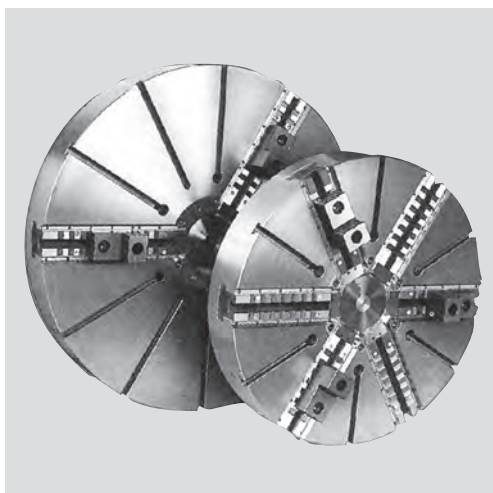


- Radial setting of jaws
- closed center
- 3 and 6 jaws (all diameters)



Application/customer benefits

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

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

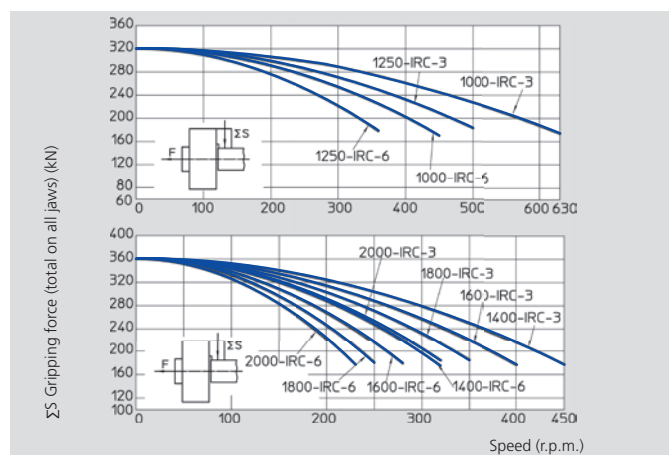
Standard equipment

3 or 6 jaws chuck
1 set T-nuts with bolts
1 set soft top jaws
mounting bolts and grease gun

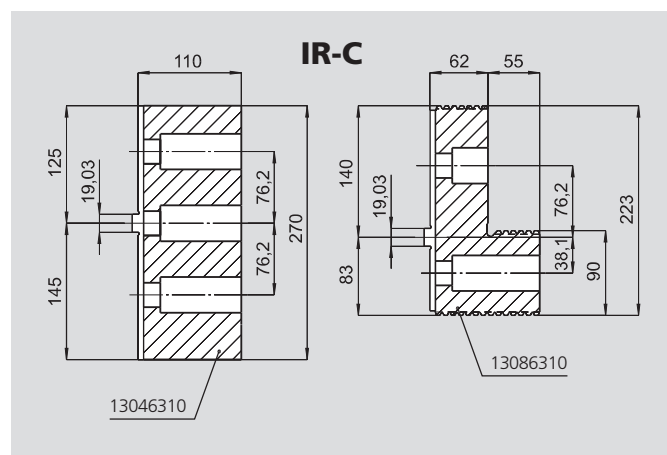
Ordering example

6 jaw chuck IR-C 1600/Z720

Actual gripping force diagrams



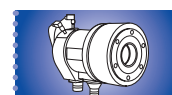
The data in the diagram refer to 3-6 jaw-chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K05 grease. The static and dynamic gripping forces have been measured using standard soft top jaws, placed in a position not exceeding the outer diameter of the chuck.



⚠ Safety advice/danger of damage:

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

SMW-AUTOBLOK Type		IR-C 1000		IR-C 1250		IR-C 1400		IR-C 1600		IR-C 1800		IR-C 2000	
Number of jaws		3	6	3	6	3	6	3	6	3	6	3	6
Radial jaw stroke + (manual setting)	mm	23 + (30)		23 + (30)		24 + (40)		24 + (40)		24 + (40)		24 + (40)	
Axial piston stroke	mm	57		57		60		60		60		60	
Max. draw pull	kN	180		180		200		200		200		200	
Max. gripping force	kN	320		320		360		360		360		360	
Max. speed	r.p.m.	630 450		500 360		450 320		400 280		350 250		320 230	
Weight (without top jaws)	kg	600		800		1200		1600		1800		2500	
Moment of inertia	kg·m ²	68		145		280		500		750		1250	
Hard top jaw (piece)	Id. No.	13086310		13086310		13086310		13086310		13086310		13086310	
Soft top jaw (piece)	Id. No.	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	



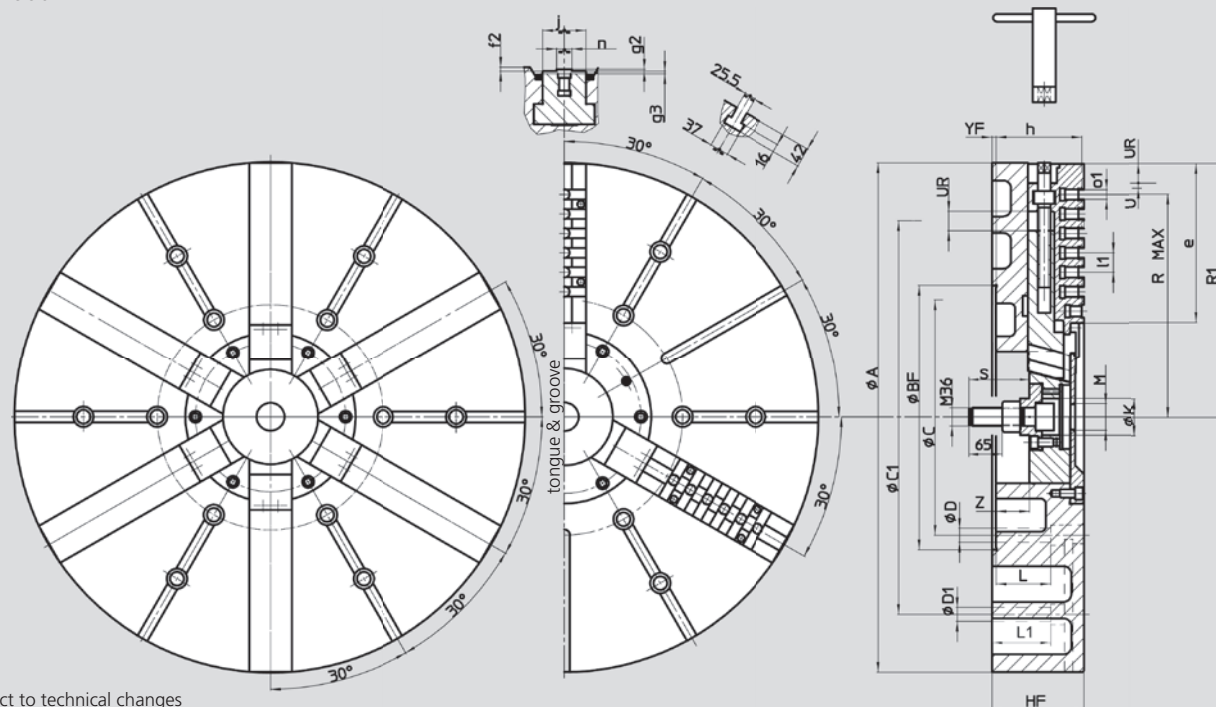
High precision power chucks Ø 1000 - 2000 mm

- Radial setting of jaws
- closed center
- 3 and 6 jaws (all diameters)

IR-C

Tongue & groove

6 jaw version



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

SMW-AUTOBLOK Type			IR-C 1000		IR-C 1250		IR-C 1400	IR-C 1600	IR-C 1800	IR-C 2000
Mounting			Z520	A20	Z520	A20	Z720	Z720	Z720	Z720
A		mm	1005		1250		1400	1600	1800	2000
Bf	H6	mm	520		520		720	720	720	720
C		mm	463.6		463.6		647.6	647.6	647.6	647.6
C1		mm	700*		700*		1110	1110	1110	1110
D		mm	27		27		33	33	33	33
D1		mm	27		27		27	27	27	27
Hf		mm	184		184		222	222	222	240
K		mm	72		72		72	72	72	72
Chuck open	L	mm	108		108		139	139	139	159
Chuck open	L1	mm	116*		116*		154	154	154	172
Radial stroke	M	mm	M52 x 1.5		M52 x 1.5		M52 x 1.5	M52 x 1.5	M52 x 1.5	M52 x 1.5
Setting stroke	R1	mm	502		623		696	796	896	996
	Rmax	mm	457		563		657	738	838	914
	U	mm	23		23		24	24	24	24
	UR	mm	30		30		40	40	40	40
	Yf	mm	8		8		8	8	8	8
max.	Z	mm	59		59		82	82	82	100
min.	Z	mm	2		2		22	22	22	40
	e	mm	295		416		446	546	639	739
	f2	mm	8		8		8	8	8	8
	g2	mm	4		4		4	4	4	4
	g3	mm	7		7		7	7	7	7
	h	mm	168		168		206	206	206	224
	j	mm	85		85		110	110	110	110
	l1	mm	38.1		38.1		38.1	38.1	38.1	38.1
	m	mm	M24		M24		M24	M24	M24	M24
	n/n1	h8	30		30		30	30	30	30
	o1	H7	19.03		19.03		19.03	19.03	19.03	19.03
Number of 01 cross grooves			6		9		10	12	14	16
Number of "m" threads			7		10		11	13	15	17

* on request only