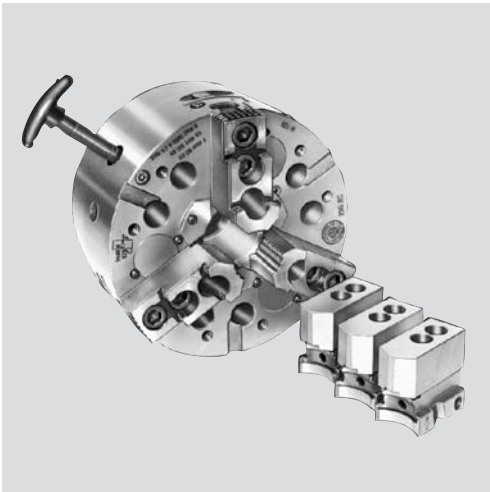


- open center - QUICK CHANGE OF MASTER JAWS
- to use all top jaws
- 3 jaws



### Application/customer's benefit

For open center or partial open center clamping. From middle size to large production batches. Shortest set-up times with quick jaw change

**RC-D:** INCH serration master jaws, interchangeable with RC-C and RC-M

**RC-C:** tongue & groove master jaws, interchangeable with RC-D and RC-M

**RC-M:** METRIC serration master jaws, interchangeable with RC-C and RC-D

### Technical features

Gripping force transmission via side column wedge hook

Quick jaw change system based on interchangeable master jaws on the same chuck

Optimal bar clamping by using collet pads easily mounted on the master jaws

Case hardened body to assure greatest precision and long chuck life

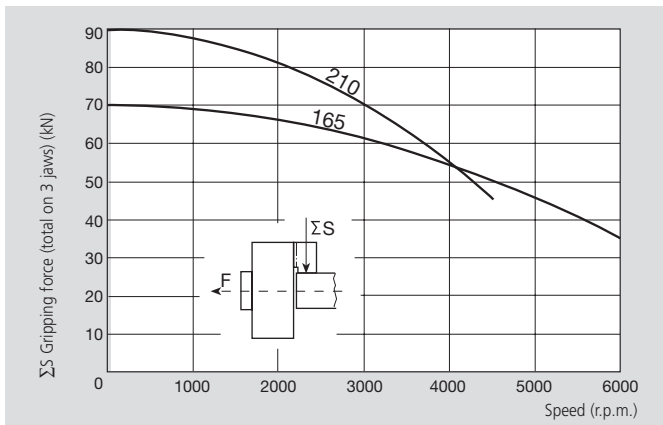
### Standard equipment

- 3 jaw chuck
- Quick change key
- Mounting bolts and grease gun
- (master jaws and top jaws are not included)

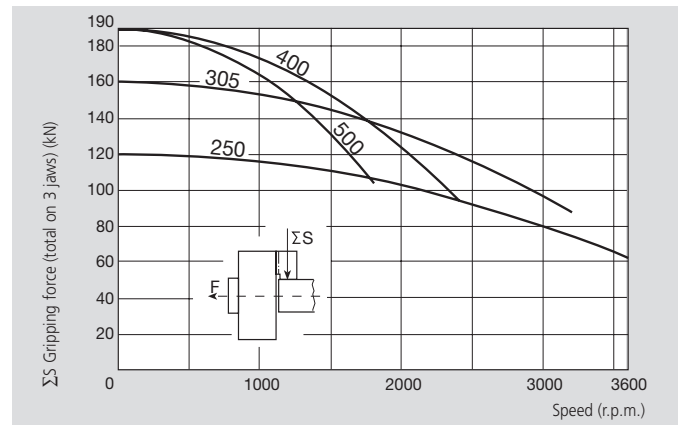
### Ordering example

- 3 jaw chuck RC-D 250/Z220
- 5 sets of D-master jaws (option)
- 5 sets of D-soft top jaws (option)
- or
- 3 jaw chuck R-C 400/A11
- 2 sets of D-master jaws (option)
- 2 sets of D-soft top jaws (option)

### Actual gripping force diagrams



The diagrams refer to 3-jaw chucks. The max. gripping force is the total, acting on the 3 jaws, obtained by applying to the chuck the max. allowed traction to the draw bar. The data refers to a chuck in good conditions, using SMW-AUTOBLOK K05 grease.



The dynamic gripping forces have been measured using the standard soft top jaws placed in the most external position, but not exceeding the outer diameter of the chuck. Using larger and heavier jaws and/or in a more external position, it is necessary to reduce the rotation speed.

### Technical data

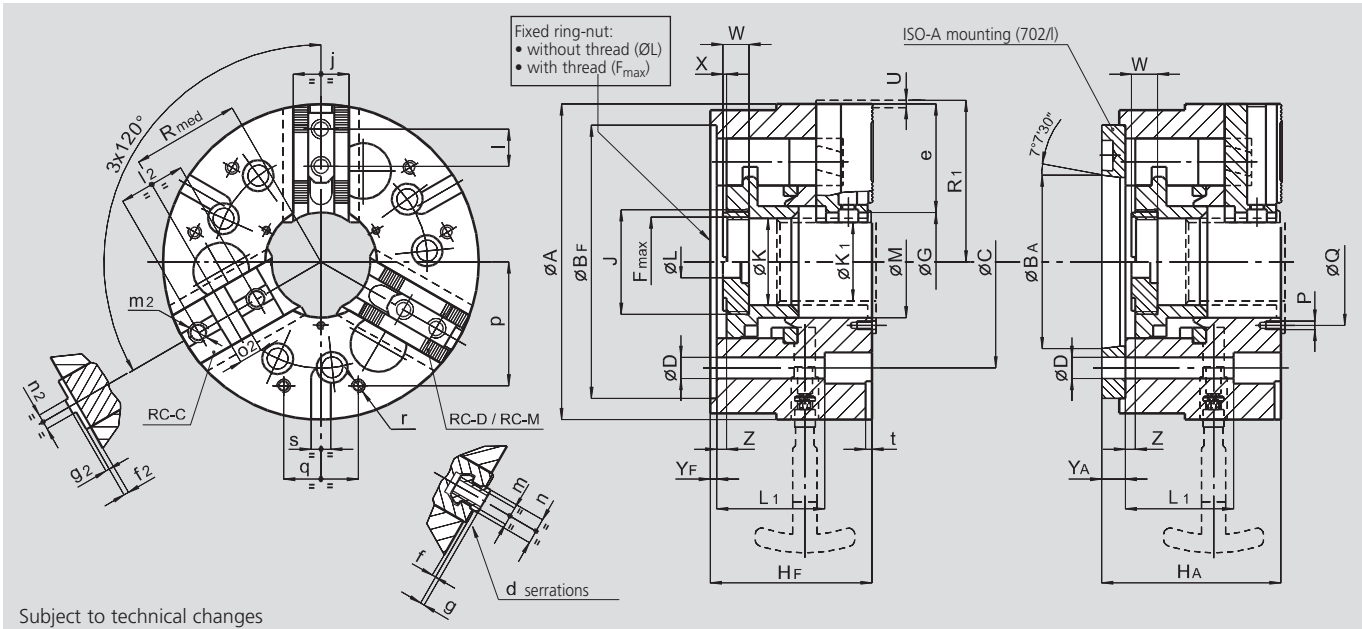
SMW-AUTOBLOK Type		RC-D 165 RC-C 165 RC-M 165	RC-D 210 RC-C 210 RC-M 210	RC-D 250 RC-C 250 RC-M 250	RC-D 305 RC-C 305 RC-M 305	RC-D 400 RC-C 400 RC-M 400
Number of jaws		3	3	3	3	3
Through-hole	mm	43	53	70	86	118
Radial jaw stroke	mm	3.5	4	5	5	6.4
Axial piston stroke	mm	13+8	15+10	19+10	19+10	24+10
Max draw-pull	kN	35	45	60	80	95
Max gripping force	kN	70	90	120	160	190
Max speed	r.p.m.	6000	4500	3600	3200	2400
Mass (without top jaws)	kg	11	24	36	55	100
Moment of inertia	kg · m <sup>2</sup>	0.04	0.15	0.29	0.72	2.1
INCH serration master jaws (RC-D)	Id. No.	73051630	73052130	73052530	73053030	73054030
Tongue & groove master jaws (RC-C)	Id. No.	73031635	73032135	73032535	73033035	73034035
METRIC serration master jaws (RC-M)	Id. No.	73051631	73052131	73052531	73053031	73054031
Recommended cylinders		SIN-S 100/125 VNK 102-46	SIN-S 100/125 VNK 130-52	SIN-S 125/150 VNK 170-77	SIN-S 150/175/200 VNK 200-86	SIN-S 175/200 VNK 320-127



# High precision power chucks Ø 165 - 400 mm

- open center - QUICK CHANGE OF MASTER JAWS
- to use all top jaws
- 3 jaws

**RC-D** | **RC-M** | **RC-C**  
 INCH serration | Metric serration | Tongue & groove  
**QUICK JAW CHANGE**



SMW-AUTOBLOK Type		RC-D/C/M 165		RC-D/C/M 210		RC-D/C/M 250		RC-D/C/M 305			RC-D/C/M 400	
Mounting		Z140	A5	Z170	A6	Z220	A8	Z280	A8	A11	Z300	A11
A	mm	165		210		254		305			390	
Bf/BA	H6 mm	140	82.563	170	106.375	220	139.719	280	139.719	196.869	300	196.869
C	mm	104.8		133.4		171.4		171.4/235	171.4	235	235	
D	mm	11.5		13.5		17		17/21	17	21	21	
F <sub>max</sub>	mm	M50 x 1.5		M60 x 1.5		M72 x 1.5		M95 x 2			M125 x 2	
G*	mm	47.62		60.32		76.2		88.9			127	
Hf/HA	mm	99	109	117	129	130	144	133	147	149	152	168
J	mm	M60 x 1.5		M72 x 1.5		M82 x 1.5		M110 x 2			M140 x 2	
K	mm	43		53		70		86			118	
K1	mm	38.5		48		63		76			108	
L1	mm	66		96		87		87			82	
L	mm	20		20		25		25			25	
M	mm	63		74		90		110			145	
P	mm	M5		M6		M6		M8			M8	
Q	mm	72		86		102		125			160	
Chuck open	R1 mm	82.6		104.5		126.4		151.4			194.7	
	R <sub>med</sub> * mm	53		69.5		85		102.5			130.5	
Jaw stroke	U mm	3.5		4		5		5			6.4	
	W mm	16		18		21		21			22	
	X mm	2		2		3		2			2	
Yf/YA	mm	5	15	5	17	5	19	5	19	21	5	21
max./min.	Z mm	21/0		25/0		29/0		29/0			34/0	
RC-D serration	d inch	1/16" x 90°		1/16" x 90°		1/16" x 90°		1/16" x 90°			1/16" x 90°	
RC-M serration	d mm	1.5 x 60°		1.5 x 60°		1.5 x 60°		1.5 x 60°			1.5 x 60°	
	e mm	57.2		72.3		86		104.5			128	
	f mm	1		1		1		3			5	
	g mm	2.5		2.5		3.5		3.5			3.5	
	j mm	30		34		45		45			55	
RC-D	l mm	16.5		23		30		30			34	
RC-D	m mm	M10		M12		M16		M16			M16	
RC-D	n h8 mm	14		17		21		21			21	
RC-M	l mm	20		25		30		30			34	
RC-M	m mm	M10		M12		M12		M16			M16	
RC-M	n h8 mm	12		14		16		21			21	
	p mm	62		78		100		110			150	
	q mm	30		45		60		100			100	
	r mm	M8		M8		M10		M10			M12	
	s mm	16		16		16		-			20	
	t mm	5		5		5		-			7	
	f2 mm	4		4		4		4			7	
	g2 mm	3		3		3		3			3	
	l2 mm	38		44.4		54		63.5			76.2	
(UNC)	m2 inch	.43754-14		.500-13		.625-11		.625-11			.750-10	
	n2 h8 mm	7.94		7.94		12.70		12.70			12.70	
	o2 H7 mm	12.68		12.68		19.03		19.03			19.03	

\* in gripping positions