

**IL-D**

INCH serration

**IL-C**

Tongue &amp; groove

**High precision power chucks Ø 500 - 800 mm**

- LONG STROKE
- closed center
- 3 and 4 jaws

**Application/customer benefits**

- For large parts
- Suitable for vertical machines
- Long clamping stroke (possibility to clamp 1st and 2nd operation with the same jaws)

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

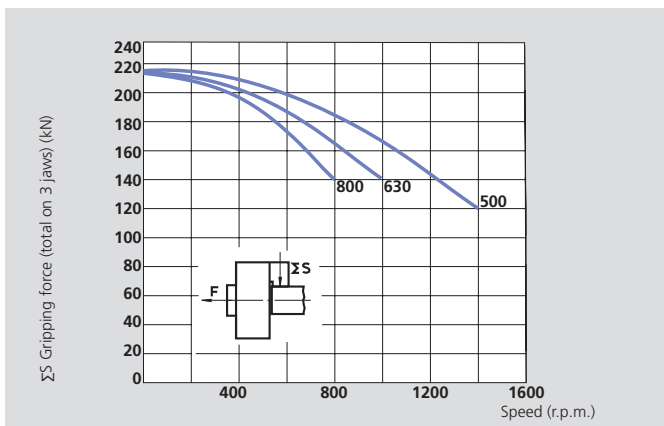
- Extra long stroke per jaw
- Gripping force transmission via wedge hook
- Sealed against swarf and chips

**Standard equipment**

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

**Ordering example**

3 jaw chuck IL-D 500/A15  
 or  
 4 jaw chuck IL-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.

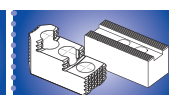
**Technical data**

SMW-AUTOBLOK Type		IL-D 500 IL-C 500		IL-D 630 IL-C 630		IL-D 800 IL-C 800	
		3	4	3	4	3	4
<b>Number of jaws</b>		3	4	3	4	3	4
<b>Radial jaw stroke</b>	mm	13	13	15	15	15	15
<b>Axial piston stroke</b>	mm	33	33	38	38	38	38
<b>Max. draw pull*</b>	kN	120	120	120	120	120	120
<b>Max. gripping force*</b>	kN	215	215	215	215	215	215
<b>Max. speed</b>	r.p.m.	1400	1100	1000	800	800	650
<b>Weight (without top jaws)</b>	kg	130	180	220	325	320	550
<b>Moment of inertia</b>	kg·m <sup>2</sup>	4.2	5.9	10.8	16	23.8	44
<b>Recommended actuating cylinders</b>		SIN-S 150/175/200		SIN-S 150/175/200		SIN-S 150/175/200	

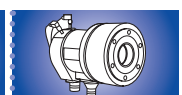
\* For internal clamping reduce the draw pull by 30 %



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- LONG STROKE
- closed center
- 3 and 4 jaws

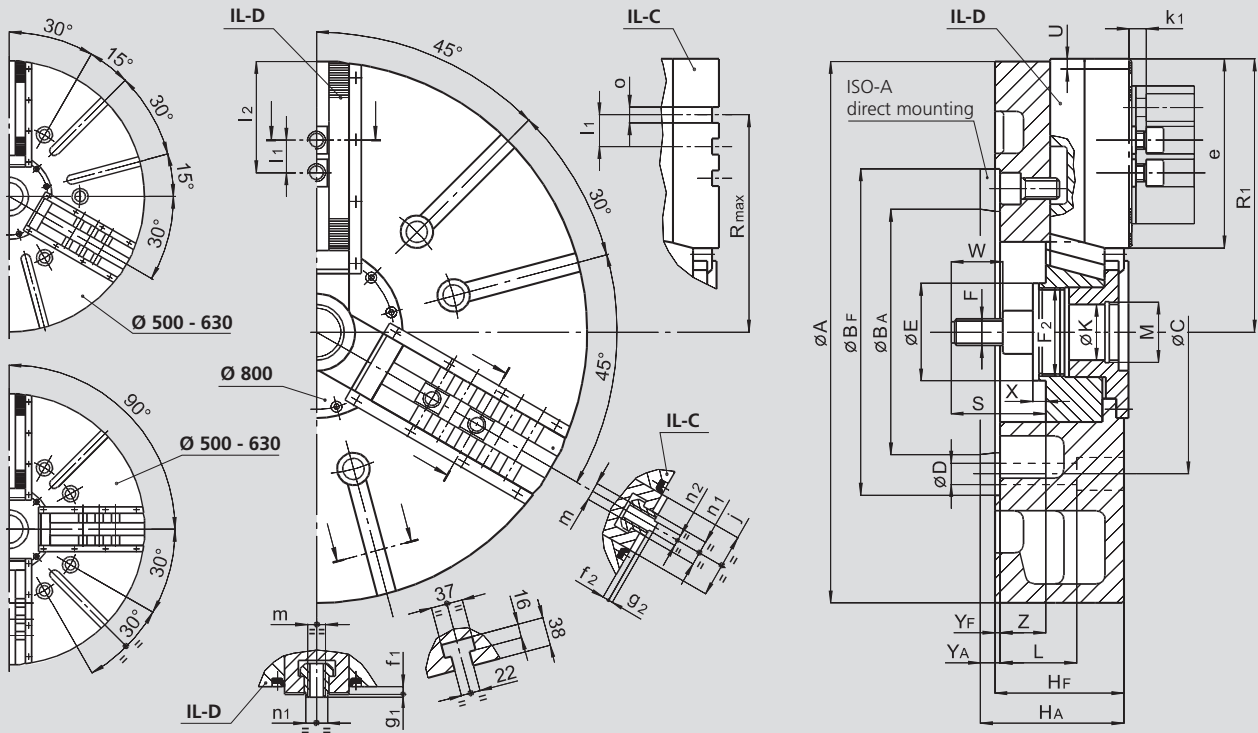
## IL-D

INCH serration

## IL-C

Tongue & groove

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

SMW-AUTOBLOK Type		IL-D 500 IL-C 500		IL-D 630 IL-C 630		IL-D 800 IL-C 800		
Mounting		Z380	A15	Z380	A15	Z380	A15	
	<b>A</b>	mm	510		630		800	
	<b>Bf/BA H6</b>	mm	380	380	285.775	380	285.775	
	<b>C</b>	mm	330.2		330.2		330.2	
	<b>D</b>	mm	25		25		25	
	<b>E</b>	mm	114		114		114	
	<b>F</b>	mm	M30		M30		M30	
	<b>F2</b>	mm	M102 x 2		M102 x 2		M102 x 2	
	<b>Hf/HA</b>	mm	130	147	150	167	150	167
	<b>K</b>	mm	65		65		65	
	<b>L</b>	mm	89		89		89	
	<b>M</b>	mm	M68 x 2		M68 x 2		M68 x 2	
Chuck open	<b>R1</b>	mm	265		321		408	
max.	<b>R</b>	mm	212		250		352	
	<b>S</b>	mm	110		110		110	
Jaw stroke	<b>U</b>	mm	13		15		15	
	<b>W</b>	mm	60		60		60	
	<b>X</b>	mm	15		15		15	
	<b>Yf/YA</b>	mm	6	23	6	23	6	23
max./min.	<b>Z</b>	mm	33/0		53/15		53/15	
	<b>e</b>	mm	164		220		307	
	<b>f1</b>	mm	9		9		9	
	<b>f2</b>	mm	8		8		8	
	<b>g1</b>	mm	4		4		4	
	<b>g2</b>	mm	3		3		3	
	<b>j</b>	mm	75		75		75	
	<b>k1</b>	mm	16		16		16	
max./min.	<b>l1</b>	mm	38.1		38.1		38.1	
	<b>l2</b>	mm	135/48		190/48		277/48	
	<b>m</b>	mm	M20		M20		M20	
	<b>n1</b> h8	mm	25.5		25.5		25.5	
	<b>n2</b> h8	mm	12.7		12.7		12.7	
	<b>o</b> H7	mm	19.03		19.03		19.03	