

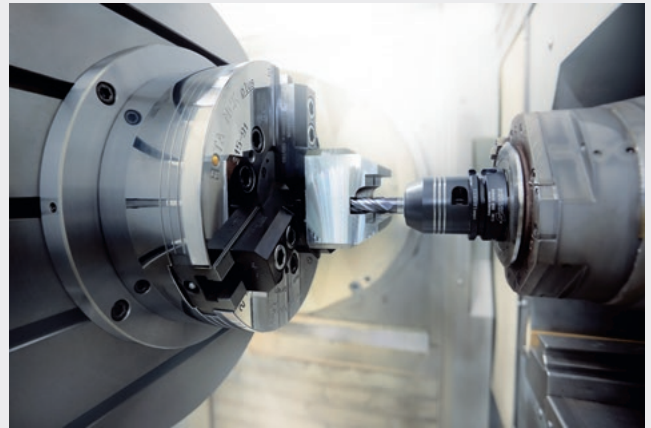


ROTA NCK-S plus

**Hydraulic power lathe chucks
for stationary applications**

Hydraulically actuated power lathe chucks with integrated hydraulic cylinder and a large control range

ROTA NCK-S plus stands for precise clamping of round workpieces on stationary machine tools with hydraulic actuation. The power lathe chucks can be adapted quickly and easily to any machine table by using a console plate. The special feature is the integrated hydraulic cylinder, which allows the chucks to be built very low and thus enables maximum utilization of the machine room. High clamping forces, a one-piece chuck body, long jaw guidances and a long and precise piston guide make the ROTA NCK-S plus the ideal clamping device for everyday use. The chucks also scores for their excellent price-performance ratio.



Advantages – Your benefits

- + Precision wedge-hook power lathe chuck for highest quality requirements**
Allows excellent machining results
- + Excellent price-performance ratio**
Optimal use of the lathe chuck
- + High efficiency of the wedge hook system**
Process-reliable clamping due to high clamping forces
- + Optimized lubrication system**
Consistently high clamping forces ensured
- + Integrated hydraulic cylinders**
Delicate clamping due to large control range
- + 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
- + Low height design**
Maximum use of the machine room and maximum rigidity of the system
- + All sides of the functional parts are hardened and ground**
Ensures a long service life

Technical data

Description	Max. clamping force [kN]	Actuation pressure [bar]	Stroke/jaw [mm]
ROTA NCK-S plus 165	57	195	2.75
ROTA NCK-S plus 210	84	195	3.7
ROTA NCK-S plus 250	111	120	4.4
ROTA NCK-S plus 315	144	120	5.3

Function ROTA NCK-S plus

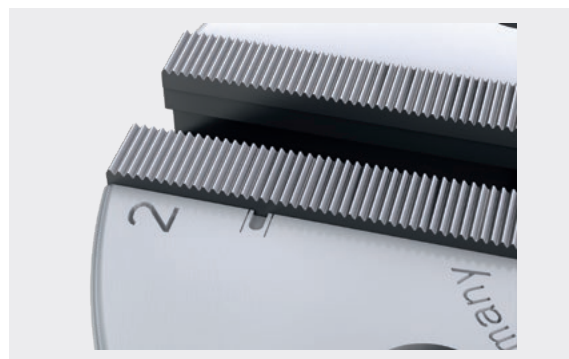
The piston that is positively guided into the power lathe chuck is shifted axially by supplying in hydraulic oil. The wedge hook system converts this axial movement of the chuck piston into a radial movement of the base jaws. Due to the use of a double-acting cylinder means that the workpieces can be clamped externally and internally.



- | | |
|--|--|
| <ul style="list-style-type: none"> ❶ Wedge hook drive
Offers constantly high clamping forces in operation ❷ Hardened and extremely rigid base body
Therefore a longer service life at highest precision. Even with maximum clamping force ❸ Long jaw guidance
Offers optimal support for O.D.- and I.D. clamping ❹ Optimized lubrication system
For a high level of efficiency ❺ Mounting thread
For workpiece stops or cover plates | <ul style="list-style-type: none"> ❻ Base jaw serration
Available in inch or metric sizes ❼ Jaw stroke display
To verify the jaw stroke ❽ Low height design
Expands your machine's workspace ❾ Integrated hydraulic cylinders
No additional backside cylinder is necessary ❿ Hydraulic system
Actuation with up to 195 bar |
|--|--|

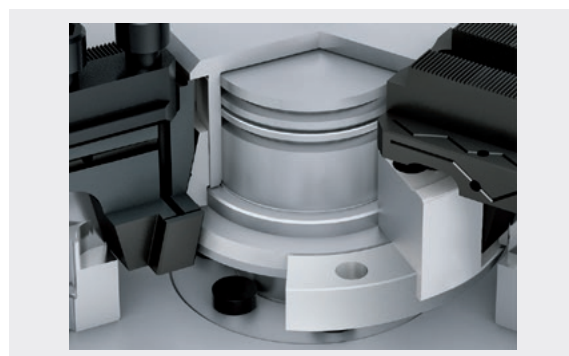
Jaw stroke display

The jaw stroke display is an additional safety feature, which ensures safe workpiece clamping and simplifies the use of the chuck in daily operation.



Long and precise piston guidance

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



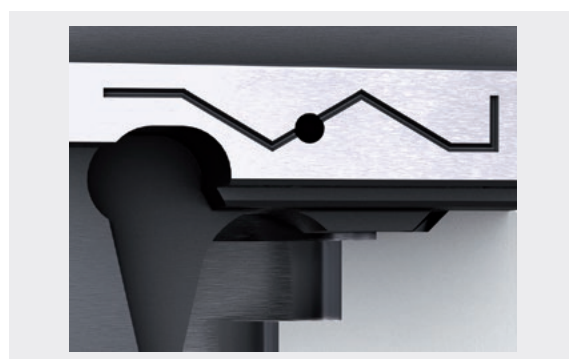
Absolute flexibility of the base jaw

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.



Base jaw safety feature

The small nose at the base jaw remains on the chuck body. This prevents the ejection of the jaws in case of a crash.



Stationary 3-jaw chuck, hydraulically actuated

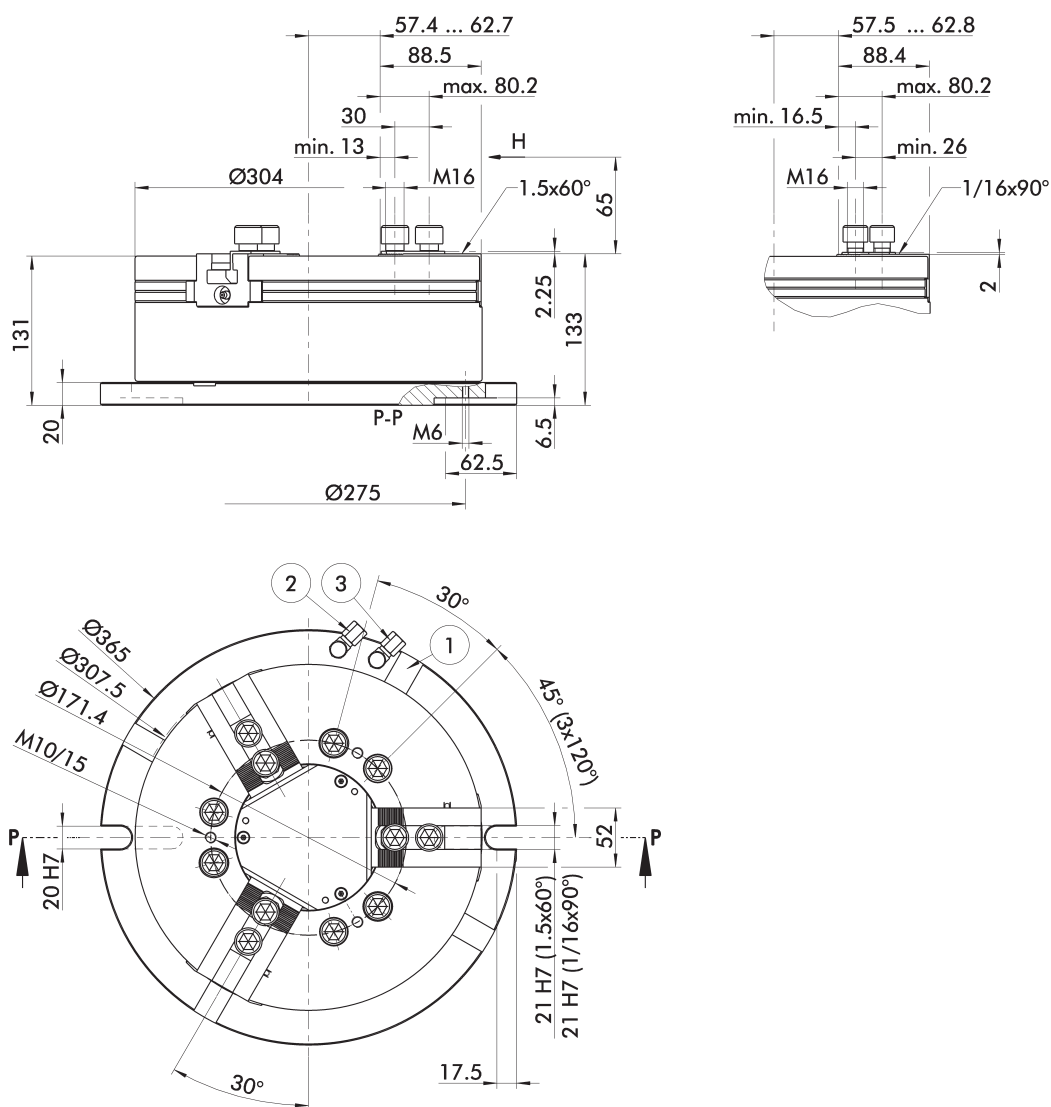
With base plate "K"

Scope of delivery

Power lathe chuck, T-nuts, operating manual; without top jaws, without mounting screws

Technical data

Description	ID	Mounting	Max. clamping force [kN]	Actuation pressure [bar]	Stroke per jaw [mm]	Weight [kg]
ROTA NCK-S plus 315 K-SV90°	0450207	Consol plate	144	120	5.3	72.4
ROTA NCK-S plus 315 K-SV60°	0450203	Consol plate	144	120	5.3	72.4

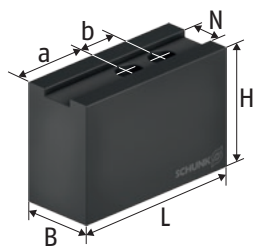


Subject to technical changes.

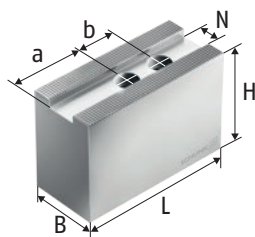
- ① Water drainage grooves
- ② Connection for opening the chuck
- ③ Connection for closing the chuck

Soft top jaws

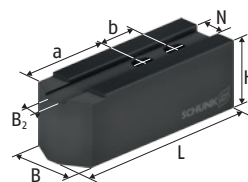
with fine serration 60°



KM-WB
Soft top jaws



KM-WBAL
Soft top jaws



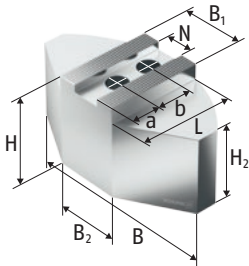
KM-WBL
Soft top jaws

Technical data

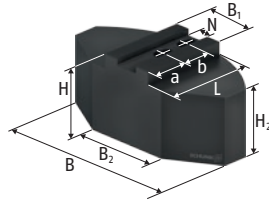
Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA NCK-S plus 315	KM-WBL 121	0132604	21	50	50	145	85	30	M16	6.9
ROTA NCK-S plus 315	KM-WBL 125	0132618	21	50	100	145	85	30	M16	13.9
ROTA NCK-S plus 315	KM-WB 126	0132131	21	50	60	129	60	30	M16	7.6
ROTA NCK-S plus 315	KM-WB 127	0132148	21	50	100	140	71	30	M16	13.8
ROTA NCK-S plus 315	KM-WB 128	0132154	21	50	80	129	60	30	M16	10.1
ROTA NCK-S plus 315	KM-WBAL 121	0132525	21	50	80	130	60	30	M16	3.8

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

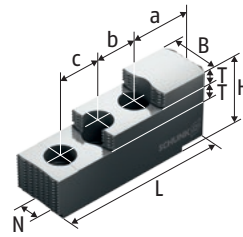
Hard stepped top jaws, Full grip jaws with fine serration 60°



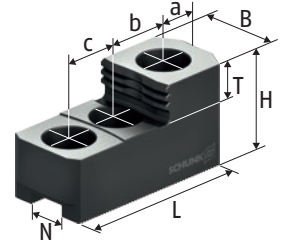
KMWB-SA
Full grip jaws



KMWB-SM
Full grip jaws



SHB-J
Hard stepped top jaws



SHB-J
Hard stepped top jaws

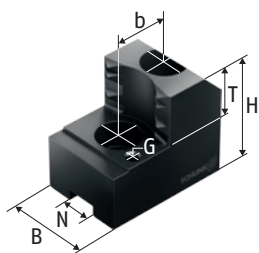
Technical data

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 NCK-S plus 315	KMWB-SA 301	0132804	21	240	50	78	63	117		45	30		M16	10.9
ROTA NCK-S plus 315	KMWB-SM 301	0132704	21	240	50	70	55	110		45	30		M16	26.4
ROTA NCK-S plus 315	SHB-J 126	0133105	21	50		62		128	14	46	30	30	M16	5.2
ROTA NCK-S plus 315	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

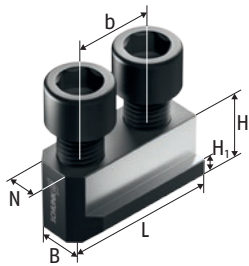
Technical data

Chuck type	Clamping range ØD	Swing diameter SDmax	Description	ID	N	B	H	L	T	G	b	Screws	m/SET
	[mm]	[mm]			[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		[kg]
ROTA NCK-S plus 315			SZAJ 30-5	0138131	21	50	65	120	25	M8	30	M16	3.8
ROTA NCK-S plus 315	104 - 182	348	SZAJ 30-6	0138132	21	50	65	100.5	25	M8	30	M16	4.1
ROTA NCK-S plus 315	170 - 249	339	SZAJ 30-7	0138133	21	50	65	79.5	25	M8	30	M16	3.4
ROTA NCK-S plus 315	234 - 304	373	SZAJ 30-8	0138134	21	50	65	109.5	25	M8	30	M16	4.8

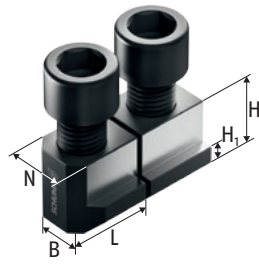
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

T-nut

with fine serration 60°



NJ
T-nut



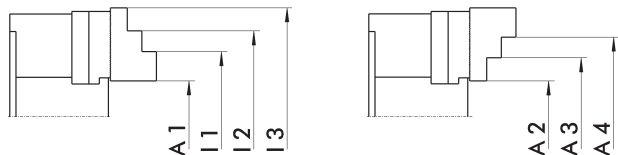
NJ sawn
T-nut

Chuck type	Description	ID	N	B	H	H1	L	b	Cyl.-screw	Max. adm. tightening torque
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[Nm]
ROTA NCK-S plus 315	NJ 124 gesägt/sawn	0146000	21	29.4	28	11.5	24.7		M16 x 40	150
ROTA NCK-S plus 315	NJ 124	0146123	21	29.4	28	11.5	55.2	30	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

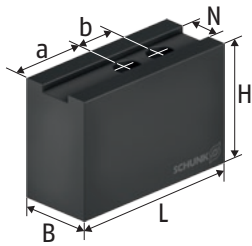
Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]
ROTA NCK-S plus 315	SHB-J 126	0133105	20 - 136	44 - 141	136 - 233	228 - 304

I.D. clamping

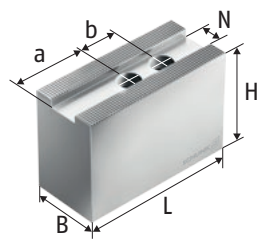
Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA NCK-S plus 315	SHB-J 126	0133105	89 - 187	181 - 278	273 - 370

Soft top jaws

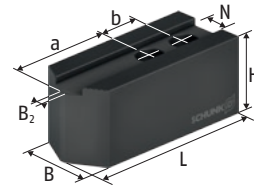
with fine serration 90°



CWB
Soft top jaws



SWB-AL
Soft top jaws



SWBL
Soft top jaws

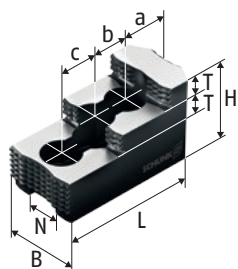
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA NCK-S plus 315	SWBL 250-21	0120155	21	50	50	120	72	28	M16	5.4
ROTA NCK-S plus 315	SWBL 315	0120156	21	50	50	140	82	28	M16	6.5
ROTA NCK-S plus 315	CWB 251	0100012	21	50	60	95	52	28	M16	5.2
ROTA NCK-S plus 315	SWB 250	0120105	21	50	80	120	62	28	M16	9.2
ROTA NCK-S plus 315	SWB-AL 250	0168102	21	50	80	120	62	28	M16	3.3

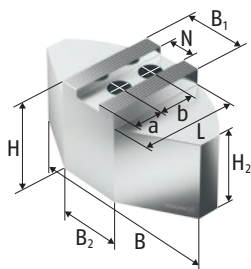
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Hard stepped top jaws, Full grip jaws

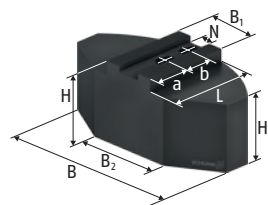
with fine serration 90°



SHB
Hard stepped top jaws



SWB-SA
Full grip jaws



SWB-SM
Full grip jaws

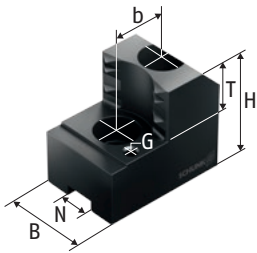
Technical data

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 NCK-S plus 315	SWB-SA 315	0170104	21	240	50	78	63	117		70	28		M16	11.0
ROTA NCK-S plus 315	SWB-SM 315	0169104	21	240	50	70	55	110		60	28		M16	26.6
ROTA NCK-S plus 315	SHB 250	0121105	21	50		58		103.5	14	34	25	25	M16	3.5

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Claw jaws

with fine serration 90°



SZA
Claw jaws

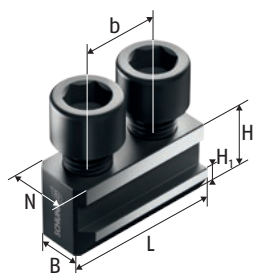
Technical data

Chuck type	Clamping range ØD	Swing diameter SDmax	Description	ID	N	B	H	L	T	G	b	Screws	m/SET
	[mm]	[mm]			[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		[kg]
ROTA NCK-S plus 315	49 - 124	325	SZA 31-10	0138184	21	50	58	115.4	25	M8	28	M16	3.4
ROTA NCK-S plus 315	100 - 182	326	SZA 31-11	0138185	21	50	58	92.1	25	M8	28	M16	3.4
ROTA NCK-S plus 315	164 - 248	324	SZA 31-12	0138186	21	50	58	87.3	25	M8	28	M16	3.2
ROTA NCK-S plus 315	228 - 304	376	SZA 31-13	0138187	21	50	58	111.1	25	M8	28	M16	4.7

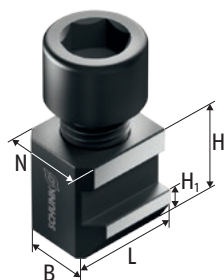
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T-nut

with fine serration 90°



NKA
T-nut



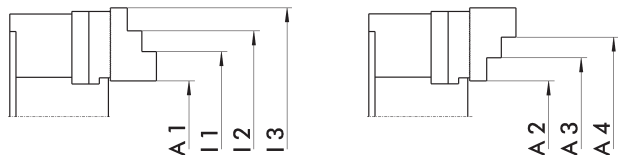
NKS
T-nut

Chuck type	Description	ID	N	B	H	H1	L	b	Cyl.-screw	Max. adm. tightening torque
			[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[Nm]
ROTA NCK-S plus 315	NKA 3	0145105	21	25	26.5	10	54	28	M16 x 35	150
ROTA NCK-S plus 315	NKS 3	0143107	21	25	26.5	10	25		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 NCK-S plus 315	SHB 250	0121105	35 - 170	65 - 153	147 - 226	220 - 304

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA NCK-S plus 315	SHB 250	0121105	86 - 164	159 - 244	239 - 370

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 NCK-S plus 315	IFT Set	1404235

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



**H.-D. SCHUNK GmbH & Co.
Spanntechnik KG**

Lothringer Str. 23
D-88512 Mengen
Tel. +49-7572-7614-1300
Fax +49-7572-7614-1039
CMM@de.schunk.com
schunk.com