

- compensating jaw clamping
- face driver with fixed or spring loaded center
- proofline® chucks = fully sealed – low maintenance



Application/customer benefits

- Complete machining of shafts in one operation
- The rough machining is done with compensating jaws clamping
- Finish machining of the complete outline with the face driver at retracted jaws

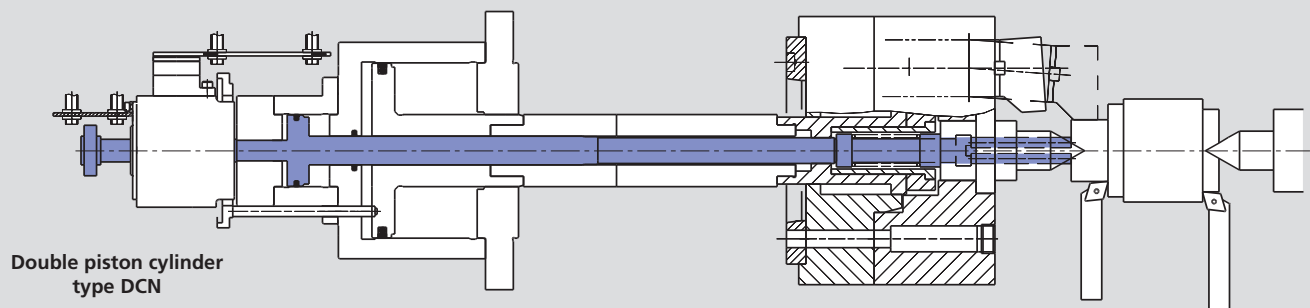
Technical features

- Retractable jaws
- Compensating jaws clamping
- Face driver adjustable with adjusting wedges
- Center point fixed or spring loaded
- Pull down of the work piece to the axial reference, ensures high position accuracy
- Case hardened internal parts
- Constant grease lubrication
- **proofline® chucks** = fully sealed – low maintenance

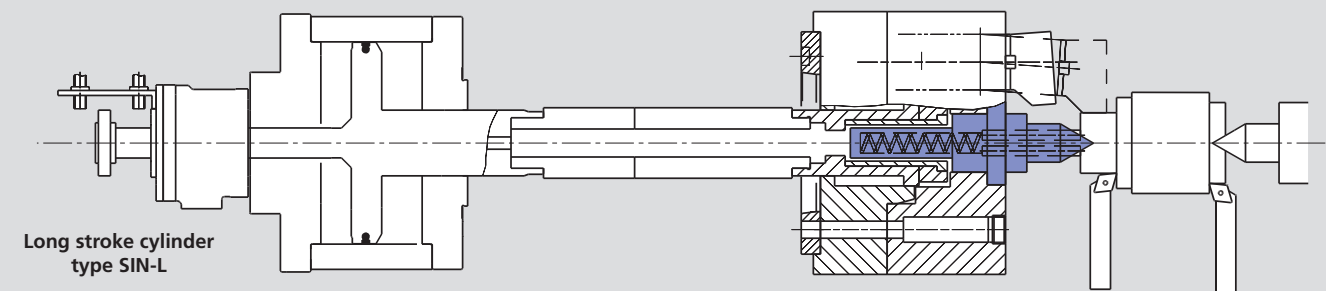
Standard equipment

Shaft chuck without face driver
with mounting bolts

Axial reference in the center point - power operated face driver Actuation via double piston cylinder type DCN



Axial reference on the component face - spring operated face driver Actuation via long stroke cylinder type SIN-L



Technical data

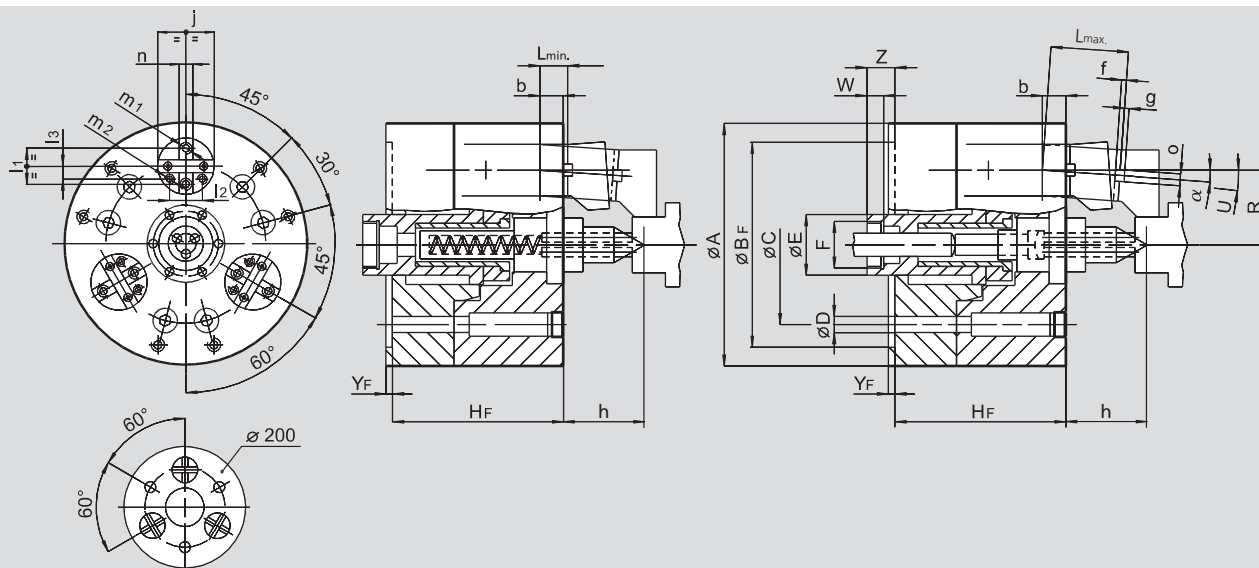
SMW-AUTOBLOK Type		GSA 200	GSA 260	GSA 320
Number of jaws		3	3	3
Angular jaw stroke	deg.	5°	5°	5°
Radial jaw stroke at distance h	mm	9	10	11.5
Compensation at distance h	mm	±0.8	±1	±1
Wedge stroke (total)	mm	57.5	66.5	77.6
Max. draw-push	kN	40	60	80
Max. gripping force at distance h	kN	40	65	100
Max. speed	r.p.m.	4500	4000	3200
Weight (without top jaws)	kg	30	55	100
Moment of inertia	kg·m²	0.15	0.46	1.28
Recommended actuating cylinders:				
- Axial reference in the center bore		DCN 125/30 70/25	DCN 125/30 70/25	DCN 125/30 87/40 DCN 170/40 95/50
- Axial reference on the component face		SIN-L 125	SIN-L 150	SIN-L 150

Shaft turning chuck Ø 200 - 320 mm

- compensating jaw clamping
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GSA

Shaft chuck with retractable jaw
Face driver



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

SMW-AUTOBLOK Type			GSA 200	GSA 260	GSA 320
Jaw pivoting	A	mm	200	260	320
	BF	H6 mm	170	220	280
	C	mm	146	171.4	235
	D	mm	17	17	21
	E	mm	50	61	75
	F	mm	M38 x 1.5	M50 x 1.5	M56 x 2
	HF	mm	160	183	215
	Lmin.	mm	24	25	33
	Lmax.	mm	74	83	98
	R	mm	60	80	102.5
	U	deg.	5°	5°	5°
	W	mm	18	18	18
	YF	mm	6	6	6
	Zmin.	mm	25	27	15.4
	Zmax.	mm	82.5	93.5	93
Reference distance	b	mm	24	25	32
	f	mm	4	5	5
	g	mm	3	3	3
	h	mm	80	90	105
	j	mm	48	55	65
	l1	mm	32	35	42
	l2	mm	27	32	35
	l3	mm	12	12.5	16
	m1	mm	M10	M12	M16
	m2	mm	M8	M10	M12
	n	H7 mm	12.68	12.68	12.68
	o	h7 mm	12.68	12.68	12.68
	α	deg.	3°	3°	3°

ISO-A flanges for GSA chucks

FF 1 - direct ISO-A mounting	FF 2 - reduction ISO-A mounting	FF 3 - increase ISO-A mounting	GSA chuck size	Spindle	Type	Id. No.	A	BF	BA	C	C1	T
			200	A5	2	24152050	-	170	82.563	104.8	146	24
			200	A6	2	24162050	-	170	106.375	133.4	146	24
			200	A8	3	24182050	210	170	139.719	171.4	146	40
			260	A6	2	24162530	-	220	106.375	133.4	171.4	24
			260	A8	1	24182500	-	220	139.719	171.4	-	19
			260	A11	3	24112510	280	220	196.869	235	171.4	45
			320	A8	2	24183500	-	280	139.719	171.4	235	30
			320	A11	1	24113500	-	280	196.869	235	-	21

