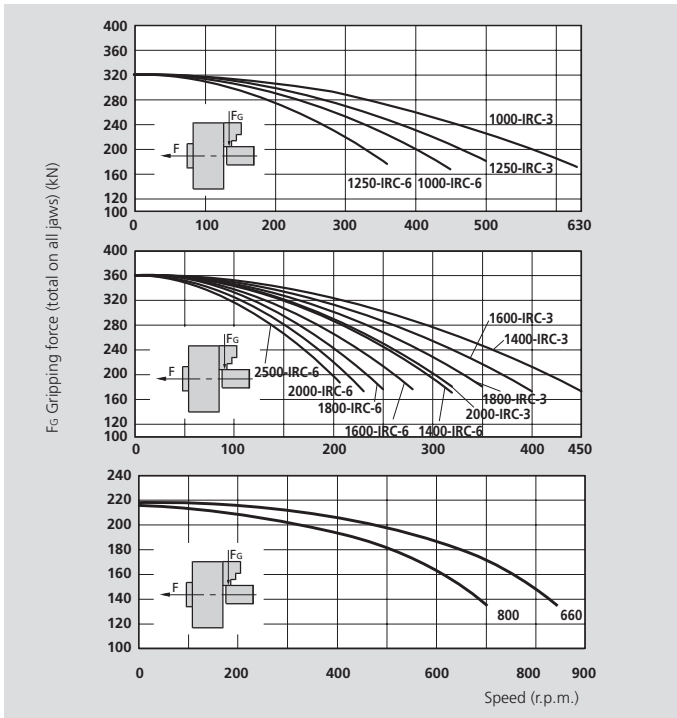
Standard equipment

- 3- or 6-jaw chuck
- 1 set soft top jaws
- Mounting bolts
- Grease gun

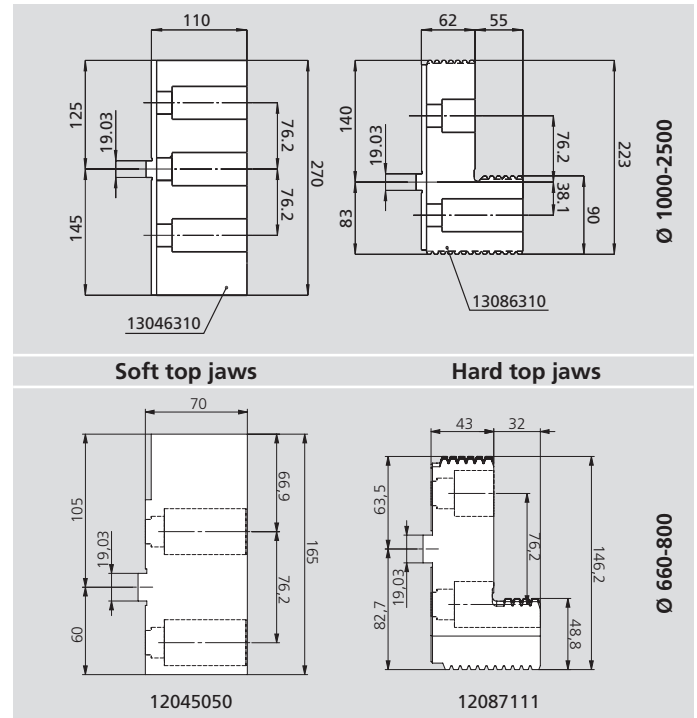
Ordering example

6-jaw chuck IR-C 1600 / Z720

Actual gripping force diagrams



Soft and hard top jaws for IR-C



The data in the diagrams refer to 3-6 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

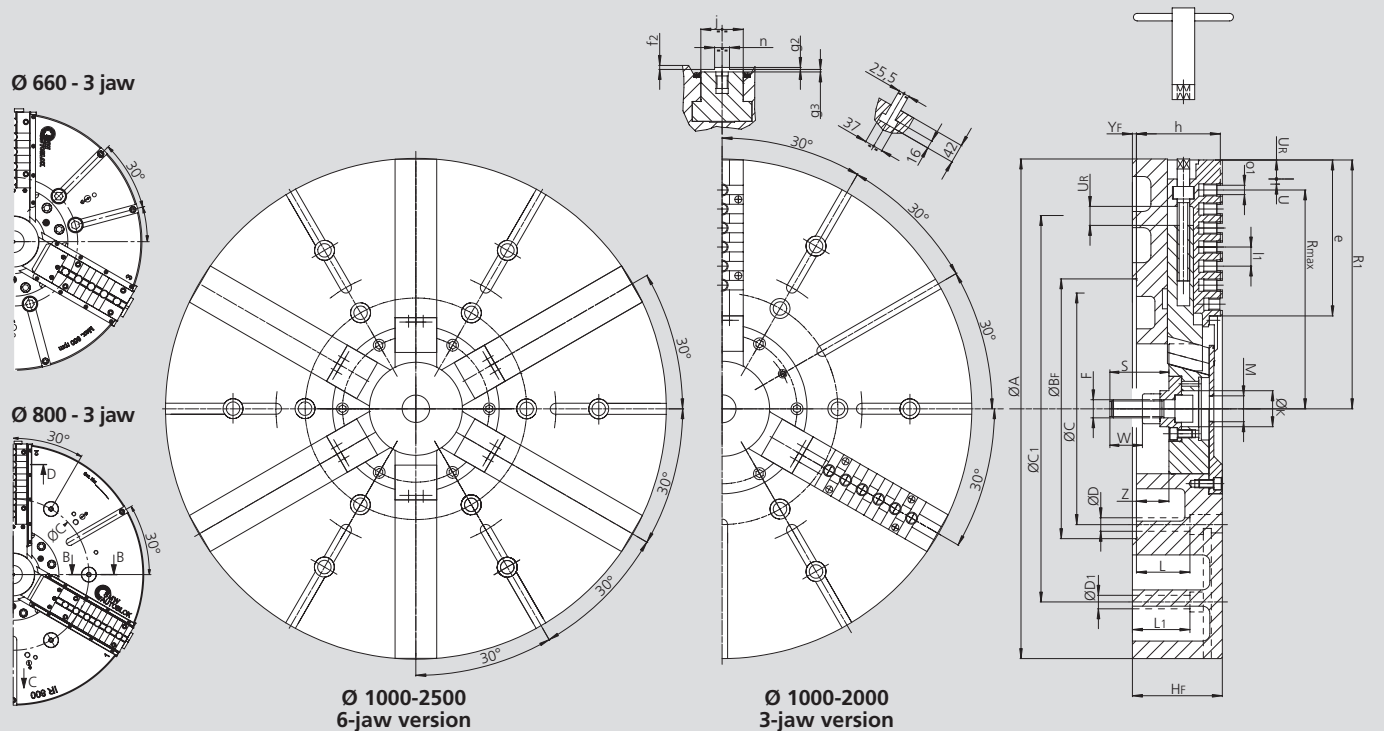
SMW-AUTOBLOK Type		IR-C 660	IR-C 800	IR-C 1000	IR-C 1250	IR-C 1400	IR-C 1600	IR-C 1800	IR-C 2000	IR-C 2500
Number of jaws		3	3	3 6	3 6	3 6	3 6	3 6	3 6	6
Radial jaw stroke (+ manual setting)	mm	20 + (20)	20 + (30)	23 + (30)	23 + (30)	24 + (40)	24 + (40)	24 + (40)	24 + (40)	30 + (40)
Axial piston stroke	mm	50	50	57	57	60	60	60	60	60
Max. draw pull*	kN	120	120	180	180	200	200	200	200	270
Max. gripping force*	kN	215	215	320	320	360	360	360	360	380
Max. speed	r.p.m.	850	700	630 450	500 360	450 320	400 280	350 250	320 230	200
Weight (without top jaws)	kg	390	520	600	800	1200	1600	1800	2500	5100
Moment of inertia	kg·m ²	15.5	25	68	145	280	500	750	1250	3860
Hard, reversible top jaw (piece)	Id. No.	12087111	12087111	13086310	13086310	13086310	13086310	13086310	13086310	13086310
Soft top jaw (piece)	Id. No.	12045050	12045050	13046310	13046310	13046310	13046310	13046310	13046310	13046310
Recommended actuating cylinders	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	SIN-S 250	SIN-S 250
Id. No. IR-C 3 jaws (Center mounting)		77996602	77998022	77137339	77137349	77137355	77137363	77137371	77137379	-
Id. No. IR-C 6 jaws (Center mounting)		-	-	77137639	77137649	77137655	77137663	77137671	77137679	77137685

High precision power chuck Ø 660 - 2500 mm

IR-C

- Radial setting of jaws
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TONGUE & GROOVE



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 1800	IR-C 2000	IR-C 2500
Mounting		Z380	A15	Z520	A20	Z520	A20	Z520	A20	Z720	Z720	Z720	Z720	Z720
	A	mm	660	800	1005	1250	1400	1600	1800	2000	2500			
	BF H6	mm	380	285.775	520	412.775	520	520	720	720	720	720	720	720
	C	mm	330.2	463.6	463.6	463.6	647.6	647.6	647.6	647.6	647.6	647.6	647.6	647.6
	C1	mm	-	-	700	700	1110	1110	1110	1110	1110	1110	1110	1640
	D	mm	27	27	27	27	33	33	33	33	33	33	33	33
	D1	mm	-	-	27	27	27	27	27	27	27	27	27	27
	F	mm	M30	M30	M36	M36	M36	M36	M36	M36	M36	M36	M36	M42
	HF	mm	154	150	184	184	222	222	222	222	222	240	280	
	K	mm	50	105	72	72	72	72	72	72	72	72	72	72
	L	mm	75	87	121	121	159	159	159	159	177	182	182	
	L1	mm	-	-	97	97	130	130	130	130	148	205		
	M	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	M52 x 1.5	M52 x 1.5	M52 x 1.5	M52 x 1.5	-
Chuck open	R1	mm	340.5	400	502	623	696	796	896	996	1248			
Chuck open	Rmax	mm	307	375	457	563	657	738	838	914	1176			
	S	mm	97	95	100	100	100	100	100	100	100	100	100	54
Radial stroke	U	mm	20	20	23	23	24	24	24	24	24	24	24	30
Setting stroke	UR	mm	20	30	30	30	40	40	40	40	40	40	40	40
	W	mm	57,5	60	65	65	65	65	65	65	65	65	65	-
	YF	mm	8	8	8	8	8	8	8	8	8	8	8	8
Max.	Z	mm	56	66	59	59	82	82	82	100	-			
Min.	Z	mm	6	16	2	2	22	22	22	40	-			
	e	mm	194	246	295	416	446	546	639	739	959			
	f2	mm	7	13	8	8	8	8	8	8	8	8	8	8
	g2	mm	3	3	4	4	4	4	4	4	4	4	4	4
	g3	mm	7	7	7	7	7	7	7	7	7	7	7	7
	h	mm	156	158	168	168	206	206	206	224	261			
	j	mm	85	85	85	85	110	110	110	110	110	110	110	110
	l1	mm	38.1	38.1	38.1	38.1	38.1	38.1	38.1	38.1	38.1	38.1	38.1	38.1
	m	mm	M20	M20	M24	M24	M24	M24	M24	M24	M24	M24	M24	M24
	n h8	mm	12.7	12.7	30	30	30	30	30	30	30	30	30	30
	o1 H7	mm	19.03	19.03	19.03	19.03	19.03	19.03	19.03	19.03	19.03	19.03	19.03	19.03
Number of „o1“ cross grooves			3	5	6	9	10	12	14	16	21			
Number of „m“ threads			5	6	7	10	11	13	15	17	21			