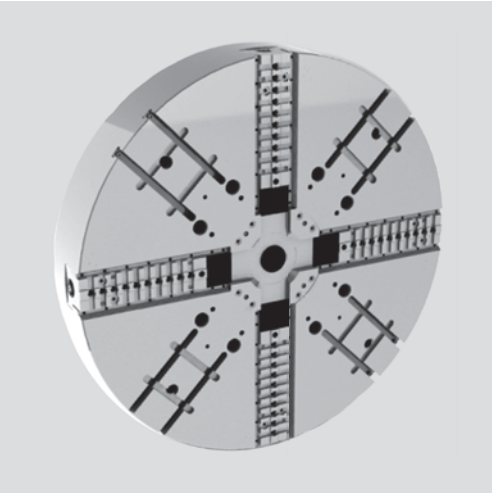
TPT-RC

2+2 independent jaw movement
Tongue & groove
Radial setting of jaws

High precision 2+2 jaw power chuck with self-centering independent jaw movement Ø 1000 - 2000 mm

- **closed center**
- **tongue & groove**



Application/customer benefits

- High versatility on large vertical lathes to clamp round, elliptical, irregular, square and rectangular work pieces, self centering in two axis
- External or internal clamping

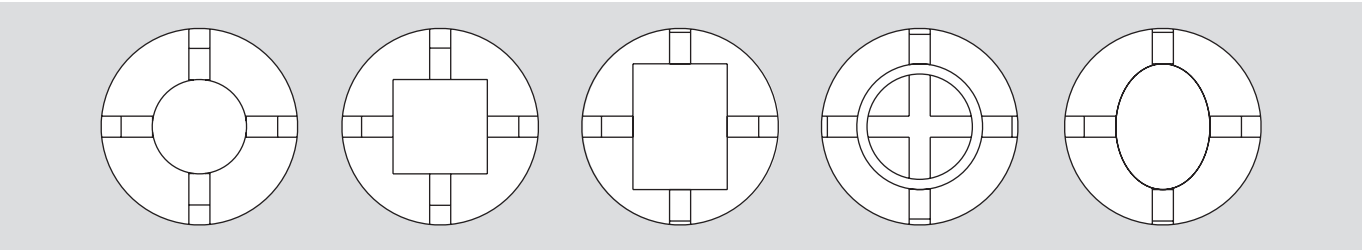
Technical features

- 2+2 jaw chuck with 2 independent self-centering jaw drives (two wedge drives)
- jaw No. 1 + 3 (clamping jaws): power operated
- jaw No. 2 + 4 (clamping jaws): power operated
- internal parts case hardened for high precision and long life
- with manual radial setting of jaws for the 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

2+2 jaw chuck
1 set of soft top jaws
Mounting bolts

Using the double centering it is possible to easily clamp a wide variaty of component shapes:
round, square, ring, rectangular, oval and irregular



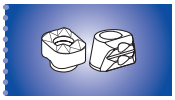
Two independent wedge drives

- Operated by independent double piston cylinders.
- Jaws 2 and 4 are power operated to center the component in one axis and to drive the component.
- Jaws 1 and 3 are power operated to center the component on the second axis and to drive the component.
- Since both pairs of jaws are power operated the chuck can reach high speeds.

Technical data

SMW-AUTOBLOK Type Number of jaws		TPT-RC 1000 2+2	TPT-RC 1250 2+2	TPT-RC 1400 2+2	TPT-RC 1600 2+2	TPT-RC 2000 2+2
Radial jaw stroke	mm	23	23	24	24	24
Wedge stroke	mm	57	57	60	60	60
Weight (plain back without top jaws)	kg	695	940	1460	1800	2760
Moment of inertia ($m \cdot r^2$)	$kg \cdot m^2$	86	180	355	565	1370
TWO independent wedge drives						
Max. draw pull (wedge 1, jaw 1 + 3)	kN	100	100	120	120	120
Max. draw pull (wedge 2, jaw 2 + 4)	kN	100	100	120	120	120
Max. gripping force jaw 1 + 3 (power operated)	kN	180	180	210	210	210
Max. centering force jaw 2 + 4 (power operated)	kN	180	180	210	210	210
Max. speed	r.p.m.	550	450	400	400	280
Recommended actuating cylinders*	type	**DCE 240/240**	**DCE 240/240**	**DCE 240/240**	**DCE 240/240**	**DCE 240/240**

*technical details of DCE cylinders see page 230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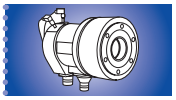
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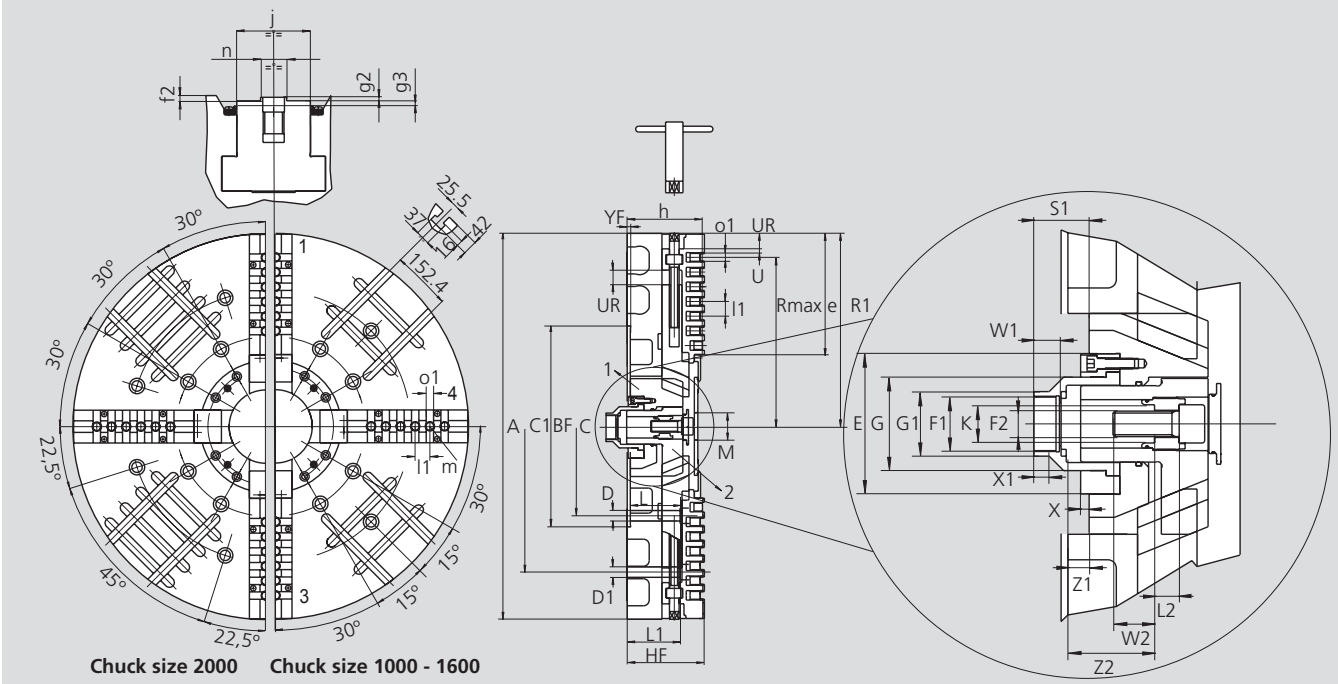
High precision 2+2 jaw power chuck with self-centering independent jaw movement Ø 1000 - 2000 mm

- closed center
- tongue & groove

TPT-RC

2+2 independent jaw movement
Tongue & groove
Radial setting of jaws



Chuck size 2000 **Chuck size 1000 - 1600**

Subject to technical changes
For more detailed information please ask for customer drawing

SMW-AUTOBLOK Type			TPT-RC 1000		TPT-RC 1250		TPT-RC 1400	TPT-RC 1600	TPT-RC 2000
Mounting			Z520	A20	Z520	A20	Z720	Z720	Z720
	A	mm	1005		1250		1400	1600	2000
	B_F H6	mm	520		520		720	720	720
	C	mm	463.6		463.6		647.6	647.6	647.6
	C_1	mm	700 (*)		700 (*)		1110	1110	1110
	D	mm	27		27		33	33	33
	D_1	mm	27(*)		27 (*)		27	27	27
	E	mm	165		165		165	165	165
	F_1	mm	M75 x 2		M75 x 2		M75 x 2	M75 x 2	M75 x 2
	F_2	mm	M30		M30		M30	M30	M30
	G	mm	110		110		110	110	110
	G_1	mm	86		86		86	86	86
	H_F	mm	200		200		240	240	260
	K	mm	45		45		45	45	45
	L	mm	146		146		179	179	199
	L_1	mm	148 (°)		148 (°)		192	192	212
	L_2	mm	29		29		29	29	29
	M	mm	70		70		70	70	70
Chuck open	**R_1**	mm	502		623		696	796	996
	R_{max}	mm	457		563		651	738	914
	S_1	mm	97		97		65	65	65
Radial jaw stroke	**U**	mm	23		23		24	24	24
Radial setting stroke	**U_R**	mm	30		30		40	40	40
	W_1	mm	30		30		30	30	30
	W_2	mm	49		49		49	49	49
	X	mm	31		31		0	0	0
	X_1	mm	23		23		23	23	23
	Y_F	mm	8		8		8	8	8
Wedge stroke 1 max./min.	**Z_1**	mm	57	0	57	0	60 0	60 0	60 0
Wedge stroke 2 max./min.	**Z_2**	mm	98	41	98	41	137 77	137 77	157 77
	e	mm	295		416		446	539	739
	f_2	mm	8		8		8	8	8
	g_2	mm	4		4		4	4	4
	g_3	mm	7		7		7	7	7
	h	mm	192		192		232	232	252
	j	mm	85		85		110	110	110
	l_1	mm	38.1		38.1		38.1	38.1	38.1
Number + size	**m**	mm	7 x M24		10 x M24		11 x M24	13 x M24	17 x M24
	n	mm	30		30		30	30	30
Number + size	**o_1**	mm	6 x 19.03		9 x 19.03		10 x 19.03	12 x 19.03	16 x 19.03

*Only on request