

ACS-E 3

Self centering
column chuck

Self-centering column chucks with pull down

Ø 130 - 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

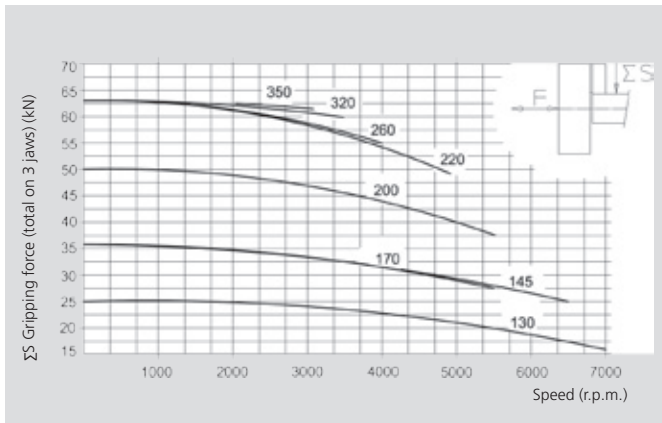
Standard equipment

3-jaw chuck with mounting bolts

Ordering example

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

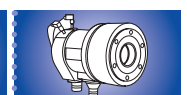
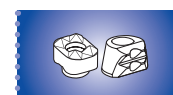
Actual gripping force diagram



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

Technical data

SMW-AUTOBLOK Type		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	3.2	4	6	6
Piston stroke	mm	10	10	10	10	12	15	15	15
Actuating force	kN	10	15	15	20	25	25	35	35
Grip force	kN	25	36	36	50	63	63	63	63
Speed	r.p.m.	7000	6500	6300	5500	4900	4300	3400	3100
Weight	kg	12	14	17	30	35	50	75	90
Moment of inertia	kg·m ²	0.02	0.03	0.06	0.16	0.21	0.35	0.84	1
Clamping range	min.	10	20	30	30	50	90	90	120
Clamping range	max.	50	70	95	100	125	165	215	245
Recommended actuating cylinders		SIN-S 70 SIN-S 85	SIN-S 70 SIN-S 85	SIN-S 85 SIN-S 100	SIN-S 100 SIN-S 125	SIN-S 125 SIN-S 150	SIN-S 125 SIN-S 150	SIN-S 125 SIN-S 150	SIN-S 125 SIN-S 150
Id.No. chuck		77690113	77690114	77690117	77690120	77690122	77690125	77690132	77690135
Id.No. jaw blanks		69761310	69761410	69761710	69762010	69762210	69762210	69763210	69763210



Self-centering column chucks with pull down

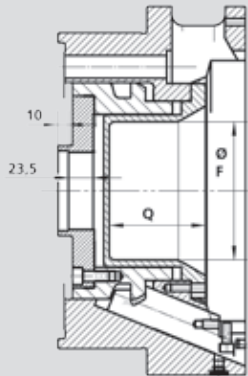
Ø 130 - 350 mm

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

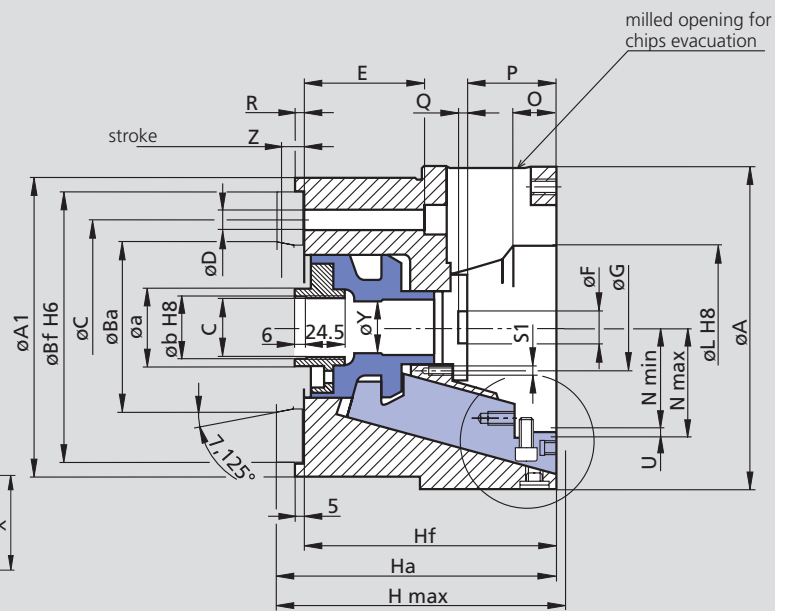
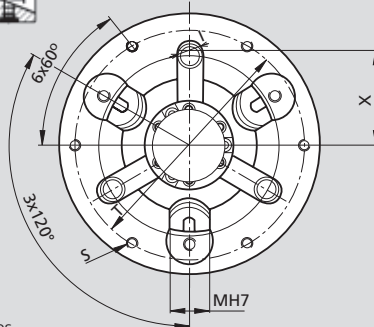
ACS-E 3

Self centering
column chuck

ACS-E 320 - 350

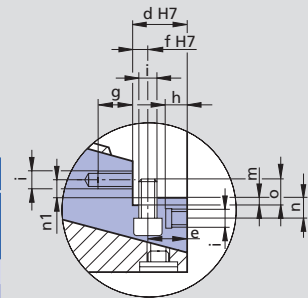


ACS-E 130-145-170



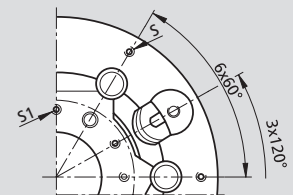
Subject to technical changes
For more detailed information please ask for customer drawing

SMW-AUTOBLOK Type ACS-E 3		130	145	170	200	220	260	320	350
Mounting		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	130/130	145/130	170/155	200/185	220/185	260/235	324/300	354/300
	Ba	63.513	63.513	82.563	106.375	106.375	139.719	196.869	196.869
	Bf	115	115	140	170	170	220	280	280
	C	82.6	82.6	104.8	133.4	133.4	171.4	235	235
	D	3x11	3x11	3x11	6x13	6x13	6x17	6x21	6x21
	E	64	64	65	75	75	91	97	97
	F	-	16	20	20	30	70	105	131
	G	-	40	65	54	68	107	154	184
	H max.	130	130	140	179	183	198.5	200.5	200.5
	Ha	125	125	135	174	177	191	193	193
	Hf	112	112	120	157	160	172	172	172
	I	20	20	20	-	-	-	-	-
	L	55	75	98	102	126	167	217	247
	M	20	20	20	30	30	30	30	30
	N min/max	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	26.5	26.5	26.5	32	33	34	33	33
	P	30	29	29	55	50.5	40	38	38
	Q	-	5	5	7	7	65.5	91.5	91.5
	R	18	18	4.5	4.5	3.5	2	6	6
	S	6xM6	6xM6	6xM6	6xM8	6xM8	6xM8	12xM8	12xM8
	S1	-	3xM5	6xM5	6xM6	6xM6	6xM6	6xM8	6xM8
	T	115	115	145	175	190	226	290	320
Stroke	U	2.6	2.6	2.6	2.6	3.2	4	6	6
Stroke	Z	10	10	10	10	12	15	15	15
	X	41.3	41.3	52.4	-	-	-	-	-
	W	5	5	5	5	5	5	6	6
	a	36	36	48	48	48	48	86	86
	b	29	29	39	39	39	39	76	76
	c	M28x1.5	M28x1.5	M38x1.5	M38x1.5	M38x1.5	M38x1.5	M75x2	M75x2
	d	20	20	20	25	25	25	25	25
	e	14	14	14	18	18	18	18	18
	f	6	6	6	7	7	7	7	7
	g	12	12	12	16	16	16	16	16
	h	-	-	-	9	9	9	9	9
	i	M6	M6	M6	M8	M8	M8	M8	M8
	m	3.5	3.5	3.5	3.5	3.5	3.5	3.5	3.5
	n	7.5	7.5	7.5	10	10	10	10	10
	n1	6.5	6.5	6.5	8.5	8.5	8.5	8.5	8.5
	o	8.5	8.5	8.5	9	9	9	9	9
	y	12.5	14	32	32	32	32	115	115



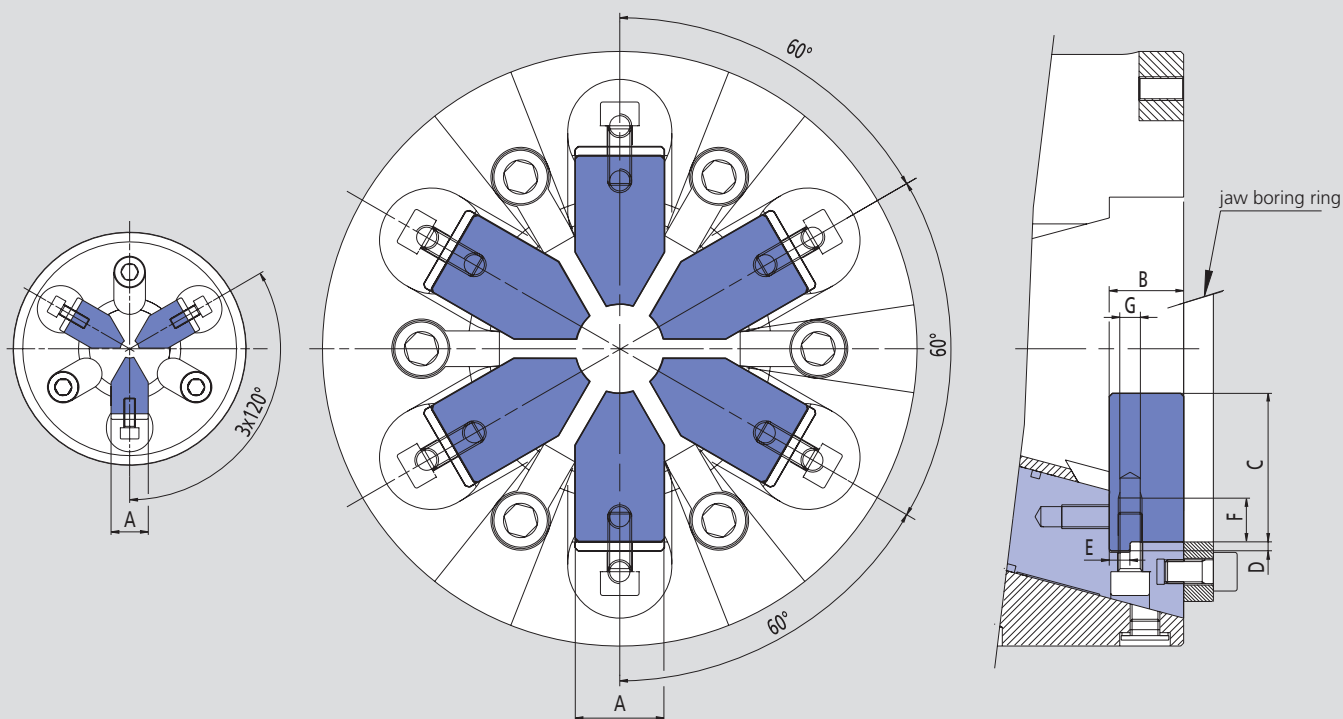
ACS-E 200-220

ACS-E 260-320-350



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

Specials on request.

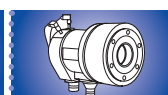
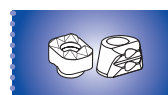


Material: 60MnSi4
HRC 56+2

Subject to technical changes
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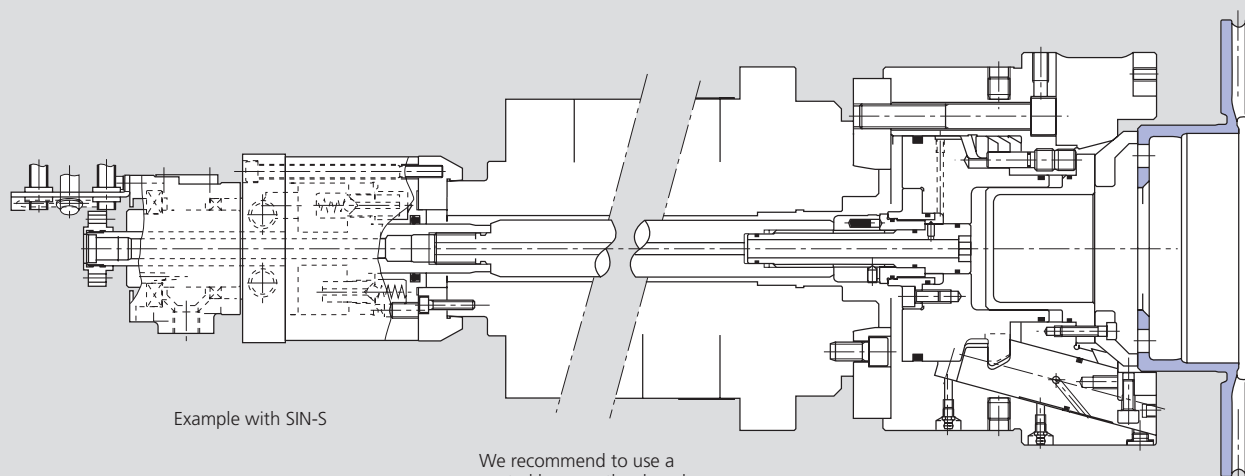
Technical data

SMW-AUTOBLOK Type		ACS-E 130	ACS-E 145	ACS-E 170	ACS-E 200	ACS-E 220	ACS-E 260	ACS-E 320	ACS-E 350	ACS-E 450
Number of jaws		3	3	3	3-6	3-6	3-6	3-6	3-6	3-6
	A h6	20	20	20	30	30	30	30	30	30
	B	20	20	20	25	25	25	25	25	25
	C	30	35	40	50	50	50	75	75	75
	D	3	3	3	3	3	3	3	3	3
	E g6	6	6	6	7	7	7	7	7	7
	F	13	13	13	15	15	15	15	15	15
	G	M6	M6	M6	M8	M8	M8	M8	M8	M8
rec. clamping range	min.	10	20	30	30	50	90	90	120	208
rec. clamping range	max.	50	70	95	100	125	165	215	245	335
Id. No. jaw blanks (1 set = 3 pcs.)		69761310	69761410	69761710	69762010	69762210	69762210	69763210	69763210	-
Id. No. boring ring		69111310	69111410	69111710	69112040	69112240	69112540	69113240	69113540	69114540



Examples

ACS-E

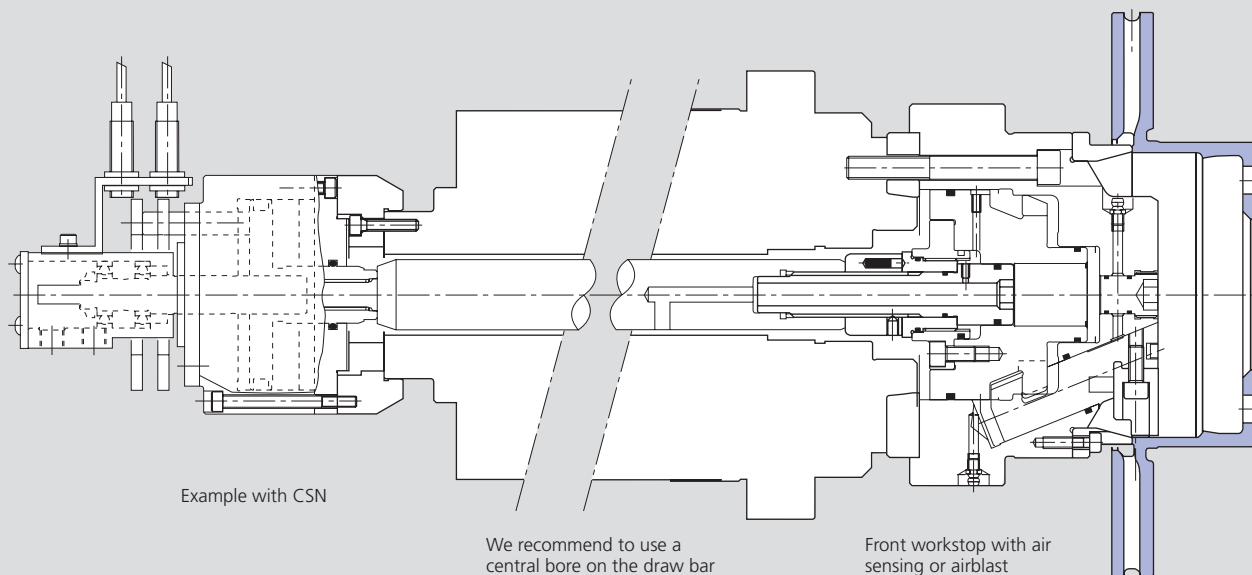


Example with SIN-S

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
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