

APL-D

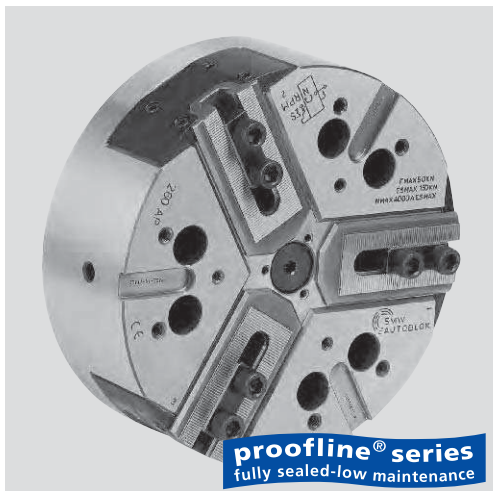
APL-M

High precision power chucks Ø 215 - 400 mm

- LONG STROKE
- closed center
- 3 jaws
- proffline® chucks = fully sealed – low maintenance

INCH serration

METRIC serration



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
- Large clamping range

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

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

Technical features

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

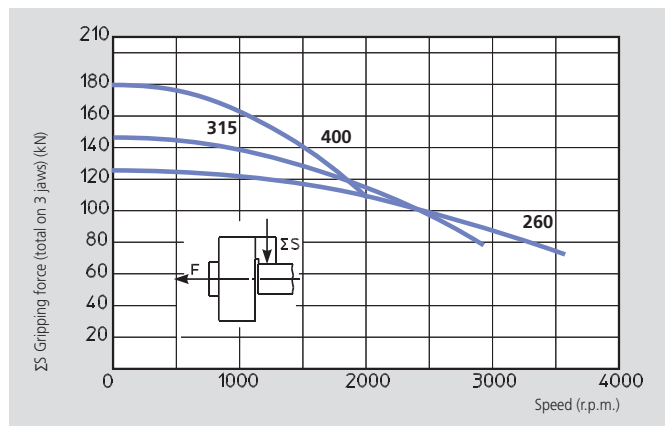
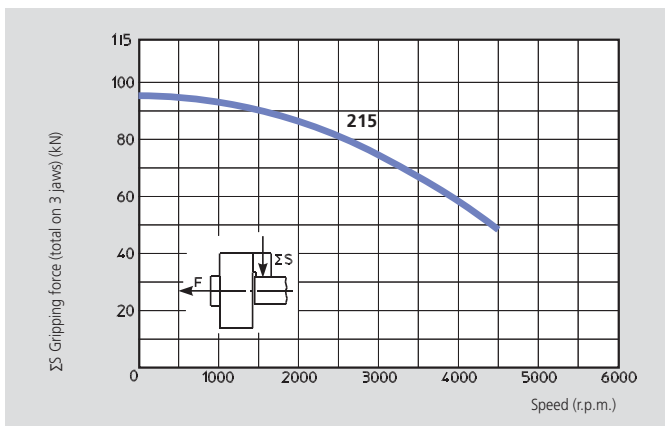
Standard equipment

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

Ordering example

- 3 jaw chuck APL-D 215/A6
- or
- 3 jaw chuck APL-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:

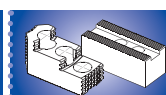
When using taller/heavier jaws and/or clamping on a bigger diameter reduce draw pull/rotating speed accordingly.

Technical data

SMW-AUTOBLOK Type		APL-D 215 APL-M 215	APL-D 260 APL-M 260	APL-D 315 APL-M 315	APL-D 400 APL-M 400
Radial jaw stroke	mm	8.5	9.7	12.1	13.3
Axial piston stroke	mm	21	24	30	33
Max. draw pull	kN	53	68	80	100
Max. gripping force	kN	95	125	145	180
Max. speed	r.p.m.	4500	3600	2800	2000
Mass (without top jaws)	kg	19.5	32.5	56	90
Moment of inertia	kg·m ²	0.113	0.28	0.69	1.7
Recommended actuating cylinders		SIN-S 100/125	SIN-S 125/150	SIN-S 125/150	SIN-S 150/175



Page 282



Page 284



Page 197