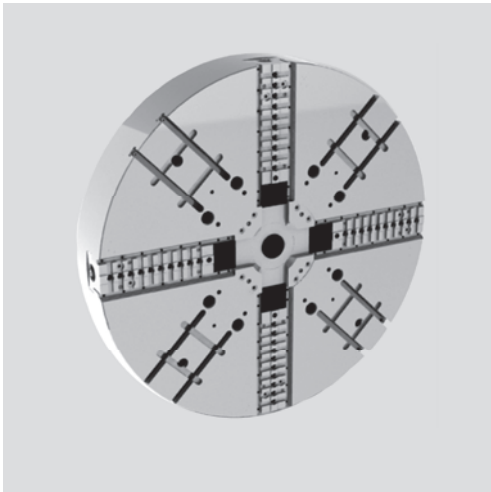


- Radial setting of jaws
- closed center
- 4 jaws (all diameters)



Application/customer benefits

- Clamping of large square and irregular parts using 2 or 4 jaws self centering
- Suitable for vertical machines thanks to the front protection of the slide ways
- Manual radial setting of master jaws
- Tongue & groove (type "American Standard")

Technical features

- Gripping force transmission via wedge hook
- Manual radial setting of master jaws for 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

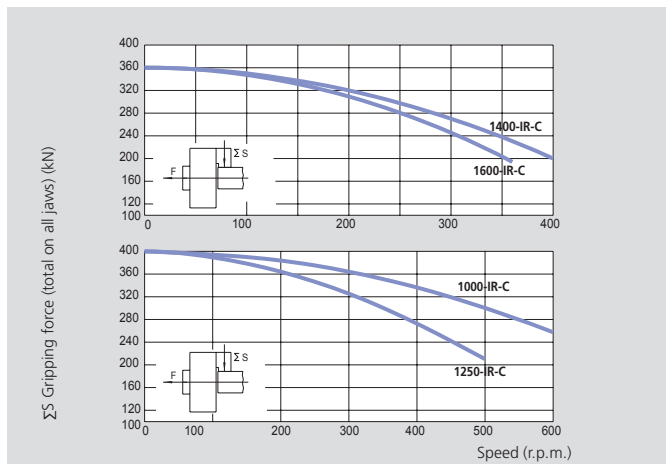
Standard equipment

4 jaws chuck
1 set of soft top jaws
mounting bolts and grease gun

Ordering example

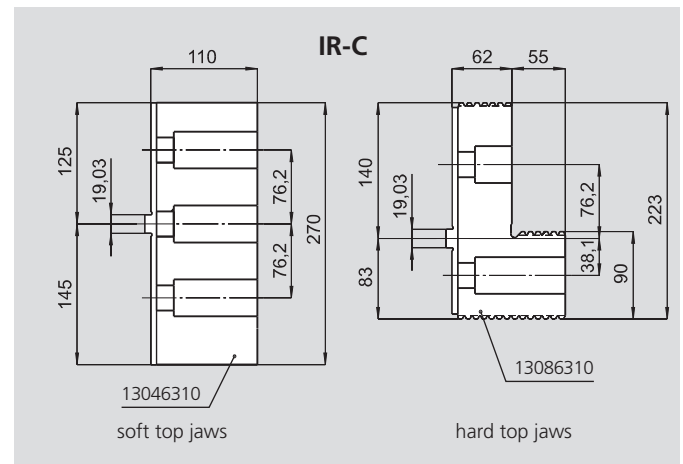
4 jaw chuck IR-C 1600/Z720

Actual gripping force diagrams



The data in the diagrams refer to 4-jaw-chucks, newly maintained according to their service manuals using SMW-AUTOBLOK 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 IR-C

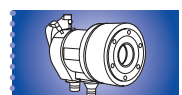


△ Safety advice/danger of damage:

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 1000	IR-C 1250	IR-C 1400	IR-C 1600	IR-C 2000
Radial jaw stroke + (manual setting)	mm	23 + (30)	23 + (30)	24 + (40)	24 + (40)	24 + (40)
Axial piston stroke	mm	57	57	60	60	60
Max. draw pull	kN	180	180	200	200	200
Max. gripping force	kN	320	320	360	360	360
Max. speed	r.p.m.	550	450	380	340	280
Weight (without top jaws)	kg	660	900	1425	1765	2730
Moment of inertia	kg·m ²	84	178	347	562	1360
Hard top jaw (piece)	Id. No.	13086310	13086310	13086310	13086310	13086310
Soft top jaw (piece)	Id. No.	13046310	13046310	13046310	13046310	13046310
Recommended actuating cylinders		SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250



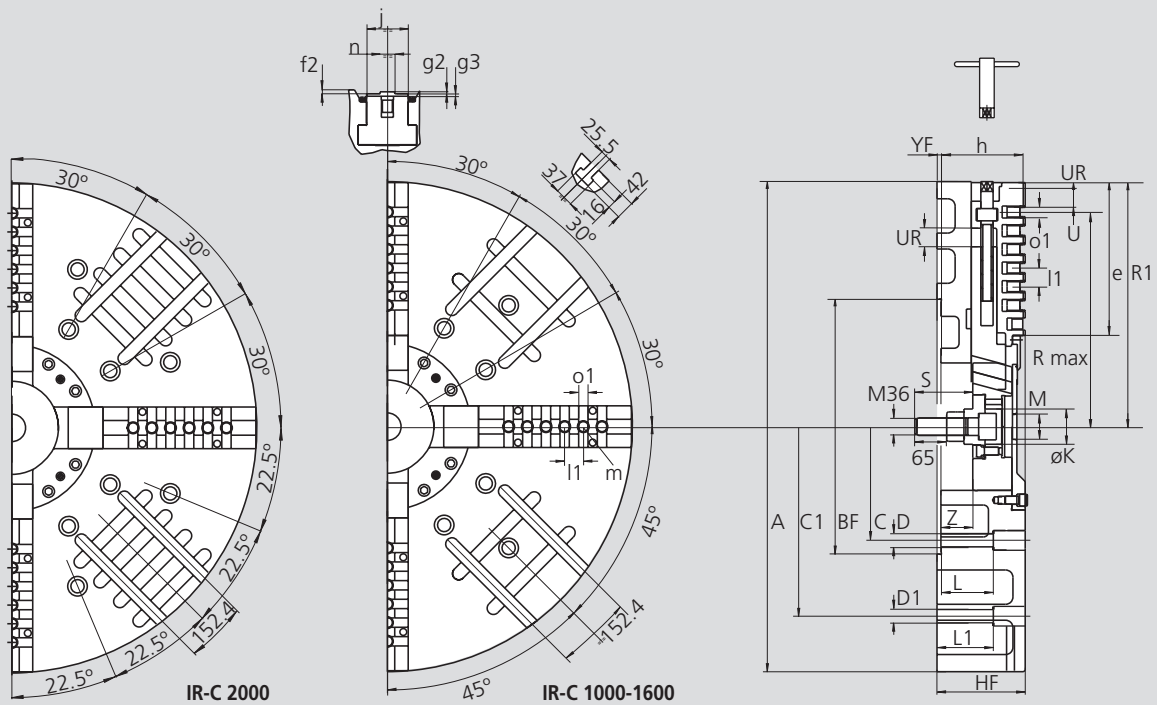
High precision power chucks Ø 1000 - 2000 mm

- Radial setting of jaws
- closed center
- 4 jaws (all diameters)

IR-C

Tongue & groove

1



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

SMW-AUTOBLOK Type	IR-C 1000		IR-C 1250		IR-C 1400	IR-C 1600	IR-C 2000
	Z520	A20	Z520	A20	Z720	Z720	Z720
Mounting							
A	mm	1005	1250	1400	1600	2000	
Bf	H6 mm	520	520	720	720	720	
C	mm	463.6	463.6	647.6	647.6	647.6	
C1	mm	700*	700*	1110	1110	1110	
D	mm	27	27	33	33	33	
D1	mm	27*	27*	27	27	27	
HF	mm	200	200	240	240	260	
K	mm	72.5	72.5	72.5	72.5	72.5	
L	mm	146	146	179	179	199	
L1	mm	148*	148*	192	192	212	
M	mm	M52 x 1.5	M52 x 1.5	M52 x 1.5	M52 x 1.5	M52 x 1.5	
Chuck open	R1	mm	502	623	696	796	996
Chuck open	Rmax	mm	457	563	651	738	914
Radial stroke	U	mm	23	23	24	24	24
Setting stroke	UR	mm	30	30	40	40	40
	S	mm	118	118	118	118	118
	Yf	mm	8	8	8	8	8
max.	Z	mm	75	75	100	100	120
min.	Z	mm	18	18	40	40	40
	e	mm	295	416	446	539	739
	f1	mm	-	-	-	-	-
	f2	mm	8	8	8	8	8
	g2	mm	4	4	4	4	4
	g3	mm	7	7	7	7	7
	h	mm	184	184	224	224	244
	j	mm	85	85	110	110	110
	l1	mm	38.1	38.1	38.1	38.1	38.1
	m	mm	M24	M24	M24	M24	M24
	n/n1	h8 mm	30	30	30	30	30
	o1	H7 mm	19.03	19.03	19.03	19.03	19.03
Number of "o1" cross grooves			6	9	10	12	16
Number of "m" threads			7	9	11	13	17

*Only on request