



ROTA NCA

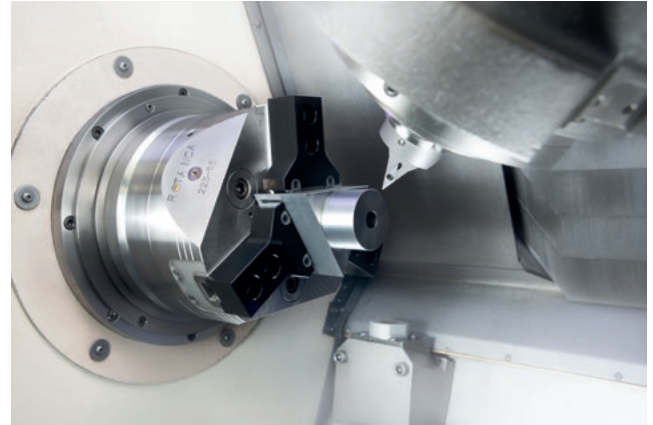
Sealed power lathe chuck for
modern turn/mill centers

Hand in hand for tomorrow

Power lathe chuck with sophisticated sealing system for permanent lubrication and constant clamping forces

Field of application

Constant clamping forces, minimum maintenance effort, as well as a high energy efficiency and productivity are ensured with the versatile ROTA NCA power lathe chuck. The geometry of the chuck body makes ensures a good accessibility of the tools, meaning that the ROTA NCA can be also used on modern turn/mill centers.



Advantages – Your benefits

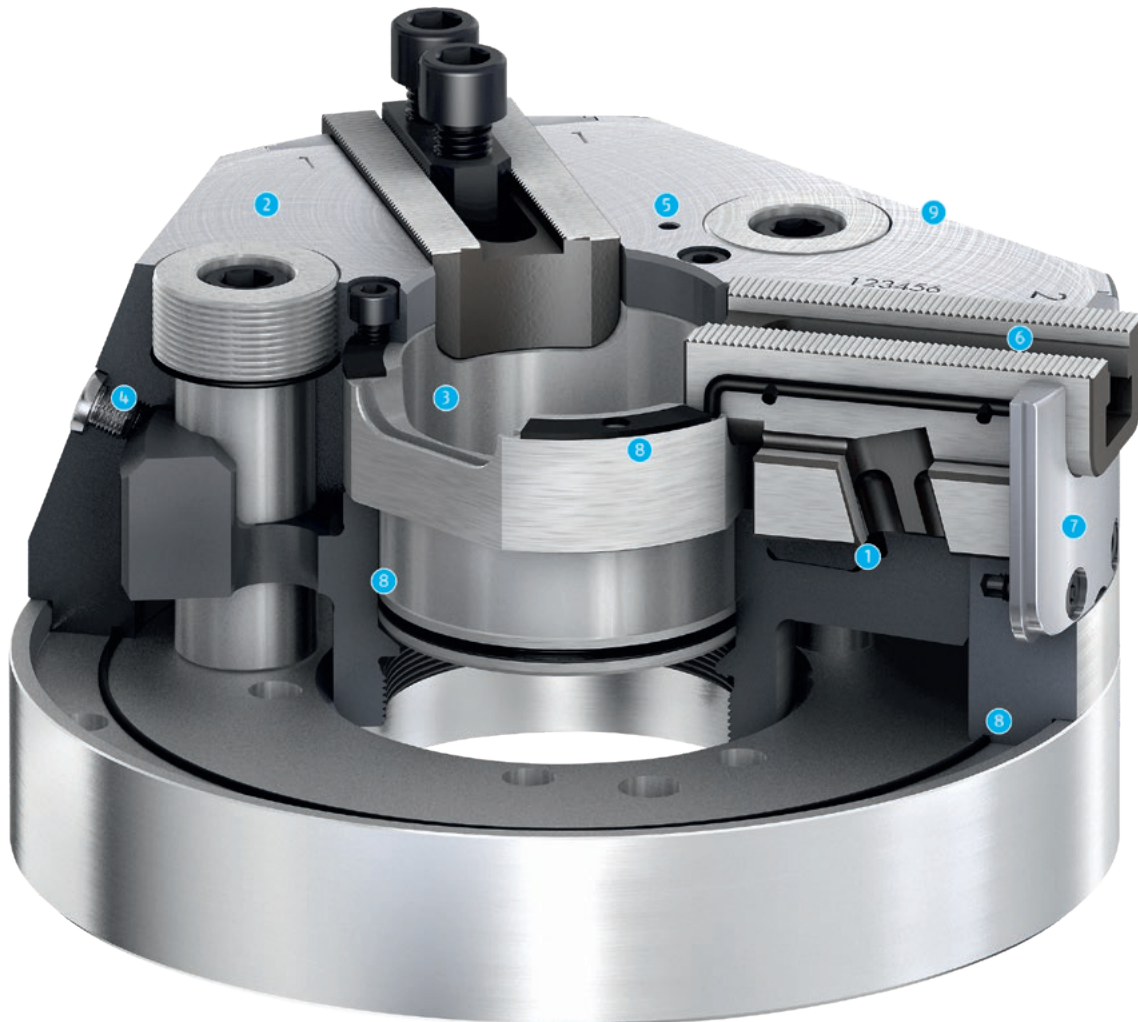
- + Sealed power lathe chuck**
For significantly longer maintenance intervals
- + Permanent grease lubrication**
For consistently high clamping forces
- + Precision wedge-hook power lathe chuck for highest quality requirements**
Allows excellent machining processes
- + High efficiency of the wedge hook system**
Process-reliable clamping due to high clamping forces
- + Low chuck weight**
Fast acceleration and deceleration operations shorten the cycle times
- + Base jaws with fine serration 1.5 mm x 60° and 1/16" x 90° as standard**
High flexibility in the range of top jaws
- + All functional parts are ground and hardened**
Ensures a long life span

Technical data

Description	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke [mm]	Through-hole [mm]
ROTA NCA 160-32	5500	45	20	4	15	32
ROTA NCA 200-52	5000	72	32	5.3	20	52
ROTA NCA 225-66	5000	100	45	5.3	20	66
ROTA NCA 280-86	4000	140	63	5.3	20	86
ROTA NCA 330-104	3500	160	72	5.3	20	104

Function of ROTA NCA

The axially movable piston transfers the force to the base jaw and generates a radial jaw movement synchronized with the rotational axis. The innovative sealing system located on the base jaws, prevents grease from being rinsed out, and the clamping force from being lost gradually.



- 1 Wedge hook drive in ring piston design**
Offers constantly high clamping forces in operation
- 2 Hardened and extremely rigid base body**
Therefore a longer life span at highest precision. Even with maximum clamping force
- 3 Large through-hole**
For machining of all commercially available raw pipe material diameters
- 4 Ventilation hole**
To drain off excess grease
- 5 Mounting threads**
For workpiece stops
- 6 Base jaw serration**
Available in inch or metric sizes
- 7 Cover**
Serves to seal the lathe chuck and additionally as base jaw safety feature
- 8 Sealing of the lathe chuck**
For significantly longer maintenance intervals
- 9 Weight-optimized design**
For great economy in daily use

Innovative sealing system

An innovative sealing system – consisting of a specially designed gasket – prevents grease from being rinsed out during machining. This in turn prevents a gradual loss of clamping force. Advantage: The chuck is additionally protected against the penetration of dirt and chips.

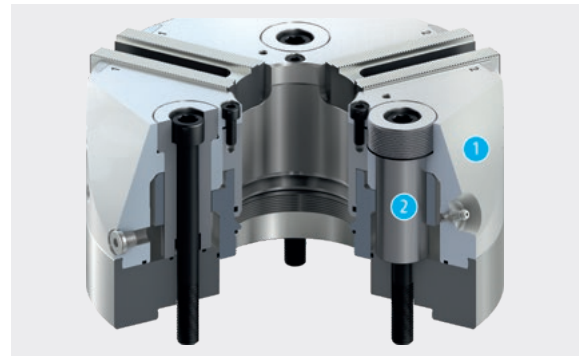
- 1 Gasket



Inlays at the mounting holes

In order to further increase the tightness and stiffness of the chuck, special inlays are installed in the area of the fastening screws.

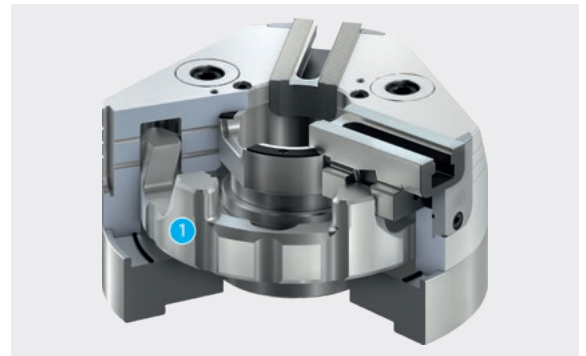
- 1 Chuck body
- 2 Inlay



Long and precise piston guidance

For high clamping repeatability and long service life. All functional components used for force transmission are hardened and ground.

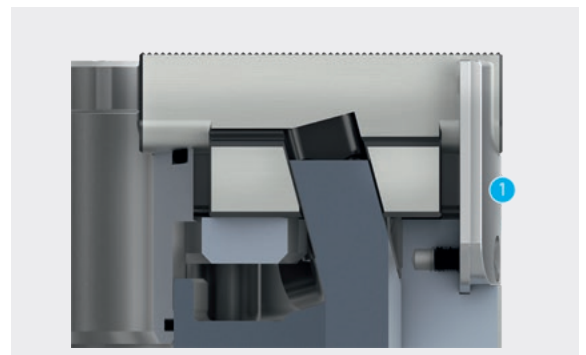
- 1 Ring piston



Base jaw safety feature

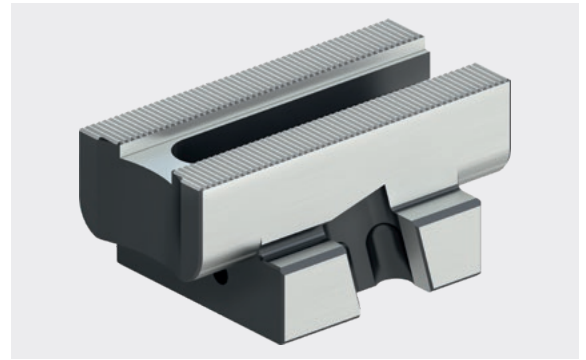
The cover elements form the end piece of the base jaw guidance. Even in the event of a crash it is avoided e.g. in the case of a component failure that the base jaws will be ejected out of the chuck.

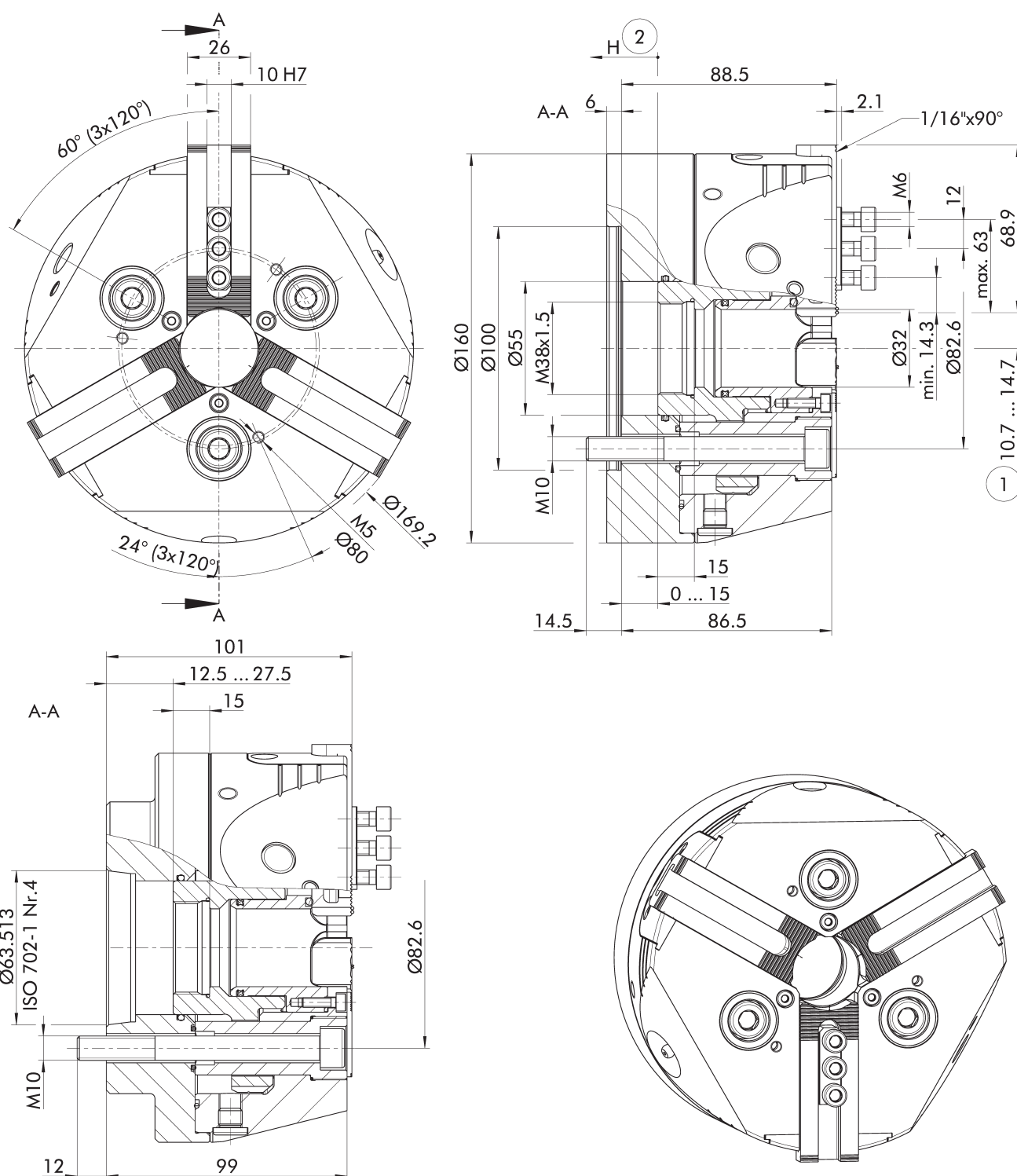
- 1 Cover



Absolute flexibility of the base jaw

Select between two standard jaw interfaces 1/16" x 90° or 1.5 mm x 60° with the benefit of being able to continue using your existing top jaws on the new SCHUNK lathe chuck.





Chuck for shaft clamping drawn in open position.
Subject to technical changes.

① Distance to center of first tooth

② Piston stroke direction

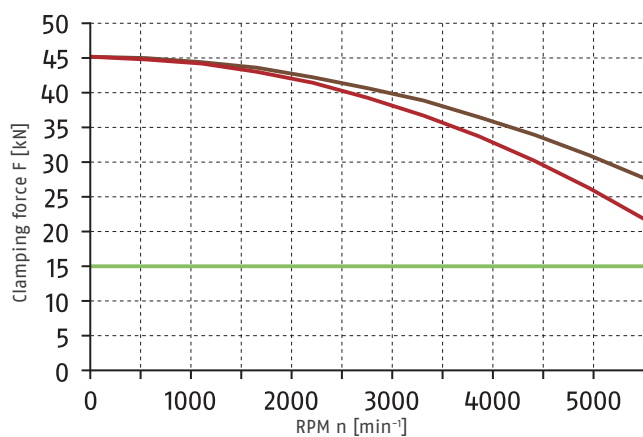
Technical data

Spindle type	Spindle size	ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm ²]	Weight [kg]
ISO 702-4	Nr. 4 (Z100)	1342599	1/16" x 90°	5500	45	20	4	15	0.04	11.5
ISO 702-1	Nr. 4	1342600	1/16" x 90°	5500	45	20	4	15	0.04	11

Scope of delivery

Chuck, T-nuts with screws, chuck mounting screws, and operating manual

Clamping force-RPM-diagram



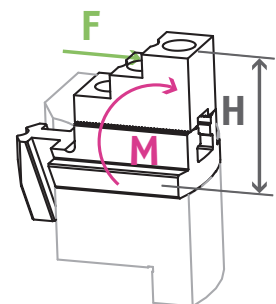
Required minimum clamping force F_{spmin} 33%

SHB-FR 130
0.62 kg

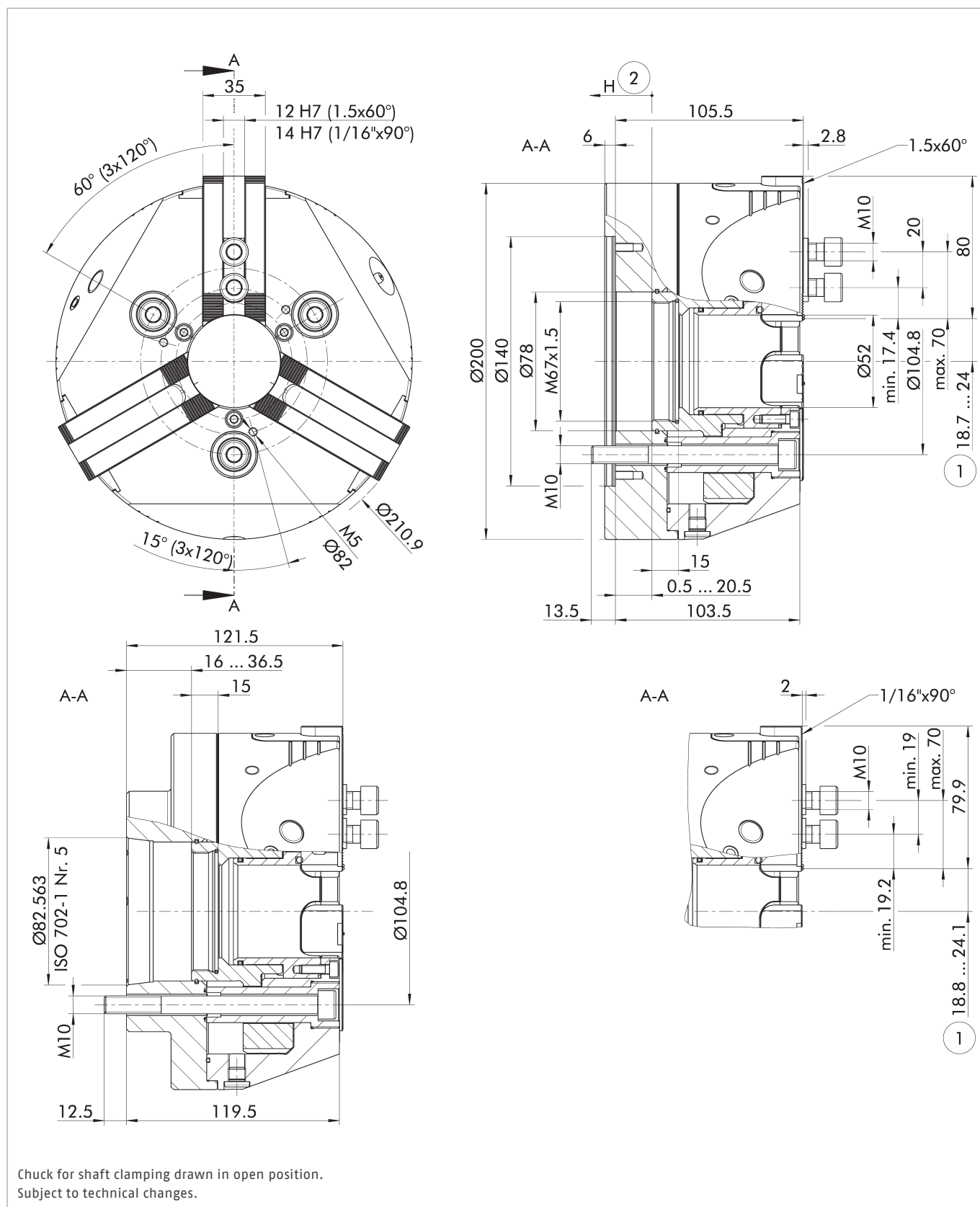
SWB-FR 132
1 kg



Load of base jaw guidance



$$M_{\max} = 323 \text{ Nm}$$



① Distance to center of first tooth

② Piston stroke direction

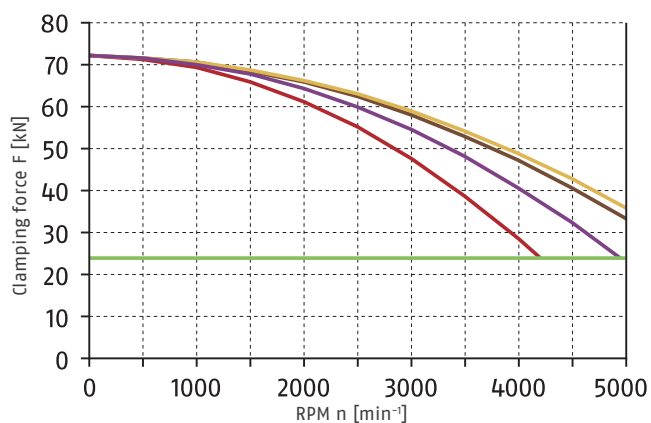
Technical data

Spindle type	Spindle size	ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm ²]	Weight [kg]
ISO 702-4	Nr. 5 (Z140)	1320177	1/16" x 90°	5000	72	32	5.3	20	0.18	19.6
ISO 702-1	Nr. 5	1307920	1/16" x 90°	5000	72	32	5.3	20	0.1	18.7
ISO 702-4	Nr. 5 (Z140)	1307921	1.5 mm x 60°	5000	72	32	5.3	20	0.18	19.6
ISO 702-1	Nr. 5	1307922	1.5 mm x 60°	5000	72	32	5.3	20	0.1	18.7

Scope of delivery

Chuck, T-nuts with screws, chuck mounting screws, and operating manual

Clamping force-RPM-diagram



Required minimum clamping force F_{spmin} 33%

SHB 165
1.3 kg



SWB 165
2.5 kg



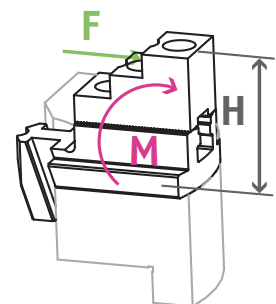
SHB-J 60
0.8 kg



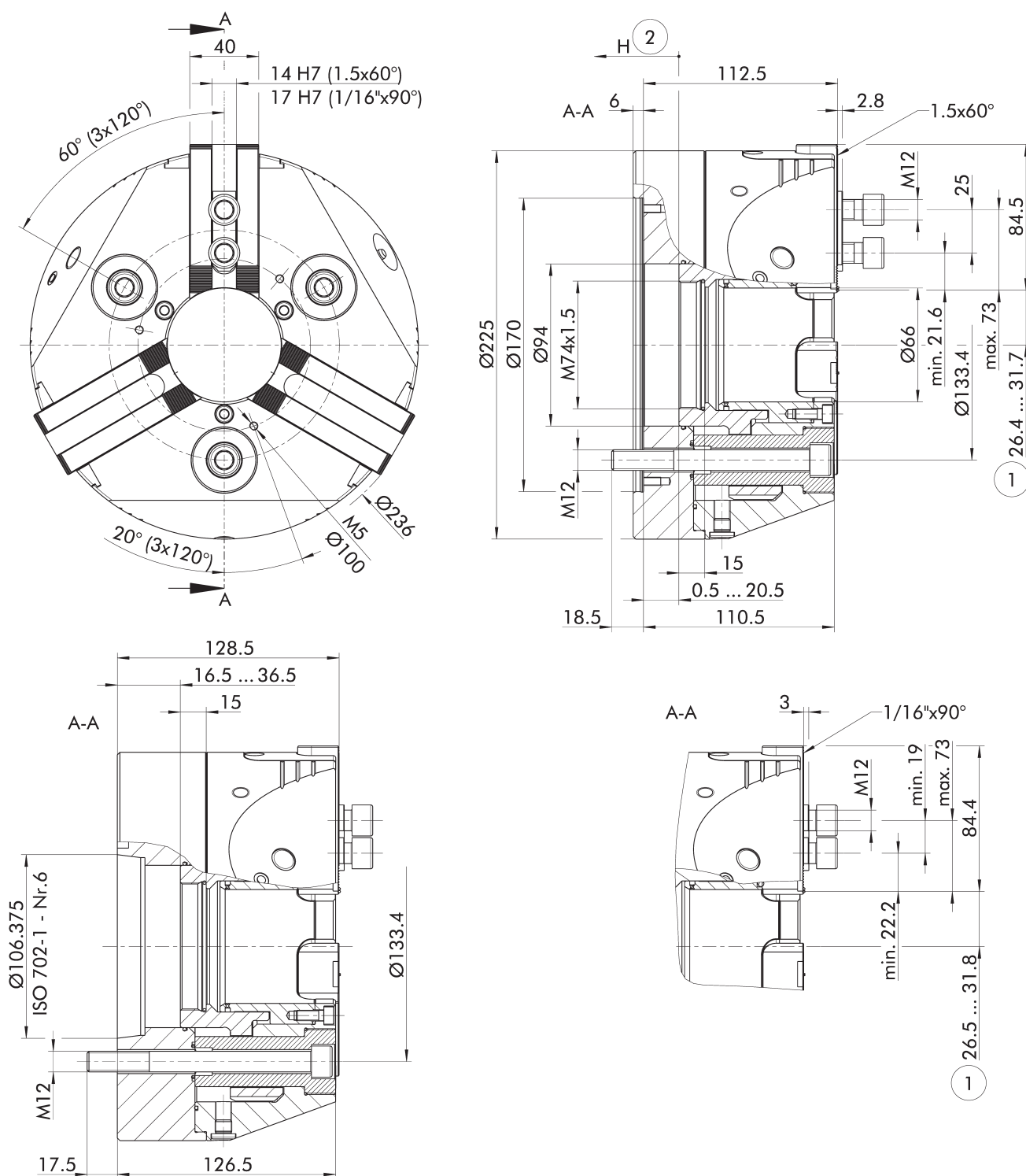
KM-WB 66
1.4 kg



Load of base jaw guidance



$$M_{max} = 972 \text{ Nm}$$



Chuck for shaft clamping drawn in open position.
Subject to technical changes.

① Distance to center of first tooth

② Piston stroke direction

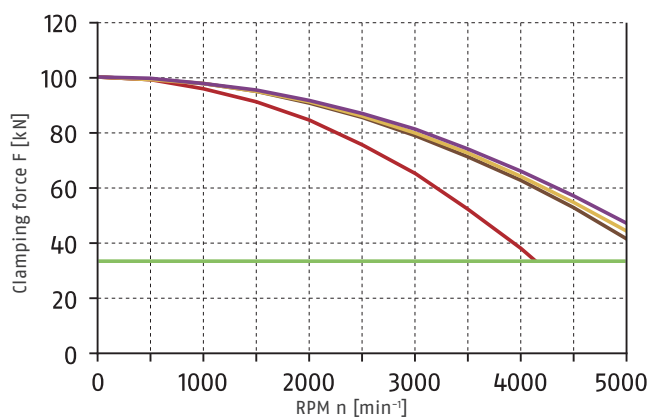
Technical data

Spindle type	Spindle size	ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm ²]	Weight [kg]
ISO 702-4	Nr. 6 (Z170)	1320178	1/16" x 90°	5000	100	45	5.3	20	0.18	26.1
ISO 702-1	Nr. 6	1307923	1/16" x 90°	5000	100	45	5.3	20	0.2	28.9
ISO 702-4	Nr. 6 (Z170)	1320179	1.5 mm x 60°	5000	100	45	5.3	20	0.18	26.1
ISO 702-1	Nr. 6	1320180	1.5 mm x 60°	5000	100	45	5.3	20	0.2	28.9

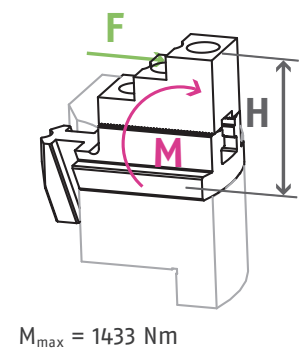
Scope of delivery

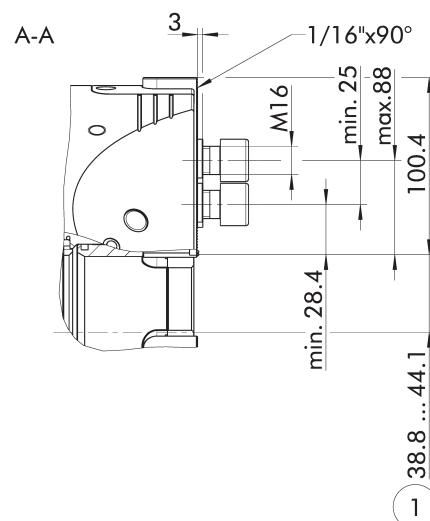
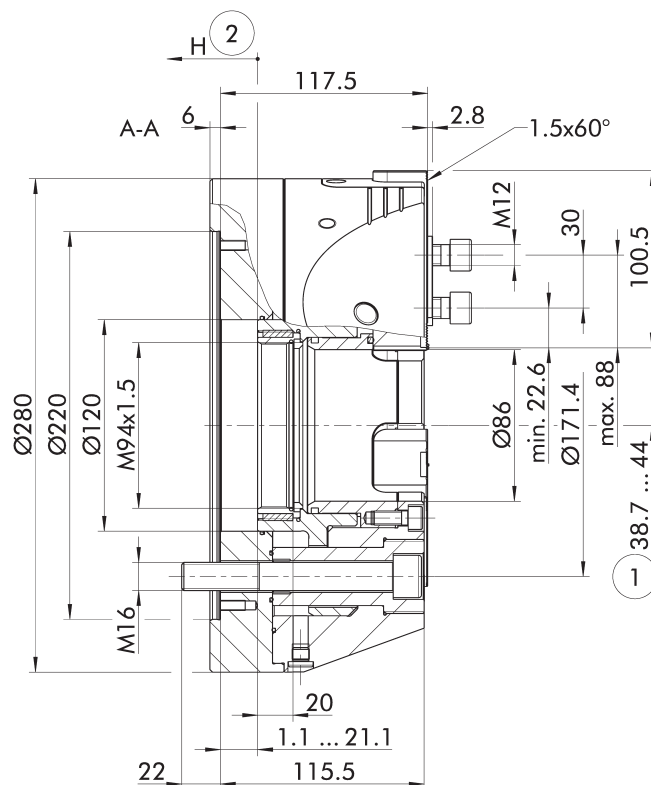
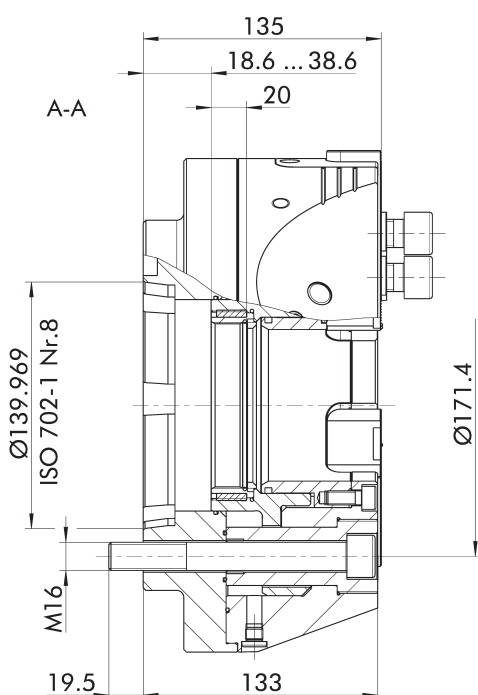
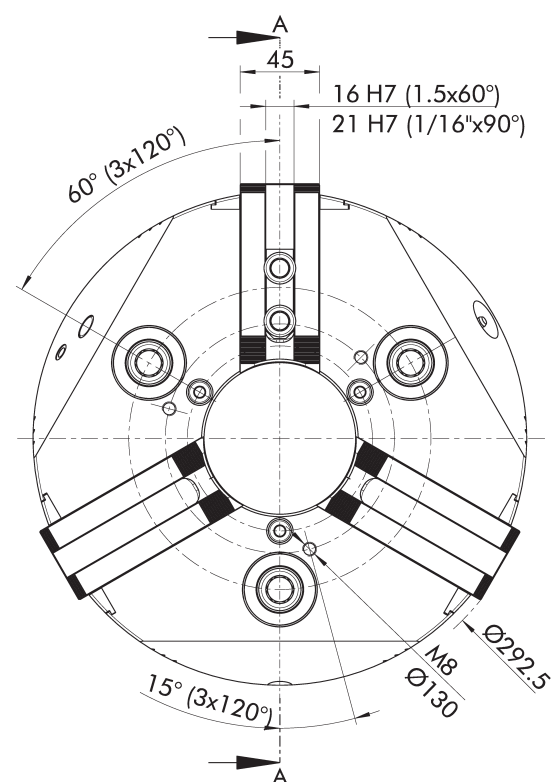
Chuck, T-nuts with screws, chuck mounting screws, and operating manual

Clamping force-RPM-diagram



Load of base jaw guidance





Chuck for shaft clamping drawn in open position.
Subject to technical changes.

① Distance to center of first tooth

② Piston stroke direction

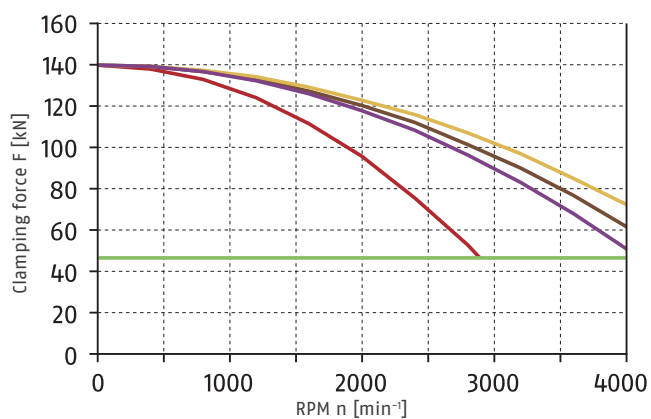
Technical data

Spindle type	Spindle size	ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm ²]	Weight [kg]
ISO 702-4	Nr. 8 (Z220)	1307917	1/16" x 90°	4000	140	63	5.3	20	0.47	41.9
ISO 702-1	Nr. 8	1320182	1/16" x 90°	4000	140	63	5.3	20	0.46	43
ISO 702-4	Nr. 8 (Z220)	1320183	1.5 mm x 60°	4000	140	63	5.3	20	0.47	42.7
ISO 702-1	Nr. 8	1320184	1.5 mm x 60°	4000	140	63	5.3	20	0.46	43

Scope of delivery

Chuck, T-nuts with screws, chuck mounting screws, mounting wrench for turnable threaded ring, eye bolt, and operating manual

Clamping force-RPM-diagram



Required minimum
clamping force F_{spmin} 33%

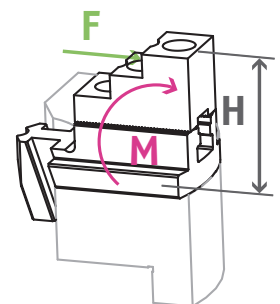
SHB 250
3.5 kg

SWB 250
9.2 kg

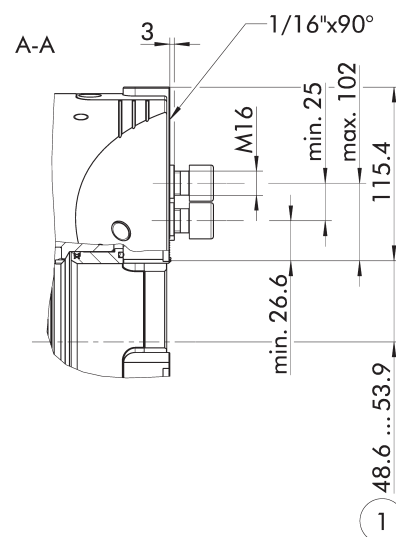
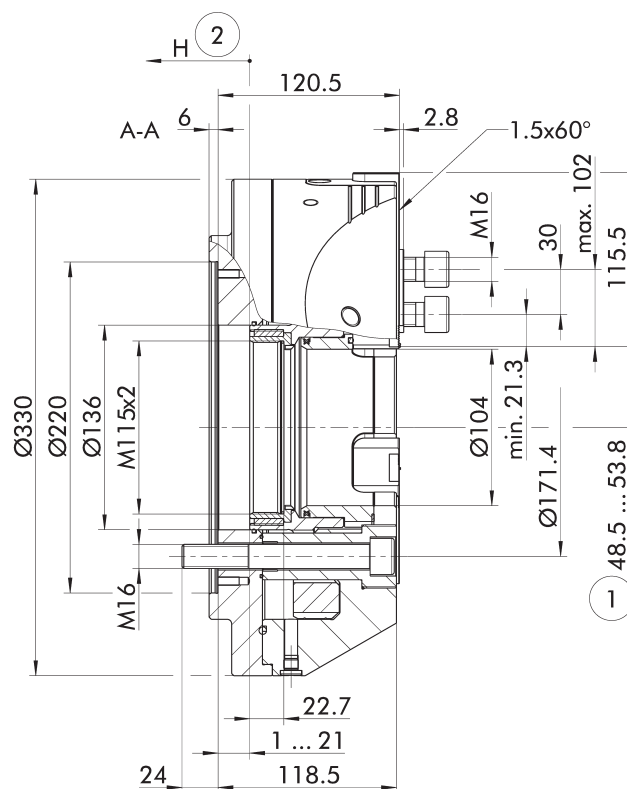
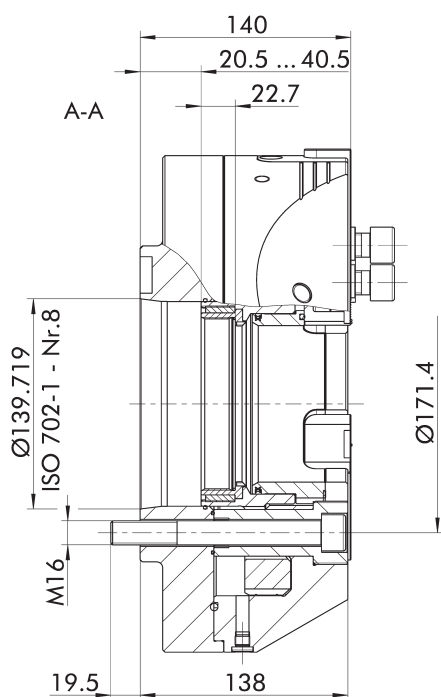
SHB-J 100
2.8 kg

KM-WB 110
3.8 kg

Load of base jaw guidance



$$M_{max} = 2380 \text{ Nm}$$



① Distance to center of first tooth

② Piston stroke direction

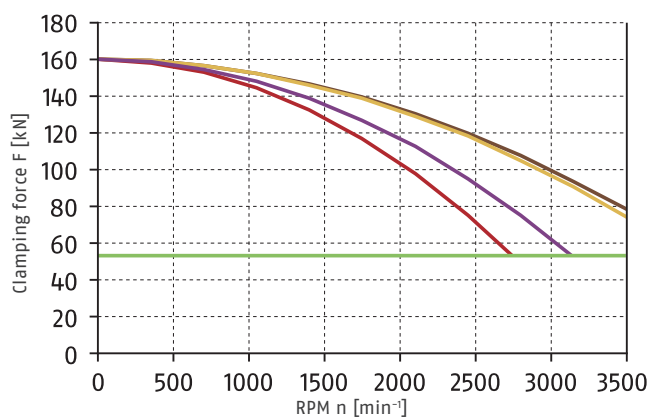
Technical data

Spindle type	Spindle size	ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm ²]	Weight [kg]
ISO 702-4	Nr. 8 (Z220)	1342606	1/16" x 90°	3500	160	72	5.3	20	0.85	56.6
ISO 702-1	Nr. 8	1342607	1/16" x 90°	3500	160	72	5.3	20	0.95	62.7
ISO 702-4	Nr. 8 (Z220)	1342608	1.5 mm x 60°	3500	160	72	5.3	20	0.85	56.7
ISO 702-1	Nr. 8	1342609	1.5 mm x 60°	3500	160	72	5.3	20	0.95	62.8

Scope of delivery

Chuck, T-nuts with screws, chuck mounting screws, mounting wrench for turnable threaded ring, eye bolt, and operating manual

Clamping force-RPM-diagram



Required minimum clamping force F_{spmin} 33%

SHB 250
3.5 kg



SWB 250
9.2 kg



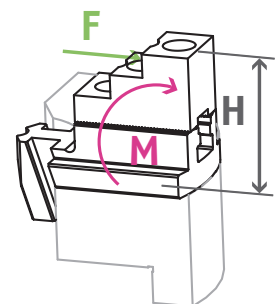
SHB-J 126
5.15 kg



KM-WB 126
7.56 kg



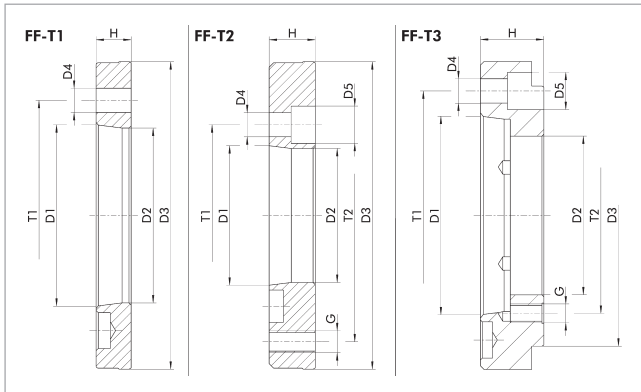
Load of base jaw guidance



$$M_{max} = 2720 \text{ Nm}$$

Adapter plates

Z-mount on short taper ISO 702-1



Technical data

Description	Adapter plate type	ID	Suitable for	D1	D2	D3	D4	D5	G	H	T1	T2
					[mm]		[mm]	[mm]		[mm]	[mm]	[mm]
FF-T1 Z100-A4	FF-T1	0803010	ROTA NCA 160-32	Nr. 4	61	Z100	11 (6 x 60°)			12	82.6	
FF-T3 Z100-A5	FF-T3	0801008	ROTA NCA 160-32	Nr. 5	66	Z100	11 (6 x 60°)	17	M10 (6 x 60°)	30	104.8	82.6
FF-T2 Z140-A4	FF-T2	0805000	ROTA NCA 200-52	Nr. 4	61	Z140	11 (6 x 60°)	17	M10 (6 x 60°)	21	82.6	104.8
FF-T1 Z140-A5	FF-T1	0803000	ROTA NCA 200-52	Nr. 5	79.6	Z140	11 (6 x 60°)			16	104.8	
FF-T3 Z140-A6	FF-T3	0801000	ROTA NCA 200-52	Nr. 6	85	Z140	13 (6 x 60°)	20	M10 (6 x 60°)	34	133.4	104.8
FF-T2 Z170-A5	FF-T2	0805001	ROTA NCA 225-66	Nr. 5	79.6	Z170	11 (6 x 60°)	18	M12 (12 x 30°)	25	104.8	133.4
FF-T1 Z170-A6	FF-T1	0803001	ROTA NCA 225-66	Nr. 6	103.2	Z170	13 (6 x 60°)			17	133.4	
FF-T3 Z170-A8	FF-T3	0801001	ROTA NCA 225-66	Nr. 8	113	Z170	17 (6 x 60°)	26	M12 (6 x 60°) M12 (2 x 180°)	40	171.4	133.4
FF-T2 Z220-A5	FF-T2	0805002	ROTA NCA 280-86 ROTA NCA 330-104	Nr. 5	79.6	Z220	11 (6 x 60°)	17	M16 (6 x 60°) M16 (2 x 180°)	28	104.8	171.4
FF-T2 Z220-A6	FF-T2	0805003	ROTA NCA 280-86 ROTA NCA 330-104	Nr. 6	103.2	Z220	13 (6 x 60°)	20	M16 (6 x 60°) M16 (2 x 180°)	28	133.4	171.4
FF-T1 Z220-A8	FF-T1	0803002	ROTA NCA 280-86 ROTA NCA 330-104	Nr. 8	136.2	Z220	17 (6 x 60°) 17 (2 x 180°)			19	171.4	
FF-T3 Z220-A11	FF-T3	0803003	ROTA NCA 280-86 ROTA NCA 330-104	Nr. 11	130	Z220	21 (6 x 60°)	32	M16 (12 x 30°)	50	235	171.4

Direct adapter plates FF-T1

Direct adapter plates are used if the spindle mounting bolt circle has the same size as the lathe chuck mounting bolt circle. The adapter plate has to be mounted on to the spindle together with the lathe chuck. The adapter plate is preassembled on the lathe chuck.

Reduction adapter plates FF-T2

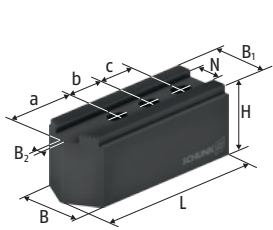
Reduction adapter plates are used if the mounting bolt circle of the spindle is smaller than the lathe chuck mounting bolt circle. The adapter plate is first mounted on the spindle and then the lathe chuck is mounted on the adapter plate.

Expansion adapter plates FF-T3

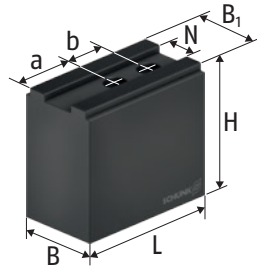
Expansion adapter plates are used if the mounting bolt circle of the spindle is larger than the lathe chuck mounting bolt circle. The adapter plate is first mounted on the spindle and then the lathe chuck is mounted on the adapter plate.

Soft top jaws

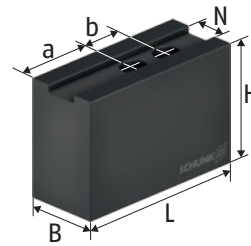
with fine serration 60°



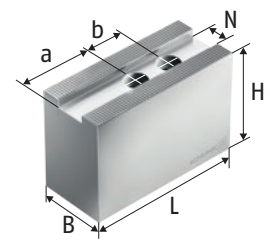
SKNL
Soft top jaws



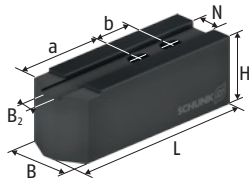
SKN
Soft top jaws



KM-WB
Soft top jaws



KM-WBAL
Soft top jaws



KM-WBL
Soft top jaws

Technical data

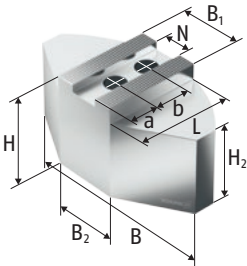
Chuck type	Description	ID	N [mm]	B [mm]	B1 [mm]	H [mm]	L [mm]	a [mm]	b [mm]	c [mm]	Screws	m/SET [kg]
ROTA NCA 200-52	KM-WBL 60	0132600	12	32		32	82	47	20		M10	1.5
ROTA NCA 200-52	KM-WBL 62	0132606	12	35		60	82	47	20		M10	3.1
ROTA NCA 200-52	KM-WB 61	0130128	12	35		60	72	37	20		M10	2.9
ROTA NCA 200-52	KM-WB 66	0132138	12	32		32	72	37	20		M10	1.4
ROTA NCA 200-52	KM-WBAL 70	0132521	12	35		50	72	37	20		M10	0.9
ROTA NCA 225-66	KM-WBL 80	0132601	14	35		40	102	57	25		M12	2.7
ROTA NCA 225-66	KM-WBL 81	0132607	14	40		80	102	57	25		M12	6.0
ROTA NCA 225-66	KM-WBL 82	0132615	14	40		100	102	57	25		M12	7.6
ROTA NCA 225-66	SKNL 215	0128101	14	40	34	42	102	42	22	22	M10	2.9
ROTA NCA 225-66	KM-WB 84	0132126	14	35		60	95	46	25		M12	3.9
ROTA NCA 225-66	KM-WB 85	0132127	14	40		80	95	46	25		M12	6.1
ROTA NCA 225-66	KM-WB 88	0132139	14	35		40	95	46	25		M12	2.7
ROTA NCA 225-66	KM-WBAL 80	0132522	14	40		60	90	45	25		M12	1.5
ROTA NCA 225-66	SKN 215	0127103	14	35	34	60	89	45	26		M10	3.6
ROTA NCA 280-86	KM-WBL 100	0132602	16	40		42	125	65	30		M12	4.1
ROTA NCA 280-86	KM-WBL 101	0132608	16	40		100	125	65	30		M12	9.8
ROTA NCA 280-86	KM-WBL 103	0132609	16	40		60	125	65	30		M12	5.7
ROTA NCA 280-86	KM-WB 102	0132104	16	40		60	90	45	30		M12	4.3
ROTA NCA 280-86	KM-WB 103	0132105	16	40		60	110	50	30		M12	5.2
ROTA NCA 280-86	KM-WB 104	0132106	16	50		80	90	45	30		M12	7.3
ROTA NCA 280-86	KM-WB 105	0132129	16	40		80	110	50	30		M12	7.2
ROTA NCA 280-86	KM-WB 106	0132152	16	40		100	120	60	30		M12	9.7
ROTA NCA 280-86	KM-WB 110	0132140	16	40		42	110	50	30		M12	3.8
ROTA NCA 280-86	KM-WB 111	0132147	16	50		50	120	60	30		M12	6.2
ROTA NCA 280-86	KM-WBAL 100	0132523	16	40		60	110	55	30		M12	1.9
ROTA NCA 330-104	KM-WBL 121	0132604	21	50		50	145	85	30		M16	6.9
ROTA NCA 330-104	KM-WBL 125	0132618	21	50		100	145	85	30		M16	13.9
ROTA NCA 330-104	KM-WB 126	0132131	21	50		60	129	60	30		M16	7.6

Chuck type	Description	ID	N [mm]	B [mm]	B1 [mm]	H [mm]	L [mm]	a [mm]	b [mm]	c [mm]	Screws	m/SET [kg]
ROTA NCA 330-104	KM-WB 127	0132148	21	50		100	140	71	30		M16	13.8
ROTA NCA 330-104	KM-WB 128	0132154	21	50		80	129	60	30		M16	10.1
ROTA NCA 330-104	KM-WBAL 121	0132525	21	50		80	130	60	30		M16	3.8
ROTA NCA 330-104	SKN 350	0127107	21	50	49	80	120	67	28		M16	9.1

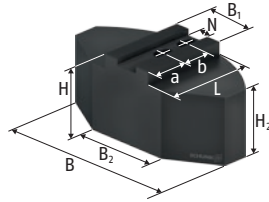
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](https://www.schunk.com)

Hard stepped top jaws, Full grip jaws

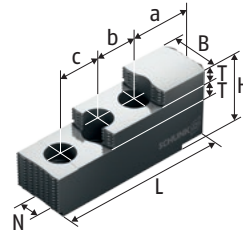
with fine serration 60°



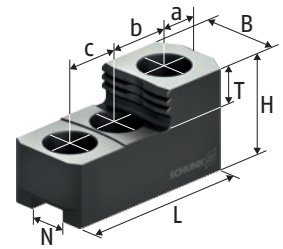
KMWB-SA
Full grip jaws



KMWB-SM
Full grip jaws



SHB-J
Hard stepped top jaws



SHB-J
Hard stepped top jaws

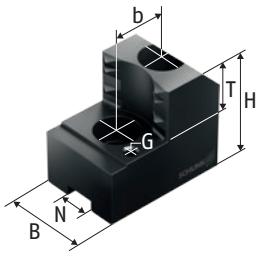
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	B1 [mm]	H [mm]	H2 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	c [mm]	Screws	m/SET [kg]
ROTA NCA 200-52	KMWB-SA 165	0132800	12	120	32	58	48	59.5		25	20		M10	2.2
ROTA NCA 200-52	KMWB-SM 165	0132700	12	120	32	50	40	60		24	20		M10	4.9
ROTA NCA 200-52	SHB-J 60	0133100	12	28		36		67	12	14	20	20	M10	0.8
ROTA NCA 225-66	KMWB-SA 210	0132801	14	140	35	58	48	72.5		35	25		M12	3.1
ROTA NCA 225-66	KMWB-SA 211	0132805	14	140	35	80	70	72.5		35	25		M12	4.5
ROTA NCA 225-66	KMWB-SM 210	0132701	14	140	35	60	50	70		30	25		M12	8.8
ROTA NCA 225-66	KMWB-SM 211	0132705	14	140	35	80	70	70		30	25		M12	12.3
ROTA NCA 225-66	SHB-J 80	0133109	14	35		51		87	12	15.5	25	25	M12	1.8
ROTA NCA 225-66	SHB-J 82	0133110	14	32		38		79	12	16	25	25	M12	1.2
ROTA NCA 280-86	KMWB-SA 250	0132802	16	180	40	58	43	87.5		40	30		M12	4.5
ROTA NCA 280-86	KMWB-SA 251	0132806	16	180	40	80	65	87.5		40	30		M12	6.6
ROTA NCA 280-86	KMWB-SM 250	0132702	16	180	40	60	45	80		29	30		M12	12.0
ROTA NCA 280-86	KMWB-SM 251	0132706	16	180	40	80	70	80		29	30		M12	18.0
ROTA NCA 280-86	SHB-J 100	0133111	16	40		54		101.5	13	25.5	30	30	M12	2.8
ROTA NCA 280-86	SHB-J 102	0133109	16	35		42		83	15	19	25	25	M12	1.5
ROTA NCA 330-104	KMWB-SA 301	0132804	21	240	50	78	63	117		45	30		M16	10.9
ROTA NCA 330-104	KMWB-SM 301	0132704	21	240	50	70	55	110		45	30		M16	26.4
ROTA NCA 330-104	SHB-J 126	0133105	21	50		62		128	14	46	30	30	M16	5.2
ROTA NCA 330-104	SHB-J 122	0133113	21	50		52		104	18	20	30	30	M16	3.3

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Claw jaws

with fine serration 60°



SZAJ
Claw jaws

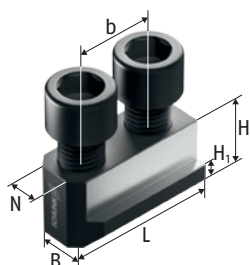
Technical data

Chuck type	Clamping range ØD	Swing diameter SDmax	Description	ID	N	B	H	T	G	b	Screws	m/SET
	[mm]	[mm]			[mm]	[mm]	[mm]	[mm]		[mm]		[kg]
ROTA NCA 200-52	27 - 89	216	SZAJ 16-6	0176100	12	30	47	20	M6	20	M10	1.2
ROTA NCA 200-52	36 - 105	215	SZAJ 16-7	0176101	12	30	47	20	M6	20	M10	1.0
ROTA NCA 200-52	52 - 121	213	SZAJ 16-8	0176102	12	30	47	20	M6	20	M10	1.1
ROTA NCA 200-52	66 - 134	215	SZAJ 16-9	0176103	12	30	47	20	M6	20	M10	1.1
ROTA NCA 200-52	82 - 150	215	SZAJ 16-10	0176104	12	40	47	20	M6	20	M10	1.2
ROTA NCA 225-66	29 - 87	237	SZAJ 20-1	0138110	14	35	53	25	M6	25	M12	1.9
ROTA NCA 225-66	56 - 114	238	SZAJ 20-2	0138112	14	35	53	25	M6	25	M12	1.6
ROTA NCA 225-66	86 - 145	238	SZAJ 20-3	0138114	14	40	53	25	M6	25	M12	1.7
ROTA NCA 225-66	116 - 175	240	SZAJ 20-4	0138116	14	40	53	25	M6	25	M12	1.6
ROTA NCA 280-86	40 - 116	296	SZAJ 25-1	0138117	16	40	58	25	M6	30	M12	2.9
ROTA NCA 280-86	83 - 158	298	SZAJ 25-2	0138119	16	40	58	25	M6	30	M12	2.3
ROTA NCA 280-86	125 - 202	302	SZAJ 25-3	0138121	16	40	58	25	M6	30	M12	2.1
ROTA NCA 280-86	170 - 248	316	SZAJ 25-4	0138123	16	40	58	25	M6	30	M12	2.3
ROTA NCA 280-86	207 - 283	348	SZAJ 25-15	0138118	16	40	58	25	M6	30	M12	2.8
ROTA NCA 330-104			SZAJ 30-5	0138131	21	50	65	25	M8	30	M16	3.8
ROTA NCA 330-104	102 - 208	379	SZAJ 30-6	0138132	21	50	65	25	M8	30	M16	4.1
ROTA NCA 330-104	168 - 275	368	SZAJ 30-7	0138133	21	50	65	25	M8	30	M16	3.4
ROTA NCA 330-104	232 - 339	412	SZAJ 30-8	0138134	21	50	65	25	M8	30	M16	4.8

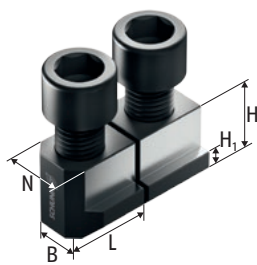
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T-nut

with fine serration 60°



NJ
T-nut



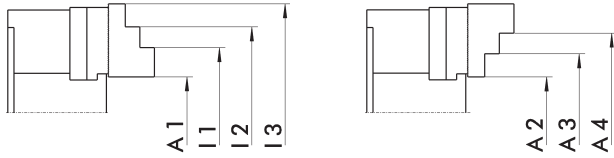
NJ sawn
T-nut

Chuck type	Description	ID	H	H1	b	G	Cyl.-screw	Max. adm. tightening torque
			[mm]	[mm]	[mm]			[Nm]
ROTA NCA 200-52	NJ 62	0146133	18.5	7.5	20	M10	M10 x 25	50
ROTA NCA 225-66	NJ 82 gesägt/sawn	0146005	20.5	8.5		M12	M12 x 30	70
ROTA NCA 225-66	NJ 82	0146131	20.5	8.5	25	M12	M12 x 30	70
ROTA NCA 280-86	NJ 103 gesägt/sawn	0146002	21.5	8.5		M12	M12 x 30	70
ROTA NCA 280-86	NJ 103	0146132	21.5	8.5	30	M12	M12 x 30	70
ROTA NCA 330-104	NJ 124 gesägt/sawn	0146000	28	11.5		M16	M16 x 40	150
ROTA NCA 330-104	NJ 124	0146123	28	11.5	30	M16	M16 x 40	150

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Hard stepped top jaws

with fine serration 60°



Jaw position I

Jaw position II

O.D. clamping

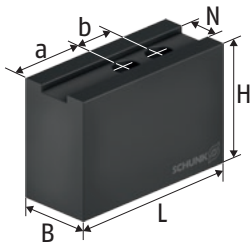
Chuck type	Description	ID	A1 [mm]	A4 [mm]	A2 [mm]	A3 [mm]
ROTA NCA 200-52	SHB-J 60	0133100	11 - 86	86 - 156		
ROTA NCA 225-66	SHB-J 80	0133109	18 - 73	134 - 188	22 - 76	84 - 138
ROTA NCA 280-86	SHB-J 100	0133111	15 - 104	155 - 228	35 - 108	121 - 161
ROTA NCA 330-104	SHB-J 126	0133105	20 - 108	227 - 299	43 - 115	135 - 207

I.D. clamping

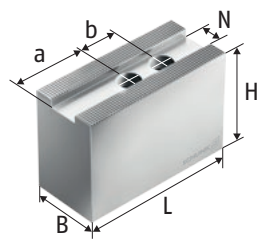
Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA NCA 200-52	SHB-J 60	0133100	67 - 144		
ROTA NCA 225-66	SHB-J 80	0133109	80 - 135	130 - 186	190 - 247
ROTA NCA 280-86	SHB-J 100	0133111	98 - 137	132 - 221	216 - 308
ROTA NCA 330-104	SHB-J 126	0133105	89 - 179	181 - 271	273 - 363

Soft top jaws

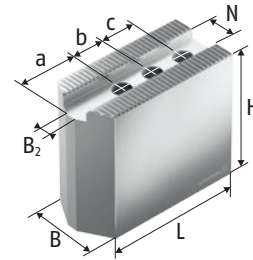
with fine serration 90°



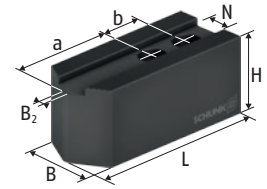
SWB-FR
Soft top jaws



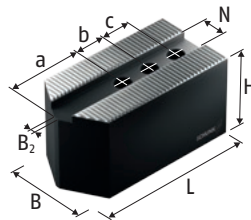
SWB-AL
Soft top jaws



FR-AL
Soft top jaws



SWBL
Soft top jaws



SWB-FR
Soft top jaws

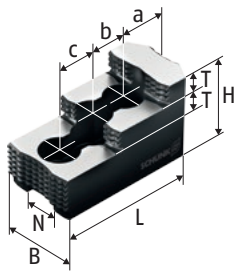
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	a [mm]	b [mm]	c [mm]	Screws	m/SET [kg]
ROTA NCA 160-32	FR-AL 130	0120600	10	25	45	53	20	12	12	M6	0.4
ROTA NCA 160-32	SWB-FR 132	0132141	10	22	47	53	20	12	12	M6	1.0
ROTA NCA 160-32	SWB-FR 130	0120400	10	25	30	55.5	20.5	12	12	M6	0.8
ROTA NCA 160-32	SWB-FR 133	0120410	10	32	32	62	29	12	12	M6	1.2
ROTA NCA 200-52	SWBL 165	0120152	14	35	40	80	45	20		M10	2.1
ROTA NCA 200-52	SWB 165	0120101	14	35	60	68	33	20		M10	2.5
ROTA NCA 200-52	SWBL 165	0168105	14	35	60	80	45	20		M10	1.2
ROTA NCA 225-66	SWBL 200	0120153	17	35	40	98	61	22		M12	2.6
ROTA NCA 225-66	CWB 200	0100006	17	40	40	90	43	22		M12	2.7
ROTA NCA 225-66	SWB 200	0120104	17	40	60	90	43	22		M12	4.1
ROTA NCA 225-66	SWB-FR 200	0120404	17	40	60	70	39	19		M12	3.1
ROTA NCA 225-66	SWB-FR 250	0120405	17	40	60	90	59	19		M12	4.1
ROTA NCA 225-66	FR-AL 200	0120602	17	40	60	90	59	19		M12	1.6
ROTA NCA 225-66	SWB-AL 200	0168101	17	40	60	90	43	22		M12	1.5
ROTA NCA 280-86	SWBL 250-21	0120155	21	50	50	120	72	28		M16	5.4
ROTA NCA 280-86	CWB 251	0100012	21	50	60	95	52	28		M16	5.2
ROTA NCA 280-86	SWB 250	0120105	21	50	80	120	62	28		M16	9.2
ROTA NCA 280-86	SWB-AL 250	0168102	21	50	80	120	62	28		M16	3.3
ROTA NCA 330-104	SWBL 315	0120156	21	50	50	140	82	28		M16	6.5
ROTA NCA 330-104	CWB 251	0100012	21	50	60	95	52	28		M16	5.2
ROTA NCA 330-104	SWB-FR 315	0120406	21	50	60	105	65	25		M16	6.0

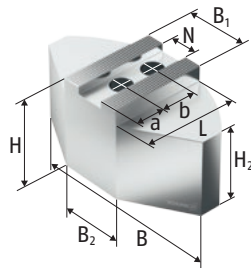
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Hard stepped top jaws, Full grip jaws

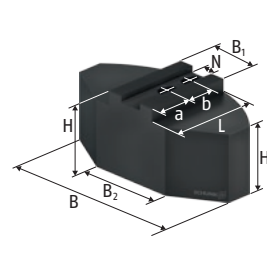
with fine serration 90°



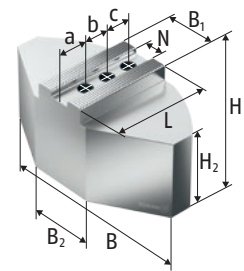
SHB-FR
Hard stepped top jaws



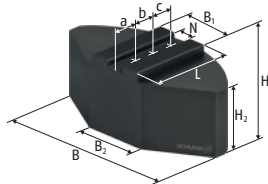
SWB-SA
Full grip jaws



SWB-SM
Full grip jaws



FR-SA
Full grip jaws



FR-SM
Full grip jaws

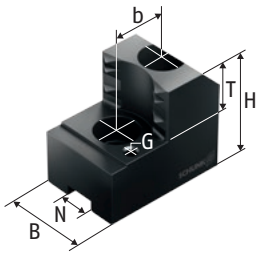
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	B1 [mm]	H [mm]	H2 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	c [mm]	Screws	m/SET [kg]
ROTA NCA 160-32	FR-SA 130	0120650	10	100	30	48	43	47.4		15	12	12	M6	1.3
ROTA NCA 160-32	FR-SM 130	0120700	10	100	30	40	35	50		14	12	12	M6	3.0
ROTA NCA 160-32	SHB-FR 130	0121109	10	26		37.5		58	10	11.6	12	12	M6	0.6
ROTA NCA 200-52	SWB-SA 165	0170099	14	120	40	58	48	59.5		25	20		M10	2.2
ROTA NCA 200-52	SWB-SM 165	0169099	14	120	40	60	50	59.5		24.5	20		M10	6.0
ROTA NCA 200-52	SHB 165	0121101	14	30		46		79.7	11	16.6	22	22	M10	1.3
ROTA NCA 225-66	SWB-SA 200	0170101	17	140	40	58	48	72.5		35	22		M12	3.1
ROTA NCA 225-66	SWB-SA 201	0170106	17	140	40	75	65	72.5		35	22		M12	4.2
ROTA NCA 225-66	SWB-SM 200	0169101	17	140	40	60	50	69.5		35	22		M12	8.6
ROTA NCA 225-66	SWB-SM 201	0169106	17	140	40	75	65	69.5		35	22		M12	11.5
ROTA NCA 225-66	SHB 210	0121102	17	40		49		84.3	12	28.7	19	19	M12	2.0
ROTA NCA 280-86	SWB-SA 250-21	0170103	21	180	50	78	63	87.5		40	28		M16	6.3
ROTA NCA 280-86	SWB-SA 251	0170107	21	180	50	100	85	87.5		40	28		M16	8.3
ROTA NCA 280-86	SWB-SM 250-21	0169103	21	180	50	70	55	80		29	28		M16	14.5
ROTA NCA 280-86	SWB-SM 251	0169107	21	180	50	100	85	80		30	28		M16	22.0
ROTA NCA 280-86	SHB 250	0121105	21	50		58		103.5	14	34	25	25	M16	3.5
ROTA NCA 330-104	SWB-SA 315	0170104	21	240	50	78	63	117		70	28		M16	11.0
ROTA NCA 330-104	SWB-SM 315	0169104	21	240	50	70	55	110		60	28		M16	26.6
ROTA NCA 330-104	SHB 315	0121111	21	50		58		128	14	46	30	30	M16	4.6

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Claw jaws

with fine serration 90°



SZA
Claw jaws

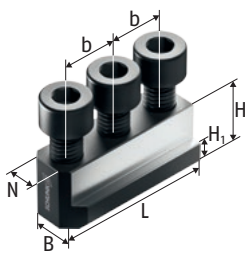
Technical data

Chuck type	Clamping range ØD	Swing diameter SDmax	Description	ID	N	B	H	T	G	b	Screws	m/SET
	[mm]	[mm]			[mm]	[mm]	[mm]	[mm]		[mm]		[kg]
ROTA NCA 200-52	32 - 90	215	SZA 17-1	0122260	14	30	47	20	M6	20	M10	1.2
ROTA NCA 200-52	44 - 113	215	SZA 17-2	0122261	14	30	47	20	M6	20	M10	1.0
ROTA NCA 200-52	70 - 139	216	SZA 17-3	0122262	14	30	47	20	M6	20	M10	1.0
ROTA NCA 200-52	96 - 165	225	SZA 17-4	0122263	14	35	47	20	M6	20	M10	1.2
ROTA NCA 225-66	24 - 88	243	SZA 20-14	0138195	17	35	50	25	M6	22	M12	1.8
ROTA NCA 225-66	51 - 117	243	SZA 20-15	0138196	17	35	50	25	M6	22	M12	1.5
ROTA NCA 225-66	80 - 146	244	SZA 20-16	0138197	17	40	50	25	M6	22	M12	1.5
ROTA NCA 225-66	107 - 173	245	SZA 20-17	0138198	17	40	50	25	M6	22	M12	1.6
ROTA NCA 225-66			SZA 20-18	0138199	17	40	50	25	M6	22	M12	1.8
ROTA NCA 280-86	39 - 128	302	SZA 25-37	0138180	21	50	58	25	M8	28	M16	3.3
ROTA NCA 280-86	97 - 169	303	SZA 25-38	0138181	21	50	58	25	M8	28	M16	2.9
ROTA NCA 280-86	147 - 219	306	SZA 25-39	0138182	21	50	58	25	M8	28	M16	2.7
ROTA NCA 280-86	194 - 266	341	SZA 25-40	0138183	21	50	58	25	M8	28	M16	3.2
ROTA NCA 330-104	50 - 156	363	SZA 31-10	0138184	21	50	58	25	M8	28	M16	3.4
ROTA NCA 330-104	108 - 213	363	SZA 31-11	0138185	21	50	58	25	M8	28	M16	3.4
ROTA NCA 330-104	174 - 280	363	SZA 31-12	0138186	21	50	58	25	M8	28	M16	3.2
ROTA NCA 330-104	238 - 344	420	SZA 31-13	0138187	21	50	58	25	M8	28	M16	4.7

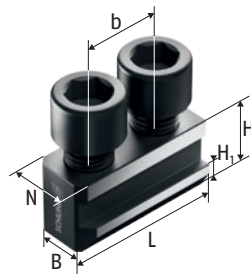
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T-nut

with fine serration 90°



NK
T-nut



NKA
T-nut



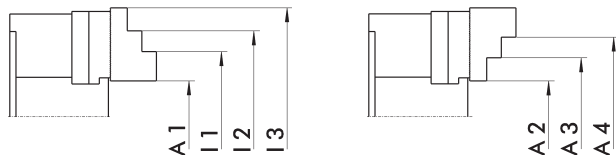
NKS
T-nut

Chuck type	Description	ID	H	H1	b	G	Cyl.-screw	Max. adm. tightening torque
			[mm]	[mm]	[mm]			[Nm]
ROTA NCA 160-32	NK 60	0147104	13.7	5.5	12	M6	M6 x 18	16
ROTA NCA 200-52	NKA 1	0145103	18.5	6.5	20	M10	M10 x 25	50
ROTA NCA 200-52	NKS 1	0143104	18.5	6.5		M10	M10 x 25	50
ROTA NCA 225-66	NKA 2	0145104	20.5	7.5	22	M12	M12 x 25	70
ROTA NCA 225-66	NKS 2	0143106	20.5	7.5		M12	M12 x 25	70
ROTA NCA 280-86	NKA 3	0145105	26.5	10	28	M16	M16 x 35	150
ROTA NCA 280-86	NKS 3	0143107	26.5	10		M16	M16 x 35	150
ROTA NCA 330-104	NKA 3	0145105	26.5	10	28	M16	M16 x 35	150
ROTA NCA 330-104	NKS 3	0143107	26.5	10		M16	M16 x 35	150

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Hard stepped top jaws

with fine serration 90°



Jaw position I

Jaw position II

O.D. clamping

Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]
ROTA NCA 160-32	SHB-FR 130	0121109	9 - 60	7 - 60	57 - 94	91 - 146
ROTA NCA 200-52	SHB 165	0121101	8 - 60	22 - 64	71 - 113	115 - 157
ROTA NCA 225-66	SHB 210	0121102	9 - 83	30 - 83	80 - 132	126 - 179
ROTA NCA 280-86	SHB 250	0121105	22 - 102	52 - 107	134 - 189	207 - 262

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA NCA 160-32	SHB-FR 130	0121109	42 - 79		
ROTA NCA 200-52	SHB 165	0121101	72 - 121	116 - 170	166 - 220
ROTA NCA 225-66	SHB 210	0121102	82 - 133	128 - 181	176 - 252
ROTA NCA 280-86	SHB 250	0121105	73 - 150	145 - 228	225 - 308

Grease

LINOMAX plus

High-performance grease as standard for regularly lubricating SCHUNK manual and power lathe chucks and steady rests.



Bundle	Description	ID
Cartridge	LINOMAX plus cartridge	1342585
Can	LINOMAX plus can	1342586
Bucket	LINOMAX plus bucket	1342587

Grease gun

Auxiliary tools for lubrication of all kinds of SCHUNK products. The grease gun can be used for cartridges of all types of SCHUNK grease.



Bundle	Description	ID
Cartridge	Grease gun	9900543

Accessories

Clamping force tester

For measuring the jaw clamping force of 2, 3 and 6-jaw chucks up to 6,000 RPM.



Suitable for	Description	ID
ROTA NCA 160-32	IFT Set	1404235
ROTA NCA 200-52		
ROTA NCA 225-66		
ROTA NCA 280-86		
ROTA NCA 330-104		

Mounting wrench

For power lathe chucks with turnable threaded rings as wrench design with driving pins that snap into the threaded ring.



Suitable for	Description	ID
ROTA NCA 280-86	SSH-MN Ø86-228	8700249
ROTA NCA 330-104	SSH-MN Ø104-228	1375097



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