

# ACS-I 3/6

Self centering  
column chuck

## Self-centering column chucks with pull down

Ø 130-300 mm

- pull down
- power operated via standard cylinders
- i.D. clamping



### Application/customer benefits

- For small, medium and large quantities at high precision
- Pull down of the workpiece to the axial workstop during clamping
- Minimum loss of gripping force at high speed
- Standard, hardened jaw blanks available

### Technical features

- Chuck body completely case hardened
- Openings in the chuck body to evacuate chips
- Central bore for coolant/air

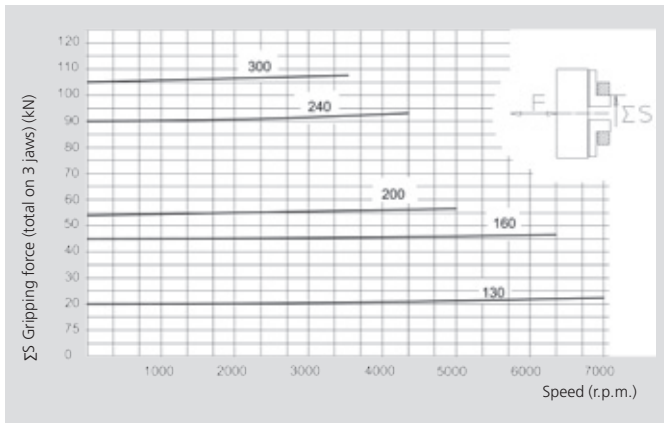
### Standard equipment

3 or 6-jaw chuck with mounting bolts

### Ordering example

3 jaw column chuck  
with center mounting Z115  
type ACS-I 130-3-Z115

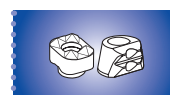
## Actual gripping force diagram



The diagrams refer to standard jaw blanks, machined to 50 % of their mass.

## Technical data

SMW-AUTOBLOK Type		ACS-I 130	ACS-I 160	ACS-I 200	ACS-I 240	ACS-I 300
<b>Number of jaws</b>		<b>3</b>	<b>3</b>	<b>3</b>	<b>6</b>	<b>6</b>
<b>Jaw stroke</b>	mm	2.6	4.4	4.4	4.4	4.4
<b>Piston stroke</b>	mm	10	11	11	11	11
<b>Actuating force</b>	kN	10	25	30	50	60
<b>Grip force</b>	kN	20	45	54	90	105
<b>Speed</b>	r.p.m.	7000	6300	5000	4300	3500
<b>Weight</b>	kg	10	12	20	30	55
<b>Moment of inertia</b>	kg·m <sup>2</sup>	0.02	0.03	0.1	0.2	-
<b>Clamping range</b>	min.	65	92	110	144	210
<b>Clamping range</b>	max.	100	140	200	232	280
<b>Recommended actuating cylinders</b>		<b>SIN-S 70</b> <b>SIN-S 85</b>	<b>SIN-S 85</b> <b>SIN-S 100</b>	<b>SIN-S 100</b> <b>SIN-S 125</b>	<b>SIN-S 125</b> <b>SIN-S 150</b>	<b>SIN-S 125</b> <b>SIN-S 150</b>
Id. No. chuck		77690613	77690616	77690620	77690624	77690930
Id. No. jaw blanks		69761360	69761660	69762060	69762490	69763090



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# Self-centering column chucks with pull down

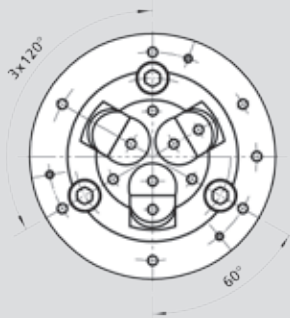
Ø 130-300 mm

- pull down
- power operated via standard cylinders
- I.D. clamping

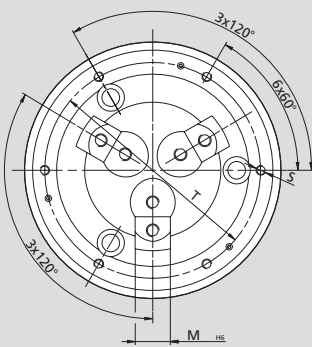
# ACS-I 3/6

Self centering column chuck

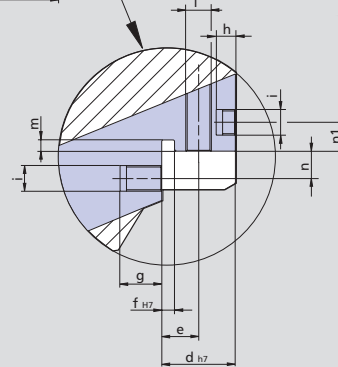
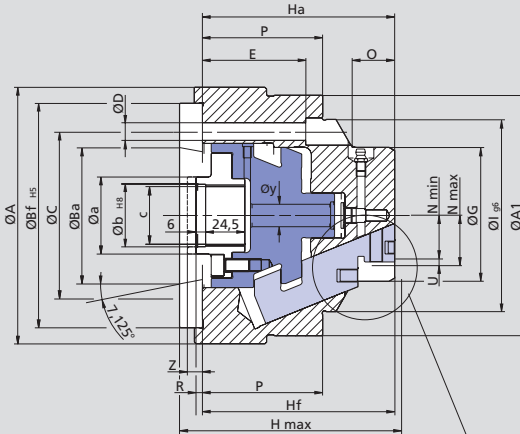
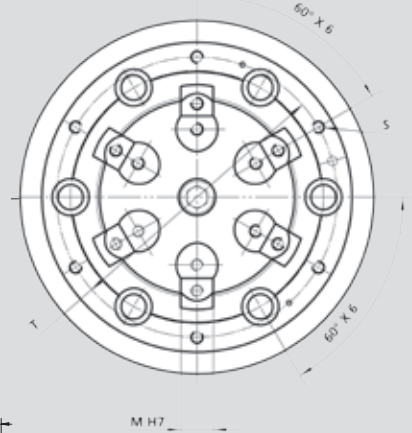
ACS-I 130



ACS-I 160-200



ACS-I 240 - 300



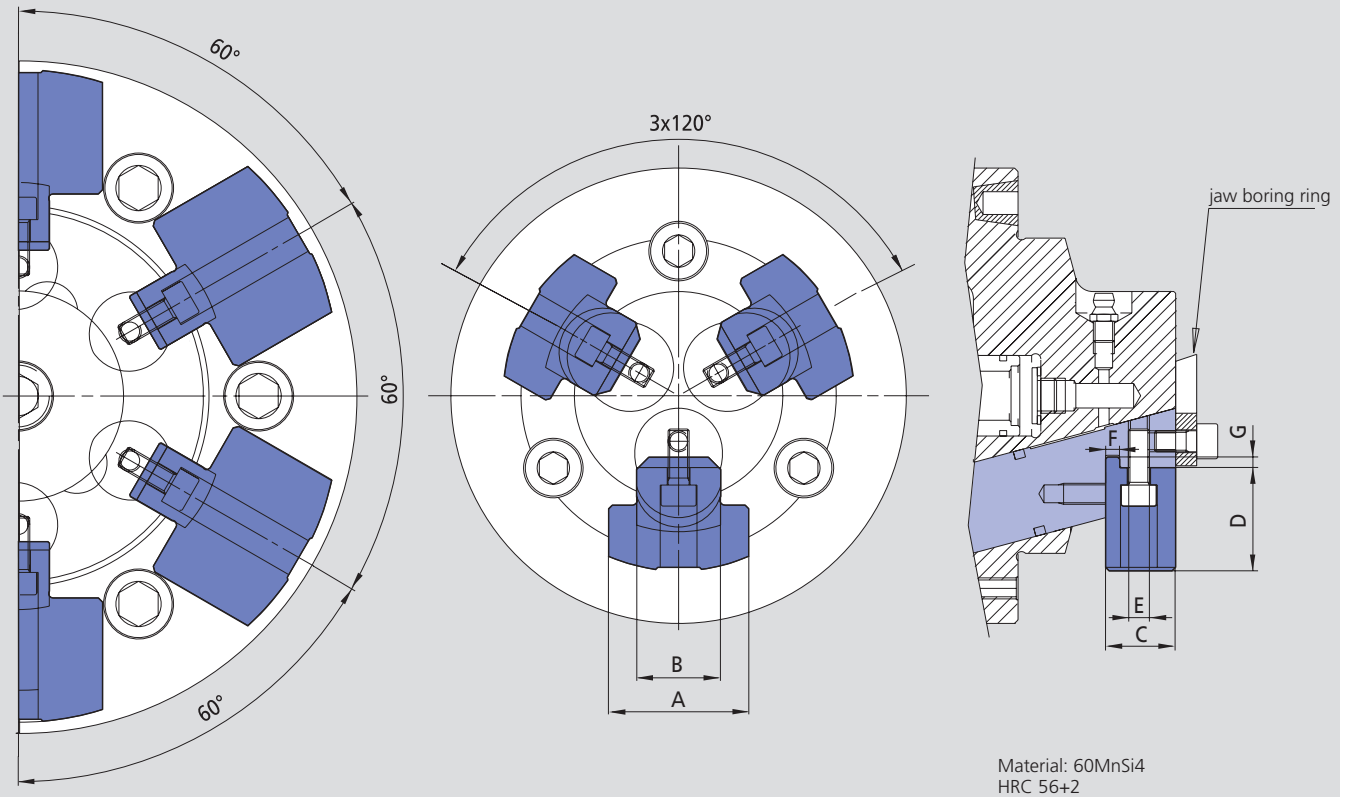
Subject to technical changes  
For more detailed information please ask for customer drawing

SMW-AUTOBLOK Type ACS-I	130	160	200	240	300	
Number of jaws	3	3	3	6	6	
Mounting	ISO-A4 Z115	ISO-A5 Z140	ISO-A6 FZ170	ISO-A8 Z220	ISO-A11 Z280	
	A/A1	130/130	160/150	200/170	240/210	300/275
	Ba	63.513	82.563	106.375	139.719	196.869
	Bf	115	140	170	220	280
	C	82.6	104.8	133.4	171.4	235
	D	11	11	13	17	21
	E	55	64.5	62	68.5	64.5
	G	59.5	85	103	136	200
	H max.	130	140.5	147.5	154.5	156.5
	Ha	125	135	142	149	151
	Hf	112	120	125	130	130
	I	90	120	140	170	232
	M	24	22	22	22	22
	N min/max	19.2/21.8	26.8/31.2	36.3/40.7	52.8/57.2	84.8/89.2
	O	27.5	26.5	27	27	27
	P	67	75	80	85	85
	R	18	4	4	4	8
	S	M6	M6	M6	M8	M8
	T	110	135	155	190	255
Stroke	U	2.6	4.4	4.4	4.4	4.4
Stroke	Z	10	11	11	11	11

	a	36	48	48	48	86
	b	29	39	39	39	76
	c	M28x1.5	M38x1.5	M38x1.5	M38x1.5	M75x2
	d	20	23	23	23	23
	e	9.5	11.5	11.5	11.5	11.5
	f	4	4	4	4	4
	g	12	13	13	13	13
	h	-	6	6	6	6
	i	M6	M8	M8	M8	M8
	m	3.5	3.5	3.5	3.5	3.5
	n	7.5	8.5	8.5	8.5	8.5
	n1	7.5	9	9	9	9
	y	14	14	32	32	115

2 media can be used through the chuck's bore.  
Specials on request.

■ for 3 and 6 jaw chucks



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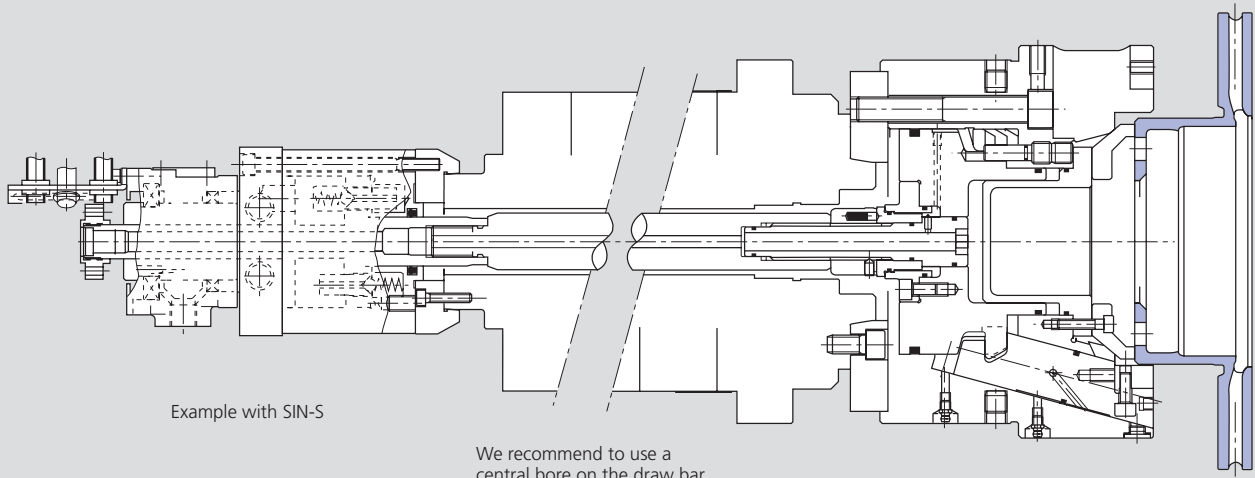
SMW-AUTOBLOK Type		ACS-I 130	ACS-I 160	ACS-I 200	ACS-I 240	ACS-I 300
Number of jaws		3	3	3	6	6
	<b>A</b>	40	40	60	60	60
	<b>B h6</b>	24	22	22	22	22
	<b>C</b>	20	23	23	23	23
	<b>D</b>	29.5	41	61.5	61.5	53
	<b>E</b>	3xM6	3xM8	3xM8	3xM8	6xM8
	<b>F g6</b>	4	4	4	4	4
	<b>G</b>	3	3	3	3	3
<b>rec. clamping range</b>	<b>min.</b>	65**	92	110	144	210
<b>rec. clamping range</b>	<b>max.</b>	100	140	200	232	280
Id. No. jaw blanks (1 set = 3 pcs.)		69761360	69761660*	69762060*	69762490*	69763090*
Id. No. boring ring		69111360	69111660	69112060	69112490	69113090

\* identical for size 160-200-240-300

\*\* min. 60 with special jaws

# Examples

## ACS-E

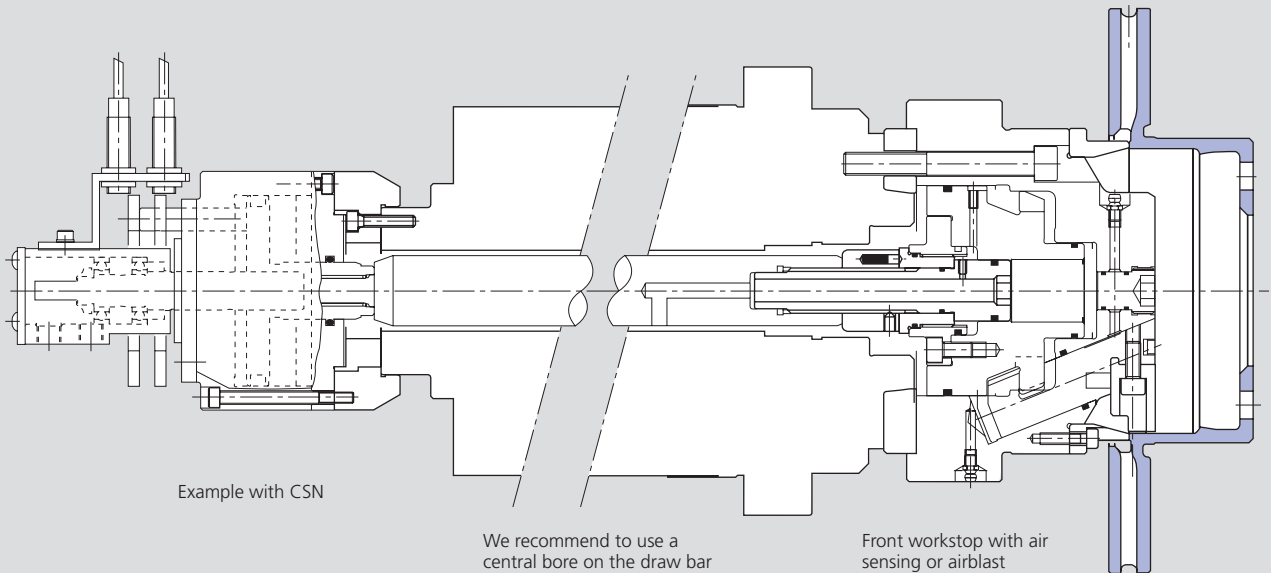


Example with SIN-S

We recommend to use a central bore on the draw bar

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

## ACS-I



Example with CSN

We recommend to use a central bore on the draw bar

Front workstop with air sensing or airblast

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