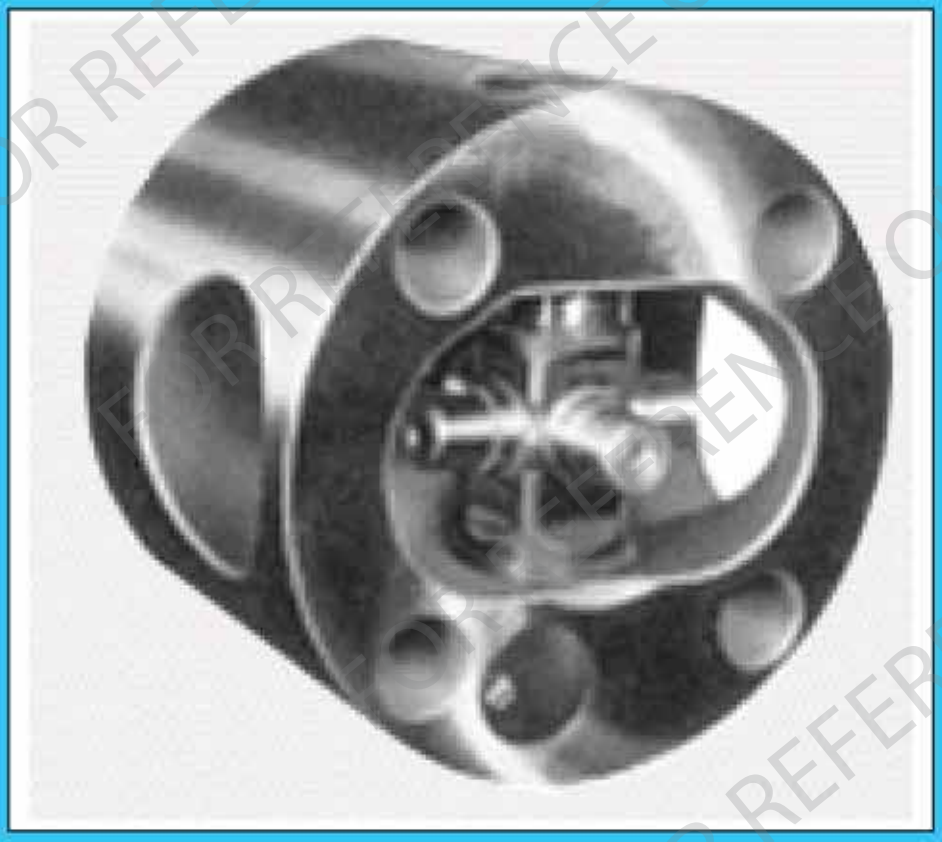
POWER OPERATED
POWER INDEXING CHUCK
POPI



POWER OPERATED POWER INDEXING CHUCKS

The production and machining of components with intersecting axes has for a long time involved high processing expenditure. These components were either processed on special machines, transfer lines or on conventional lathes in several chucking operations.

GMT has developed Indexing Chucks to meet the persistent problems in machining components with intersecting axes.

GMT indexing chucks of different sizes are designed for machining typical parts like Universal joints, spider and valve bodies etc.

GMT's Power Operated Power Indexing chucks are offered with index position:

1. 4×90^0
2. 3×120^0
3. 2×180^0

Indexing Accuracy

Roughing: Approx. 0.1mm at 100mm from indexing centre.
Finishing: 0.03 to 0.05 at 100mm from indexing centre.

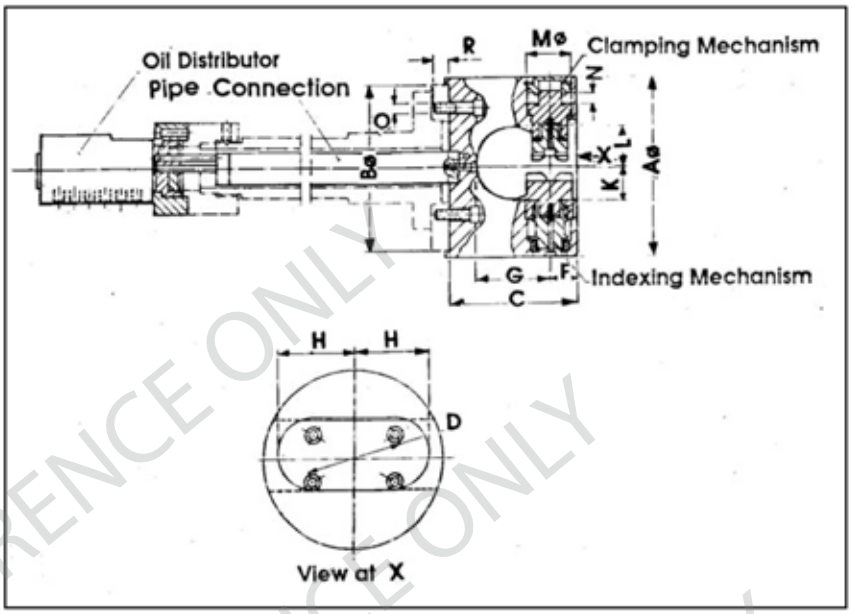
Clamping, declamping, indexing and locking of index drum are performed by integral hydraulic cylinders. The oil fed to the different cylinders through a pipe bundle running through the spindle bore.

The component is clamped by moving the lower jaw through an integral cylinder. The upper jaw is stationary. Thee automatic indexing chucks is hydraulically controlled through two, four-way solenoid valves. In addition the electrical circuit includes an adjustable time delay relay to incorporate short time lag between indexing and locking cycles.

The indexing is done when the main spindle is running

Important information required by us for preparing a quotation

1. Component drawing with operation details.
2. Sample component.
3. Machine spindle drawing.
4. Chuck diameter.
5. Voltage and frequency for power unit & solenoid valve.



DIMENSIONAL SPECIFICATIONS (All dimensions are in mm)

Model No.	20-10	20-11	20-12	20-13
Size ϕ	**200**	**250**	**315**	**400**
A ϕ	200	250	315	400
B ϕ H6	185	185	300	300
C	141	185	227	253
D PCD	104.8	133.4	171.4	171.4
F	30	40	50	60
G (Swing of the Jobs)	82	113	136	170
H	85	106	136	170
K	36.5	46	69.5	95
L	46	55	85	114
M ϕ	50	70	85	100
* N (Jaw Stroke)	12	17	20	28
O	4xM10	4xM12	4xM16	4xM16
R	15	18	27	25
Piston Area (Cm^2)	19.5	38.5	56.5	78.5
Clamping force at 60 bar in kgf	2300	4600	6800	9400
GD^2 in kpm^2	0.5	1.5	5	12
RPM Max	4200	3600	2600	2000
Wt. in kgs (approx.)	20	39	73	115

Note:

* The stroke is for only one jaw. The other jaw is for indexing and will not have any axial movement.

1. Time required for indexing 1-2 secs.
2. Time required for gripping 1 sec.
3. Number of indexing available 4x90°.
4. Customer should send component drawing & spindle drawing for our study to offer suitable jaws & pipe connection.
5. Pipe connection, oil distributor and power pack should also be ordered along with chuck.

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