

# IN-D

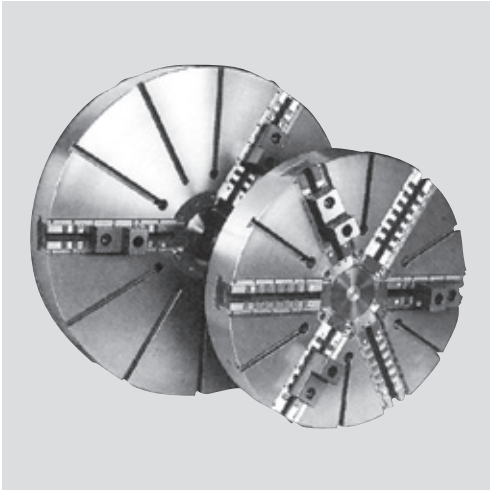
MODULE 2 serrations

# IL-D

Long jaw stroke  
MODULE 2 serration

## High precision power chucks Ø 1000 - 1600 mm

- 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

**IN-D/ IL-D:** MODULE 2 serrated master jaws (pitch 6.28 mm) (Ø 1000 - 1600 mm)

### Technical features

- Gripping force transmission via wedge hook
- Front protection of the slide ways against swarf and chips penetration

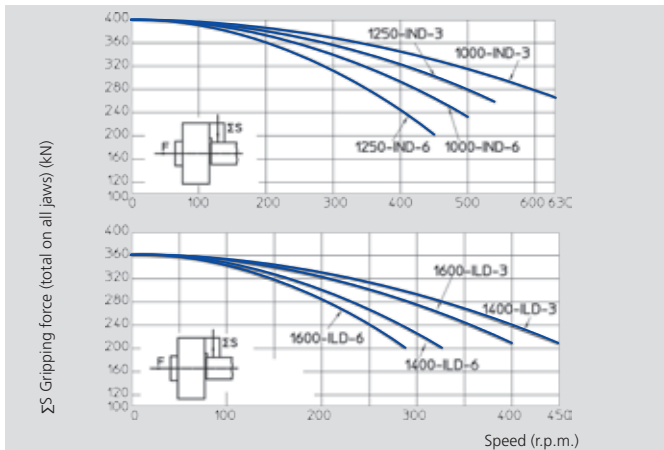
### Standard equipment

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

### Ordering example

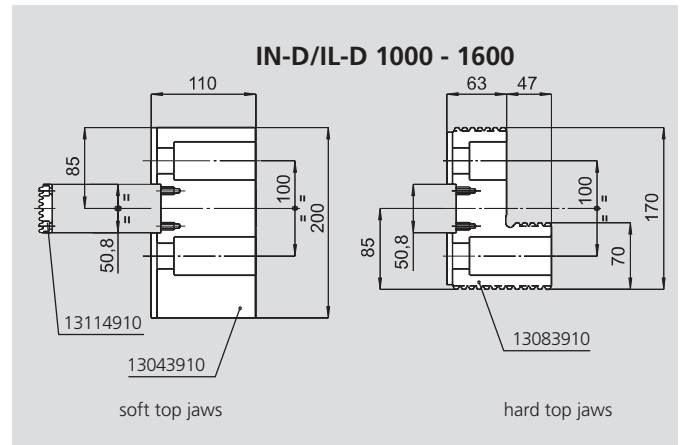
- 3 jaw chuck IL-D 1600/Z720
- or
- 6 jaw chuck IL-D 1600/Z720

### 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.

### Soft and hard top jaws for IN-D and IL-D



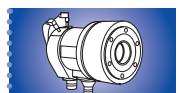
### △ Safety advice/danger of damage:

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

### Technical data

SMW-AUTOBLOK Type		IN-D 1000		IN-D 1250		IL-D 1400		IL-D 1600	
Number of jaws		3	6	3	6	3	6	3	6
Radial jaw stroke	mm	15		15		24		24	
Axial piston stroke	mm	57		57		60		60	
Max. draw pull*	kN	180		180		200		200	
Max. gripping force*	kN	400		400		360		360	
Max. speed	r.p.m.	630	500	500	450	450	320	400	280
Weight (without top jaws)	kg	600		800		1200		1600	
Moment of inertia	kg·m <sup>2</sup>	68		145		347		562	
Hard top jaw (piece)	Id. No.	13083910		13083910		13083910		13083910	
Soft top jaw (piece)	Id. No.	13043910		13043910		13043910		13043910	
Recommended actuating cylinders		SIN-S 250		SIN-S 250		SIN-S 250		SIN-S 250	

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



# High precision power chucks Ø 1000 - 1600 mm

## IN-D

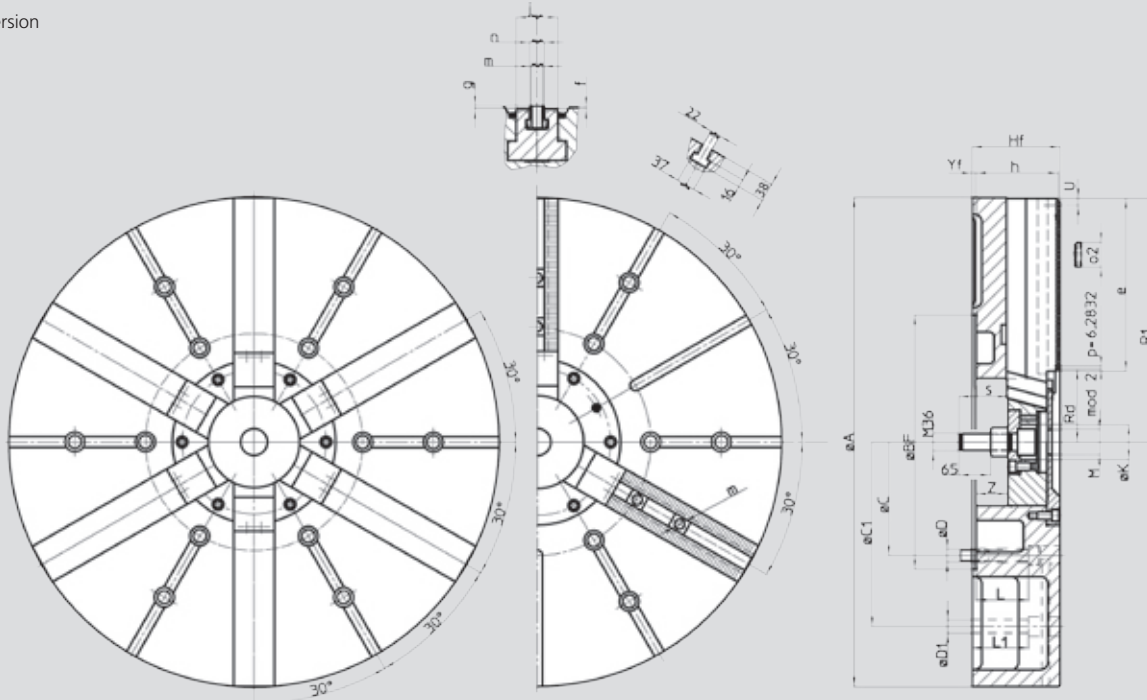
## IL-D

- closed center
- 3 and 6 jaws (all diameters)

MODULE 2  
serrations

Long jaw stroke  
MODULE 2 serration

6 jaw version



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

SMW-AUTOBLOK Type			IN-D 1000		IN-D 1250		IL-D 1400	IL-D 1600
Mounting			Z520	A20	Z520	A20	Z720	Z720
	A	mm	1005		1250		1400	1600
	Bf	H6 mm	520		520		720	720
	C	mm	463.6		463.6		647.6	647.6
	C1	mm	700*		700*		1110	1110
	D	mm	27		27		33	33
	D1	mm	27*		27*		27	27
	Hf	mm	184		184		222	222
	K	mm	72		72		72	72
	L	mm	108		108		179	179
	L1	mm	116*		116*		154	154
	M	mm	M52 x 1.5		M52 x 1.5		M52 x 1.5	M52 x 1.5
Chuck open	R1	mm	498		623		696	796
Chuck open	Rd	mm	148.5		148.5		179.5	179.5
Radial stroke	U	mm	15		15		24	24
	S	mm	100		100		100	100
	Yf	mm	8		8		8	8
max.	Z	mm	65		65		82	82
min.	Z	mm	8		8		22	22
	e	mm	353		478		519	619
	f	mm	8		8		8	8
	g	mm	4		4		4	4
	h	mm	168		168		206	206
	j	mm	85		85		110	110
	m	mm	M24		M24		M24	M24
	n	h8 mm	30		30		30	30
	o2	h6 mm	50.8		50.8		50.8	50.8

\* on request only