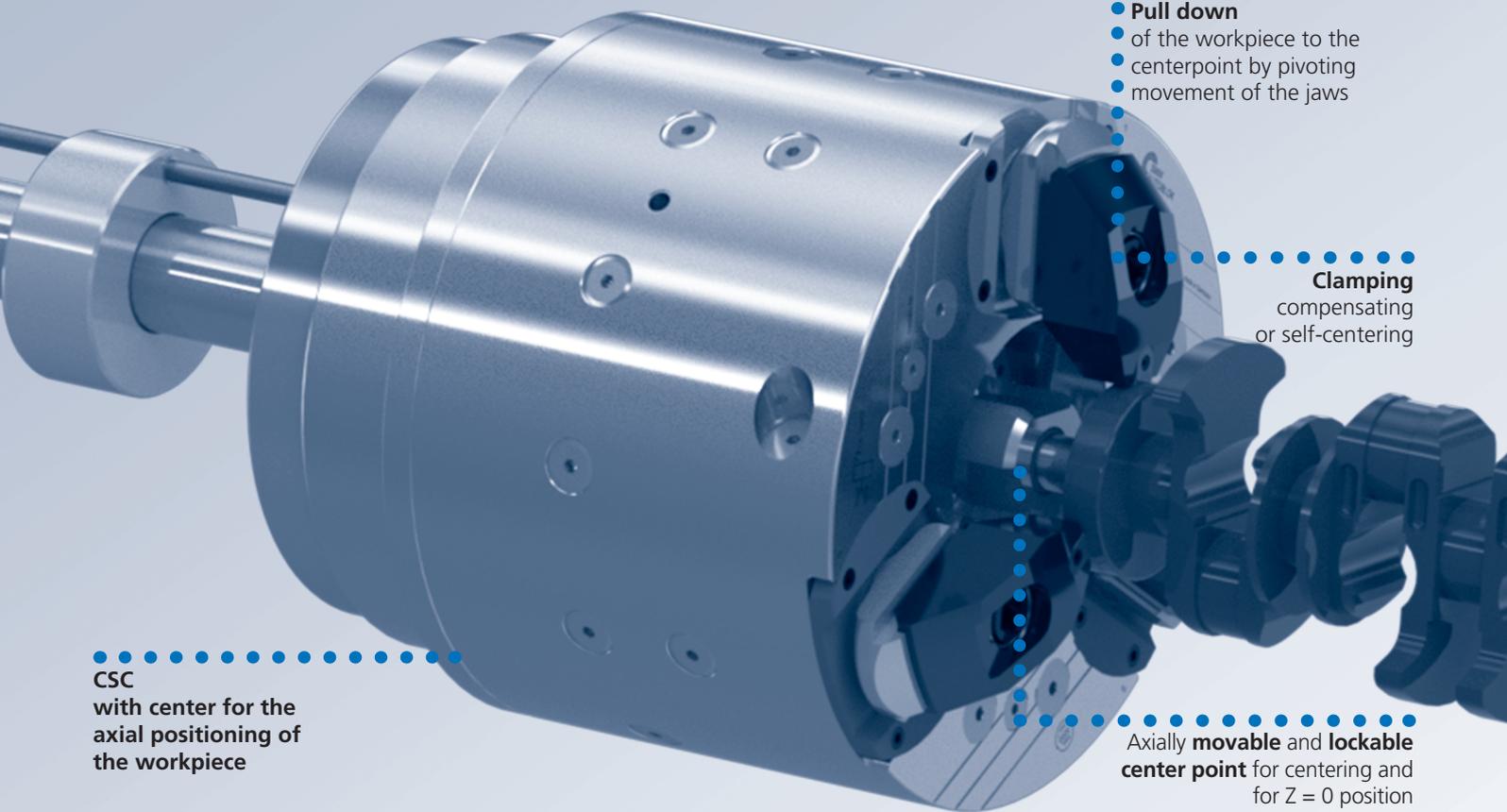


Crank shaft chuck with retractable jaws

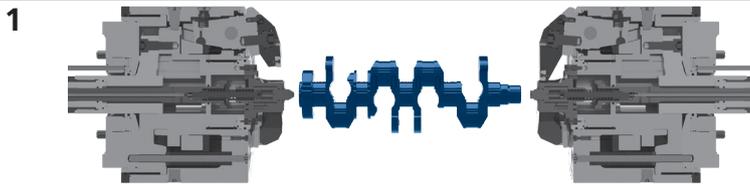


• **Pull down**
• of the workpiece to the
• centerpoint by pivoting
• movement of the jaws

Clamping
compensating
or self-centering

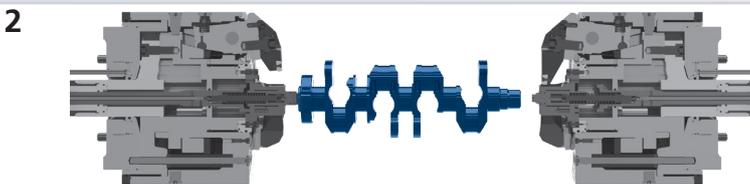
Axially **movable** and **lockable**
center point for centering and
for Z = 0 position

CSC
with center for the
axial positioning of
the workpiece



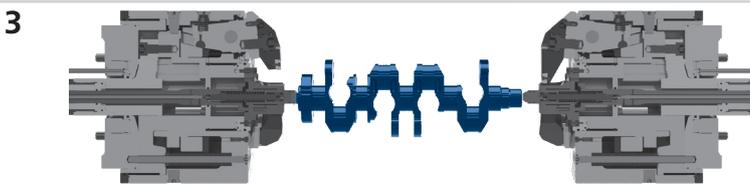
Step 1, loading of the workpiece:

- The centers are retracted
- The jaws are retracted and open



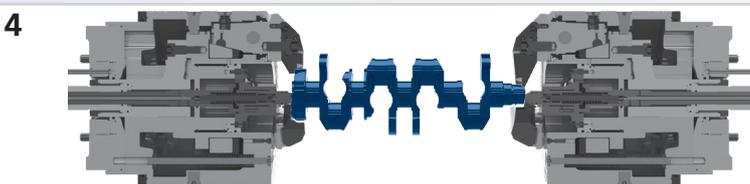
Step 2, create the Z = 0 position:

- The left center point moves forward to its end stop to create the Z = 0 position and is locked
- The jaws are retracted and open



Step 3, centering the workpiece:

- the right center moves forward to center the workpiece between the 2 centers and is locked



Step 4, clamping the workpiece:

- The jaws move forward and clamp the work piece with a pull down effect
- The jaw carrier is locked

Clamping glossary

Pull down: The jaws of the CSC crankshaft chuck clamp inwards by means of a pivoting movement. This generates a **pull-down movement in the Z axis - in the direction of the centering point**. This pull-down movement **prevents the crankshaft from being pushed off the center point** and keeps the crankshaft exactly stable in the center axis. This guarantees **high concentricity accuracies**.

Sealing: The CSC crankshaft chuck is completely sealed and **protected against dirt and coolant**. This prevents inaccuracies, malfunctions and increased wear and makes the system **extremely reliable**.

Low Maintenance: The CSC crankshaft chuck is equipped with **permanent oil bath lubrication**. This allows **continuous operation of the machine** without regular interruptions for maintenance, which guarantees to **increase machine availability**.

Clamping: The centering point and the jaw carrier of the CSC crankshaft chuck are **hydraulically clamped in the clamping position**. This **increases the rigidity** of the clamping system and **reduces vibrations**. This is reflected in **improved workpiece quality** and **reduced tool wear**.

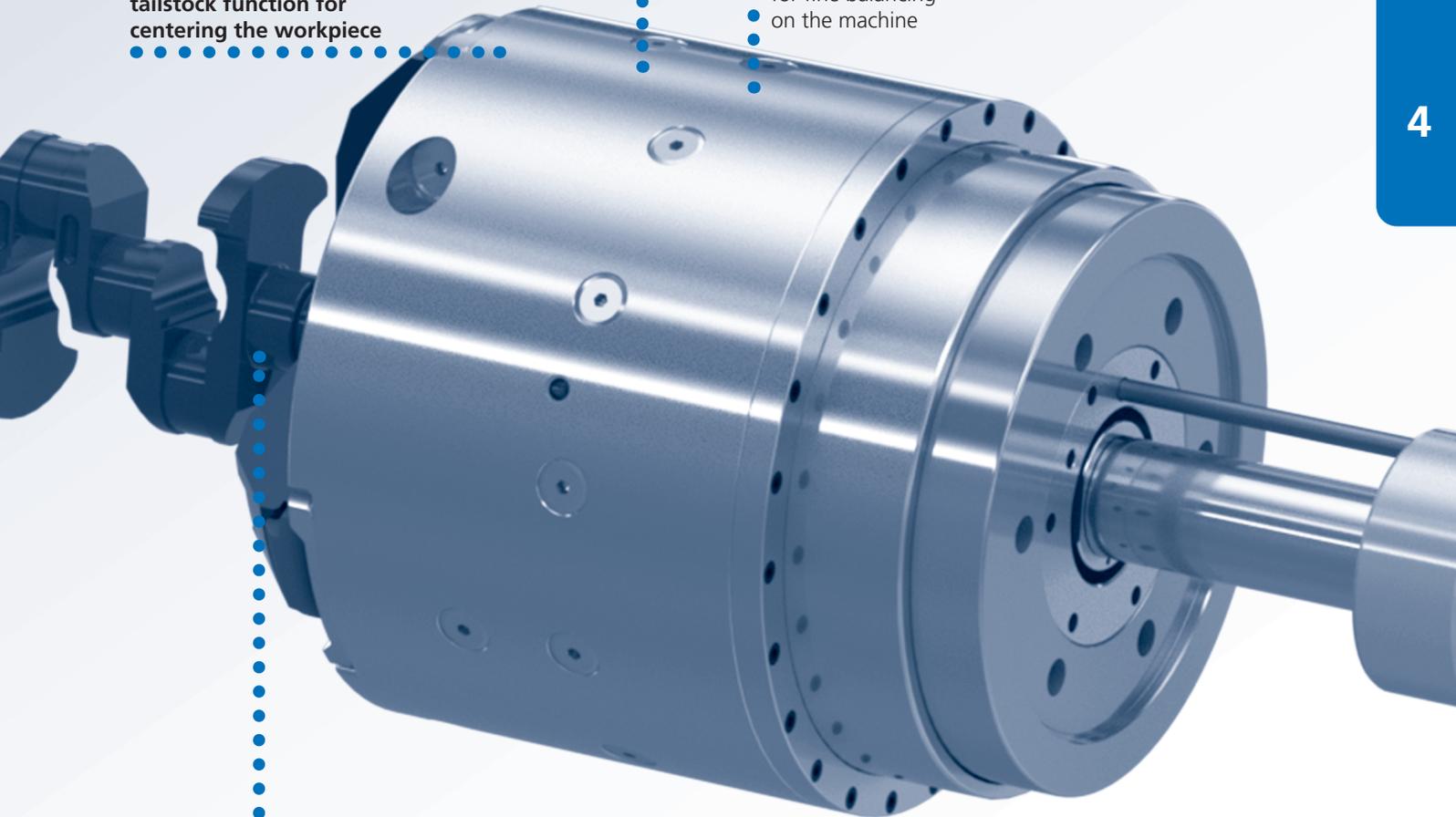
Balancing chambers: The CSC crankshaft chuck has radial **balancing chambers** on the outer diameter. By removing inserted balance weights the **system can be easily fine-balanced on the machine**.

CSC
with center with
tailstock function for
centering the workpiece

low maintenance
due oil bath lubrication

Balancing chambers
for fine balancing
on the machine

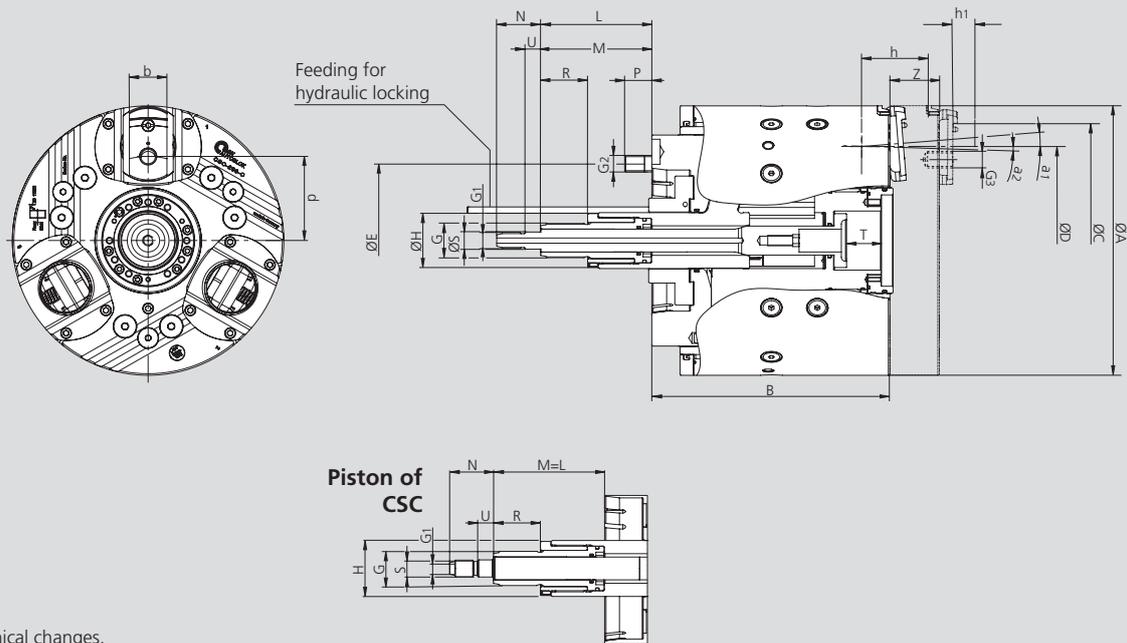
Axially **movable** and **lockable**
center point to center the work
piece (tailstock function)



QUICK JAW CHANGE IN LESS THAN 1 MINUTE



• QUICK AND SIMPLE - NO LOOSE PARTS



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

SMW-AUTOBLOK Type		CSC-260	CSC-325
Mounting		A8	A8
Chuck outside dia.	A	260	325
Chuck height	B	228	274
In clamping position (radius)	C	R115	R143
Max. clamping dia.	D	175	226
	E	171.4	171.4
	G	M33 x 1.5	M45 x 1.5
	G1	M16	M16
	G2	M16	M16
	G3	M16 x 24	M20 x 30
	H	54	72
Push rod center point min. / max.	L	106.3 / 66.5	43 / 123
Min. / max.	M	106.5 / 36.4	83 / 123
	N	42	39
	P	21	24
	R	45	50
	S₆	16.5	16.5
Check dimension center insert	T	33	46
	U	15	-
Axial movement / jaw carrier	Z	53	58
Piston stroke for jaw clamping	Z1	17	22
Opening / residual stroke angle	a1/a2	4.5° / 1.3°	4.5° / 1.3°
Opening / residual stroke at distance h1	h1	4.5 / 1.3	5.7 / 1.9
Max. jaw stroke at distance h1	mm	5.8	7.6
Max. compensation / chuck (type C)	mm	± 1.0	± 1.5
	b	36	44
	d	78	96.5
Reference height	h	57	72
Oil volume horizontal use	l	0.50	0.75
Max. speed*	r.p.m.	4000	3200
Max. draw pull*	kN	55	75
Max. gripping force at reference distance h*	kN	110	150
Moment of inertia	kg·m ²	0.606	1.83
Weight (without top jaws)	kg	70	137

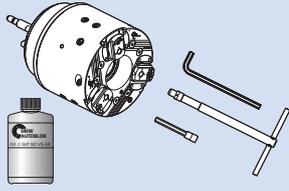
* With higher top jaws, the actuating force and thus the gripping force must be reduced. The maximum speed is reduced accordingly..

■ Ordering review

Crank shaft chuck with retractable jaws

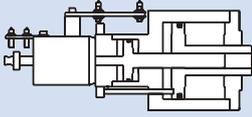
Supply range:

Compensating clamping (Type C) chuck with mounting bolts and mounting keys, oil



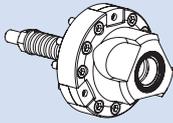
Spindle mounting	Type C	CSC-260	CSC-325
A6		-	-
A8		162600	-
A11		-	-
A15		-	-

Actuating cylinder



Double piston cylinder	Type	DCN
DCN		125-30 / 87 / 40
Id. No.		046796

Centering inserts



Centering insert main and subspindle (without custom center point)		
	CSC-260	CSC-325
	209285	5315643

Oil



Oil for permanent oil bath lubrication	
Oil specification	CGLP ISO VG 68
Contents	1 liter / 1.05 quart (U.S.)
Id. No.	197859