

IEP-D

2+2+2 movement
INCH serration

IEP-C

2+2+2 movement
Tongue & groove

High precision 6 jaw chucks 2+2+2 equalising Ø 500 - 800 mm

- closed center
- Equalising mechanism lockable



Application/customer benefits

- Clamping of thin walled workpieces
- Low radial deformation with 2+2+2 clamping
- Suitable for horizontal and vertical machines

IEP-D: Master jaws with INCH serration (3/32" x 90° all sizes)

IEP-C: Master jaws with Tongue & groove

Technical features

- Adjustable to 6 jaw 2+2+2 or true 6 jaw clamping
- Possibility to regulate the equalizing stroke from full for OP10 to very small for OP20
- Constant gripping force with permanent lubrication
- Centrifugal compensation for high spindle speed
- **proofline® chucks** = fully sealed – low maintenance

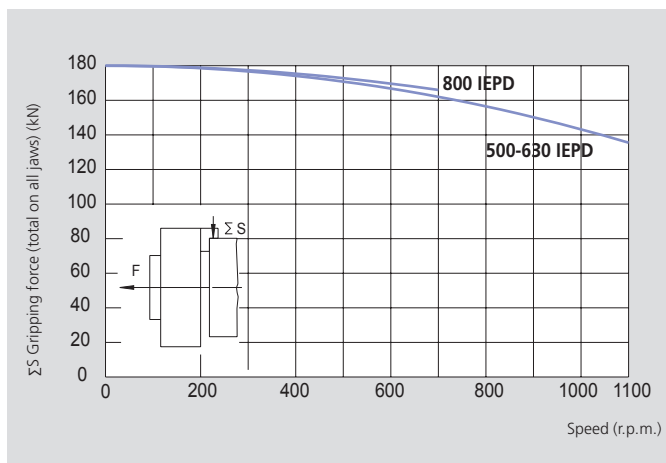
Standard equipment

- chuck with mounting bolts
- 1 set of soft top jaws
- 1 equalizing stroke regulating key

Ordering example

IEP-D 500/Z380

Actual gripping force diagram



The data in the diagram refer to 6-jaw-chucks, newly maintained according to their service manuals using the original oil. 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:

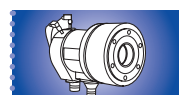
When using taller/heavier jaws and/or clamping on a bigger diameter reduce draw pull/rotating speed accordingly.

Technical data

SMW-AUTOBLOK Type		IEP-D 500	IEP-C 500	IEP-D 630	IEP-C 630	IEP-D 800	IEP-C 800
Number of jaws		2+2+2		2+2+2		2+2+2	
Radial jaw stroke	mm	15		15		15	
Jaw compensation	mm	±4		±4		±4	
Axial piston stroke	mm	30		30		30	
Max. draw pull**	kN	120		120		120	
Max. gripping force**	kN	180		180		180	
Max. speed	r.p.m.	1100		800		650	
Weight (without top jaws)	kg	260		410		670	
Moment of inertia	kg·m ²	8.5		20		55	
Hard top jaw (set of 3) for IEP-D	Id. No.	12084546		12084546		12084546	
Soft top jaw (piece) for IEP-D	Id. No.	12074040		12075050		12075050	
Soft top jaw (piece) for IEP-C	Id. No.	12044050		12045050		12045050	
Recommended actuating cylinders		SIN-S 150/175/200		SIN-S 150/175/200		SIN-S 150/175/200	

* 2 sets (=6 pieces) per chuck are required

** For internal clamping reduce the draw pull by 30 %



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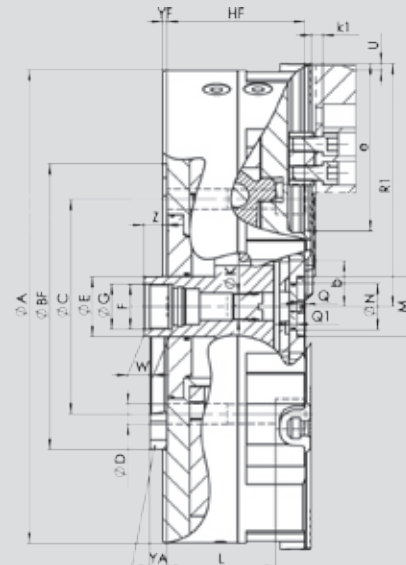
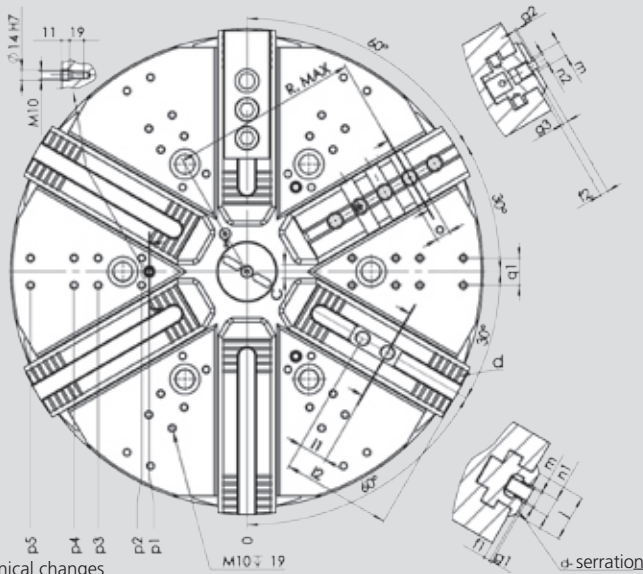
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Subject to technical changes
For more detailed information please ask for customer drawing

ISO-A direct
mounting

SMW-AUTOBLOK Type			IEP-D 500	IEP-C 500	IEP-D 630	IEP-C 630	IEP-D 800	IEP-C 800
	A	mm	510	510	630	630	800	800
	Bf	H6 mm	380	380	380	380	520	520
	C	mm	330.2	330.2	330.2	330.2	463.6	463.6
	D	mm	25.5	25.5	25.5	25.5	25.5	25.5
	E	mm	80	80	80	80	80	80
	F	mm	M60 x 1.5	M60 x 1.5	M60 x 1.5	M60 x 1.5	M60 x 1.5	M60 x 1.5
	G	H8 mm	61	61	61	61	61	61
	Hf	mm	184	184	184	184	184	184
Through hole	K	mm	33	33	33	33	33	33
	L	mm	144	144	144	144	144	144
	M	mm	M80 x 2	M80 x 2	M80 x 2	M80 x 2	M80 x 2	M80 x 2
	N	H8 mm	62	62	62	62	62	62
	Q	mm	10	10	10	10	10	10
	Q1	mm	10	10	10	10	10	10
Chuck open	R1	mm	263.5	263.5	323.5	323.5	408.5	408.5
Jaw stroke	U	mm	15	15	15	15	15	15
	W	mm	38	38	38	38	38	38
max/min.	Z	mm	61/31	61/31	61/31	61/31	61/31	61/31
min.	b	mm	46.5	46.5	46.5	46.5	46.5	46.5
min.	c	mm	3.5	3.5	3.5	3.5	3.5	3.5
	d	inch	3/32" x 90°	-	3/32" x 90°	-	3/32" x 90°	-
	e	mm	174	174	234	234	319	319
	f1	mm	8		8		8	
	f2	mm		11		11		11
	g1	mm	3.5		3.5		3.5	
	g2	mm		3		3		3
	g3	mm		6.5		6.5		6.5
	j	mm	63	63	63	63	63	63
	k1	mm	15.5	15.5	15.5	15.5	15.5	15.5
	l1	mm	38	38	38	38	38	38
max./min.	l2	mm	138/54	138/54	198/54	198/54	283/54	283/54
	m	mm	M20	M20	M20	M20	M20	M20
	n1	h8 mm	25.5		25.5		25.5	
	n2	mm		12.7		12.7		12.7
	o	mm	-	19.03	-	19.03	-	19.03
Radial position	p1	mm	130	130	130	130	130	130
Radial position	p2	mm	140	140	140	140	140	140
Radial position	p3	mm	-	-	198	198	215	215
Radial position	p4	mm	230	230	230	230	230	230
Radial position	p5	mm	-	-	288	288	305	305
	q1	mm	36	36	36	36	36	36
	Rmax	mm		198		250		351
	Yf/YA	mm	6 23	6 23	6 23	6 23	6 23	6 23
Number of cross grooves (IEP-C)			2		3		6	