

AP[®]-D

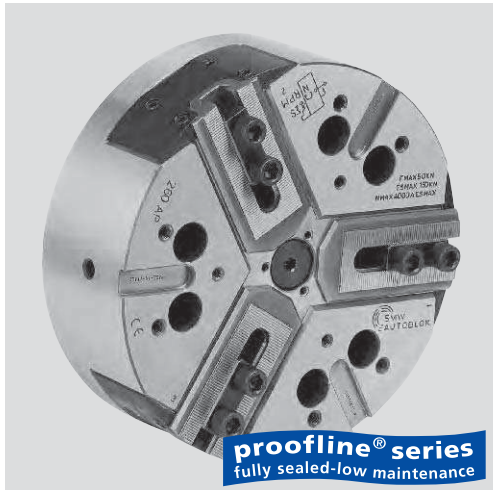
AP[®]-M

High precision power chucks Ø 170 - 400 mm

INCH serration

METRIC serration

- closed center
- 3 jaws
- **proofline[®]** chucks = fully sealed – low maintenance



Application/customer benefits

- For mid to large batch production
- Fully sealed, ideal for dry machining of castings and forgings or if high pressure coolant is used

AP-D: Master jaws with INCH serration (1/16" x 90°, 3/32" x 90°)

AP-M: Master jaws with METRIC serration (1.5 mm x 60°)
(suitable for japanese chuck jaws)

Technical features

- Constant gripping force with permanent grease lubrication
- Central bore for coolant and/or air
- Chuck body and internal parts case hardened
- **proofline[®]** chucks = fully sealed – low maintenance

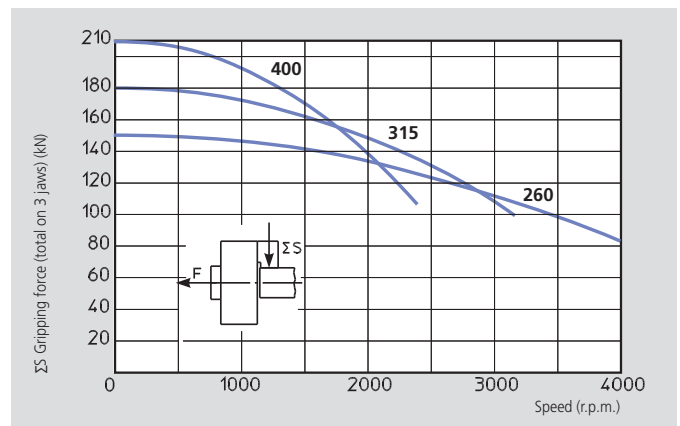
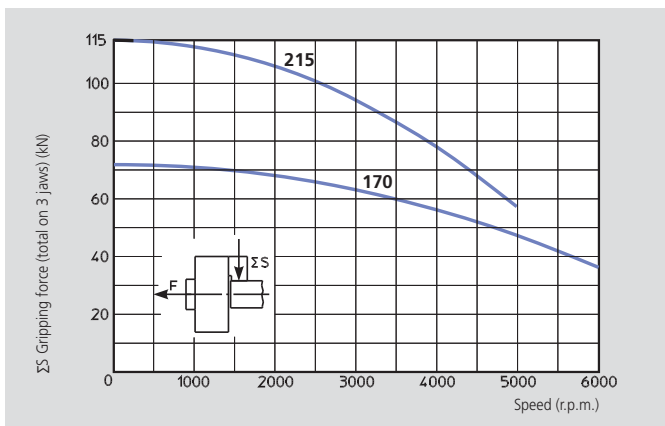
Standard equipment

- 3 jaw chuck
- 1 set T-nuts and bolts
- 1 set soft top jaws
- mounting bolts

Ordering example

- 3 jaw chuck AP-D 215/A6
- or
- 3 jaw chuck AP-M 260/Z220

Actual gripping force diagrams



The data in the diagrams refer to 3-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.

△ Safety advice/danger of damage:

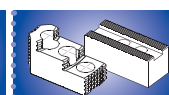
When using taller/heavier jaws and/or clamping on a bigger diameter reduce draw pull/rotating speed accordingly.

Technical data

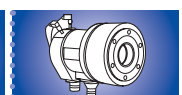
SMW-AUTOBLOK Type		AP-D 170 AP-M 170	AP-D 215 AP-M 215	AP-D 260 AP-M 260	AP-D 315 AP-M 315	AP-D 400 AP-M 400
Number of jaws		3	3	3	3	3
Radial jaw stroke	mm	3.6	4.6	5	6.3	7
Axial piston stroke	mm	17	22	24	30	33
Max. draw pull	kN	30	42	55	65	75
Max. gripping force	kN	72	112	150	180	210
Max. speed	r.p.m.	6000	5000	4000	3200	2400
Mass (without top jaws)	kg	10	19.5	32.5	56	90
Moment of inertia	kg·m ²	0.037	0.113	0.28	0.69	1.7
Recommended actuating cylinders		SIN-S 100	SIN-S 100/125	SIN-S 125/150	SIN-S 125/150	SIN-S 150/175



Page 282



Page 284



Page 197