

# IN-D

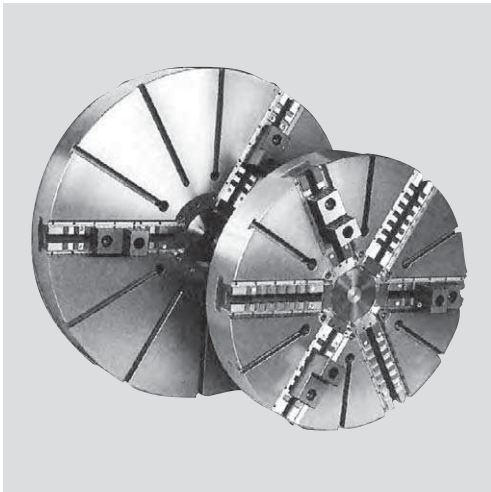
MODULE 2  
serrations

# IR-C

Tongue & groove  
Radial setting of jaws

## High precision power chucks Ø 1000 - 2000 mm

- closed center
- 3 and 6 jaws (all diameters)



### Application/customer benefits

- Chucking operations of very large components
- Suitable for vertical machines thanks to the front protection of the slide ways

**IN-D:** MODULE 2 serrated master jaws (pitch 6.28 mm) (Ø 1000 and 1250 mm)

**IR-C:** manual radial setting of master jaws, tongue & groove (type "American Standard") (all diameters)

### Technical features

- Gripping force transmission via wedge hook
- Front protection of the slide ways against swarf and chips penetration
- IR-C chucks with manual radial setting of master jaws for the workpiece centering

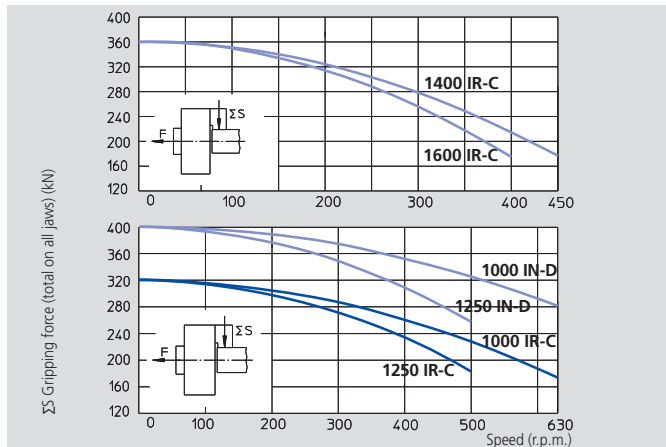
### Standard equipment

- 3 or 6 jaws chuck
- 1 set T-nuts with bolts (not in IR-C)
- 1 set soft top jaws (not in IR-C) with cross keys, mounting bolts and grease gun

### Ordering example

- 3 jaw chuck IN-D 1000/A20
- or
- 6 jaw chuck IR-C 1600/Z720

### Actual gripping force diagrams

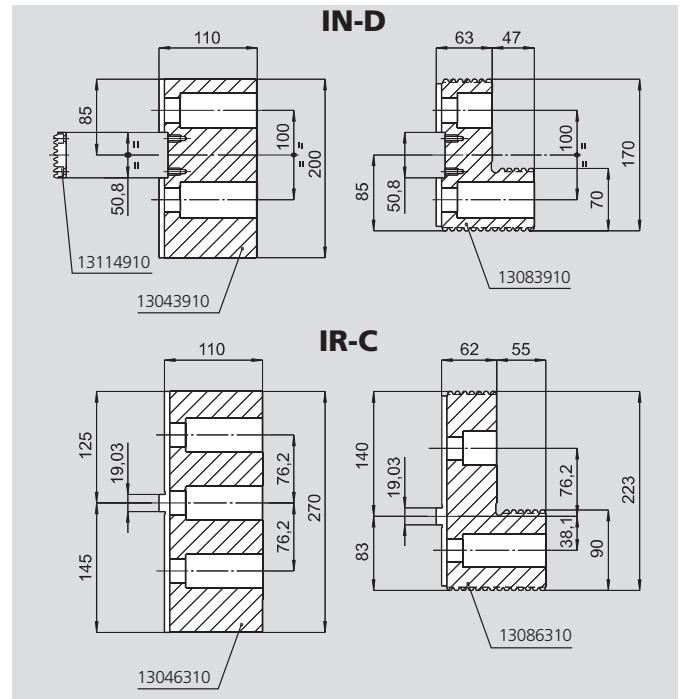


The data in the diagram refer to 3-jaw-chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K05 grease. The static and dynamic gripping forces have been measured using standard soft top jaws, placed in a position not exceeding the outer diameter of the chuck.

#### ▲ Safety advice/danger of damage:

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

### Soft and hard top jaws for IN-D and IR-C



### Technical data

SMW-AUTOBLOK Type	IN-D 1000		IN-D 1250		IR-C 1000		IR-C 1250		IR-C 1400		IR-C 1600		IR-C 2000		
	3	6	3	6	3	6	3	6	3	6	3	6	3	6	
Number of jaws	3		6		3		6		3		6		3		
Radial jaw stroke + (manual setting)	mm	15	15	23 + (30)	23 + (30)	24 + (40)	24 + (40)	24 + (40)	24 + (40)	24 + (40)	24 + (40)	24 + (40)	24 + (40)	24 + (40)	
Axial piston stroke	mm	57	57	57	57	60	60	60	60	60	60	60	60	60	
Max. draw pull	kN	180	180	180	180	200	200	200	200	200	200	200	200	200	
Max. gripping force	kN	400	400	320	320	360	360	360	360	360	360	360	360	360	
Max. speed	r.p.m.	630	500	500	450	630	450	500	360	450	320	400	280	320	230
Mass (without top jaws)	kg	600	800	600	800	1200	1600	2500							
Moment of inertia	kg·m <sup>2</sup>	68	145	68	145	280	500	1250							
Hard top jaw (piece)	p/n	13083910	13083910	13086310	13086310	13086310	13086310	13086310	13086310	13086310	13086310	13086310	13086310	13086310	
Soft top jaw (piece)	p/n	13043910	13043910	13046310	13046310	13046310	13046310	13046310	13046310	13046310	13046310	13046310	13046310	13046310	
Recommended actuating cylinders		SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	SIN-S 250	

