

# IN-D

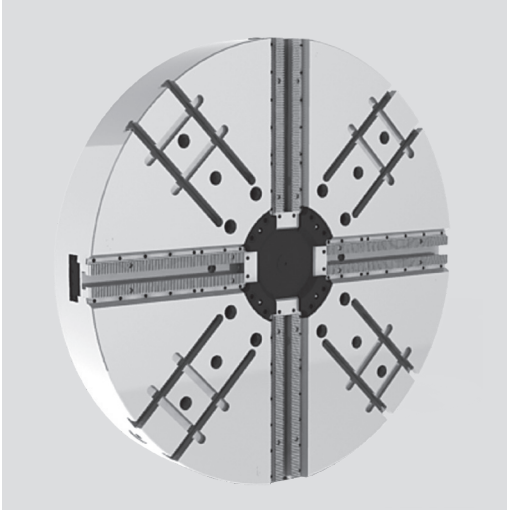
MODULE 2  
SERRATION

# IL-D

LONG JAW STROKE  
MODULE 2  
SERRATION

## High precision power chucks 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 und 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

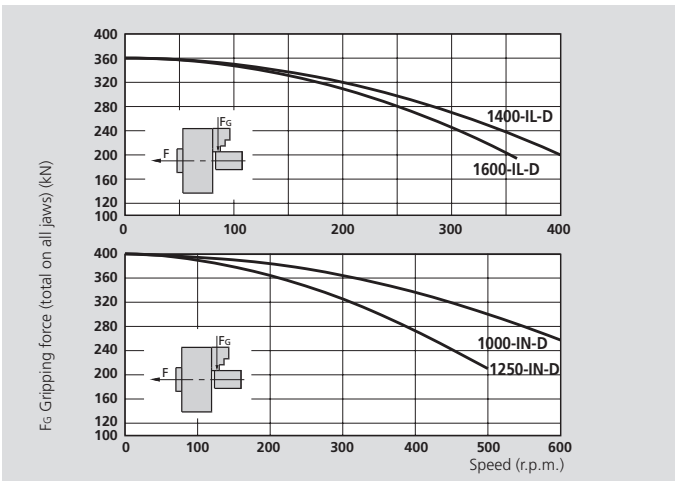
### Standard equipment

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

### Ordering example

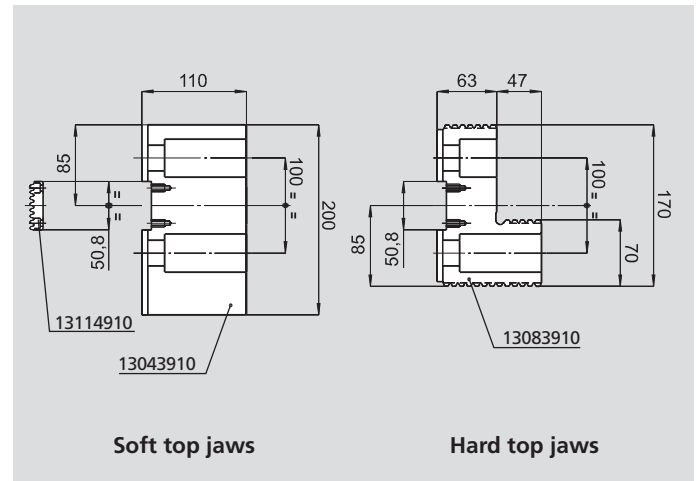
4 jaw chuck IN-D 1600 / Z720

### Actual gripping force diagrams



The data in the diagram refer to 4 jaw chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K05 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 <sup>2</sup>	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

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



SMW-AUTOBLOK  
297

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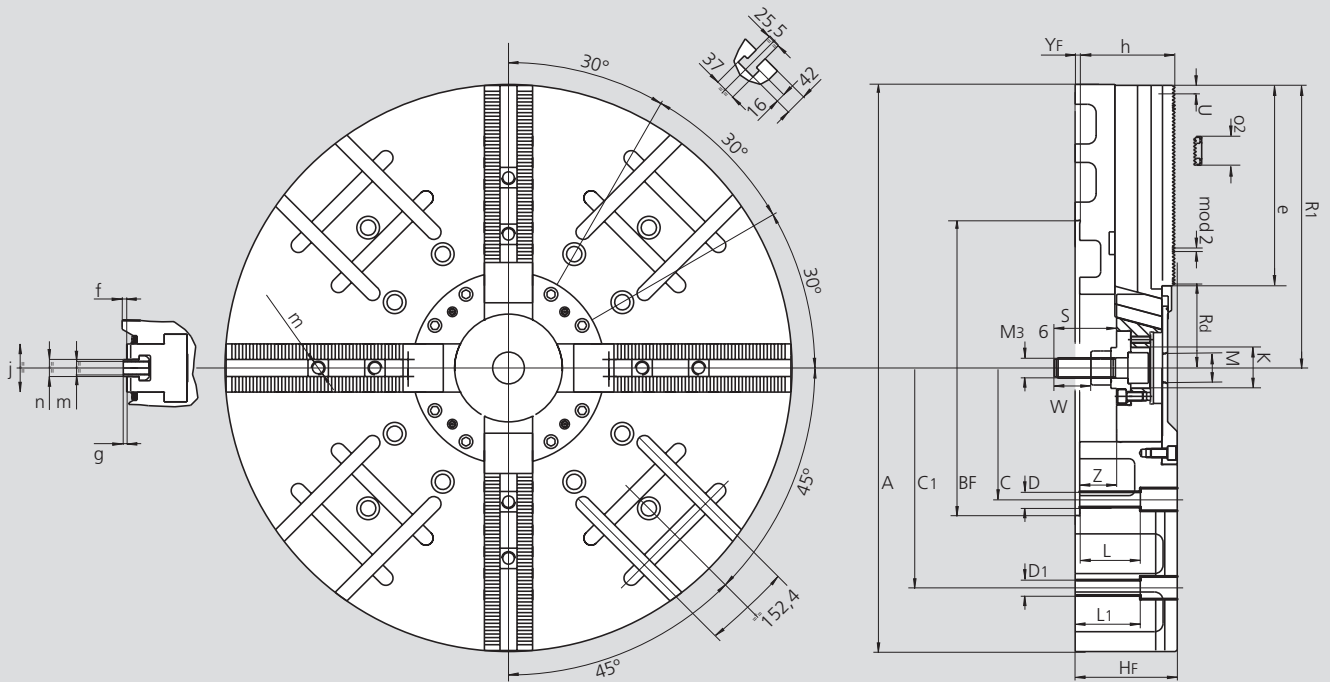
- Closed center
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## IL-D

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

1

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