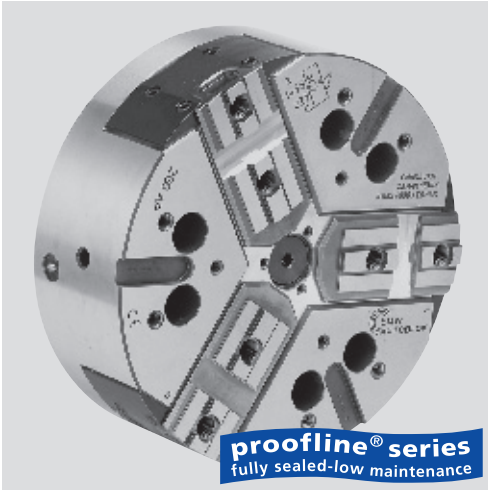


- closed center
- 3 jaws
- proofline[®] chucks = fully sealed – low maintenance



Application/customer benefits

- For large batch production
- Fully sealed, ideal for dry machining of castings and forgings or if high pressure coolant is used

AP-C: Tongue & groove master jaws (American Standard)

Technical features

- Constant gripping force with permanent grease lubrication
- Central bore for coolant and/or air
- Chuck body and internal parts case hardened
- **proofline[®] chucks** = fully sealed – low maintenance

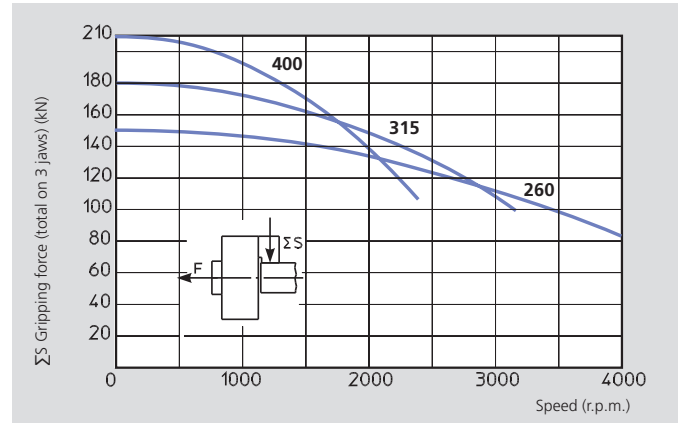
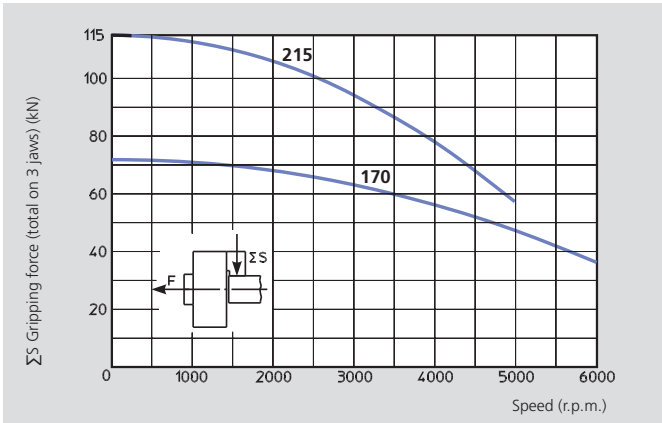
Standard equipment

3 jaw chuck
mounting bolts

Ordering example

3 jaw chuck AP-C 215/A6

Actual gripping force diagrams



The data in the diagrams refer to 3-jaw-chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K67 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		AP-C 170	AP-C 215	AP-C 260	AP-C 315	AP-C 400
Number of jaws		3	3	3	3	3
Radial jaw stroke	mm	3.6	4.6	5	6.3	7
Axial piston stroke	mm	17	22	24	30	33
Max. draw pull*	kN	30	42	55	65	75
Max. gripping force*	kN	72	112	150	180	210
Max. speed	r.p.m.	6000	5000	4000	3200	2400
Weight (without top jaws)	kg	10	19.5	32.5	56	90
Moment of inertia	kg·m ²	0.037	0.113	0.28	0.69	1.7
Recommended actuating cylinders		SIN-S 100	SIN-S 100/125	SIN-S 125/150	SIN-S 125/150	SIN-S 150/175

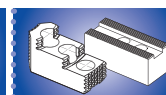
* For internal clamping reduce the draw pull by 30 %



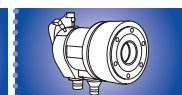
on request:
Tooling Standard
Parts Catalog



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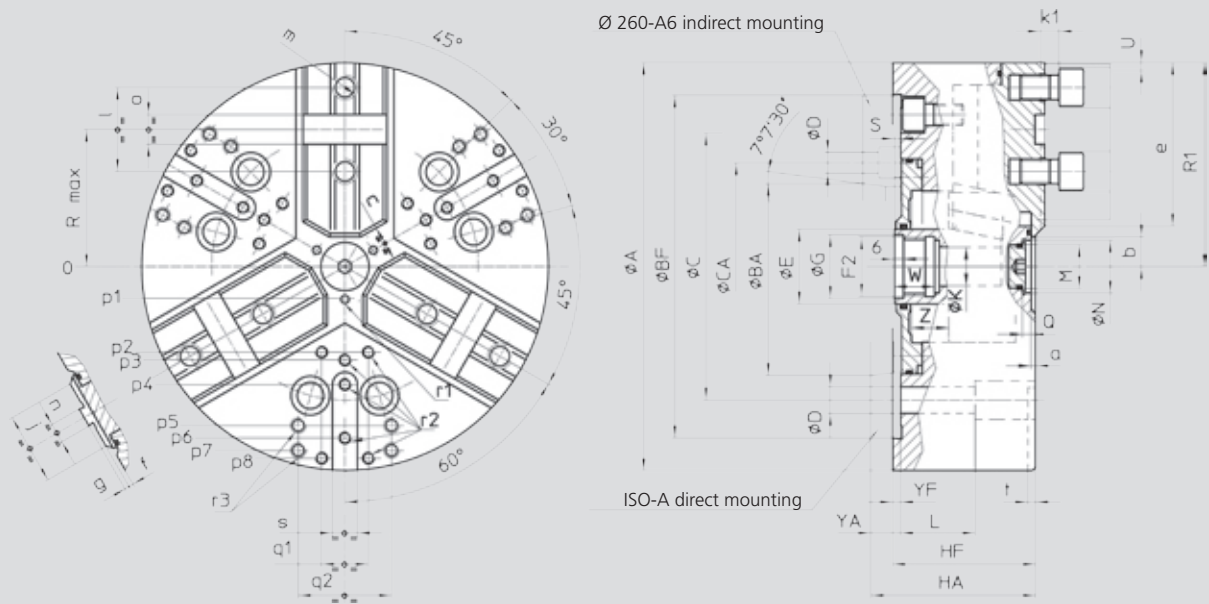
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High precision power chucks Ø 170 - 400 mm

AP[®]-C

- closed center
- 3 jaws
- proofline[®] chucks = fully sealed – low maintenance

Tongue & groove



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

SMW-AUTOBLOK Type	AP-C 170		AP-C 215		AP-C 260			AP-C 315		AP-C 400			
	Z140	A5	Z170	A6	Z220	A6	A8	Z220	A8	Z300	A11		
Mounting													
A	mm	172	216		262			315		390			
Bf/BA H6	mm	140	82.563	170	106.375	220	106.375	139.719	220	139.719	300	196.869	
C	mm	104.8		133.4			171.4		235				
CA	mm	-	-	-	-	-	133.4	-	-	-	-		
D	mm	11.5		13.5			17		21				
E	mm	32		42			48		75				
F2	mm	M24 x 2		M32 x 1.5			M38 x 1.5		M60 x 1.5				
G H8	mm	25		33			39		61				
Hf/HA	mm	68	78	81	93	92	111	106	101	115	112	127	
K	mm	18.5		20			25		48				
L	mm	23		32			38		54				
M	mm	M22 x 1.5		M22 x 1.5			M28 x 1.5		M52 x 1.5				
N H9	mm	24		24			34		60				
Q	mm	5.5		5.5			5.5		9				
Chuck open max.	R1	mm	86.5	108			131		157.5		195		
max./min.	R	mm	56	72			88		105		133.5		
Radial jaw stroke	S	mm	21/4	26/4			28/4		34/4		37/4		
	U	mm	3.6	4.6			5		6.3		7		
	W	mm	22	26			26		26		38		
max./min.	Yf/YA	mm	5	15	5	17	5	24	19	5	19	6	21
	Z	mm	17/0		22/0			24/0		30/0		33/0	
min.	a	mm	3		3			3		3		3	
min.	b	mm	8.5		12			14		16.5		31	
	c	mm	9		13			14		16		38	
	e	mm	70		87			107		129		150	
	f	mm	3		3			3		3		6	
	g	mm	3		3			3		3		3	
	j	mm	34		46			48		58		63	
	k1	mm	10		11			12		12		14	
	l	mm	38		44.4			54		63.5		76.2	
	m	mm	M10		M12			M16		M16		M20	
	n h8	mm	7.94		7.94			12.70		12.70		12.70	
	o H7	mm	12.68		12.68			19.03		19.03		19.03	
	p1	mm	16		16			21		21		37.5	
	p2	mm	-		-			-		60		80	
	p3	mm	38		49			55		62.5		83	
	p4	mm	-		80			70		80		110	
	p5	mm	65		80			102		102		140	
	p6	mm	70		-			102		120		155	
	p7	mm	-		-			-		135		170	
	p8	mm	-		-			-		-		170	
	q1	mm	-		-			-		30		36	
	q2	mm	36		45			60		60		80	
	r1	mm	M5/7		M5/8			M6/10		M6/10		M6/12	
	r2	mm	M6/14		M8/17			M8/17		M8/17		M10/19	
	r3	mm	M8/17		M8/17			M10/19		M10/19		M12/22	
	s	mm	16		16			16		16		20	
	t	mm	5		5			5		5		5	