

IN-D

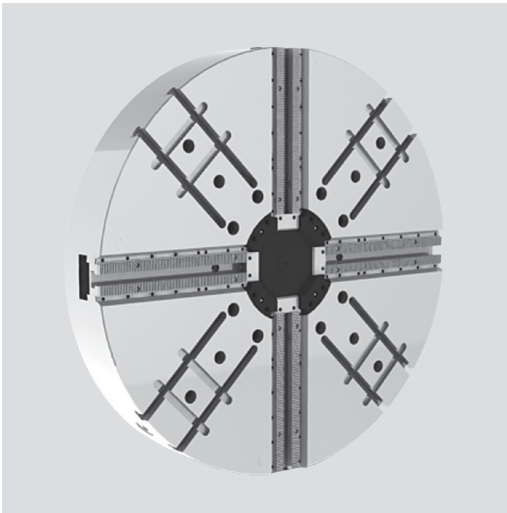
MODULE 2
SERRATION

IL-D

LONG JAW STROKE
MODULE 2
SERRATION

High precision power chuck Ø 1000 - 1600 mm

- Closed center
- Long jaw stroke
- 4 jaws (all diameters)



Application/customer benefits

- Clamping of large square and irregular shaped parts, using 2 or 4 jaws self centering
- Suitable for vertical machines thanks to the front protection of the slide ways

IN-D/IL-D: MODULE 2 SERRATED master jaws (pitch 6.28 mm)
(Ø 1000 and 1600 mm)

Technical features

- Gripping force transmission via wedge hook
- 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

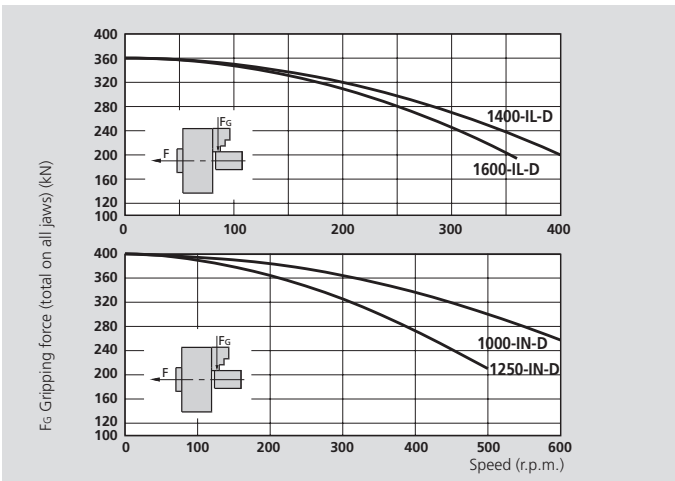
Standard equipment

4-jaw chuck
1 set T-nuts with bolts
1 set soft top jaws with cross keys
Mounting bolts
Grease gun

Ordering example

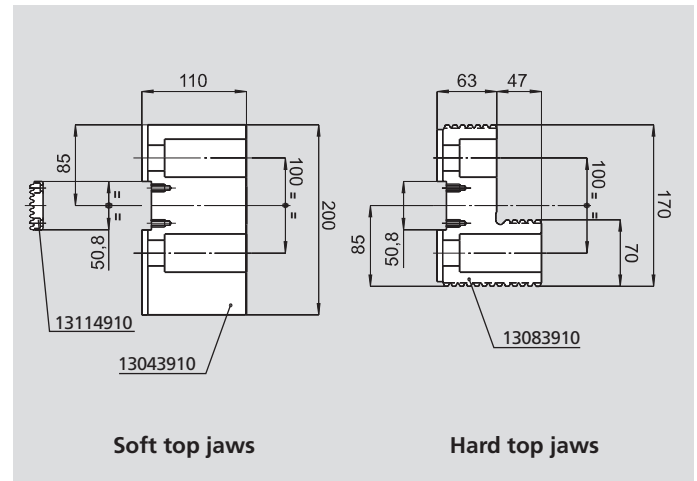
4-jaw chuck IN-D 1600 / Z720

Actual gripping force diagrams



The data in the diagrams 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.

Soft and hard top jaws for IN-D and IL-D



△ 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		IN-D 1000	IN-D 1250	IL-D 1400	IL-D 1600
Radial jaw stroke	mm	15	15	24	24
Axial piston stroke	mm	57	57	60	60
Max. draw pull*	kN	180	180	200	200
Max. gripping force*	kN	400	400	360	360
Max. speed	r.p.m.	600	500	400	360
Weight (without top jaws)	kg	660	900	1425	1765
Moment of inertia	kg·m ²	84	178	347	562
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 250	SIN-S 250	SIN-S 250	SIN-S 250
Id. No. IN-D/IL-D (Center mounting)		77133439	77133449	77133855	77133863

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



SMW-AUTOBLOK
327

High precision power chuck Ø 1000 - 1600 mm

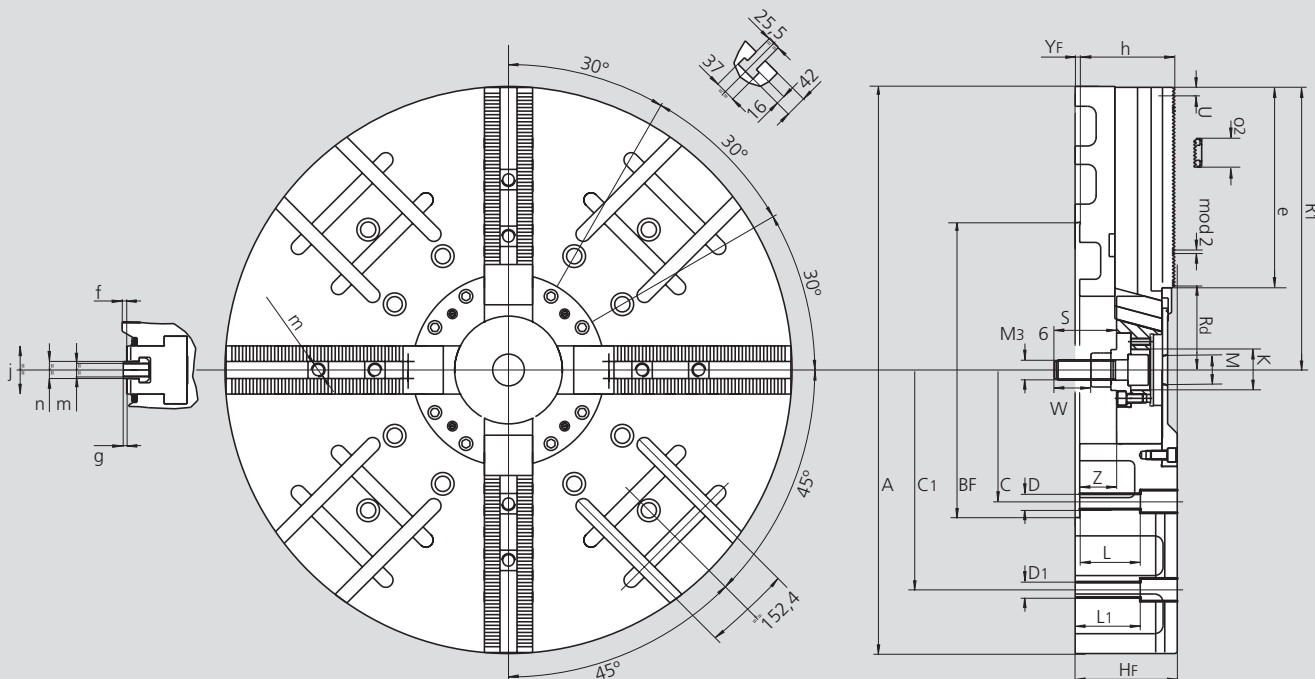
- Closed center
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Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type			IN-D 1000		IN-D 1250		IL-D 1400	IL-D 1600
Mounting			Z520	A20	Z520	A20	Z720	Z720
	A	mm	1005		1250		1400	1600
	BF H6	mm	520		520		720	720
	C	mm	463.6		463.6		647.6	647.6
	C1	mm	700		700		1110	1110
	D	mm	27		27		33	33
	D1	mm	27		27		27	27
	HF	mm	200		200		240	240
	K	mm	72		72		72.5	72.5
	L	mm	137		137		177	177
	L1	mm	145		145		177	177
	M	mm	M52 x 1.5		M52 x 1.5		M52 x 1.5	M52 x 1.5
Chuck open	R1	mm	498		623		696	796
Chuck open	Rd	mm	148.5		148.5		179.5	179.5
Jaw stroke	U	mm	15		15		24	24
	S	mm	118		118		118	118
	YF	mm	8		8		8	8
Max.	Z	mm	75		75		100	100
Min.	Z	mm	18		18		40	40
	e	mm	353		478		519	619
	f	mm	8		8		8	8
	g	mm	4		4		4	4
	h	mm	184		184		224	224
	j	mm	85		85		110	110
	m	mm	M24		M24		M24	M24
	n h8	mm	30		30		30	30
	o2 h6	mm	50.8		50.8		50.8	50.8