

IN-D

INCH serration

IN-C

Tongue & groove

High precision power chucks Ø 500 - 800 mm

- closed center
- 3 and 4 jaws

**Application/customer benefits**

- For large parts
- Suitable for vertical machines

IN-D: Master jaws with INCH serration (3/32" x 90°)**IN-C:** Tongue & groove master jaws**Technical features**

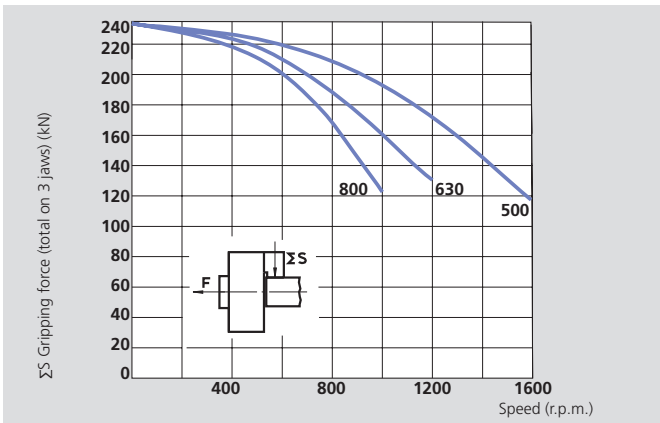
- Gripping force transmission via wedge hook
- Sealed against swarf and chips

Standard equipment

- 3 or 4 jaw chuck
- 1 set T-nuts with bolts
- 1 set soft top jaws (not IN-C)
- Mounting bolts
- Grease gun

Ordering example

- 3 jaw chuck IN-D 500/A15
- or
- 4 jaw chuck IN-C 630/Z380

Actual gripping force diagram

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.

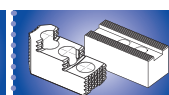
Technical data

SMW-AUTOBLOK Type		IN-D 500 IN-C 500		IN-D 630 IN-C 630		IN-D 800 IN-C 800	
		3	4	3	4	3	4
Number of jaws		3	4	3	4	3	4
Radial jaw stroke	mm	8.5	8.5	10	10	10	10
Axial piston stroke	mm	32	32	38	38	38	38
Max. draw pull*	kN	100	100	100	100	100	100
Max. gripping force*	kN	240	240	240	240	240	240
Max. speed	r.p.m.	1500	1200	1100	850	900	750
Weight (without top jaws)	kg	130	180	220	325	320	550
Moment of inertia	kg·m ²	4.2	5.9	10.8	16	23.8	44
Recommended actuating cylinders		SIN-S 150/175/200		SIN-S 150/175/200		SIN-S 150/175/200	

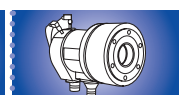
* For internal clamping reduce the draw pull by 30 %



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IN-D

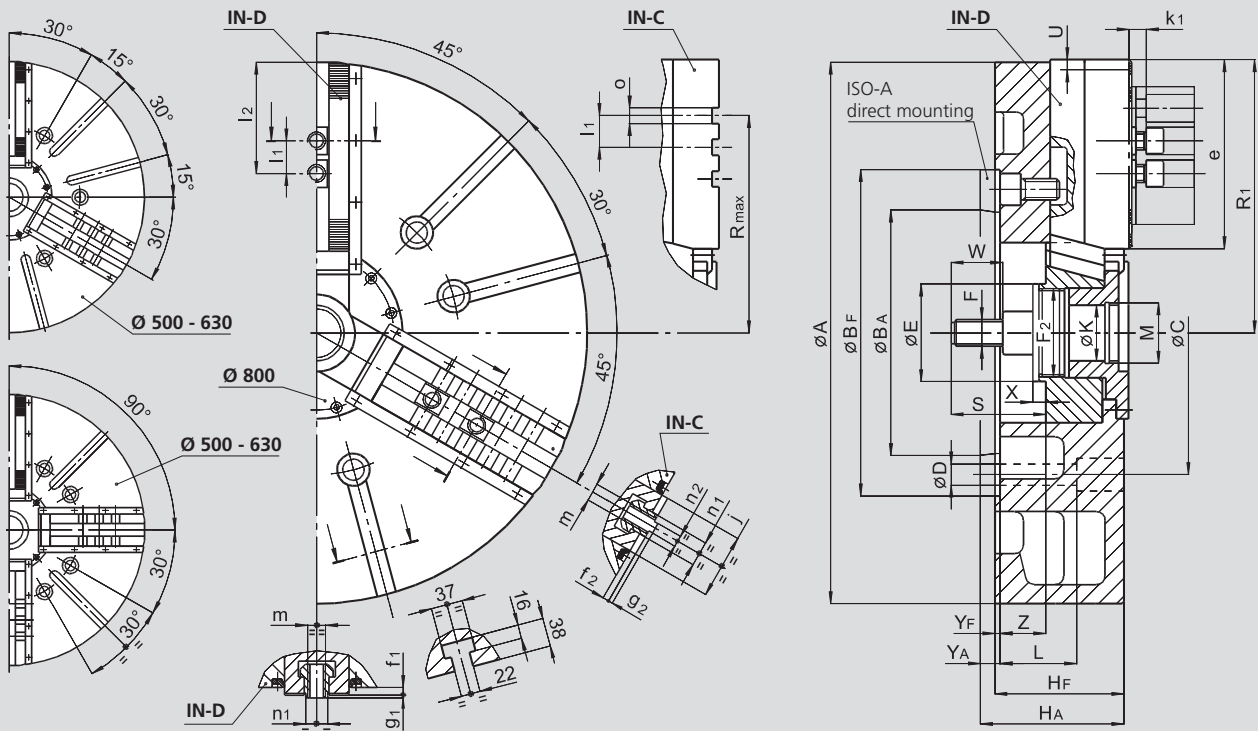
IN-C

- closed center
- 3 and 4 jaws

INCH serration

Tongue & groove

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

SMW-AUTOBLOK Type		IN-D 500 IN-C 500		IN-D 630 IN-C 630		IN-D 800 IN-C 800		
Mounting		Z380	A15	Z380	A15	Z380	A15	
	A	mm	510		630		800	
	Bf/BA H6	mm	380	380	285.775	380	285.775	
	C	mm	330.2		330.2		330.2	
	D	mm	25		25		25	
	E	mm	114		114		114	
	F	mm	M30		M30		M30	
	F2	mm	M102 x 2		M102 x 2		M102 x 2	
	Hf/HA	mm	130	147	150	167	150	167
	K	mm	65		65		65	
	L	mm	89		89		89	
	M	mm	M68 x 2		M68 x 2		M68 x 2	
Chuck open	R1	mm	263		318		405	
	Rmax	mm	209.5		247.5		349	
	S	mm	110		110		110	
Stroke per jaw	U	mm	8.5		10		10	
	W	mm	60		60		60	
	X	mm	15		15		15	
	Yf/YA	mm	6	23	6	23	6	23
max./min.	Z	mm	33/1		53/15		53/15	
	e	mm	165		220		307	
	f1	mm	9		9		9	
	f2	mm	8		8		8	
	g1	mm	4		4		4	
	g2	mm	3		3		3	
	j	mm	75		75		75	
	k1	mm	16		16		16	
	l1	mm	38.1		38.1		38.1	
max./min.	l2	mm	135/48		190/48		277/48	
	m	mm	M20		M20		M20	
	n1	h8 mm	25.5		25.5		25.5	
	n2	h8 mm	12.7		12.7		12.7	
	o	H7 mm	19.03		19.03		19.03	