

ACS-E 3

Self centering
column chuck

Self-centering column chuck with pull down Ø 110 - 350 mm

- Pull down
- Power operated via standard cylinders
- O.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

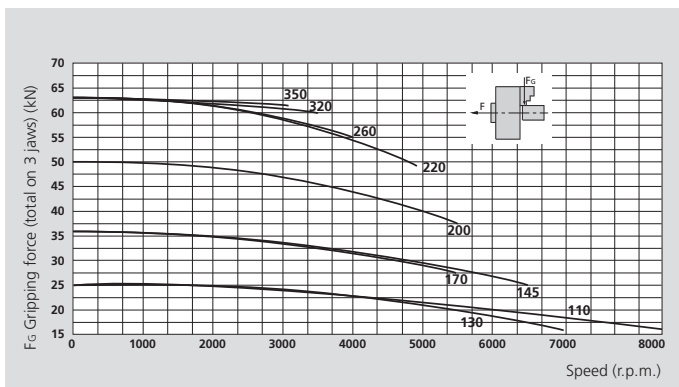
3-jaw chuck
Mounting bolts

Ordering example

3-jaw column chuck
with center mounting Z170
type ACS-E 220-3-Z170



Actual gripping force diagram



The diagram refers to standard jaw blanks,
machined to 50% of their mass.

Technical data

SMW-AUTOBLOK Type		ACS-E 3 110	ACS-E 3 130	ACS-E 3 145	ACS-E 3 170	ACS-E 3 200	ACS-E 3 220	ACS-E 3 260	ACS-E 3 320	ACS-E 3 350
Jaw stroke	mm	2.6	2.6	2.6	2.6	2.6	3.2	4	6	6
Piston stroke	mm	10	10	10	10	10	12	15	15	15
Actuating force max.	kN	10	10	15	15	20	25	25	35	35
Grip force max.	kN	25	25	36	36	50	63	63	63	63
Speed max.	r.p.m.	8000	7000	6500	6300	5500	4900	4300	3400	3100
Weight	kg	5	12	14	17	30	35	50	75	90
Moment of inertia	kg·m ²	0.07	0.02	0.03	0.06	0.16	0.21	0.35	0.84	1
Clamping range	min.	4	10	20	30	30	50	90	90	120
Clamping range	max.	45	50	70	95	100	125	165	215	245
Rec. actuating cylinders	Type	SIN-S 70	SIN-S 70	SIN-S 70	SIN-S 85	SIN-S 100	SIN-S 125	SIN-S 125	SIN-S 125	SIN-S 125
Rec. actuating cylinders	Type	SIN-S 85	SIN-S 85	SIN-S 85	SIN-S 100	SIN-S 125	SIN-S 150	SIN-S 150	SIN-S 150	SIN-S 150
Id.-No. ACS-E 3		77690111	77690113	77690114	77690117	77690120	77690122	77690125	77690132	77690135
Id.-No. Jaw blanks		69731110	69761310	69761410	69761710	69762010	69762210	69762210	69763210	69763210



Self-centering column chuck with pull down Ø 110 - 350 mm

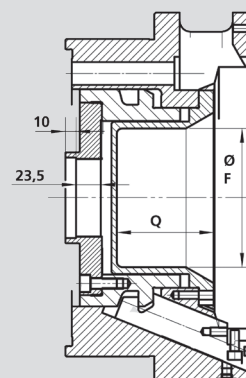
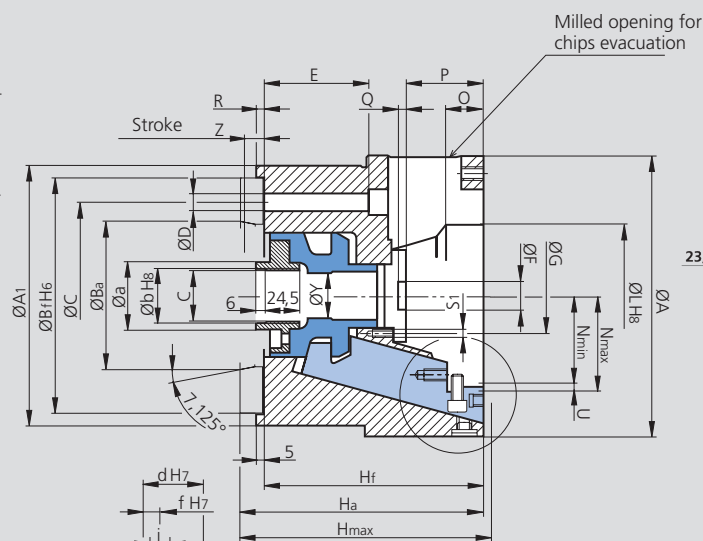
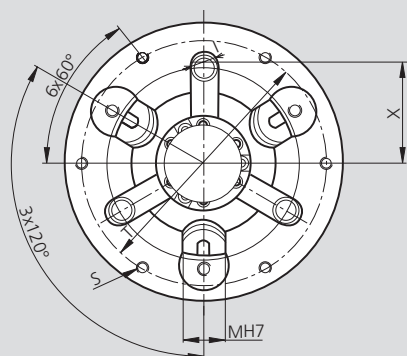
- Pull down
- Power operated via standard cylinders
- O.D. clamping

ACS-E 3

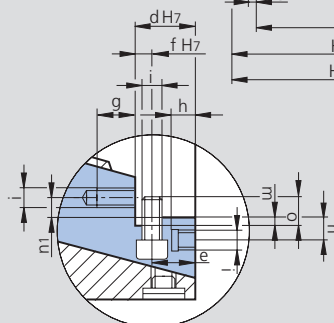
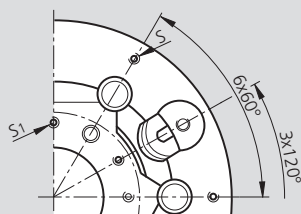
Self centering
column chuck

ACS-E 110-130-145-170

ACS-E 320 - 350



ACS-E 200-220 ACS-E 260-320-350



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

Media can be used through
the chuck's bore.

Specials on request.

SMW-AUTOBLOK Type		ACS-E 3 110	ACS-E 3 130	ACS-E 3 145	ACS-E 3 170	ACS-E 3 200	ACS-E 3 220	ACS-E 3 260	ACS-E 3 320	ACS-E 3 350
Mounting		ISO-* Z90	ISO-A4 Z115	ISO-A4 Z115	ISO-A5 Z140	ISO-A6 Z170	ISO-A6 Z170	ISO-A8 Z220	ISO-A11 Z280	ISO-A11 Z280
A/A1	mm	112 / 100	130 / 130	145 / 130	170 / 155	200 / 185	220 / 185	260 / 235	324 / 300	354 / 300
Ba	mm	-	63.513	63.513	82.563	106.375	106.375	139.719	196.869	196.869
Bf	mm	90	115	115	140	170	170	220	280	280
C	mm	70	82.6	82.6	104.8	133.4	133.4	171.4	235	235
D	mm	3x8.5	3x11	3x11	3x11	6x13	6x13	6x17	6x21	6x21
E	mm	48	64	64	65	75	75	91	97	97
F	mm	-	-	16	20	20	30	70	105	131
G	mm	38	-	40	65	54	68	107	154	184
Hmax.	mm	-	130	130	140	179	183	198.5	200.5	200.5
Ha	mm	-	125	125	135	174	177	191	193	193
Hf	mm	95	112	112	120	157	160	172	172	172
I	mm	-	20	20	20	-	-	-	-	-
L	mm	52	55	75	98	102	126	167	217	247
M	mm	18	20	20	20	30	30	30	30	30
Nmin./max.	mm	30.2 / 32.8	33.7 / 36.3	43.7 / 46.3	56.2 / 58.8	63.7 / 66.3	73.4 / 76.6	93 / 97	117 / 123	132 / 138
O	mm	22.5	26.5	26.5	26.5	32	33	34	33	33
P	mm	25	30	29	29	55	50.5	40	38	38
Q	mm	-	-	5	5	7	7	65.5	91.5	91.5
R	mm	15	18	18	4.5	4.5	3.5	2	6	6
S	mm	6 x M5	6 x M6	6 x M6	6 x M6	6 x M8	6 x M8	6 x M8	12 x M8	12 x M8
S1	mm	-	-	3 x M5	6 x M5	6 x M6	6 x M6	6 x M6	6 x M8	6 x M8
T	mm	90	115	115	145	175	190	226	290	320
Stroke U	mm	2.6	2.6	2.6	2.6	2.6	3.2	4	6	6
Stroke Z	mm	10	10	10	10	10	12	15	15	15
X	mm	-	41.3	41.3	52.4	-	-	-	-	-
W	mm	4	5	5	5	5	5	5	6	6
a	mm	28	36	36	48	48	48	48	86	86
b	mm	22	29	29	39	39	39	39	76	76
c	mm	M20 x 1.5	M28 x 1.5	M28 x 1.5	M38 x 1.5	M38 x 1.5	M38 x 1.5	M38 x 1.5	M75 x 2	M75 x 2
d	mm	18	20	20	20	25	25	25	25	25
e	mm	13	14	14	14	18	18	18	18	18
f	mm	5	6	6	6	7	7	7	7	7
g	mm	12	12	12	12	16	16	16	16	16
h	mm	8	-	-	-	9	9	9	9	9
i	mm	M6	M6	M6	M6	M8	M8	M8	M8	M8
m	mm	3.5	3.5	3.5	3.5	3.5	3.5	3.5	3.5	3.5
n	mm	9	7.5	7.5	7.5	10	10	10	10	10
n1	mm	5	6.5	6.5	6.5	8.5	8.5	8.5	8.5	8.5
o	mm	8.5	8.5	8.5	8.5	9	9	9	9	9
y	mm	10.5	12.5	14	32	32	32	32	115	115

* Flange ISO-A on request.

ACS-E 6

Self centering
column chuck

Self-centering column chuck with pull down
Ø 200 - 450 mm

- Pull down
- Power operated via standard cylinders
- O.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

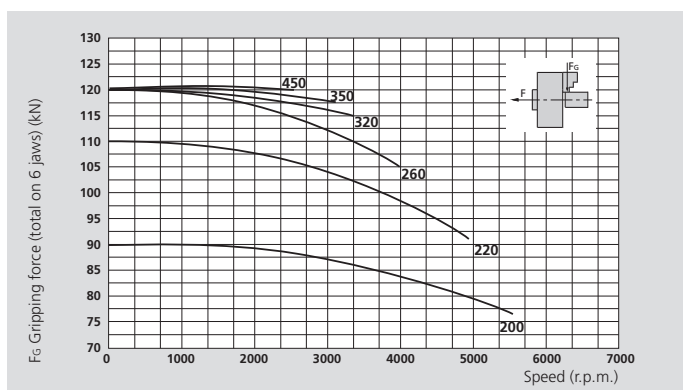
6-jaw chuck
Mounting bolts

Ordering example

6-jaw column chuck
with center mounting Z170
type ACS-E 6 220 Z170



Actual gripping force diagram



The diagram refers to standard jaw blanks,
machined to 50% of their mass.

Technical data

SMW-AUTOBLOK Type		ACS-E 6 200	ACS-E 6 220	ACS-E 6 260	ACS-E 6 320	ACS-E 6 350	ACS-E 6 450
Jaw stroke	mm	2.6	3.2	4	6	6	6
Piston stroke	mm	10	12	15	15	15	15
Actuating force max.	kN	40	50	50	65	65	65
Grip force max.	kN	90	110	120	120	120	120
Speed max.	r.p.m.	5500	4900	4300	3400	3100	2200
Weight	kg	30	35	50	75	90	130
Moment of inertia	kg·m ²	0.16	0.21	0.35	0.84	1	3
Clamping range	min.	30	50	90	90	120	210
Clamping range	max.	100	125	165	215	245	335
Rec. actuating cylinders	Type	SIN-S 100	SIN-S 125	SIN-S 125	SIN-S 125	SIN-S 125	SIN-S 125
Rec. actuating cylinders	Type	SIN-S 125	SIN-S 150	SIN-S 150	SIN-S 150	SIN-S 150	SIN-S 150
Id.-No. ACS-E 6		77690420	77690422	77690425	77690432	77690435	77690445
Id.-No. Jaw blanks		69762040	69762240		69763210		



SMW-AUTOBLOK
472



SMW-AUTOBLOK
466



SMW-AUTOBLOK
327

Self-centering column chuck with pull down

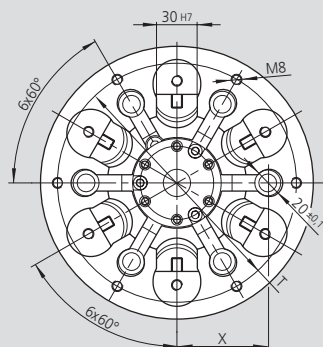
Ø 200 - 450 mm

- Pull down
- Power operated via standard cylinders
- O.D. clamping

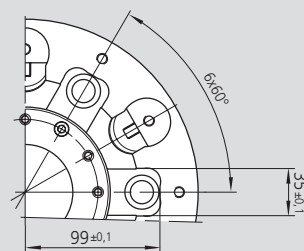
ACS-E 6

Self centering
column chuck

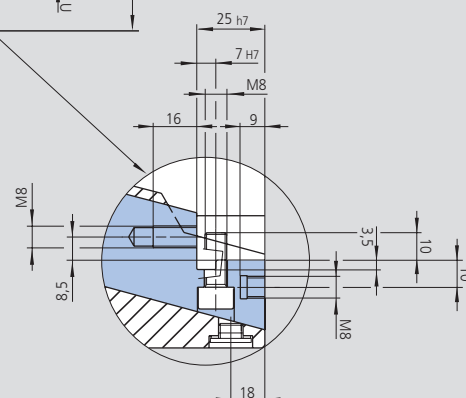
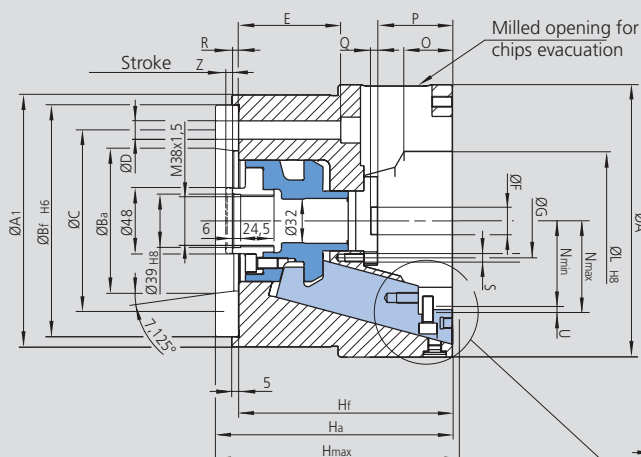
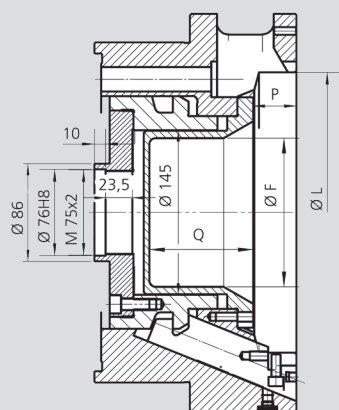
ACS-E 450



ACS-E 260



ACS-E 320-350-450



Media can be used through
the chuck's bore.

Specials on request.

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

SMW-AUTOBLOK Type			ACS-E 6 200	ACS-E 6 220	ACS-E 6 260	ACS-E 6 320	ACS-E 6 350	ACS-E 6 450
Mounting			ISO-A6 Z170	ISO-A6 Z170	ISO-A8 Z220	ISO-A11 Z280	ISO-A11 Z280	ISO-A15 Z380
	A	mm	200	220	260	324	354	450
	A1	mm	185	185	235	300	300	410
	Ba	mm	106.375	106.375	139.719	196.869	196.869	285.775
	Bf	mm	170	170	220	280	280	380
	C	mm	133.4	133.4	171.4	235	235	330.2
	D	mm	13	13	17	21	21	25
	E	mm	75	75	91	97	97	97
	F	mm	20	30	70	105	131	180
	G	mm	54	68	107	154	184	270
	Hmax.	mm	179	183	198.5	200.5	200.5	200.5
	Ha	mm	174	177	191	193	193	195
	Hf	mm	157	160	172	172	172	172
	L	mm	102	126	167	217	247	336
	Nmin.	mm	66.3	76.6	97	123	138	182
	Nmax.	mm	63.7	73.4	93	117	132	176
	O	mm	32	33	34	33	33	33
	P	mm	55	50.5	40	38	38	38
	Q	mm	7	7	65.5	91.5	91.5	90
	R	mm	4.5	3.5	2	6	6	6
	S	mm	6 x M6	6 x M6	6 x M6	6 x M6	6 x M6	6 x M6
	T	mm	175	190	226	290	320	405
Stroke	U	mm	2.6	3.2	4	6	6	6
Stroke	Z	mm	10	12	15	15	15	15
	X	mm	66.7	72	-	-	-	-
	W	mm	5	5	5	6	6	6

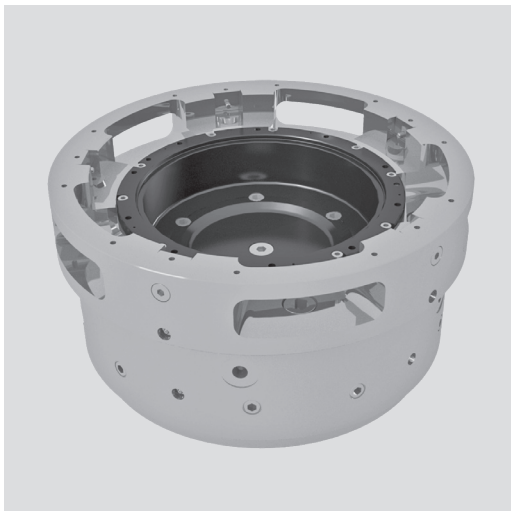
ACS-E 5

Self centering
column chuck

Self-centering column chuck with pull down

Ø 520 mm

- Pull down
- Power operated via standard cylinders
- O.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
- Jaws on request

Technical features

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

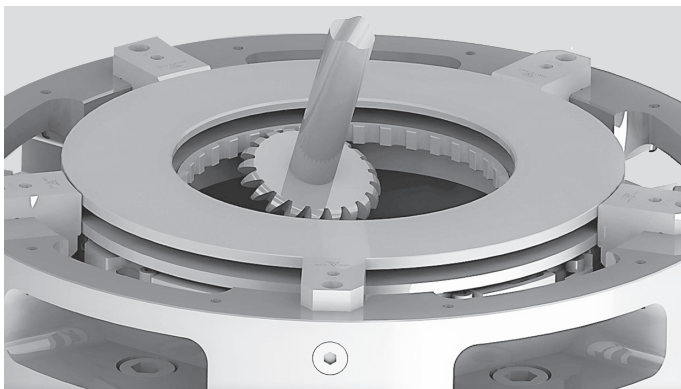
Standard equipment

5-jaw chuck
Mounting bolts

Ordering example

5-jaw column chuck
with center mounting Z450
type ACS-E 5 520 Z450

Precise distribution of clamping forces



5-jaw model assures a very precise distribution of the clamping forces, since there's no contrast of two opposite jaws on the same axis.

Suitable for the following parts machining:

- Ring gears
- Shafts with internal and external gears
- Keys or single-gear components with external gear wheels and internal keys

Technical data

SMW-AUTOBLOK Type		ACS-E 5 520
Jaw stroke	mm	4
Piston stroke	mm	15
Actuating force max.	kN	20
Grip force max.	kN	48
Speed max.	r.p.m.	1000
Weight	kg	259
Moment of inertia	kg·m ²	9
Clamping range	min.	265
Clamping range	max.	420
Rec. actuating cylinders	Type	SIN-S 125
Rec. actuating cylinders	Type	SIN-S 150
Id.-No. ACS-E 5		on request
Id.-No. Jaw blanks		on request

Self-centering column chucks with pull down

Ø 520 mm

■ Pull down

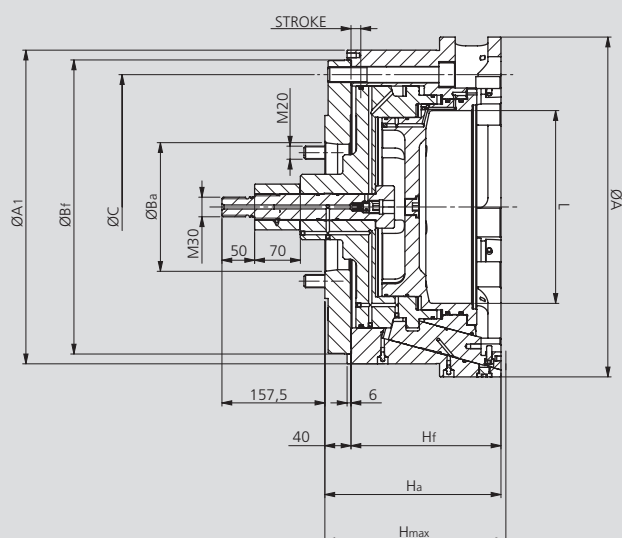
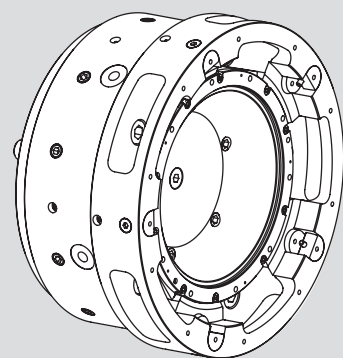
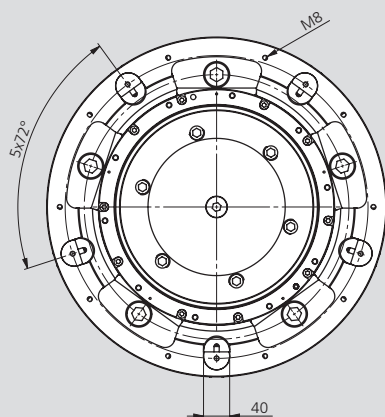
■ Power operated via standard cylinders

■ O.D. clamping

ACS-E 5

Self centering
column chuck

ACS-E 520



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

SMW-AUTOBLOK Type		ACS-E 5 520
Mounting		ISO-A11 Z450
A	mm	520
A1	mm	480
Ba	mm	196.869
Bf	mm	450
C	mm	405
H max.	mm	277
Ha	mm	270.5
Hf	mm	229
L	mm	295
Stroke	mm	15

ACS-I 3 / 6

Self centering
column chuck

Self-centering column chuck 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

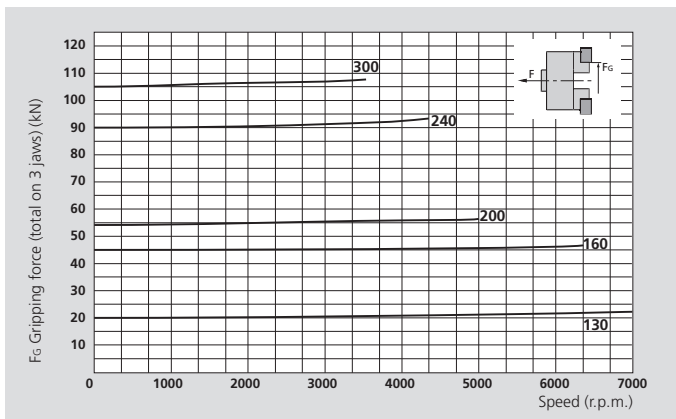
Standard equipment

3- or 6-jaw chuck
Mounting bolts

Ordering example

3-jaw column chuck
with center mounting Z115
type ACS-I 130-3-Z-115

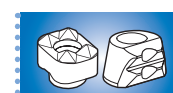
Actual gripping force diagram



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



SMW-AUTOBLOK
472



SMW-AUTOBLOK
466



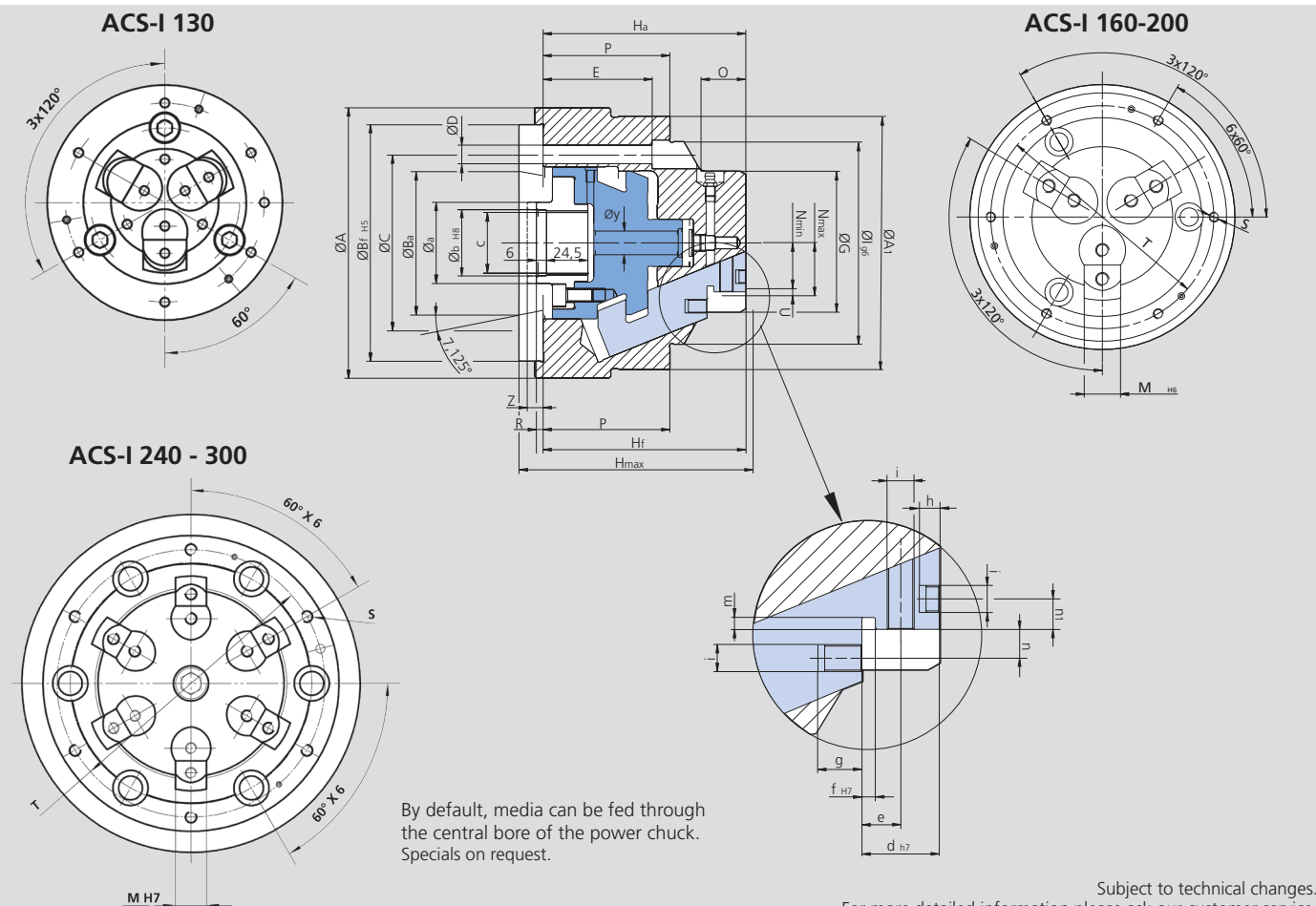
SMW-AUTOBLOK
327

Self-centering column chuck with pull down Ø 130 - 300 mm

- Pull down
- Power operated via standard cylinders
- I.D. clamping

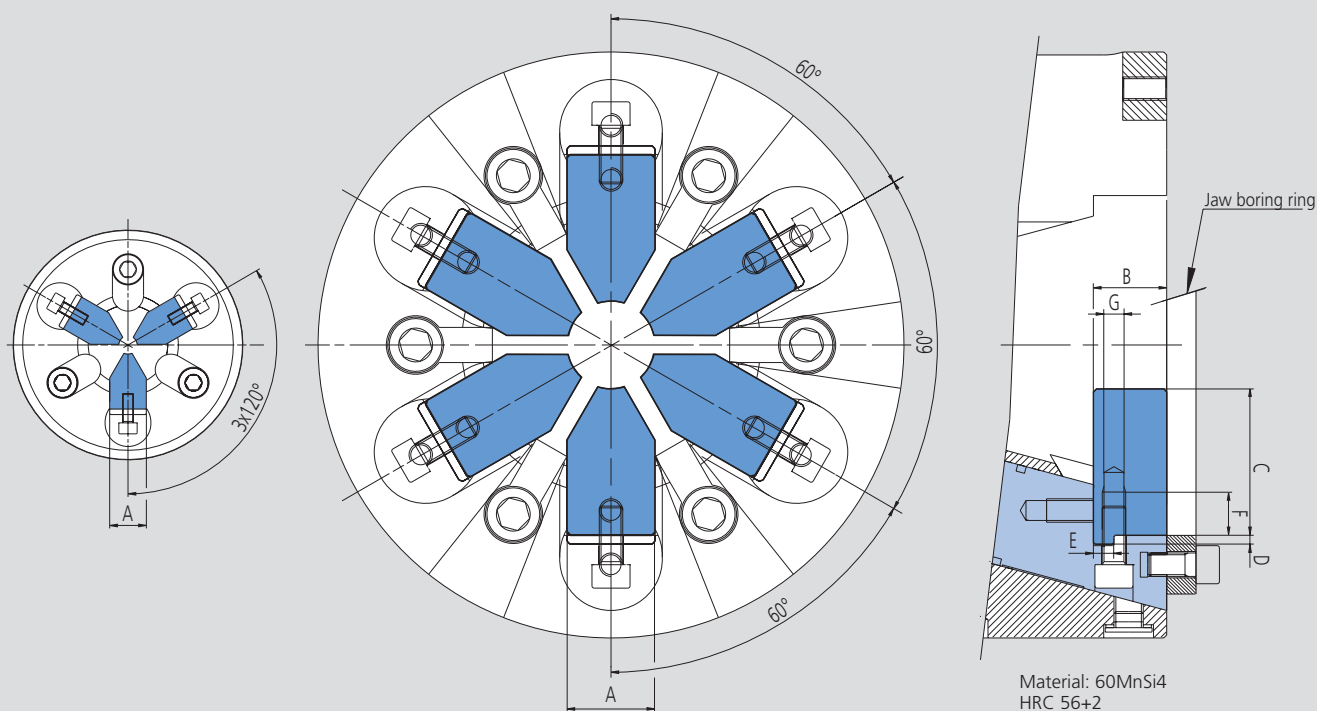
ACS-I 3 / 6

Self centering
column chuck



4

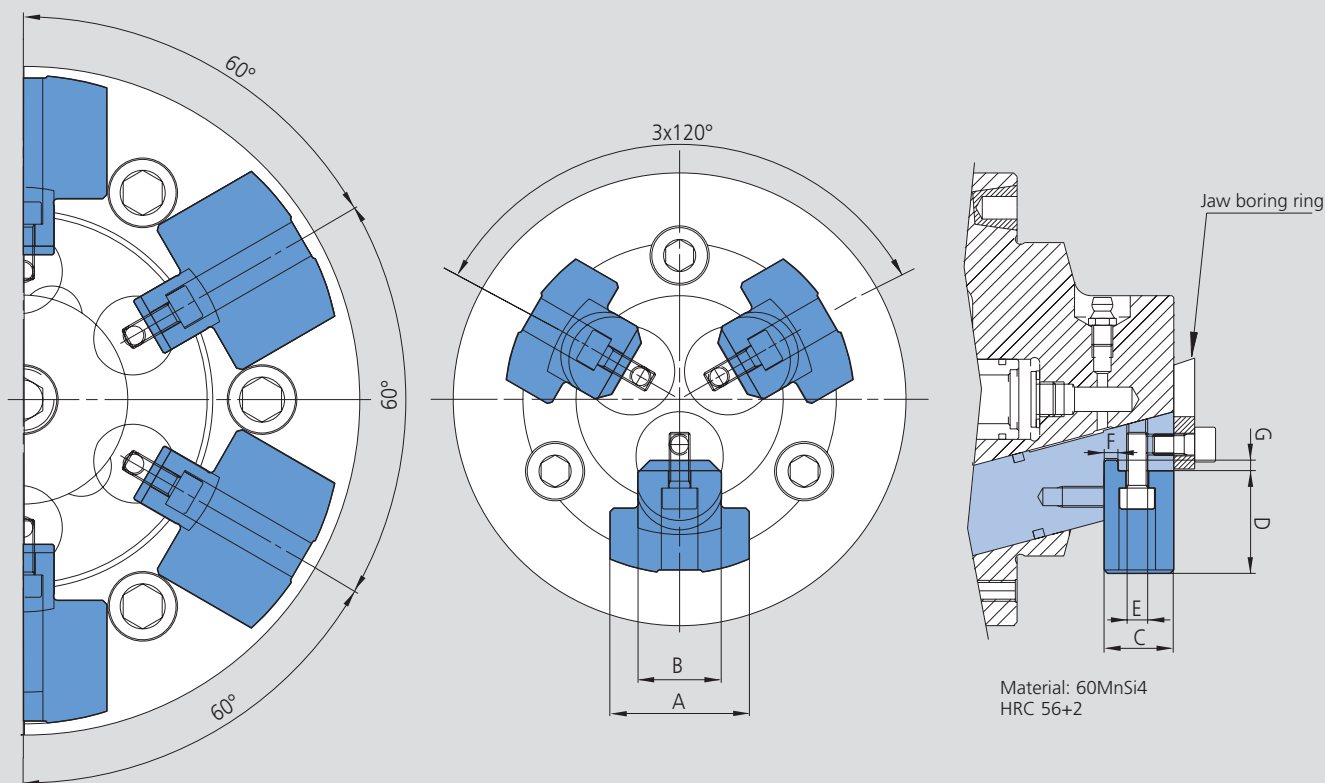
SMW-AUTOBLOK Type			ACS-I 3 130	ACS-I 3 160	ACS-I 3 200	ACS-I 6 240	ACS-I 6 300
Number of jaws			3	3	3	6	6
Mounting			ISO-A4 Z115	ISO-A5 Z140	ISO-A6 Z170	ISO-A8 Z220	ISO-A11 Z280
	A/A1	mm	130 / 130	160 / 150	200 / 170	240 / 210	300 / 275
	Ba	mm	63.513	82.563	106.375	139.719	196.869
	Bf	mm	115	140	170	220	280
	C	mm	82.6	104.8	133.4	171.4	235
	D	mm	11	11	13	17	21
	E	mm	55	64.5	62	68.5	64.5
	G	mm	59.5	85	103	136	200
	Hmax.	mm	130	140.5	147.5	154.5	156.5
	Ha	mm	125	135	142	149	151
	Hf	mm	112	120	125	130	130
	I	mm	90	120	140	170	232
	M	mm	24	22	22	22	22
	Nmin./max.	mm	19.2 / 21.8	26.8 / 31.2	36.3 / 40.7	52.8 / 57.2	84.8 / 89.2
	O	mm	27.5	26.5	27	27	27
	P	mm	67	75	80	85	85
	R	mm	18	4	4	4	8
	S	mm	M6	M6	M6	M8	M8
	T	mm	110	135	155	190	255
Stroke	U	mm	2.6	4.4	4.4	4.4	4.4
Stroke	Z	mm	10	11	11	11	11
	a	mm	36	48	48	48	86
	b	mm	29	39	39	39	76
	c	mm	M28 x 1.5	M38 x 1.5	M38 x 1.5	M38 x 1.5	M75 x 2
	d	mm	20	23	23	23	23
	e	mm	9.5	11.5	11.5	11.5	11.5
	f	mm	4	4	4	4	4
	g	mm	12	13	13	13	13
	h	mm	-	6	6	6	6
	i	mm	M6	M8	M8	M8	M8
	m	mm	3.5	3.5	3.5	3.5	3.5
	n	mm	7.5	8.5	8.5	8.5	8.5
	n1	mm	7.5	9	9	9	9
	y	mm	14	14	32	32	115



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

SMW-AUTOBLOK Type ACS-E		110	130	145	170	200	220	260	320	350	450
Number of jaws		3	3	3	3	3 / 6	3 / 6	3 / 6	3 / 6	3 / 6	3 / 6
	A h6	18	20	20	20	30	30	30	30	30	30
	B	18	20	20	20	25	25	25	25	25	25
	C	29.5	30	35	40	50	50	50	75	75	75
	D	3	3	3	3	3	3	3	3	3	3
	E g6	5	6	6	6	7	7	7	7	7	7
	F	13	13	13	13	15	15	15	15	15	15
	G	M6	M6	M6	M6	M8	M8	M8	M8	M8	M8
Rec. clamping range	min.	4	10	20	30	30	50	90	90	120	208
Rec. clamping range	max.	45	50	70	95	100	125	165	215	245	335
Jaw blanks (1 set = 3 pcs.)	Id. No.	69761110	69761310	69761410	69761710	69762010*	69762210*	69762210*	69763210*	69763210*	-
Boring ring	Id. No.	69111110	69111310	69111410	69111710	69112040	69112240	69112540	69113240	69113540	69114540
Id. No ACS-E 3 Jaws		77690111	77690113	77690114	77690117	77690120	77690122	77690125	77690132	77690135	-
Id. No ACS-E 6 Jaws		-	-	-	-	77690420	77690422	77690425	77690432	77690435	77690445

* For 6-jaw chucks use 2 set of 3 pcs.



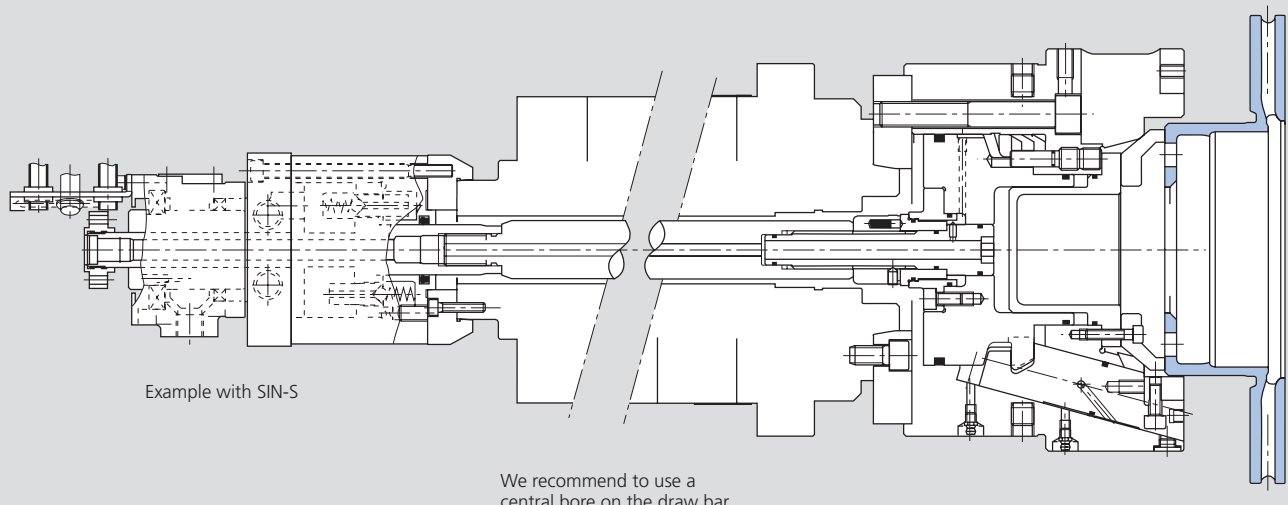
Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type ACS-I		ACS-I 130	ACS-I 160	ACS-I 200	ACS-I 240	ACS-I 300
Number of jaws		3	3	3	6	6
	A	40	40	60	60	60
	B h6	24	22	22	22	22
	C	20	23	23	23	23
	D	29.5	41	61.5	61.5	53
	E	3 x M6	3 x M8	3 x M8	3 x M8	6 x M8
	F g6	4	4	4	4	4
	G	3	3	3	3	3
Rec. clamping range	min.	65**	92	110	144	210
Rec. clamping range	max.	100	140	200	232	280
Jaw blanks (set of 3 or 6 pieces)	Id. No.	69761360	69761660*	69762060*	69762490*	69763090*
Boring ring	Id. No.	69111360	69111660	69112060	69112490	69113090
Id. No ACS-I		77690613	77690616	77690620	77690924	77690930

* Identical for size 160-200-240-300.

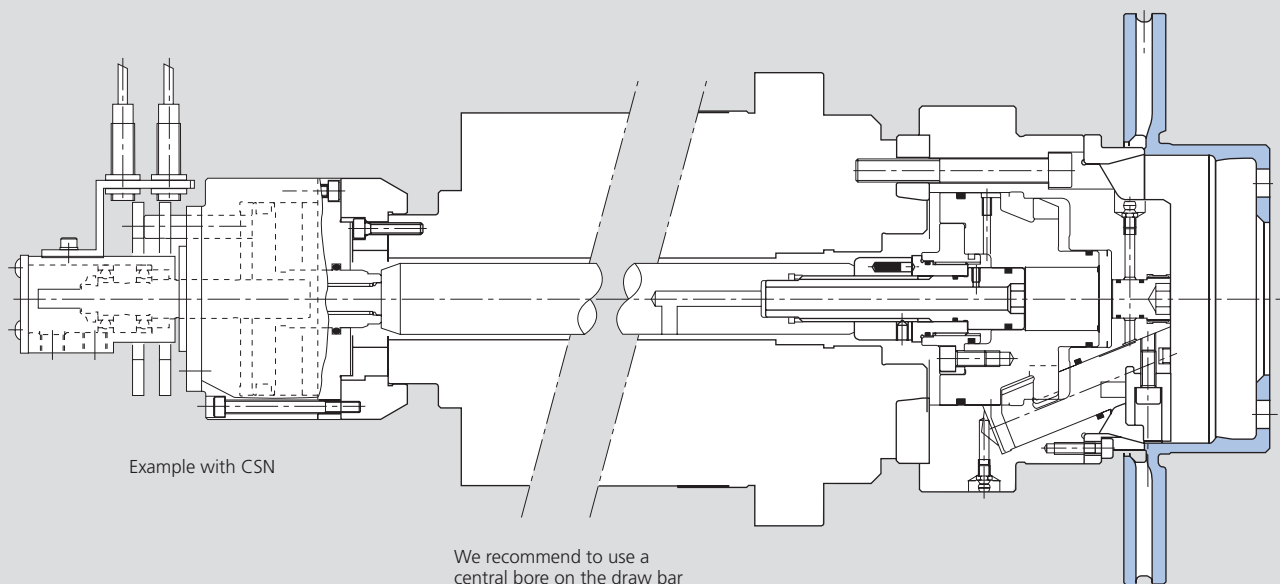
** Min. 60 with special jaws and mounting bolts.

ACS-E e.g. OP10 „Machining brake disc“



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

ACS-I e.g. OP20 „Machining brake disc“



Front workstop with air
sensing or airblast

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