

ACS-E 3

Self centering
column chuck

Self-centering column chucks with pull down

Ø 130 - 254 mm

- pull down
- power operated via standard cylinders
- O.D. clamping



Application/customer benefits

- For small, medium and large quantities at high precision
- Pull down of the workpiece to the axial workstop during clamping
- Minimum loss of gripping force at high speed
- Standard, hardened jaw blanks available

Technical features

- Chuck body completely case hardened
- Openings in the chuck body to evacuate chips
- Central bore for coolant/air

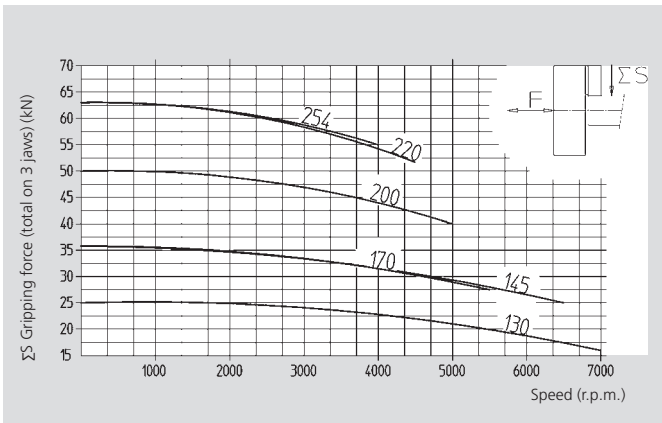
Standard equipment

3-jaw chuck with mounting bolts

Ordering example

3 jaws column chuck
with center mounting Z170
type ACS-E 220-3-Z170

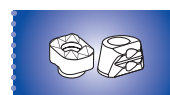
Actual gripping force diagram



The diagrams refer to standard jaw blanks, machined to 50 % of their mass.

Technical data

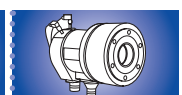
SMW-AUTOBLOK Type		ACS-E 3 130	ACS-E 3 145	ACS-E 3 170	ACS-E 3 200	ACS-E 3 220	ACS-E 3 254
Jaw stroke	mm	2.6	2.6	2.6	2.6	3.2	4
Piston stroke	mm	10	10	10	10	12	15
Actuating force	kN	10	15	15	20	25	25
Grip force	kN	25	36	36	50	63	63
Speed	r.p.m.	7000	6500	5500	5000	4500	4000
Weight	kg	12	14	17	30	35	50
Moment of inertia	kg·m ²	0.02	0.03	0.06	0.16	0.21	0.35
Clamping range	min.	10	20	30	30	50	90
Clamping range	max.	50	70	95	100	125	165
Recommended actuating cylinders		SIN-S 70 SIN-S 85	SIN-S 70 SIN-S 85	SIN-S 85 SIN-S 100	SIN-S 100 SIN-S 125	SIN-S 125 SIN-S 150	SIN-S 125 SIN-S 150
Id.No. chuck		77690113	77690114	77690117	77690120	77690122	77690125
Id.No. jaw blanks		69761310	69761410	69761710	69762010	69762210	69762210



Page 310



Page 304



Page 217

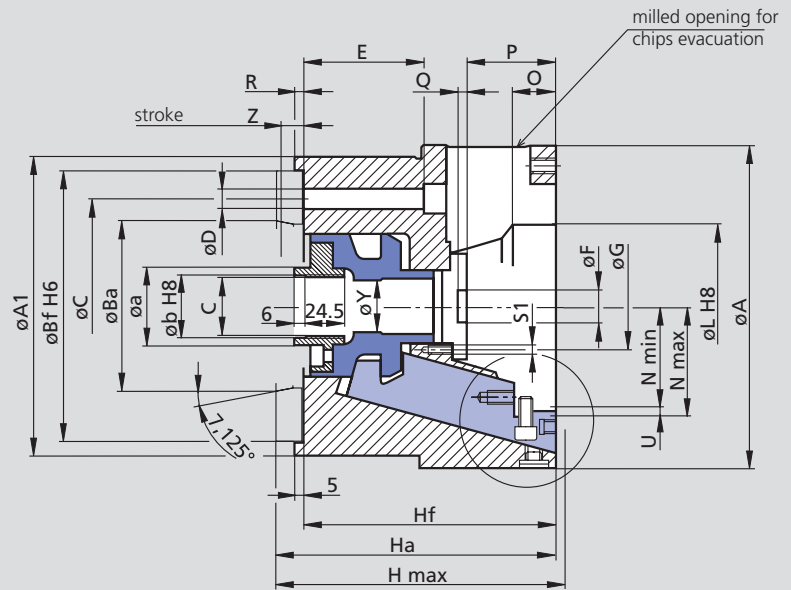
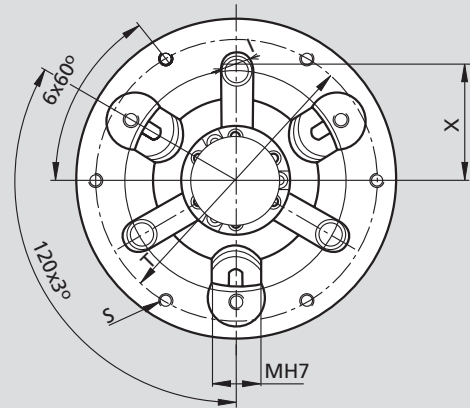
Self-centering column chucks with pull down

Ø 130 - 254 mm

- pull down
- power operated via standard cylinders
- O.D. clamping

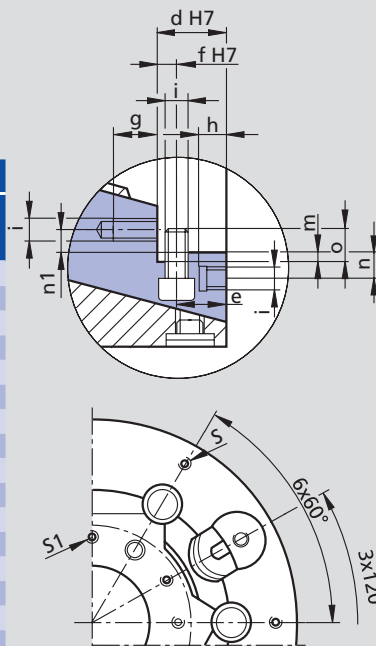
ACS-E 3

Self centering column chuck



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

SMW-AUTOBLOK Type ACS-E 3	130	145	170	200	220	254	
Mounting	ISO-A4 FL 115	ISO-A4 FL 115	ISO-A5 FL 140	ISO-A6 FL 170	ISO-A6 FL 170	ISO-A8 FL 220	
A/A1	130/130	145/130	170/155	200/185	220/185	254/235	
Ba	63.513	63.513	82.563	106.375	106.375	139.719	
Bf	115	115	140	170	170	220	
C	82.6	82.6	104.8	133.4	133.4	171.4	
D	3x11	3x11	3x11	6x13	6x13	6x17	
E	64	64	65	75	75	91	
F	-	16	20	20	30	70	
G	-	40	65	54	68	107	
H max.	130	130	140	179	183	198.5	
Ha	125	125	135	174	177	191	
Hf	112	112	120	157	160	172	
I	20	20	20	-	-	-	
L	55	75	98	102	126	167	
M	20	20	20	30	30	30	
N min/max	33.7/36.3	43.7/46.3	56.2/58.8	63.7/66.3	73.4/76.6	93/97	
O	26.5	26.5	26.5	32	33	34	
P	30	29	29	55	50.5	40	
Q	-	5	5	7	7	65.5	
R	18	18	4.5	4.5	3.5	2	
S	6xM6	6xM6	6xM6	6xM8	6xM8	6xM8	
S1	-	3xM5	6xM5	6xM6	6xM6	6xM6	
T	115	115	145	175	190	226	
Stroke	U	2.6	2.6	2.6	2.6	3.2	4
Stroke	Z	10	10	10	10	12	15
Stroke	X	41.3	41.3	52.4	-	-	-



2 media can be used through the chuck's bore.
Specials on request.

a	36	36	48	48	48	48
b	29	29	39	39	39	39
c	M28x1.5	M28x1.5	M38x1.5	M38x1.5	M38x1.5	M38x1.5
d	20	20	20	25	25	25
e	14	14	14	18	18	18
f	6	6	6	7	7	7
g	12	12	12	16	16	16
h	-	-	-	9	9	9
i	M6	M6	M6	M8	M8	M8
m	3.5	3.5	3.5	3.5	3.5	3.5
n	7.5	7.5	7.5	10	10	10
n1	6.5	6.5	6.5	8.5	8.5	8.5
o	8.5	8.5	8.5	9	9	9
y	12.5	14	32	32	32	32

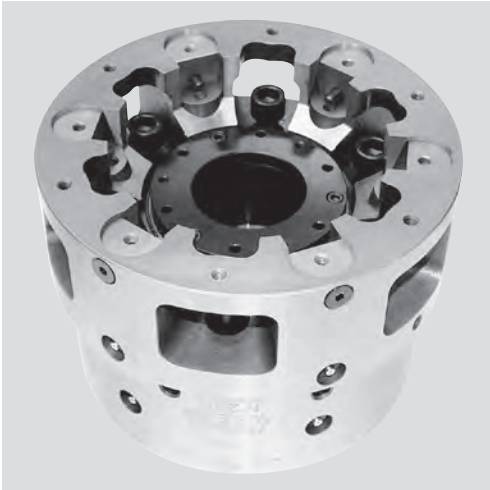
ACS-E 6

Self centering
column chuck

Self-centering column chucks with pull down

Ø 200 - 254 mm

- pull down
- power operated via standard cylinders
- O.D. clamping



Application/customer benefits

- For small, medium and large quantities at high precision
- Pull down of the workpiece to the axial workstop during clamping
- Minimum loss of gripping force at high speed
- Standard, hardened jaw blanks available

Technical features

- Chuck body completely case hardened
- Openings in the chuck body to evacuate chips
- Central bore for coolant/air

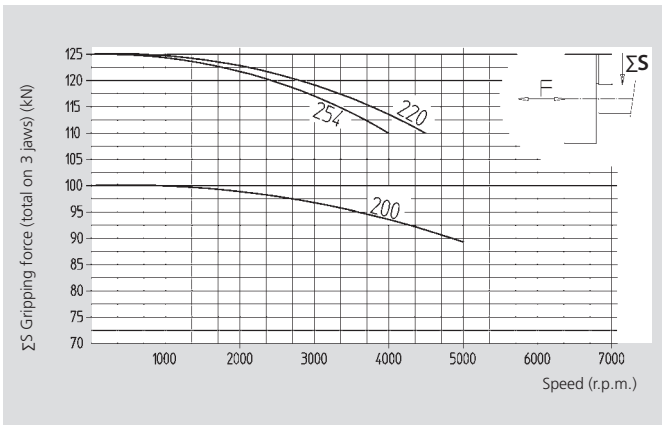
Standard equipment

6-jaw chuck with mounting bolts

Ordering example

6 jaw column chuck
with center mounting Z170
type ACS-E 220-6-Z170

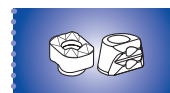
Actual gripping force diagram



The diagrams refer to standard jaw blanks, machined to 50 % of their mass.

Technical data

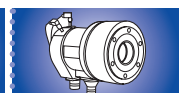
SMW-AUTOBLOK Type		ACS-E 6 200	ACS-E 6 220	ACS-E 6 254
Jaw stroke	mm	2.6	3.2	4
Piston stroke	mm	10	12	15
Actuating force	kN	40	50	50
Grip force	kN	100	125	125
Speed	r.p.m.	5000	4500	4000
Weight	kg	30	35	50
Moment of inertia	kg·m ²	0.16	0.21	0.35
Clamping range	min.	30	50	90
Clamping range	max.	100	125	165
Recommended actuating cylinders		SIN-S 100 SIN-S 125	SIN-S 125 SIN-S 150	SIN-S 125 SIN-S 150
Id. No. chuck		77690420	77690422	77690425
Id. No. jaw blanks		69762040	69762240	



Page 310



Page 304



Page 217

Self-centering column chucks with pull down

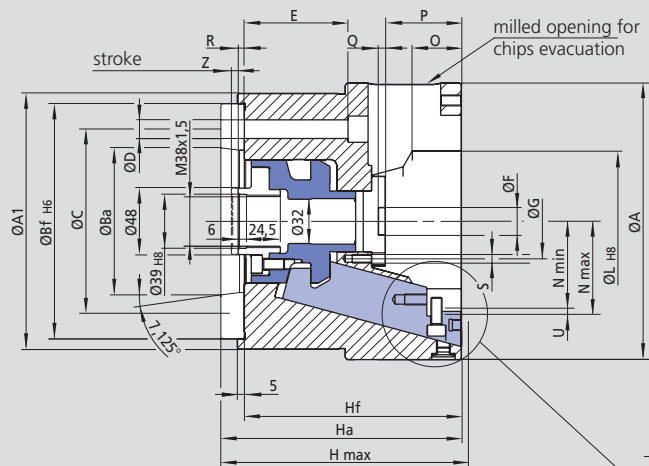
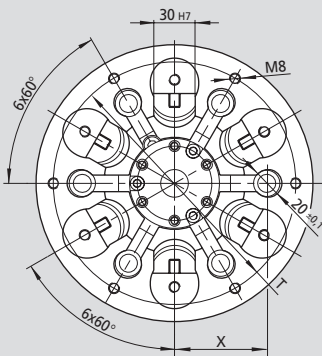
Ø 200 - 254 mm

- pull down
- power operated via standard cylinders
- O.D. clamping

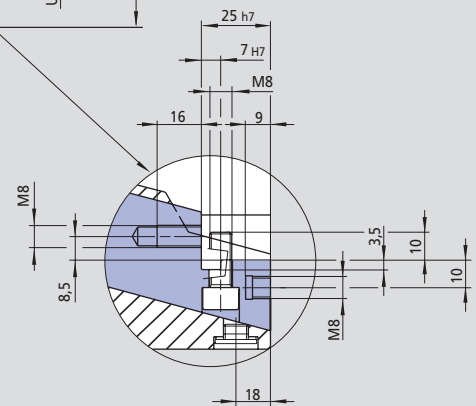
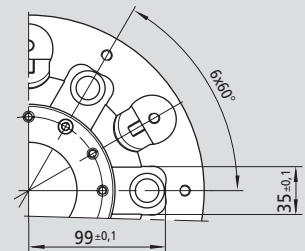
ACS-E 6

Self centering column chuck

ACS-E



ACS-E 254



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

SMW-AUTOBLOK Type ACS-E 6		200	220	254
Mounting		ISO-A6 FL 170	ISO-A6 FL 170	ISO-A8 FL 220
	A	200	220	254
	A1	185	185	235
	Ba	106.375	106.375	139.719
	Bf	170	170	220
	C	133.4	133.4	171.4
	D	13	13	17
	E	75	75	91
	F	20	30	70
	G	54	68	107
	H max.	179	183	198.5
	Ha	174	177	191
	Hf	157	160	172
	L	102	126	167
	M	30	30	30
	N min.	66.3	76.6	97
	N max.	63.7	73.4	93
	O	32	33	34
	P	55	50.5	40
	Q	7	7	65.5
	R	4.5	3.5	2
	S	6xM6	6xM6	6xM6
	T	175	190	226
Stroke	U	2.6	3.2	4
Stroke	Z	10	12	15
	X	66.7	72	-

2 media can be used through the chuck's bore.
Specials on request.

ACS-I 3/6

Self centering
column chuck

Self-centering column chucks with pull down

Ø 130-240 mm

- pull down
- power operated via standard cylinders
- i.D. clamping



Application/customer benefits

- For small, medium and large quantities at high precision
- Pull down of the workpiece to the axial workstop during clamping
- Minimum loss of gripping force at high speed
- Standard, hardened jaw blanks available

Technical features

- Chuck body completely case hardened
- Openings in the chuck body to evacuate chips
- Central bore for coolant/air

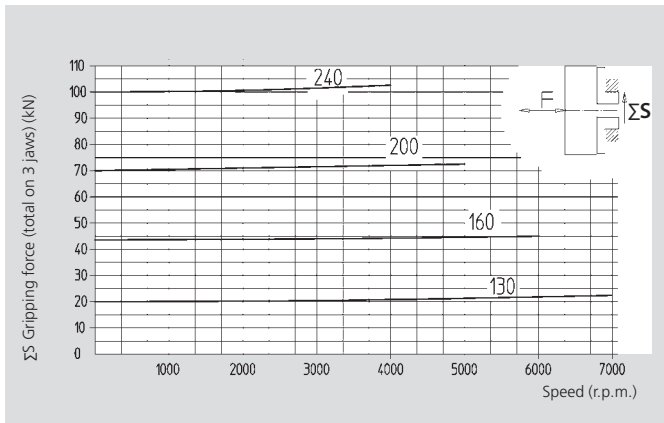
Standard equipment

3 or 6-jaw chuck with mounting bolts

Ordering example

3 jaw column chuck
with center mounting Z115
type ACS-I 130-3-Z115

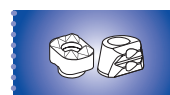
Actual gripping force diagram



The diagrams refer to standard jaw blanks, machined to 50 % of their mass.

Technical data

SMW-AUTOBLOK Type		ACS-I 130	ACS-I 160	ACS-I 200	ACS-I 240	ACS-I 240
Number of jaws		3	3	3	3	6
Jaw stroke	mm	2.6	4.4	4.4	4.4	4.4
Piston stroke	mm	10	11	11	11	11
Actuating force	kN	10	20	40	60	60
Grip force	kN	20	36	70	100	100
Speed	r.p.m.	7000	6000	5000	4000	4000
Weight	kg	10	12	20	30	30
Moment of inertia	kg·m ²	0.02	0.03	0.1	0.2	0.2
Clamping range	min.	65	92	110	144	144
Clamping range	max.	100	140	200	232	232
Recommended actuating cylinders		SIN-S 70 SIN-S 85	SIN-S 85 SIN-S 100	SIN-S 100 SIN-S 125	SIN-S 125 SIN-S 150	SIN-S 125 SIN-S 150
Id. No. chuck		77690613	77690616	77690620	77690624	77690624
Id. No. jaw blanks		69761360	69761660	69762060	69762490	69762490



Page 310



Page 304



Page 217

Self-centering column chucks with pull down

Ø 130-240 mm

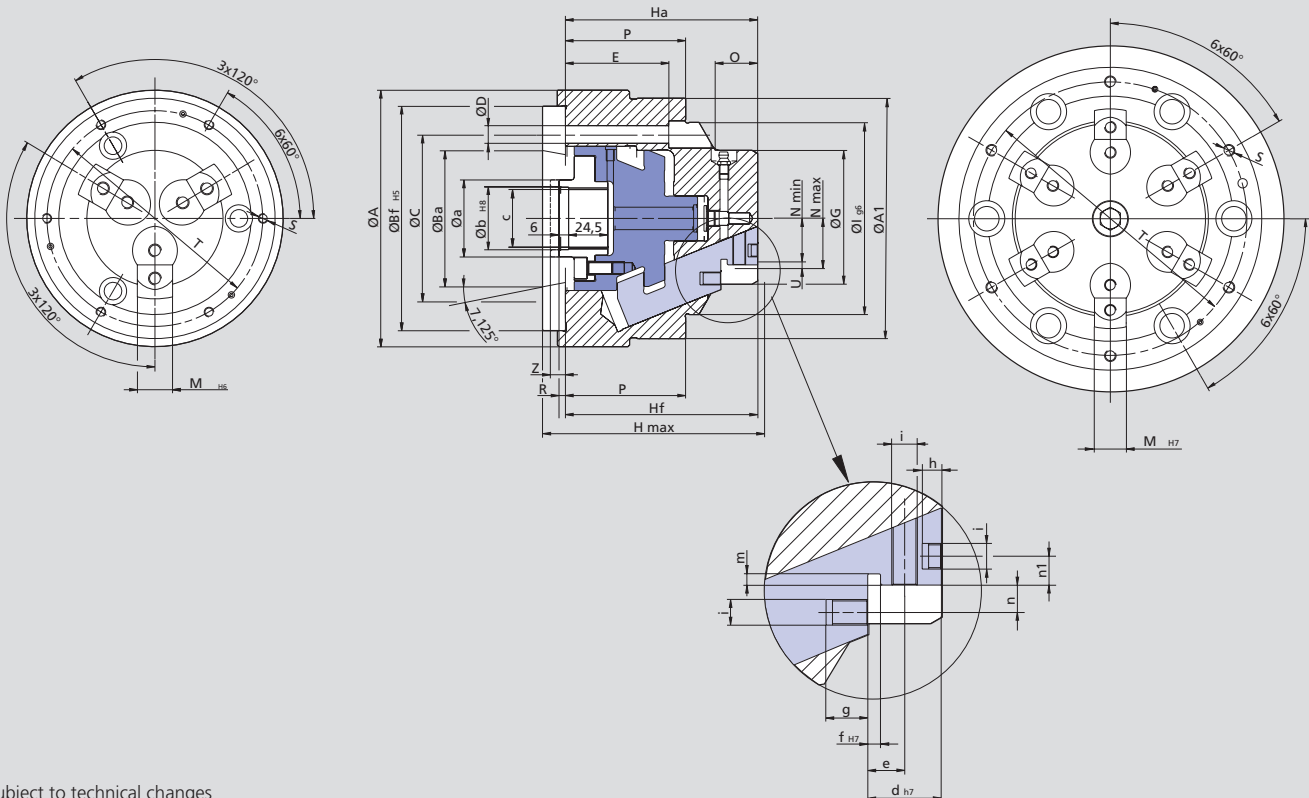
- pull down
- power operated via standard cylinders
- O.D. clamping

ACS-I 3/6

Self centering column chuck

ACS-I 130-160-200

ACS-I 240

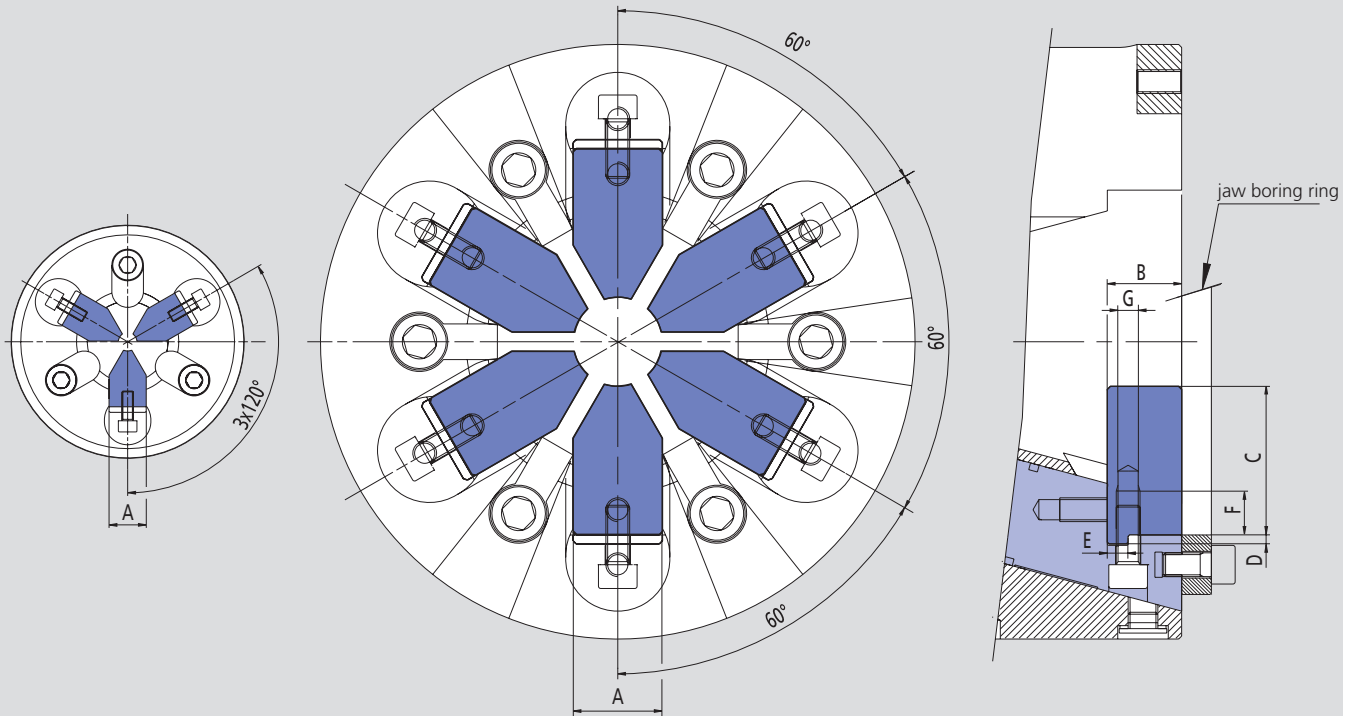


Subject to technical changes
For more detailed information please ask for customer drawing

2 media can be used through the chuck's bore.
Specials on request.

SMW-AUTOBLOK Type ACS-I	130	160	200	240
Number of jaws	3	3	3	6
Mounting	ISO-A4 FL 115	ISO-A5 FL 140	ISO-A6 FL 170	ISO-A8 FL 220
A/A1	130/130	160/150	200/170	240/210
Ba	63.513	82.563	106.375	139.719
Bf	115	140	170	220
C	82.6	104.8	133.4	171.4
D	11	11	13	17
E	55	64.5	62	68.5
G	59.5	85	103	136
H max.	130	140.5	147.5	154.5
Ha	125	135	142	149
Hf	112	120	125	130
I	90	120	140	170
M	24	22	22	22
N min/max	19.2/21.8	26.8/31.2	36.3/40.7	52.8/57.2
O	27.5	26.5	27	27
P	67	75	80	85
R	18	4	4	4
S	M6	M6	M6	M8
T	110	135	155	190
Stroke	U	2.6	4.4	4.4
Stroke	Z	10	11	11

a	36	48	48	48
b	29	39	39	39
c	M28x1.5	M38x1.5	M38x1.5	M38x1.5
d	20	23	23	23
e	9.5	11.5	11.5	11.5
f	4	4	4	4
g	12	13	13	13
h	-	6	6	6
i	M6	M8	M8	M8
m	3.5	3.5	3.5	3.5
n	7.5	8.5	8.5	8.5
n1	7.5	9	9	9
y	14	14	32	32

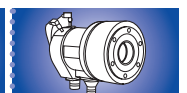
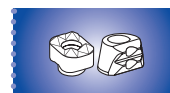


Material: 60MnSi4
HRC 56+2

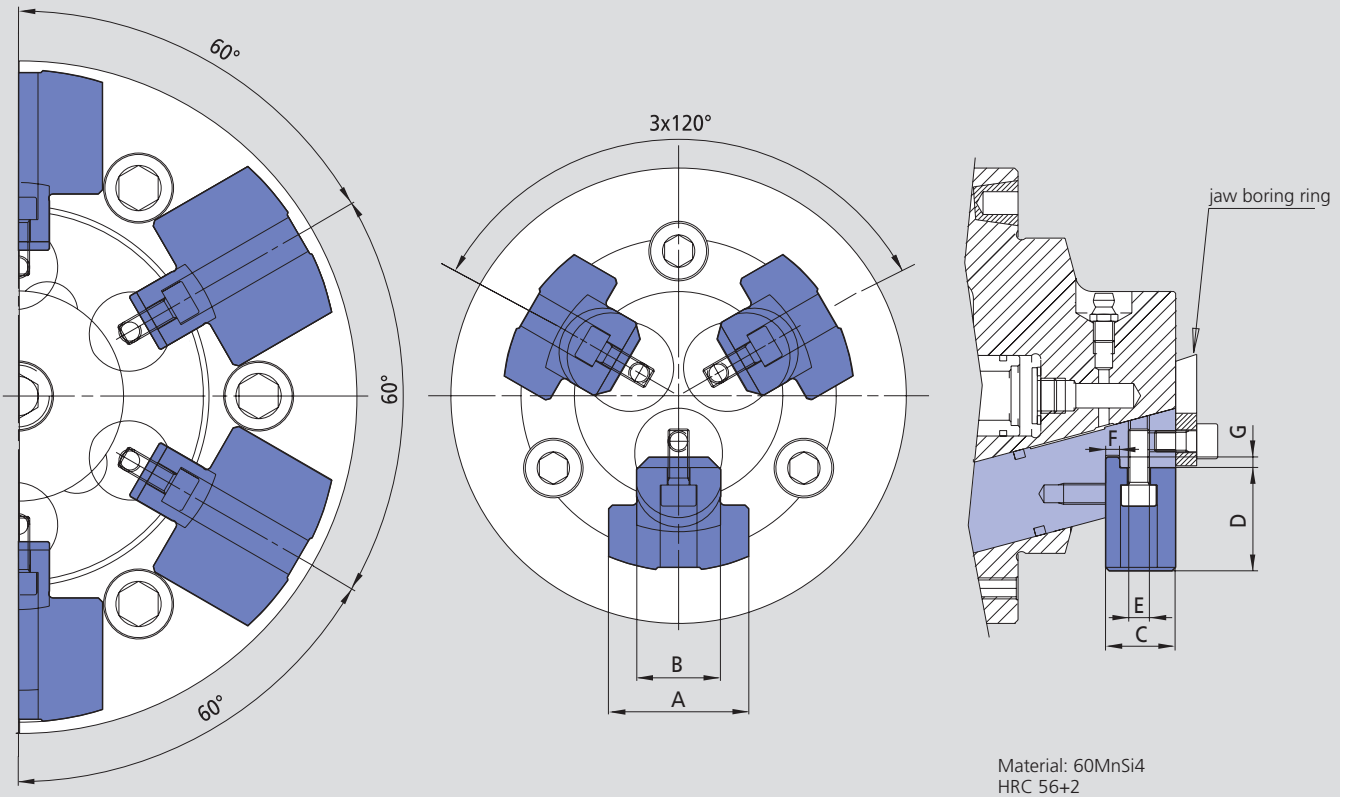
Subject to technical changes
For more detailed information please ask for customer drawing

Technical data

SMW-AUTOBLOK Type	ACS-E 130	ACS-E 145	ACS-E 170	ACS-E 200	ACS-E 200	ACS-E 220	ACS-E 220	ACS-E 254	ACS-E 254
Number of jaws	3	3	3	3	6	3	6	3	6
A h6	20	20	20	30	30	30	30	30	30
B	20	20	20	25	25	25	25	25	25
C	30	35	40	50	50	50	50	50	50
D	3	3	3	3	3	3	3	3	3
E g6	6	6	6	7	7	7	7	7	7
F	13	13	13	15	15	15	15	15	15
G	M6	M6	M6	M8	M8	M8	M8	M8	M8
rec. clamping range	min.	10	20	30	30	50	50	90	90
rec. clamping range	max.	50	70	95	100	125	125	165	165
Id. No. jaw blanks (1 set = 3 pcs.)	69761310	69761410	69761710	69762010	69762040	69762210	69762240	69762210	69762240
Id. No. boring ring	69111310	69111410	69111710	69112040	69112040	69112240	69112240	69112540	69112540



■ for 3 and 6 jaw chucks



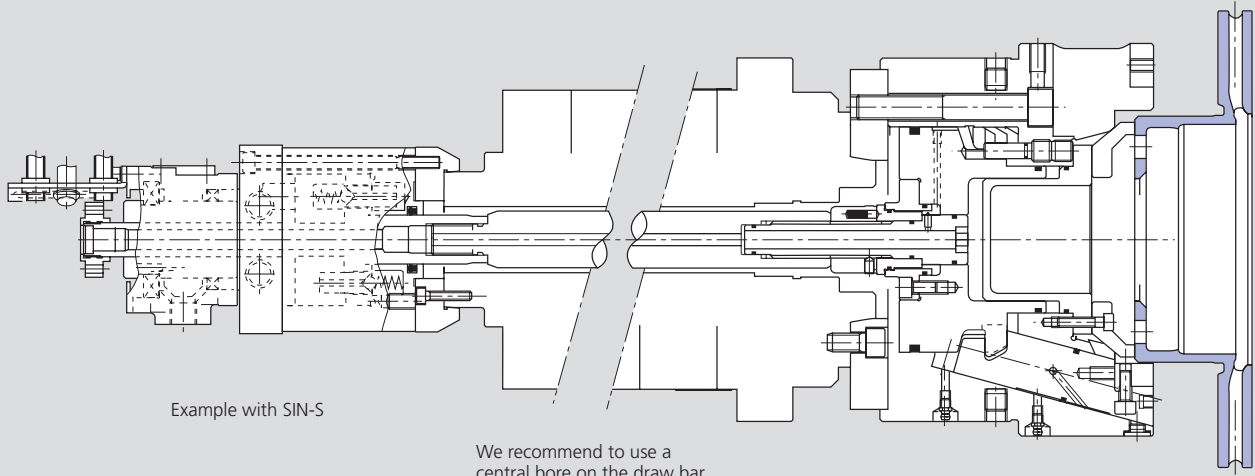
Subject to technical changes
For more detailed information please ask for customer drawing

SMW-AUTOBLOK Type		ACS-I 130	ACS-I 160	ACS-I 200	ACS-I 240
Number of jaws		3	3	3	6
	A	40	40	60	60
	B h6	24	22	22	22
	C	20	23	23	23
	D	20.5	41	61.5	61.5
	E	3xM6	3xM8	3xM8	6xM8
	F g6	4	4	4	4
	G	3	3	3	3
rec. clamping range	min.	65**	92	110	144
rec. clamping range	max.	100	140	200	232
Id. No. jaw blanks (1 set = 3 pcs.)		69761360	69761660*	69762060*	69762490*
Id. No. boring ring		69111360	69111660	69112060	69112490

* identical for size 160-200-240
** min. 60 with special jaws

Examples

ACS-E

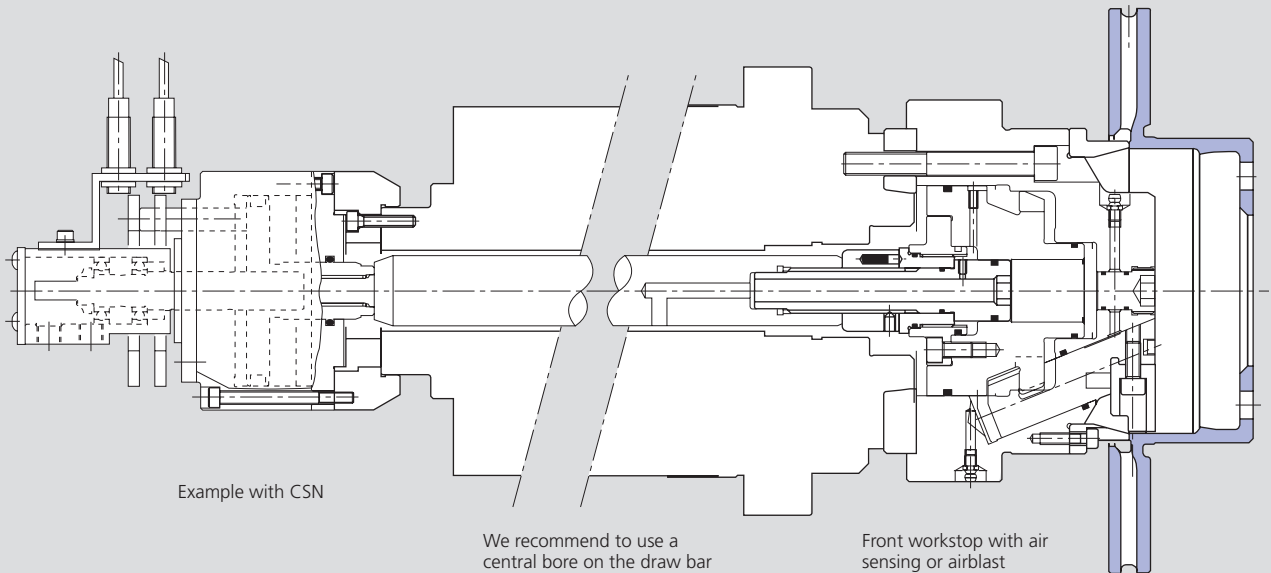


Example with SIN-S

We recommend to use a central bore on the draw bar

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

ACS-I



Example with CSN

We recommend to use a central bore on the draw bar

Front workstop with air sensing or airblast

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