

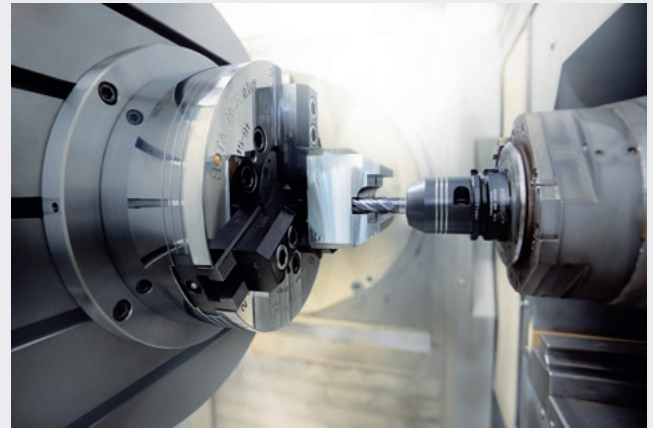


ROTA NCK-S plus

**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

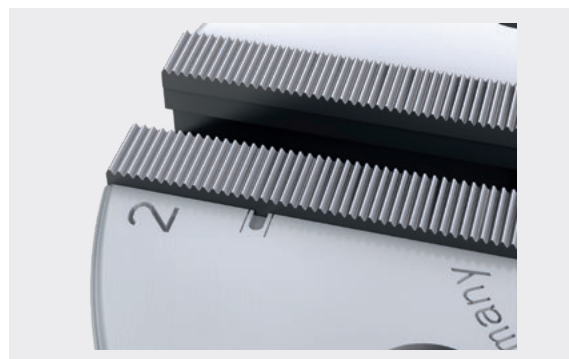
The piston that is positively guided into the power lathe chuck is shifted axially by supplying in hydraulic oil. The wedge hook system converts this axial movement of the chuck piston into a radial movement of the base jaws. Due to the use of a double-acting cylinder means that the workpieces can be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

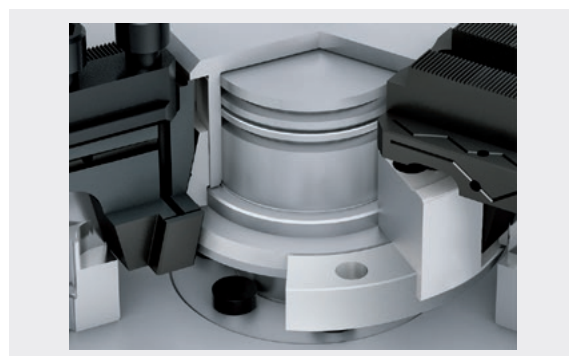
Jaw stroke display

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.



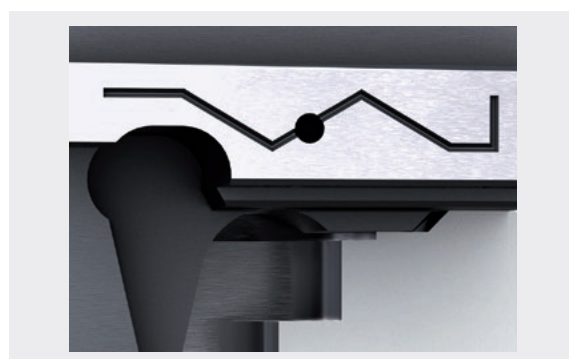
Absolute flexibility of the base jaw

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

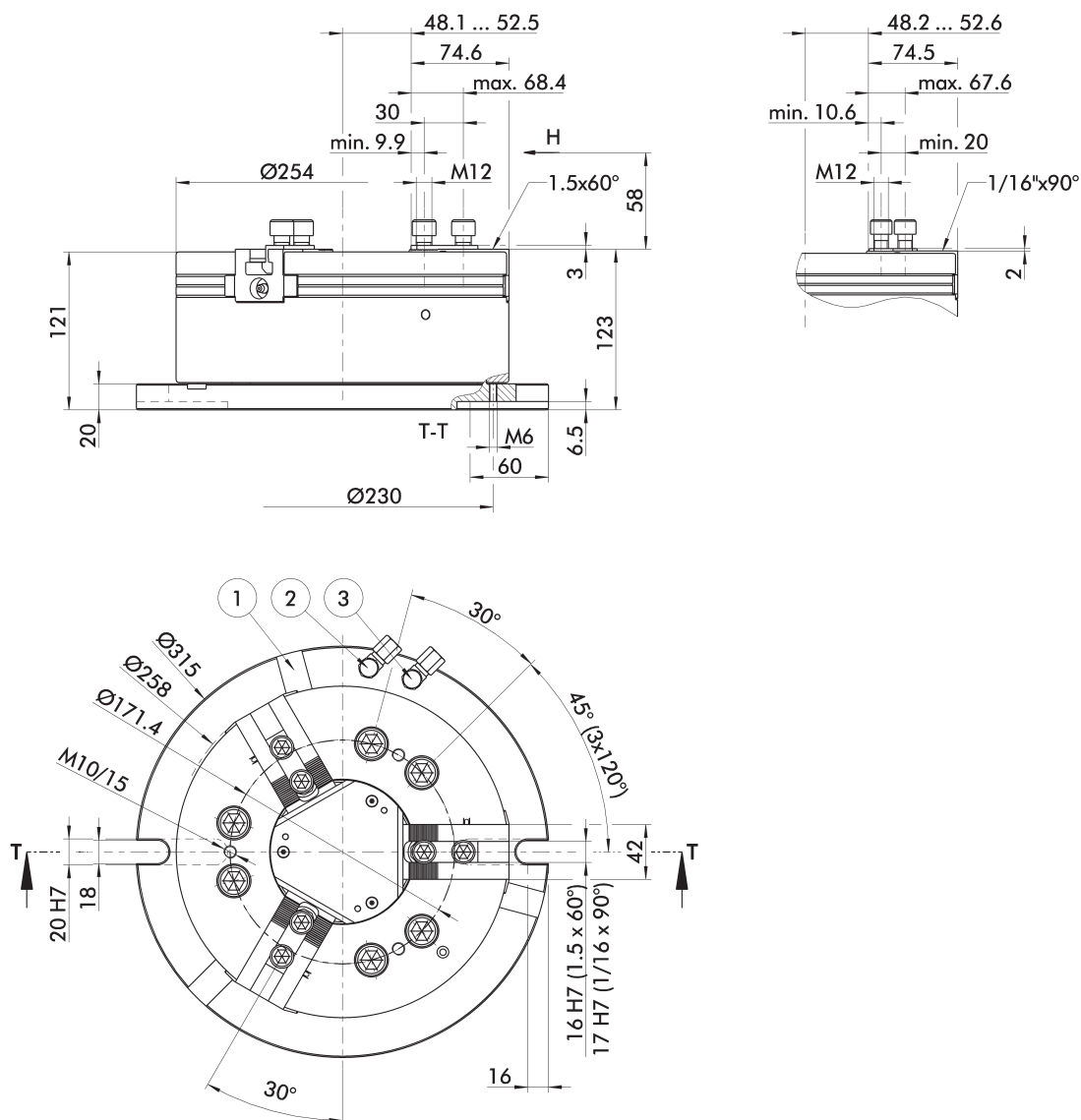
With base plate "K"

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 250 K-SV90°	0450206	Consol plate	111	120	4.4	47.6
ROTA NCK-S plus 250 K-SV60°	0450202	Consol plate	111	120	4.4	47.6

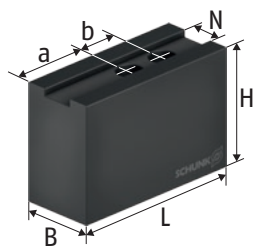


Subject to technical changes.

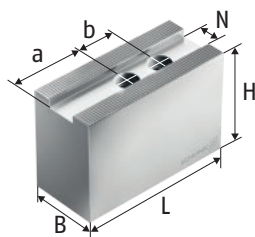
- ① Water drainage grooves
- ② Connection for opening the chuck
- ③ Connection for closing the chuck

Soft top jaws

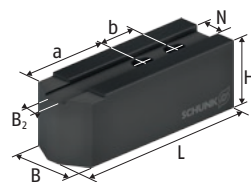
with fine serration 60°



KM-WB
Soft top jaws



KM-WBAL
Soft top jaws



KM-WBL
Soft top jaws

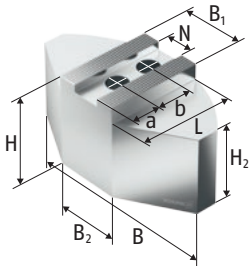
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA NCK-S plus 250	KM-WBL 100	0132602	16	40	42	125	65	30	M12	4.1
ROTA NCK-S plus 250	KM-WBL 101	0132608	16	40	100	125	65	30	M12	9.8
ROTA NCK-S plus 250	KM-WBL 103	0132609	16	40	60	125	65	30	M12	5.7
ROTA NCK-S plus 250	KM-WB 102	0132104	16	40	60	90	45	30	M12	4.3
ROTA NCK-S plus 250	KM-WB 103	0132105	16	40	60	110	50	30	M12	5.2
ROTA NCK-S plus 250	KM-WB 104	0132106	16	50	80	90	45	30	M12	7.3
ROTA NCK-S plus 250	KM-WB 105	0132129	16	40	80	110	50	30	M12	7.2
ROTA NCK-S plus 250	KM-WB 106	0132152	16	40	100	120	60	30	M12	9.7
ROTA NCK-S plus 250	KM-WB 110	0132140	16	40	42	110	50	30	M12	3.8
ROTA NCK-S plus 250	KM-WB 111	0132147	16	50	50	120	60	30	M12	6.2
ROTA NCK-S plus 250	KM-WBAL 100	0132523	16	40	60	110	55	30	M12	1.9

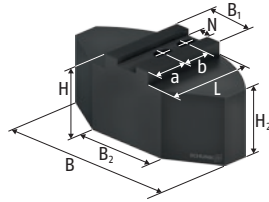
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](https://www.schunk.com)

Hard stepped top jaws, Full grip jaws

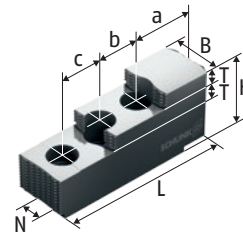
with fine serration 60°



KMWB-SA
Full grip jaws



KMWB-SM
Full grip jaws



SHB-J
Hard stepped top jaws

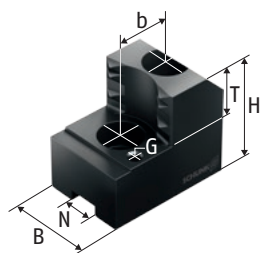
Technical data

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 250	KMWB-SA 250	0132802	16	180	40	58	43	87.5		40	30		M12	4.5
ROTA NCK-S plus 250	KMWB-SA 251	0132806	16	180	40	80	65	87.5		40	30		M12	6.6
ROTA NCK-S plus 250	KMWB-SM 250	0132702	16	180	40	60	45	80		29	30		M12	12.0
ROTA NCK-S plus 250	KMWB-SM 251	0132706	16	180	40	80	70	80		29	30		M12	18.0
ROTA NCK-S plus 250	SHB-J 100	0133111	16	40		54		101.5	13	25.5	30	30	M12	2.8

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Claw jaws

with fine serration 60°



SZAJ
Claw jaws

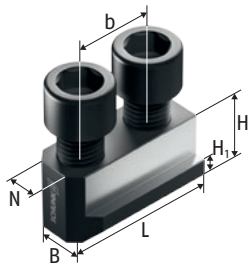
Technical data

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 250	37 - 94	272	SZAJ 25-1	0138117	16	40	58	99.5	25	M6	30	M12	2.9
ROTA NCK-S plus 250	77 - 137	272	SZAJ 25-2	0138119	16	40	58	81	25	M6	30	M12	2.3
ROTA NCK-S plus 250	121 - 181	276	SZAJ 25-3	0138121	16	40	58	70.5	25	M6	30	M12	2.1
ROTA NCK-S plus 250	166 - 226	292	SZAJ 25-4	0138123	16	40	58	75	25	M6	30	M12	2.3
ROTA NCK-S plus 250	201 - 250	313	SZAJ 25-15	0138118	16	40	58	94.5	25	M6	30	M12	2.8

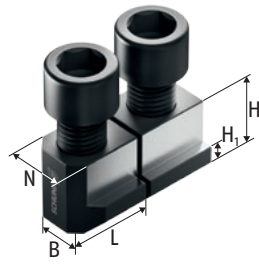
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T-nut

with fine serration 60°



NJ
T-nut



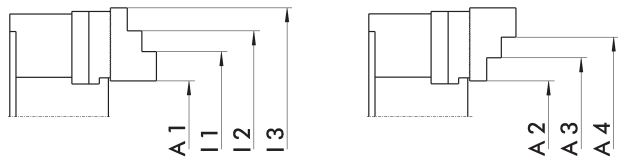
NJ sawn
T-nut

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 250	NJ 103 gesägt/sawn	0146002	16	22.4	21.5	8.5	22.7		M12 x 30	70
ROTA NCK-S plus 250	NJ 103	0146132	16	22.4	21.5	8.5	50.7	30	M12 x 30	70

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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 250	SHB-J 100	0133111	11 - 127	29 - 119	115 - 153	149 - 250

I.D. clamping

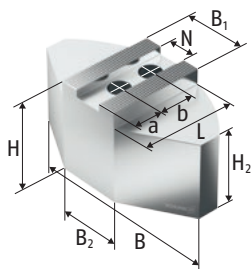
Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA NCK-S plus 250	SHB-J 100	0133111	94 - 133	128 - 216	212 - 325

Hard stepped top jaws, Full grip jaws

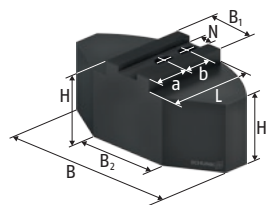
with fine serration 90°



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 250	SWB-SA 200	0170101	17	140	40	58	48	72.5		35	22		M12	3.1
ROTA NCK-S plus 250	SWB-SA 201	0170106	17	140	40	75	65	72.5		35	22		M12	4.2
ROTA NCK-S plus 250	SWB-SM 200	0169101	17	140	40	60	50	69.5		35	22		M12	8.6
ROTA NCK-S plus 250	SWB-SM 201	0169106	17	140	40	75	65	69.5		35	22		M12	11.5
ROTA NCK-S plus 250	SWB-SM 250-17	0169102	17	180	40	60	45	79		44.5	22		M12	12.0
ROTA NCK-S plus 250	SHB 210	0121102	17	40		49		84.3	12	28.7	19	19	M12	2.0

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Claw jaws

with fine serration 90°



SZA
Claw jaws

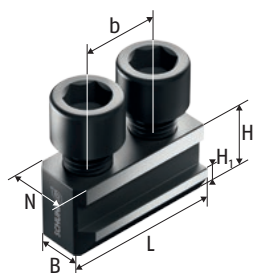
Technical data

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 250	39 – 110	282	SZA 25-6	0138176	17	35	55	97.7	25	M6	22	M12	2.3
ROTA NCK-S plus 250	70 – 143	263	SZA 25-7	0138177	17	35	55	76.2	25	M6	22	M12	1.9
ROTA NCK-S plus 250	127 – 200	270	SZA 25-8	0138178	17	40	55	63.5	25	M6	22	M12	1.8
ROTA NCK-S plus 250	162 – 235	305	SZA 25-9	0138179	17	40	55	81	25	M6	22	M12	2.4

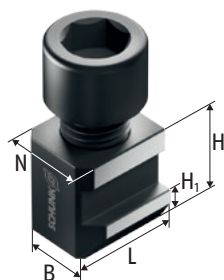
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T-nut

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 250	NKA 2	0145104	17	19	20.5	7.5	42	22	M12 x 25	70
ROTA NCK-S plus 250	NKS 2	0143106	17	19	20.5	7.5	19		M12 x 25	70

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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 250	SHB 210	0121102	25 - 145	51 - 105	101 - 151	147 - 254

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA NCK-S plus 250	SHB 210	0121102	98 - 148	144 - 196	192 - 312

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 250	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



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