

- 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

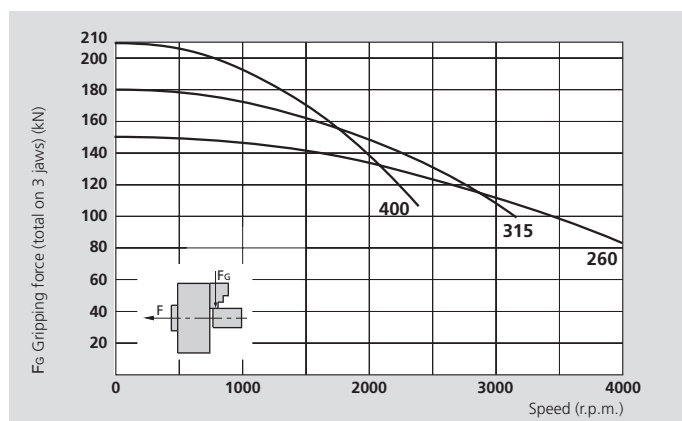
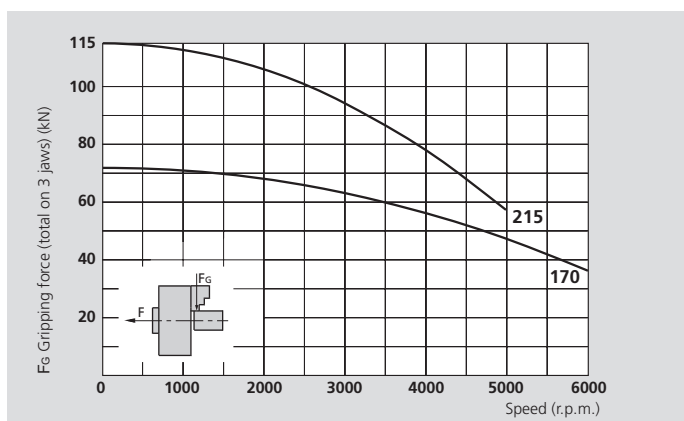
3-jaw chuck
Mounting bolts

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.

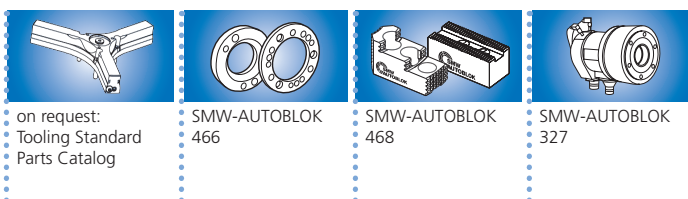
△ Safety advice / danger of damage:

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		Type	SIN-S 100	SIN-S 100 / 125	SIN-S 125 / 150	SIN-S 125 / 150
Id. No. AP-C (Center mounting)			77186817	77186821	77186826	77186831
						77186840

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



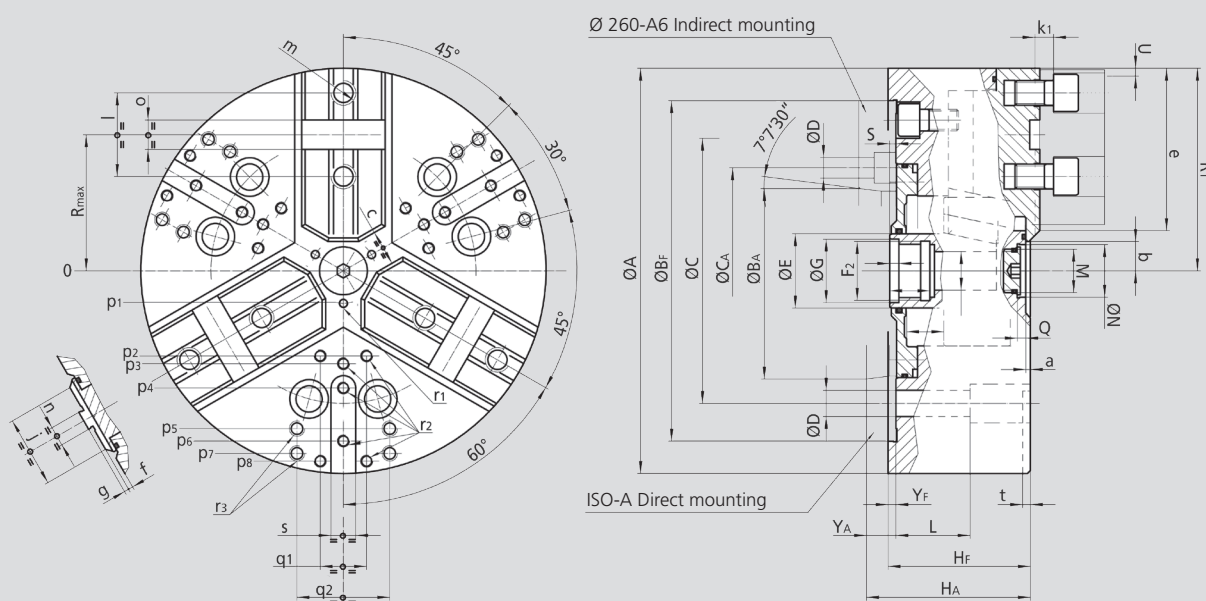
High precision power chuck Ø 170 - 400 mm

- Closed center
- 3 jaws
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AP®-C

TONGUE & GROOVE

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Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type			AP-C 170		AP-C 215		AP-C 260			AP-C 315		AP-C 400	
Mounting			Z140	A5	Z170	A6	Z220	A6	A8	Z220	A8	Z300	A11
	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		171.4	171.4		235	
	CA	mm	-	-	-	-	-	133.4	-	-	-	-	-
	D	mm	11.5		13.5		17	13.5	17	17		21	
	E	mm	32		42			48		48		75	
	F2	mm	M24 x 2		M32 x 1.5			M38 x 1.5		M38 x 1.5		M60 x 1.5	
	G H8	mm	25		33			39		39		61	
	HF/HA	mm	68	78	81	93	92	111	106	101	115	112	127
	K	mm	18.5		20			25		25		48	
	L	mm	23		32			38		38		54	
	M	mm	M10 x 1		M22 x 1.5			M28 x 1.5		M28 x 1.5		M52 x 1.5	
	N H9	mm	15		24			34		34		60	
	Q	mm	4.5		5.5			5.5		5.5		9	
Chuck open	R1	mm	86.5		108			131		157.5		195	
Max.	R	mm	56		72			88		105		133.5	
Max. / min.	S	mm	21 / 4		26 / 4			28 / 4		34 / 4		37 / 4	
Radial jaw stroke	U	mm	3.6		4.6			5		6.3		7	
	W	mm	22		26			26		26		38	
	YF/YA	mm	5	15	5	17	5	24	19	5	19	6	21
Max. / min.	Z	mm	17 / 0		22 / 0			24 / 0		30 / 0		33 / 0	
	a	mm	3		3			3		3		3	
Min.	b	mm	8.5		12			14		16.5		31	
Min.	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	