SCHUNK



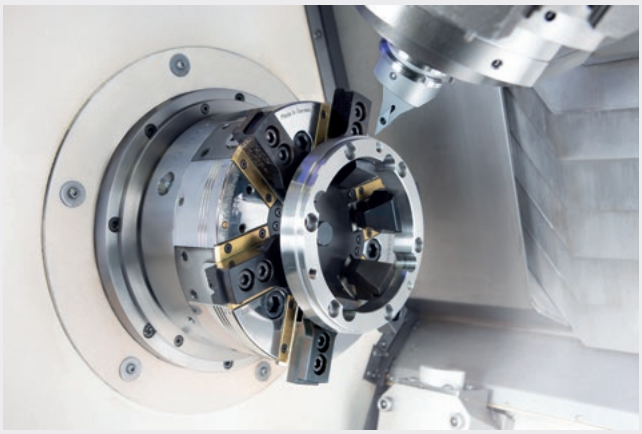
ROTA NCR-A

Sealed 6-jaw compensation chuck with pendular compensation

Hand in hand for tomorrow

Sealed 6-jaw compensation chuck for deformation sensitive clamping of thin-walled workpieces

Sealed 6-jaw compensation chuck for deformation-sensitive clamping of thin-walled workpieces. The sealing system ensures constant clamping forces, minimal maintenance costs and an even wider range of applications, such as the machining of cast-iron parts.



Advantages – Your benefits

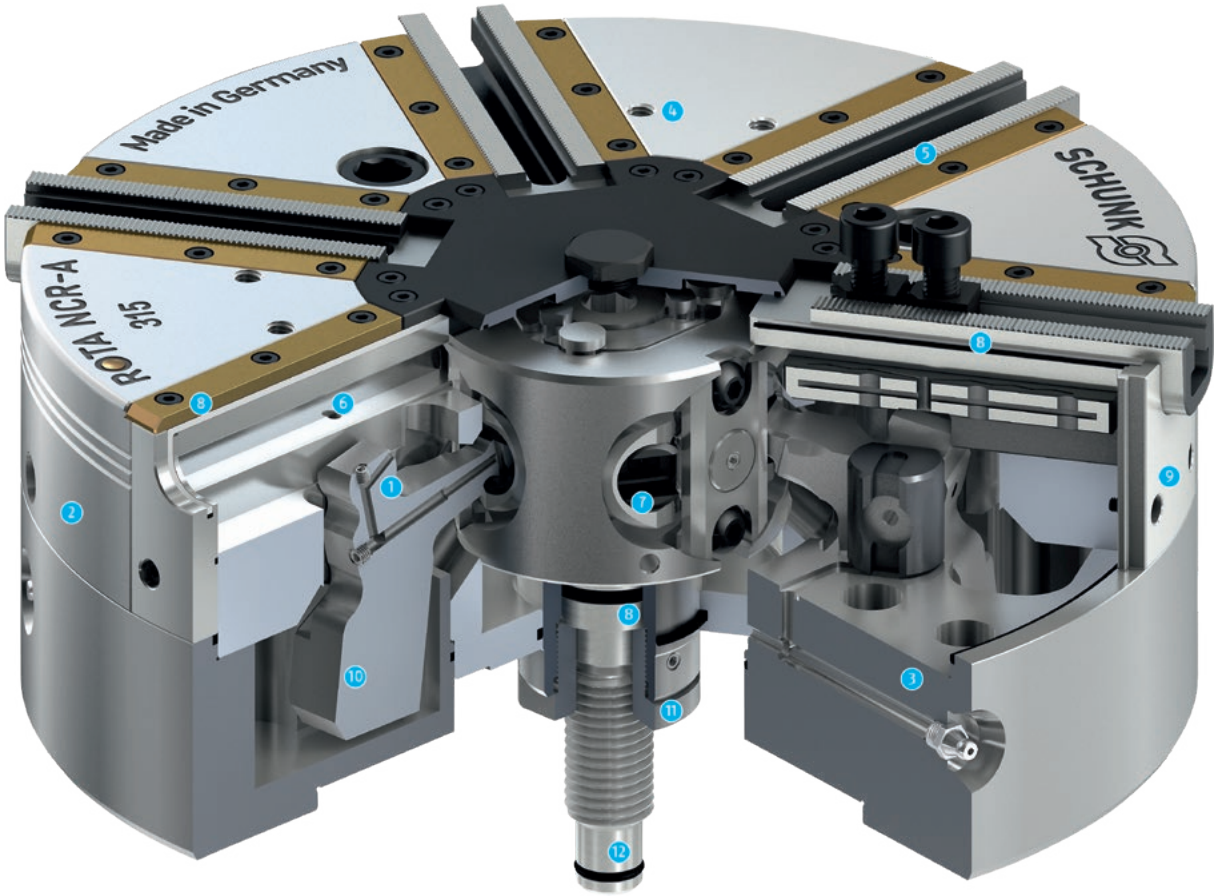
- **Sealed power lathe chuck**
  For significantly longer maintenance intervals
- **Precision angle lever power lathe chuck for top quality demands**
  Allows excellent machining results
- **High efficiency of the angle lever system**
  Process-reliable clamping due to high clamping forces
- **Optimum jaw support for O.D. and I.D. clamping due to a very long base jaw guidance**
  Allows high clamping forces at a long service life
- **Optimized lubrication system**
  Consistently high clamping forces ensured
- **Media feed-through (coolant or air) as standard option integrated in the chuck body**
  Flexibility depending on the application
- **Low height design**
  For maximum utilization of the machine room
- **Deformation sensitive clamping of thin-walled workpieces**
  High degree of roundness of the workpieces
- **Very accurate clamping of non-circular components**
  Perfect for castings
- **Turning ring simplifies and optimizes top jaw boring/machining**
  Quick and easy adaptation of the top jaws to new clamping tasks
- **All sides of the functional parts are hardened and ground**
  Ensures a long service life

Technical data

Description	Max. rotational speed [min^{-1}]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke [mm]	Pendulum compensation [mm]
ROTA NCR-A 190	4000	36	22	6	13.5	±1
ROTA NCR-A 250	3000	64	38	8	18.5	±2
ROTA NCR-A 315	2500	80	40	8	20	±2
ROTA NCR-A 400	1400	100	54	12	30	±2.5
ROTA NCR-A 500	1200	125	65	12	30	±2.5
ROTA NCR-A 630	1000	160	80	16	40	±3.5
ROTA NCR-A 800	700	160	80	16	40	±3.5
ROTA NCR-A 1000	600	300	150	25	60	±6

Function of ROTA NCR-A

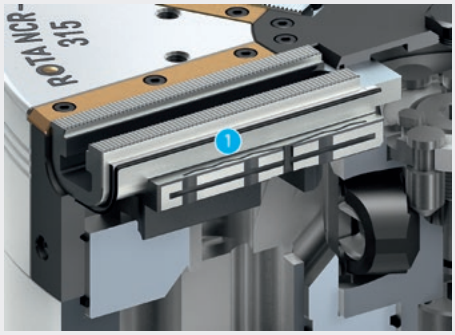
The axially movable piston transfers the force to the base jaws via angle levers mounted in the base body, and generates a radial jaw movement synchronized with the rotation axis.



1. **Angle lever drive**
   Offers constantly high clamping forces in operation
2. **Hardened and extremely rigid base body**
   Therefore a longer service life at highest precision. Even with maximum clamping force
3. **Optimized lubrication system**
   For a high level of efficiency
4. **Mounting thread**
   For workpiece stops or cover plates
5. **Base jaw serration**
   Size 190 with tongue and groove and available in inches for size 250 and larger
6. **Long jaw guidance**
   Offers optimal support for O.D.- and I.D. clamping
7. **Internal pendulum body**
   Connection with one each base jaw pair
8. **Sealing of the lathe chuck**
   Consists of a gasket and O-rings for the initial tension
9. **Cover element**
   Serves to seal the lining and additionally protects the base jaw
10. **Integrated centrifugal force compensation as an option**
    For constant clamping force even at top speeds
11. **Optimized piston mount**
    For easy and fast chuck assembly
12. **Central media supply**
    Available on request for air control or coolant

Innovative sealing system starting from size 250

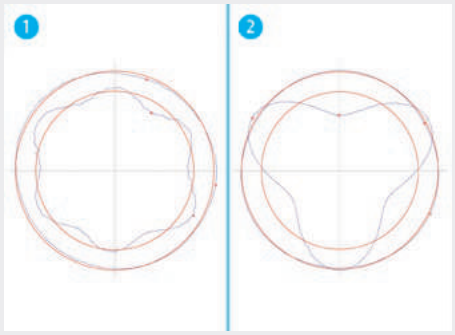
An innovative sealing system – consisting of a specially designed gasket – prevents grease from being rinsed out during machining. This in turn prevents a gradual loss of clamping force. Advantage: The chuck is additionally protected against the penetration of dirt and chips.



1. **Gasket**
   Guarantees a smooth pendulum mechanism

Advantages of the 6-point clamping

The inner pendulum mechanism evenly transmits the clamping force to all six jaws. Thin-walled workpiece are then clamped with minimal deformation. The deformation in the case of a ring-shaped workpiece is therefore reduced up to a factor of 10 as opposed to a comparable clamping set-up in a 3-jaw chuck.



1. **Clamping of a ring in the 6-jaw pendulum compensation chuck ROTA NCR-A with 20 kN total clamping force**
   Diameter: Ø 114 mm
   Wall thickness: 6 mm
   Material: Steel
   Deformation: approx. 0.035 mm
2. **Clamping of a ring in the 3-jaw power lathe chuck with a total clamping force of 20 kN**
   Diameter: Ø 114 mm
   Wall thickness: 6 mm
   Material: Steel
   Deformation: approx. 0.32 mm

Easy actuation

The centric, six-point workpiece clamping uses two base jaws linked by a compensation piece. The internal mechanics is contamination-free and very smoothly running. The lathe chuck actuation is also possible with very low clamping forces.

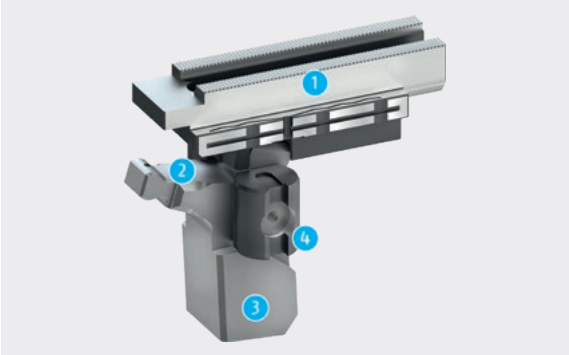


1. **Pendulum bodies**
2. **Angle lever**
3. **Chuck piston**

Force transmission

The force is transmitted via extremely rigid angle levers that ensures a long service life.

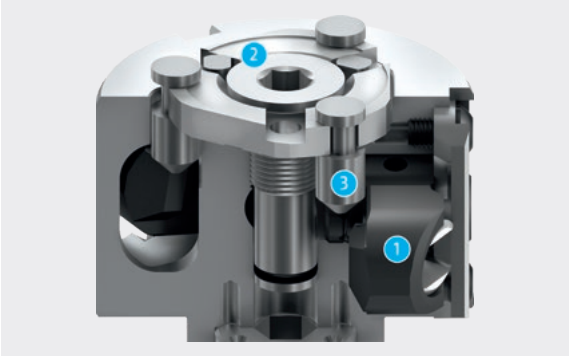
1. **Base jaw**
   With jaw interface for standard top jaws by SCHUNK
2. **Angle lever**
   Transfers the axial piston movement onto the jaw
3. **Optional with centrifugal force compensation**
   For less clamping force loss
4. **Lever bearing**



Compensating workpiece clamping

The compensating workpiece clamping is achieved by using a floating compensation piece. The oscillating clamp is retracted completely, releasing all three compensation pieces. This allows a compensating clamping of the workpiece.

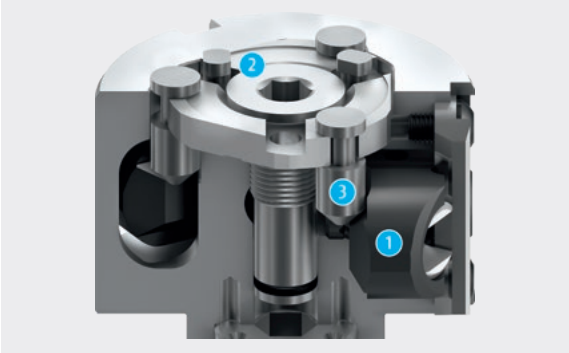
1. **Pendulum body loose**
2. **Adjusting screw**
3. **Pendulum locking open**

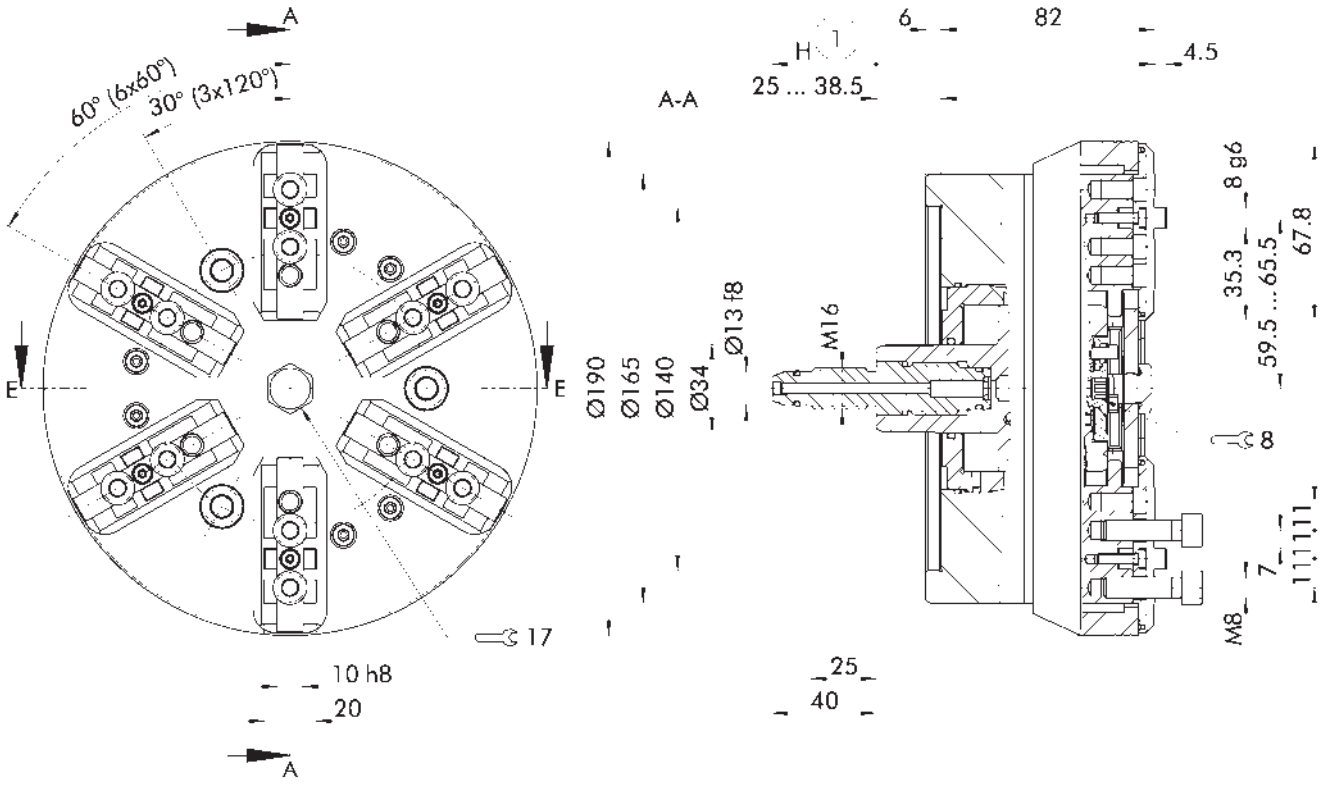


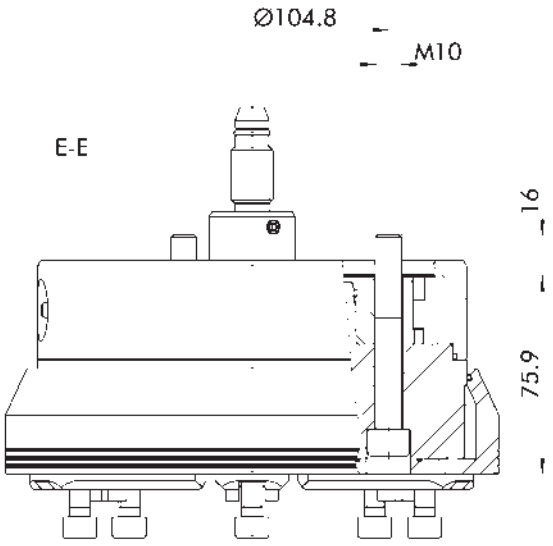
Centric workpiece clamping

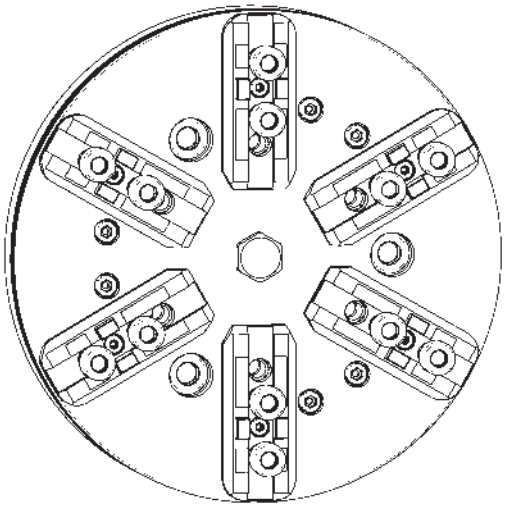
The centric workpiece clamping is achieved using a fixed compensation piece. The oscillating clamp is moved all the way to the bottom so that all three compensation pieces are clamped. As a result, all six jaws clamp centrically.

1. **Pendulum body locked**
2. **Adjusting screw**
3. **Pendulum clamping locked**









Chuck for shaft clamping drawn in open position.
Pendulum compensation shown in center positon.
Subject to technical changes.

① Piston stroke direction

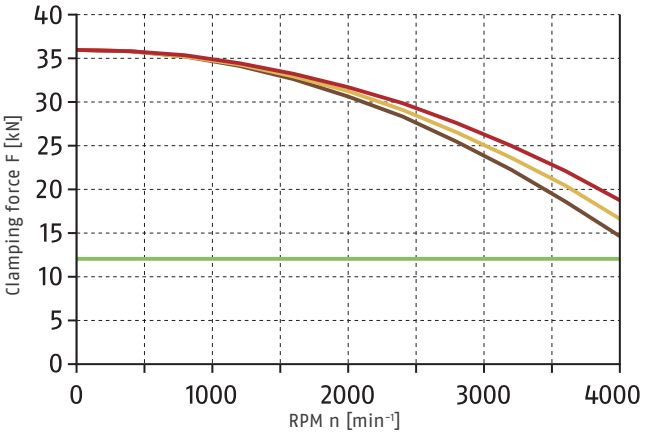
Technical data

Spindle type	Spindle size	ID	Serration	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Pendulum compensation [mm]	Weight [kg]
ISO 702-4	Nr. 5 (Z140)	1339981	Tongue and groove	4000	36	22	6	13.5	±1	14

Scope of delivery

Chuck, mounting screws for top jaws, chuck mounting screws, and operating manual

Clamping force-RPM-diagram



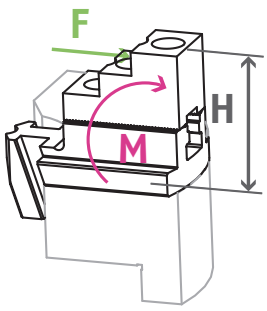
Required minimum clamping force F_{spmin} 33%

SRK 132 0.76 kg

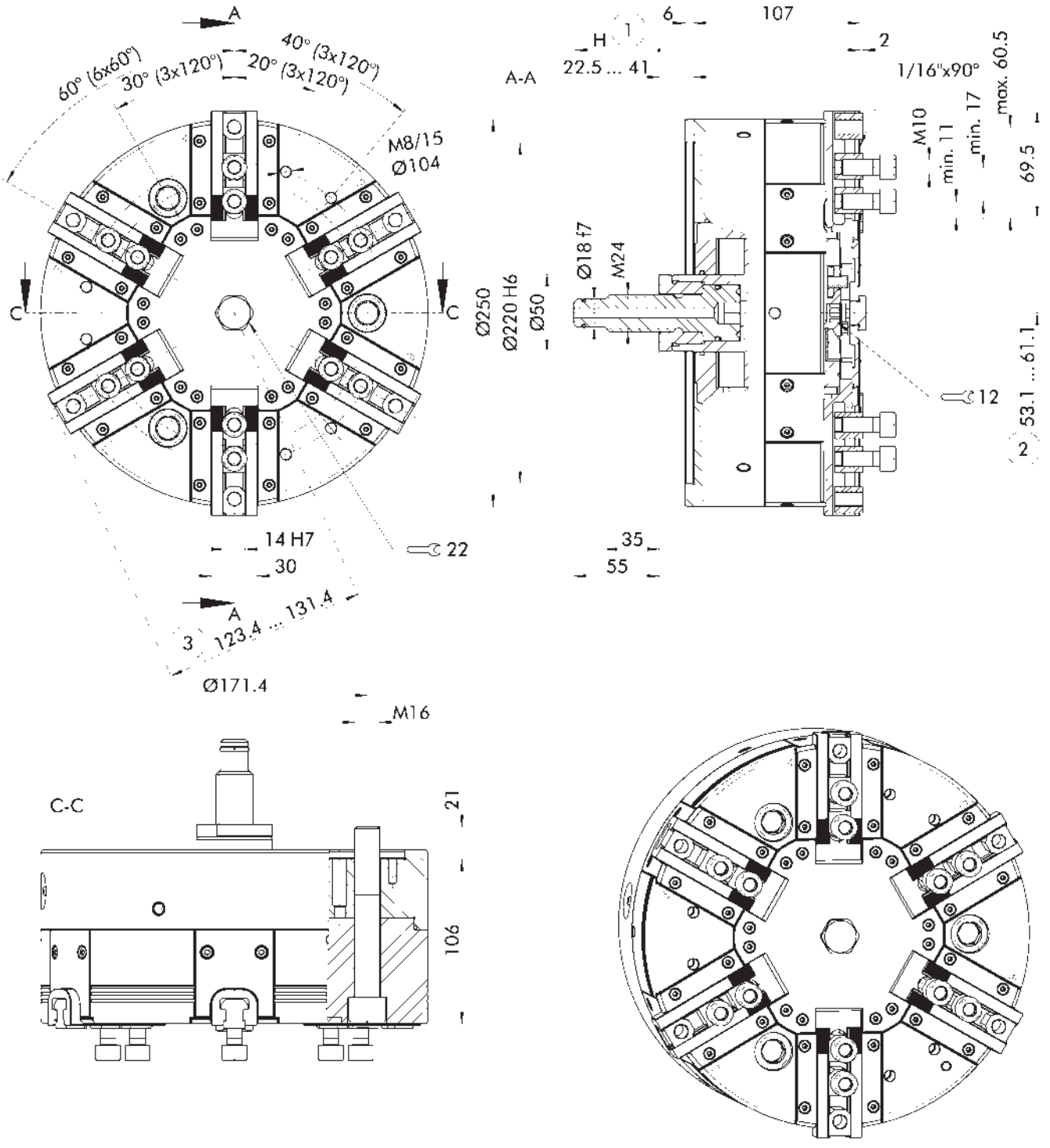
SRK 132 1.2 kg

SRK 132 0.9 kg

Load of base jaw guidance



M_{max} = 222 Nm



Chuck for shaft clamping drawn in open position.
Pendulum compensation shown in center positon.
Subject to technical changes.

① Piston stroke direction
② Distance to center of first tooth
③ Swing diameter radius

Technical data

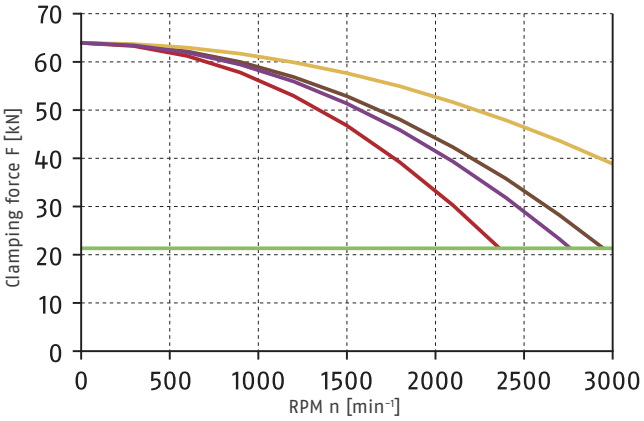
Spindle type	Spindle size	ID	Serration	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Pendulum compensation [mm]	Weight [kg]
ISO 702-4	Nr. 8 (Z220)	1331058	1/16" x 90°	3000	64	38	8	18.5	±2	36
ISO 702-4	Nr. 8 (Z220)	1339984	1/16" x 90°	3000	64	38	8	18.5	±2	38

ID 1339984 with centrifugal force compensation (chuck installation height on request)

Scope of delivery

Chuck, T-nuts or mounting screws for top jaws, chuck mounting screws, eye bolt, and operating manual

Clamping force-RPM-diagram



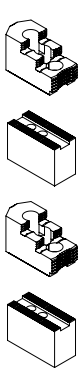
Required minimum clamping force F_{spmin} 33%

SHB 165
1.3 kg

SWB 165
2.5 kg

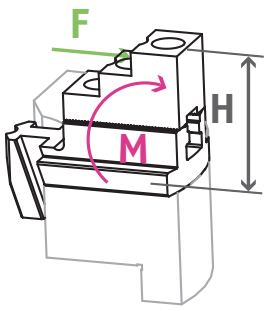
SHB 165*
1.3 kg

SWB 165*
2.5 kg

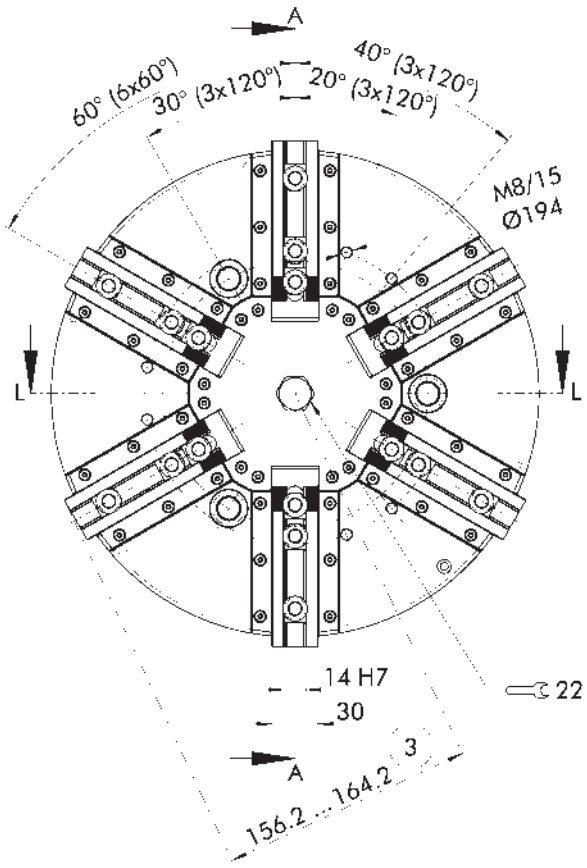


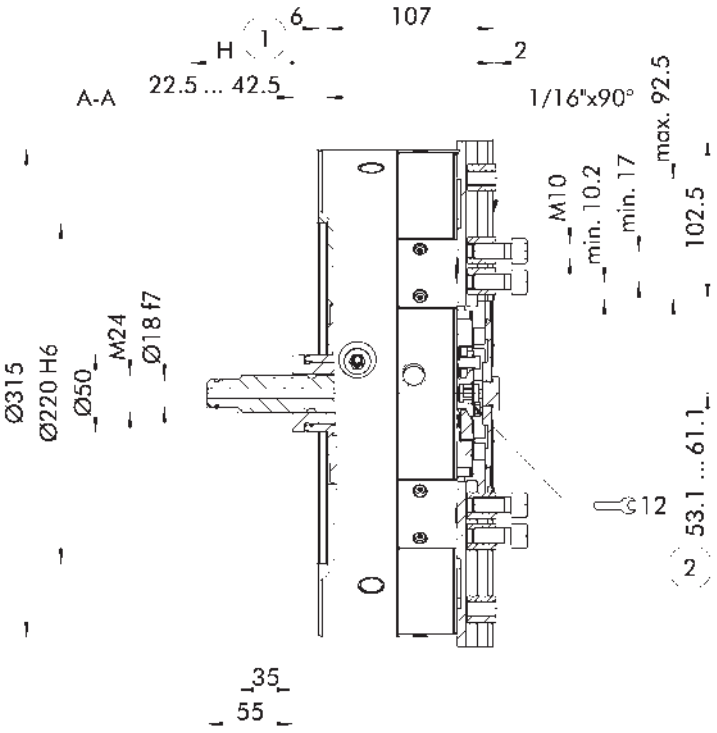
*with centrifugal force compensation

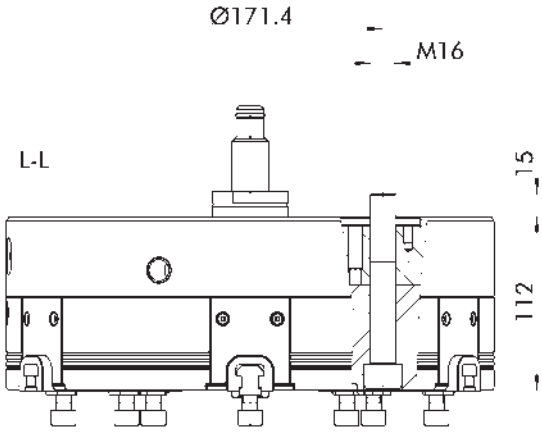
Load of base jaw guidance

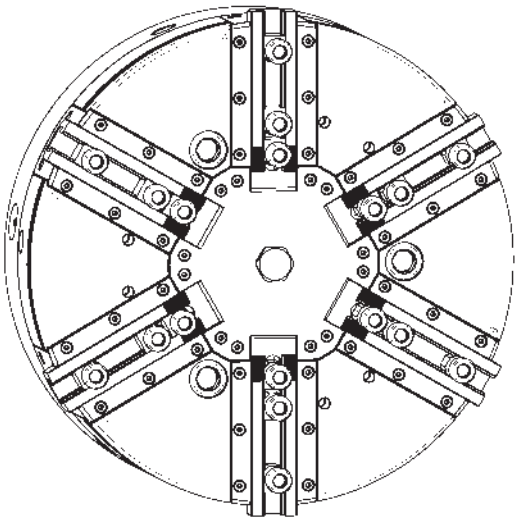


M_{max} = 565 Nm









Chuck for shaft clamping drawn in open position.
Pendulum compensation shown in center positon.
Subject to technical changes.

(1) Piston stroke direction
(2) Distance to center of first tooth
(3) Swing diameter radius

Technical data

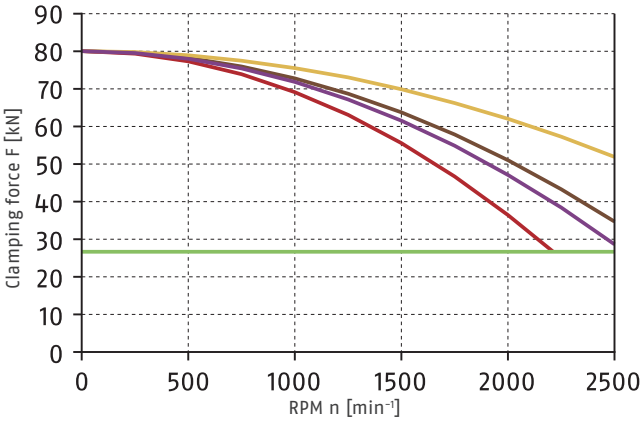
Spindle type	Spindle size	ID	Serration	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Pendulum compensation [mm]	Weight [kg]
ISO 702-4	Nr. 8 (Z220)	1339987	1/16" x 90°	2500	80	40	8	20	±2	55
ISO 702-4	Nr. 8 (Z220)	1339988	1/16" x 90°	2500	80	40	8	20	±2	61

ID 1339988 with centrifugal force compensation (chuck installation height on request)

Scope of delivery

Chuck, T-nuts or mounting screws for top jaws, chuck mounting screws, eye bolt, 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 165*
1.3 kg

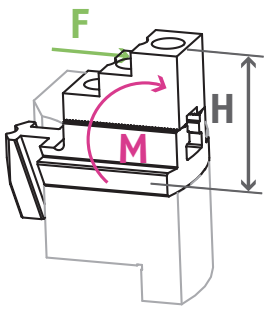


SWB 165*
2.5 kg

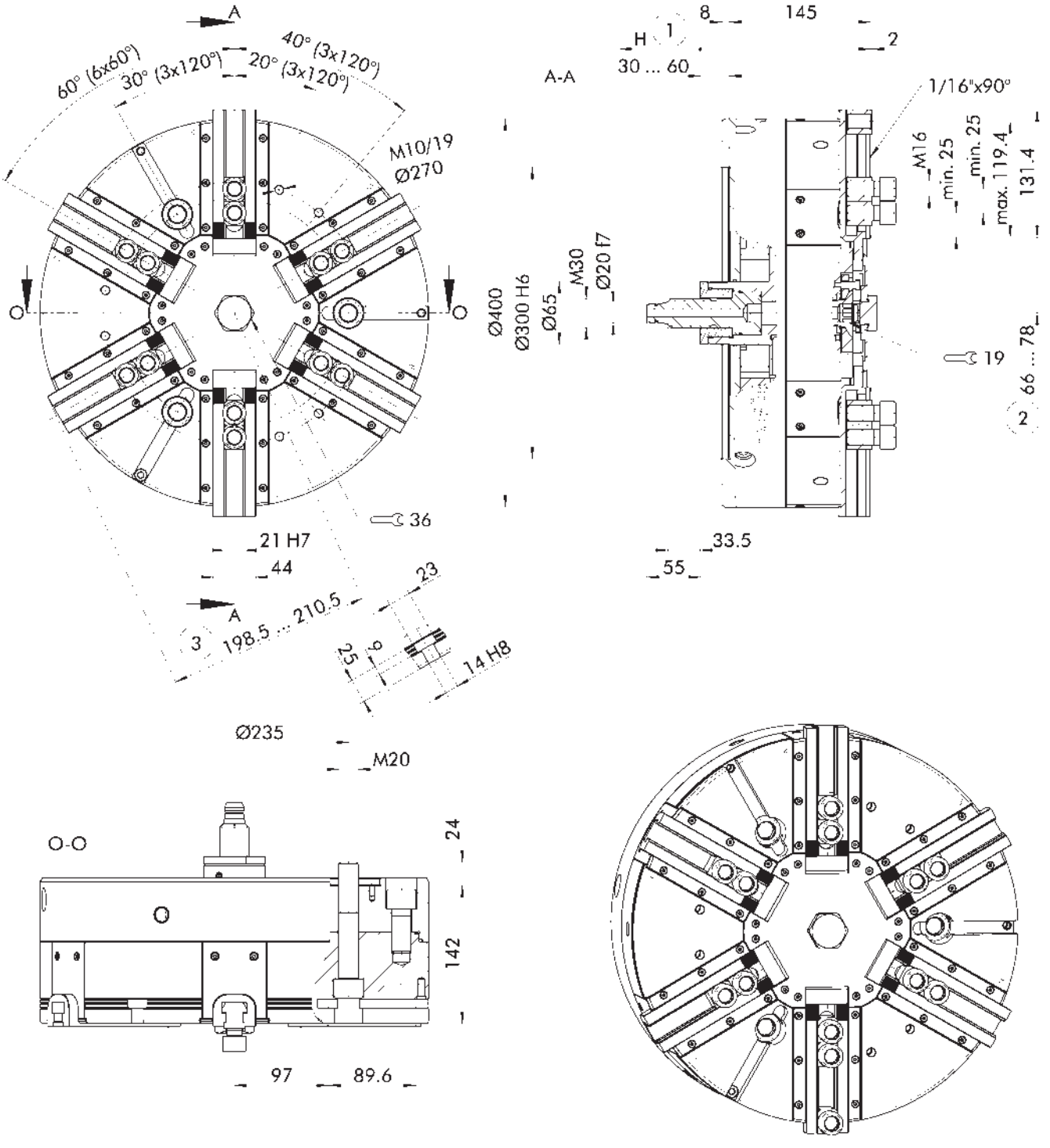


*with centrifugal force compensation

Load of base jaw guidance



M_{max} = 707 Nm



Chuck for shaft clamping drawn in open position.
Pendulum compensation shown in center positon.
Subject to technical changes.

① Piston stroke direction
② Distance to center of first tooth
③ Swing diameter radius

Technical data

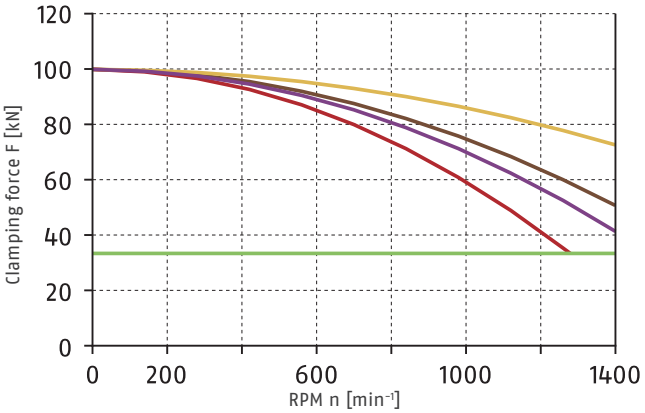
Spindle type	Spindle size	ID	Serration	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Pendulum compensation [mm]	Weight [kg]
ISO 702-4	Nr. 11 (Z300)	1339989	1/16" x 90°	1400	100	54	12	30	±2.5	118
ISO 702-4	Nr. 11 (Z300)	1339990	1/16" x 90°	1400	100	54	12	30	±2.5	130

ID 1339990 with centrifugal force compensation (chuck installation height on request)

Scope of delivery

Chuck, T-nuts or mounting screws for top jaws, chuck mounting screws, eye bolt, and operating manual

Clamping force-RPM-diagram



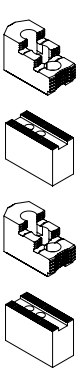
Required minimum clamping force F_{spmin} 33%

SHB 250
3.5 kg

SWB 250
9.2 kg

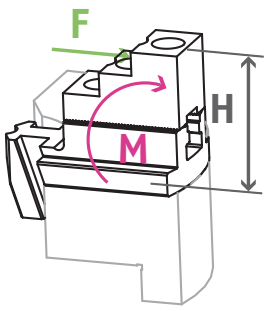
SHB 250*
3.5 kg

SWB 250*
9.2 kg

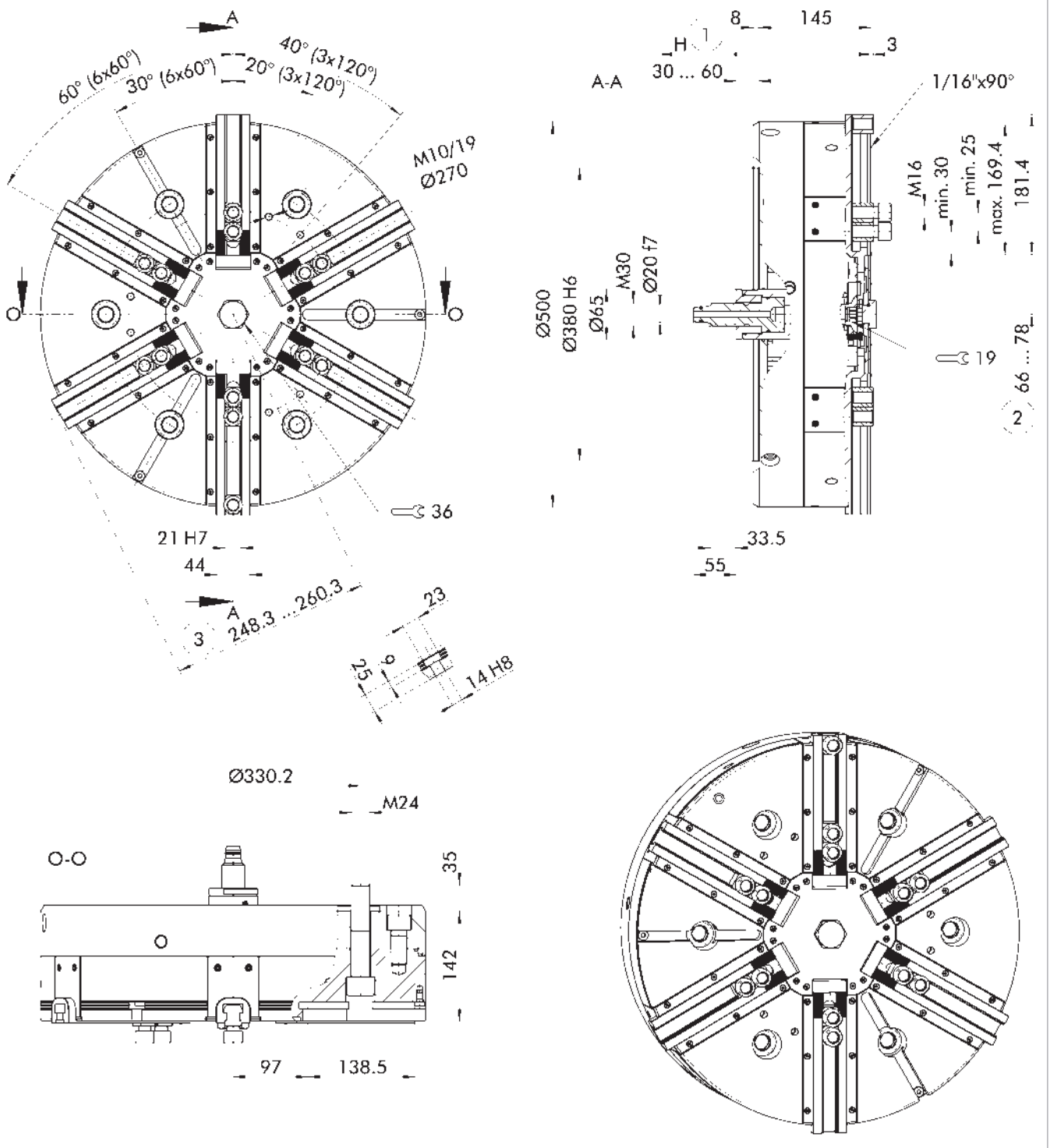


*with centrifugal force compensation

Load of base jaw guidance



M_{max} = 1200 Nm



Chuck for shaft clamping drawn in open position.
Pendulum compensation shown in center positon.
Subject to technical changes.

① Piston stroke direction
② Distance to center of first tooth
③ Swing diameter radius

Technical data

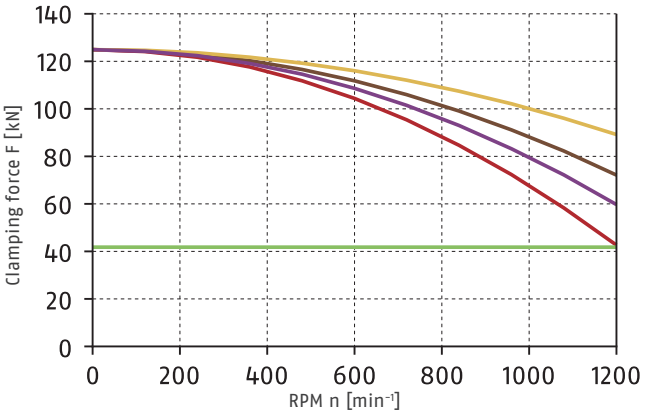
Spindle type	Spindle size	ID	Serration	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Pendulum compensation [mm]	Weight [kg]
ISO 702-4	Nr. 15 (Z380)	1339995	1/16" x 90°	1200	125	65	12	30	±2.5	177
ISO 702-4	Nr. 15 (Z380)	1339996	1/16" x 90°	1200	125	65	12	30	±2.5	198

ID 1339996 with centrifugal force compensation (chuck installation height on request)

Scope of delivery

Chuck, T-nuts or mounting screws for top jaws, chuck mounting screws, eye bolt, and operating manual

Clamping force-RPM-diagram



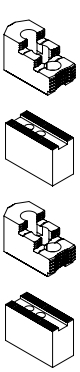
Required minimum clamping force F_{spmin} 33%

SHB 250
3.5 kg

SWB 250
9.2 kg

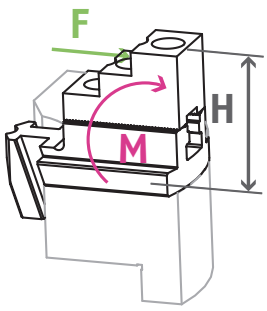
SHB 250*
3.5 kg

SWB 250*
9.2 kg

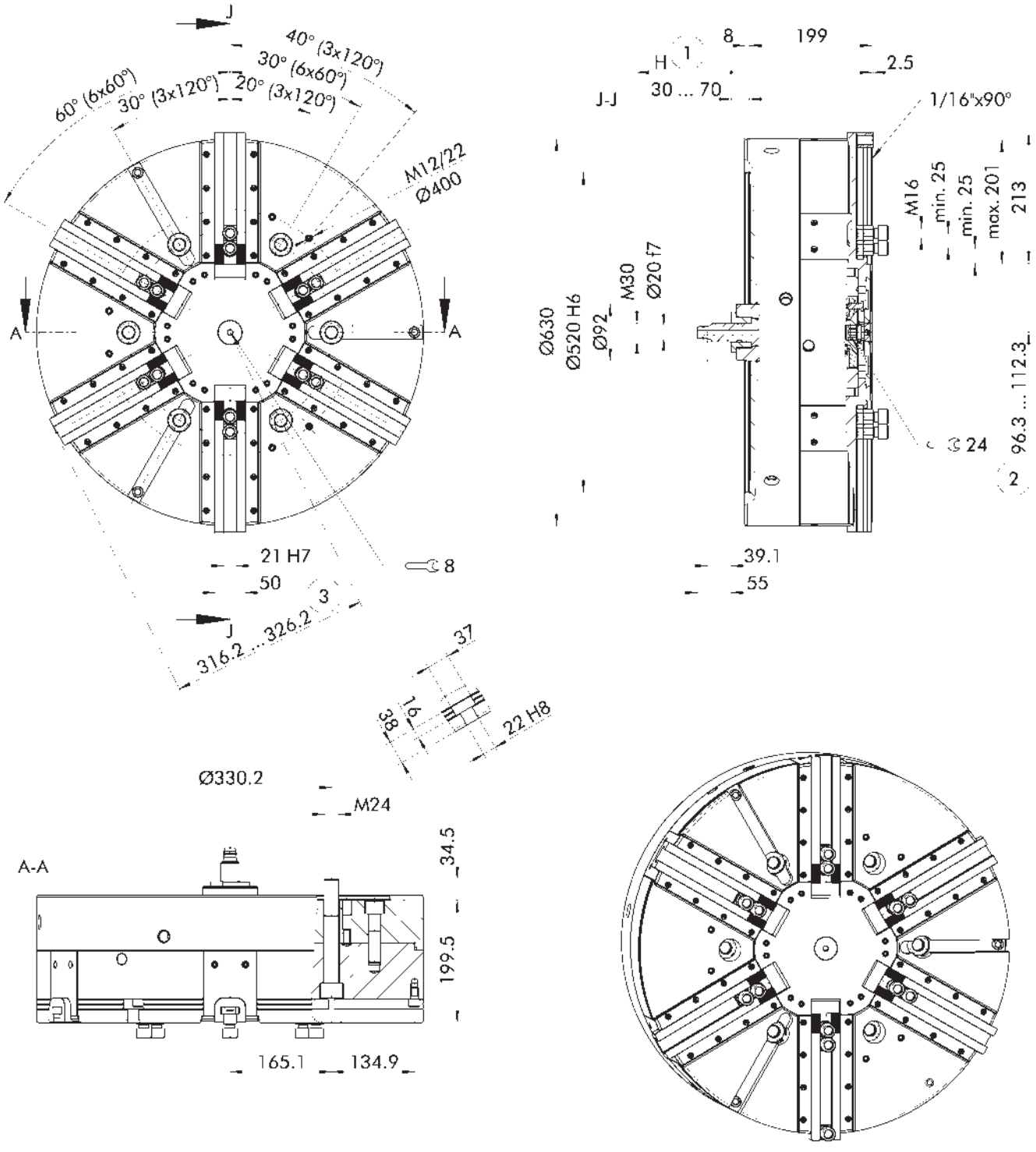


*with centrifugal force compensation

Load of base jaw guidance



M_{max} = 1500 Nm



Chuck for shaft clamping drawn in open position.
Pendulum compensation shown in center positon.
Subject to technical changes.

① Piston stroke direction
② Distance to center of first tooth
③ Swing diameter radius

Technical data

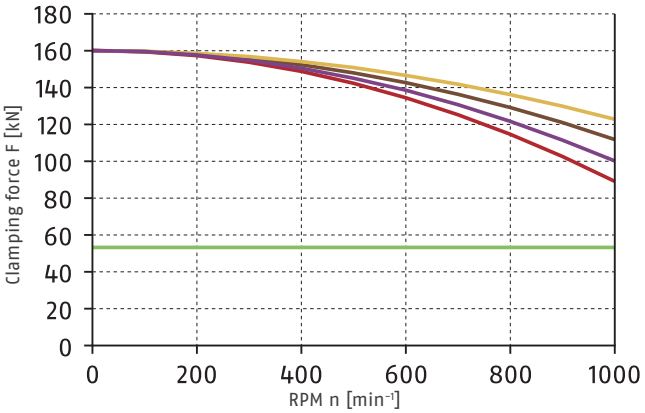
Spindle type	Spindle size	ID	Serration	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Pendulum compensation [mm]	Weight [kg]
ISO 702-4	Nr. 20 (Z520)	1339997	1/16" x 90°	1000	160	80	16	40	±3.5	400
ISO 702-4	Nr. 20 (Z520)	1339998	1/16" x 90°	1000	160	80	16	40	±3.5	417

ID 1339998 with centrifugal force compensation (chuck installation height on request)

Scope of delivery

Chuck, T-nuts or mounting screws for top jaws, chuck mounting screws, eye bolt, and operating manual

Clamping force-RPM-diagram



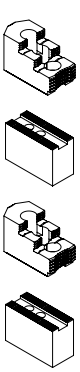
Required minimum clamping force F_{spmin} 33%

SHB 315
4.6 kg

SWB 250
9.2 kg

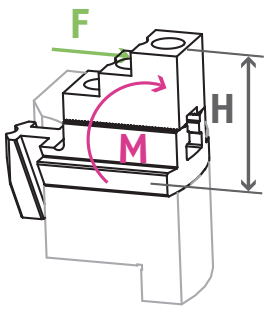
SHB 315*
4.6 kg

SWB 250*
9.2 kg

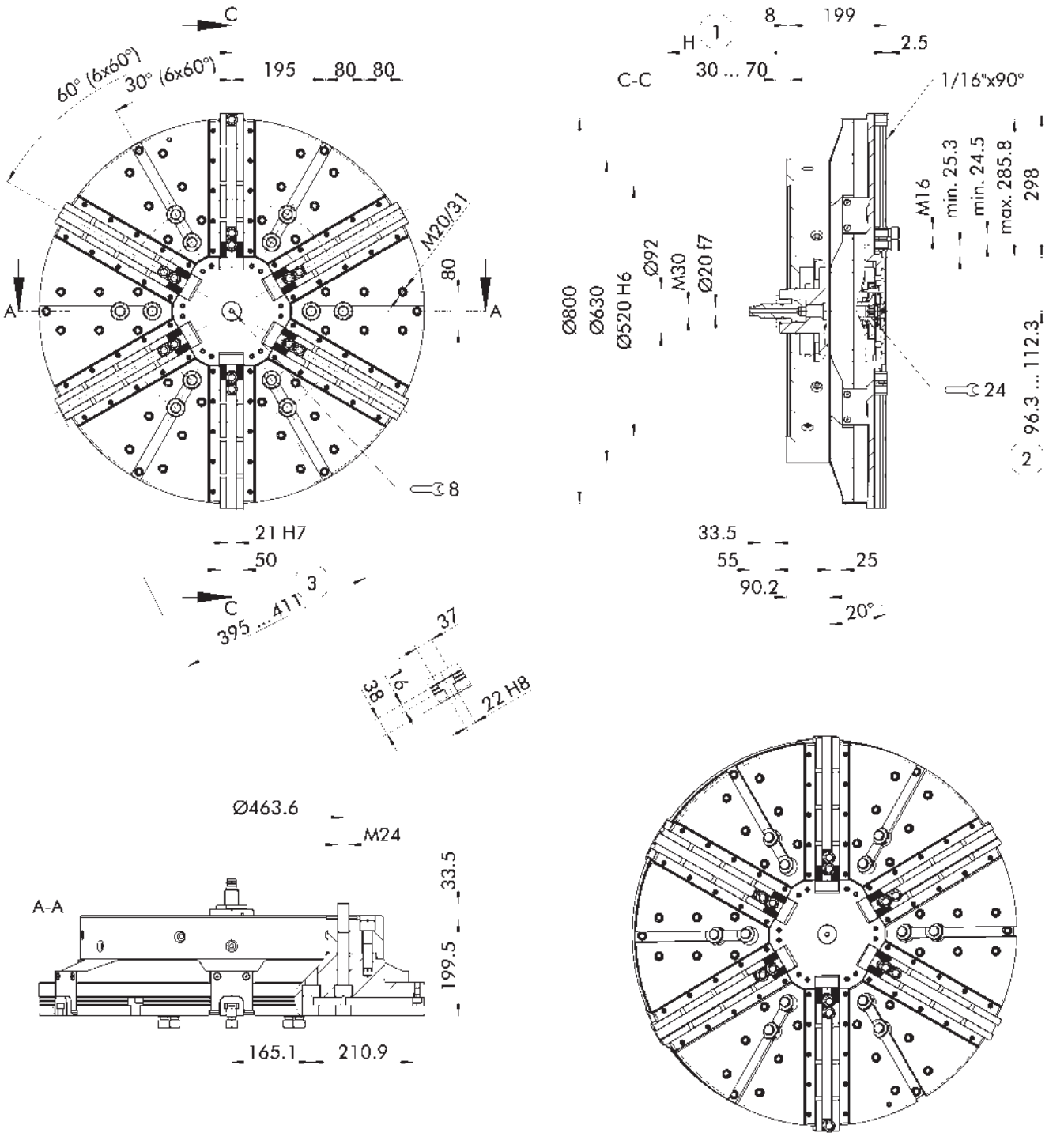


*with centrifugal force compensation

Load of base jaw guidance



M_{max} = 2213 Nm



Chuck for shaft clamping drawn in open position.
Pendulum compensation shown in center positon.
Subject to technical changes.

① Piston stroke direction
② Distance to center of first tooth
③ Swing diameter radius

Technical data

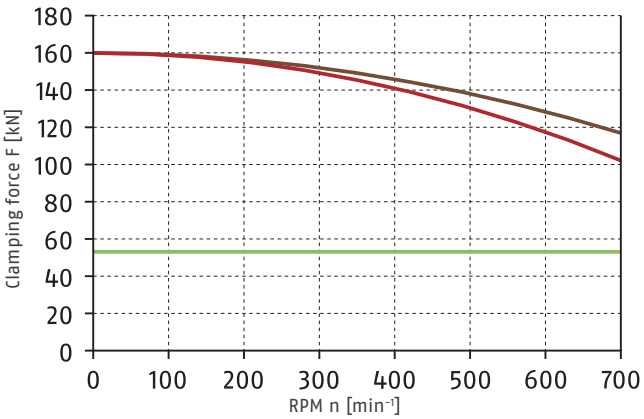
Spindle type	Spindle size	ID	Serration	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Pendulum compensation [mm]	Weight [kg]
ISO 702-4	Nr. 20 (Z520)	1340108	1/16" x 90°	700	160	80	16	40	±3.5	497

Chuck with centrifugal force compensation on request

Scope of delivery

Chuck, T-nuts or mounting screws for top jaws, chuck mounting screws, eye bolt, and operating manual

Clamping force-RPM-diagram



Required minimum clamping force F_{spmin} 33%

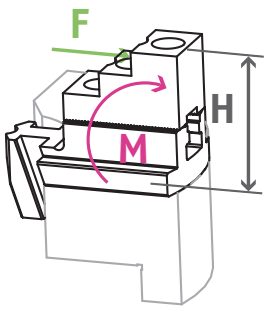
SHB 315
4.6 kg



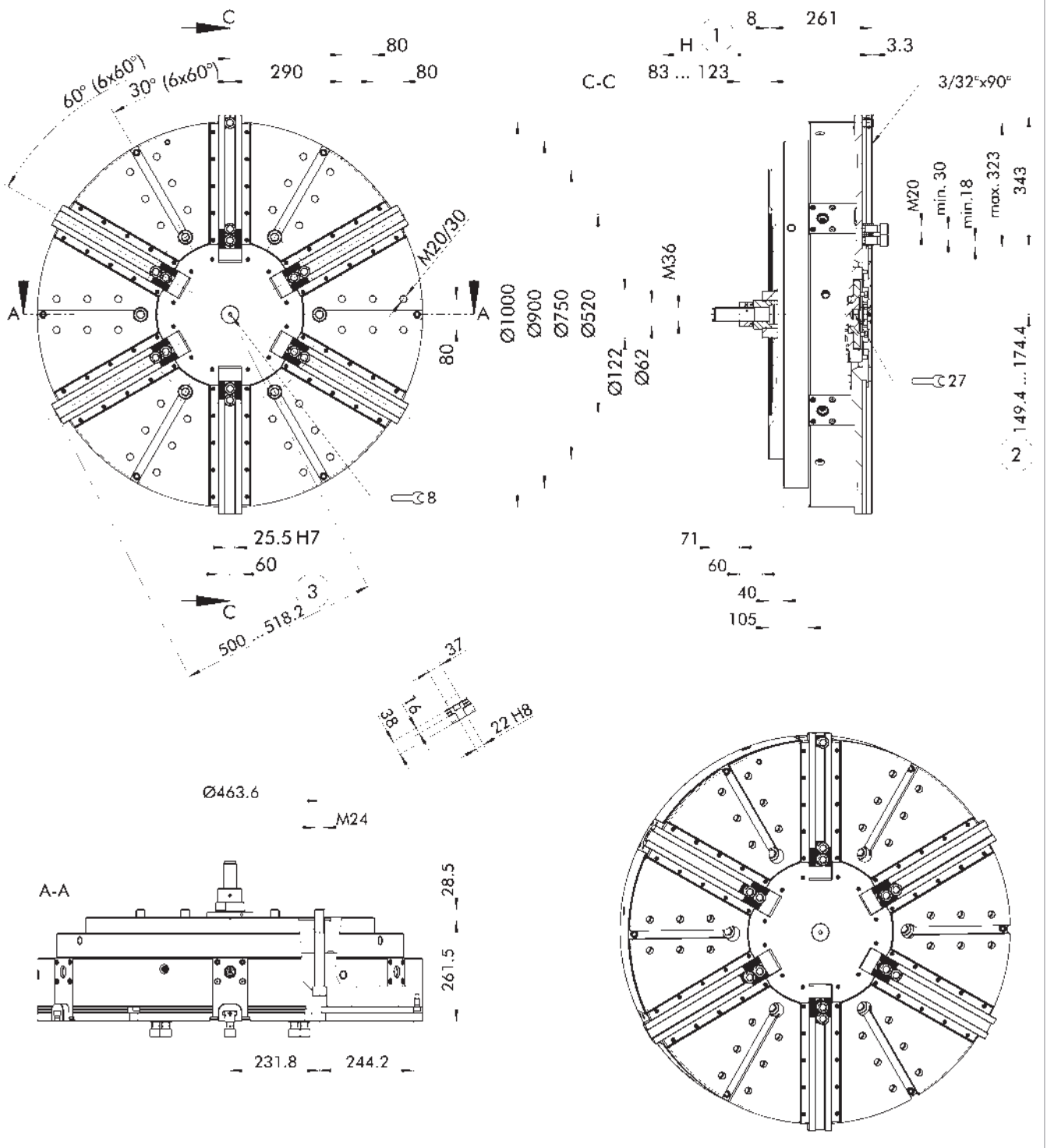
SWB 250
9.2 kg



Load of base jaw guidance



M_{max} = 2987 Nm



Chuck for shaft clamping drawn in open position.
Pendulum compensation shown in center positon.
Subject to technical changes.

① Piston stroke direction
② Distance to center of first tooth
③ Swing diameter radius

Technical data

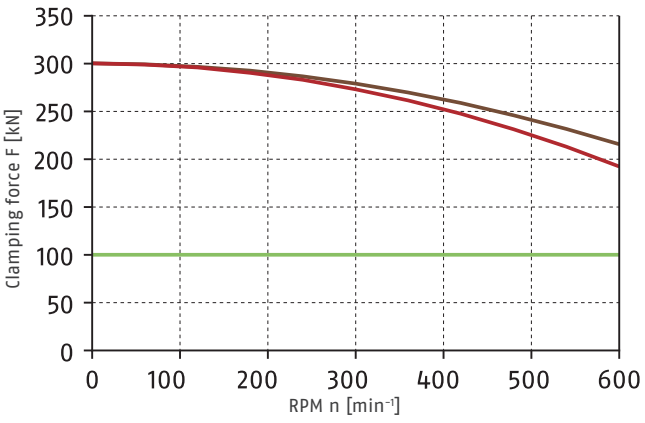
Spindle type	Spindle size	ID	Serration	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Pendulum compensation [mm]	Weight [kg]
ISO 702-4	Nr. 20 (Z520)	1340109	3/32" x 90°	600	300	150	25	60	±6	1244

Chuck with centrifugal force compensation on request

Scope of delivery

Chuck, T-nuts or mounting screws for top jaws, chuck mounting screws, eye bolt, and operating manual

Clamping force-RPM-diagram

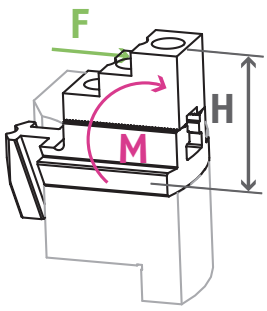


Required minimum clamping force F_{spmin} 33%

SHB 400
7.8 kg

SWB 400
16 kg

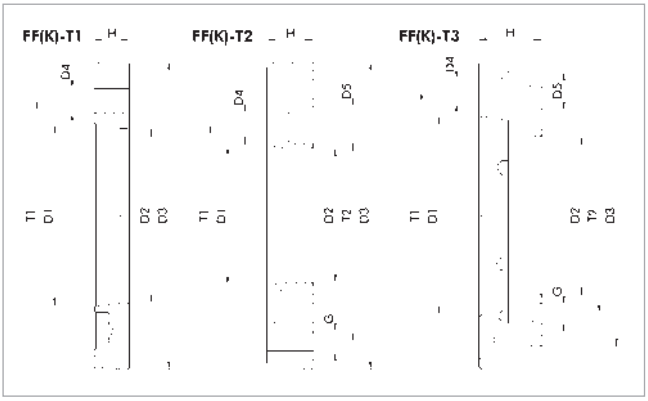
Load of base jaw guidance

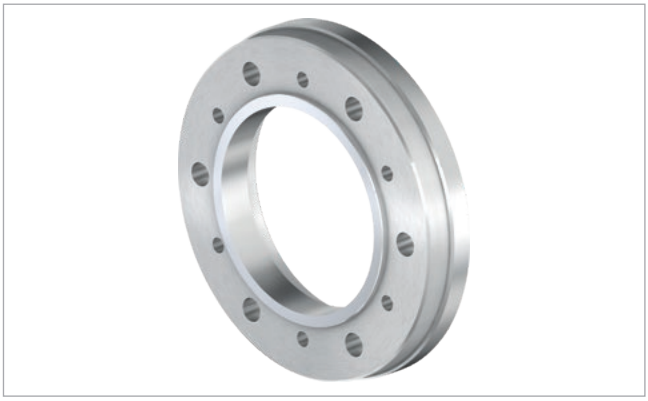


M_{max} = 5700 Nm

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	T3
					[mm]		[mm]	[mm]		[mm]	[mm]	[mm]	[mm]
FF-T2 Z140-A4	FF-T2	0805000	ROTA NCR-A 190	Nr. 4	61	Z140	11 (6x60°)	17	M10 (6x60°)	21	82.6	104.8	
FF-T1 Z140-A5	FF-T1	0803000	ROTA NCR-A 190	Nr. 5	79.6	Z140	11 (6x60°)			16	104.8		
FF-T3 Z140-A6	FF-T3	0801000	ROTA NCR-A 190	Nr. 6	85	Z140	13 (6x60°)	20	M10 (6x60°)	34	133.4	104.8	
FF-T2 Z220-A5	FF-T2	0805002	ROTA NCR-A 250 ROTA NCR-A 315	Nr. 5	79.6	Z220	11 (6x60°)	17	M16 (6x60°) M16 (2x180°)	28	104.8	171.4	
FF-T2 Z220-A6	FF-T2	0805003	ROTA NCR-A 250 ROTA NCR-A 315	Nr. 6	103.2	Z220	13 (6x60°)	20	M16 (6x60°) M16 (2x180°)	28	133.4	171.4	
FF-T1 Z220-A8	FF-T1	0803002	ROTA NCR-A 250 ROTA NCR-A 315	Nr. 8	136.2	Z220	17 (6x60°) 17 (2x180°)			19	171.4		
FF-T3 Z220-A11	FF-T3	0803003	ROTA NCR-A 250 ROTA NCR-A 315	Nr. 11	130	Z220	21 (6x60°)	32	M16 (12 x 30°)	50	235	171.4	
FF-T3 Z220-A15-1	FF-T3	0803020	ROTA NCR-A 250 ROTA NCR-A 315	Nr. 15	145	Z220	26 (6x60°)	38	M16 (6x60°)	55	330.2	171.4	
FF-T3 Z220-A15-2	FF-T3	0803021	ROTA NCR-A 250 ROTA NCR-A 315	Nr. 15	145	Z220	23 (6x60°)	35	M16 (6x60°)	55	330.2	171.4	
FF-T2 Z300-A6	FF-T2	0805004	ROTA NCR-A 400	Nr. 6	103.2	Z300	14 (6x60°)	20	M20 (6x60°) M20 (3x120°)	30	133.4	235	
FF-T2 Z300-A8	FF-T2	0805005	ROTA NCR-A 400	Nr. 8	136.2	Z300	17 (6x60°)	26	M20 (6x60°) M20 (3x120°)	30	171.4	235	
FF-T1 Z300-A11	FF-T1	0803004	ROTA NCR-A 400	Nr. 11	192.9	Z300	22 (6x60°) 22 (3x120°)			21	235		
FF-T3 Z300-A15-1	FF-T3	0803005	ROTA NCR-A 400	Nr. 15	190	Z300	26 (6x60°)	38	M20 (6x60°)	55	330.2	235	
FF-T3 Z300-A15-2	FF-T3	0803022	ROTA NCR-A 400	Nr. 15	190	Z300	23 (6x60°)	35	M20 (6x60°)	55	330.2	235	
FF-T2 Z380-A8	FF-T2	0805010	ROTA NCR-A 500	Nr. 8	136.2	Z380	17 (6x60°)	26	M24 (12 x 30°)	38	171.4	330.2	
FF-T2 Z380-A11	FF-T2	0803006	ROTA NCR-A 500	Nr. 11	192.9	Z380	21 (6x60°)	32	M24 (6x60°) M24 (3x120°)	38	235	330.2	
FF-T1 Z380-A15-1	FF-T1	0803023	ROTA NCR-A 500	Nr. 15	281.5	Z380	26 (6x60°)			47	330.2		
FF-T1 Z520-A15	FF-T1	0805007	ROTA NCR-A 630	Nr. 15	281.5	Z520	26 (6x60°)			28	330.2		
FF-T2 Z520-A20	FF-T2	0805008	ROTA NCR-A 800	Nr. 20	290	Z520	26 (6x60°)	40	M24 (12 x 30°)	62	330.2	463.6	
FF-T2 Z520-A15-1	FF-T2	0801004	ROTA NCR-A 800	Nr. 15	281.5	Z520	26 (6x60°)	40	M24 (6x60°)	40	330.2	463.6	
FF-T2 Z520-A15-2	FF-T2	0803025	ROTA NCR-A 800	Nr. 15	281.5	Z520	23 (6x60°)	35	M24 (6x60°)	40	330.2	463.6	
FF-T2 Z520-A11	FF-T2	0801003	ROTA NCR-A 1000	Nr. 11	192.9	Z520	21 (6x60°)	33	M24 (12 x 30°)	40	235	330.2	463.6

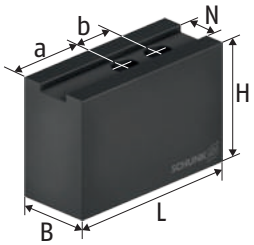
Direct adapter plates
Direct adapter plates are used if the spindle mounting bolt circle has the same size as the lathe chuck mounting bolt circle. The adapter plate has to be mounted on to the spindle together with the lathe chuck. The adapter plate is preassembled on the lathe chuck.

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.

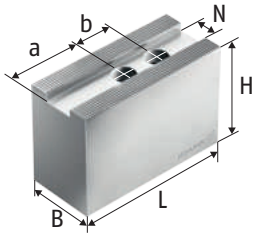
Expansion adapter plates FF-T3
Expansion adapter plates are used if the mounting bolt circle of the spindle is larger than the lathe chuck mounting bolt circle. The adapter plate is first mounted on the spindle and then the lathe chuck is mounted on the adapter plate.

Soft top jaws

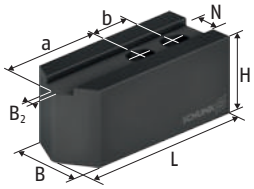
with fine serration 90°



SWB
Soft top jaws



SWB-AL
Soft top jaws



SWBL
Soft top jaws

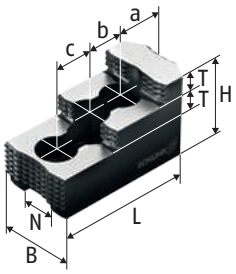
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA NCR-A 250	SWBL 165	0120152	14	35	40	80	45	20	M10	2.1
ROTA NCR-A 250	SWB 165	0120101	14	35	60	68	33	20	M10	2.5
ROTA NCR-A 250	SWB-AL 165	0168105	14	35	60	80	45	20	M10	1.2
ROTA NCR-A 315	SWBL 165	0120152	14	35	40	80	45	20	M10	2.1
ROTA NCR-A 315	SWB 165	0120101	14	35	60	68	33	20	M10	2.5
ROTA NCR-A 315	SWB-AL 165	0168105	14	35	60	80	45	20	M10	1.2
ROTA NCR-A 400	SWBL 250-21	0120155	21	50	50	120	72	28	M16	5.4
ROTA NCR-A 400	CWB 251	0100012	21	50	60	95	52	28	M16	5.2
ROTA NCR-A 400	SWB 250	0120105	21	50	80	120	62	28	M16	9.2
ROTA NCR-A 400	SWB-AL 250	0168102	21	50	80	120	62	28	M16	3.3
ROTA NCR-A 500	SWBL 250-21	0120155	21	50	50	120	72	28	M16	5.4
ROTA NCR-A 500	CWB 251	0100012	21	50	60	95	52	28	M16	5.2
ROTA NCR-A 500	SWB 250	0120105	21	50	80	120	62	28	M16	9.2
ROTA NCR-A 500	SWB-AL 250	0168102	21	50	80	120	62	28	M16	3.3
ROTA NCR-A 630	SWBL 250-21	0120155	21	50	50	120	72	28	M16	5.4
ROTA NCR-A 630	CWB 251	0100012	21	50	60	95	52	28	M16	5.2
ROTA NCR-A 630	SWB 250	0120105	21	50	80	120	62	28	M16	9.2
ROTA NCR-A 630	SWB-AL 250	0168102	21	50	80	120	62	28	M16	3.3
ROTA NCR-A 800	SWBL 250-21	0120155	21	50	50	120	72	28	M16	5.4
ROTA NCR-A 800	CWB 251	0100012	21	50	60	95	52	28	M16	5.2
ROTA NCR-A 800	SWB 250	0120105	21	50	80	120	62	28	M16	9.2
ROTA NCR-A 800	SWB-AL 250	0168102	21	50	80	120	62	28	M16	3.3
ROTA NCR-A 1000	SWB-AL 400	0168103	25.5	60	100	155	90	35	M20	6.4
ROTA NCR-A 1000	SWB 400	0120107	25.5	60	90	155	90	35	M20	16.0
ROTA NCR-A 1000	SP-WB 400	0124105	25.5	60	100	155	80	40	M18	18.6
ROTA NCR-A 1000	CWB 400	0100008	25.5	60	80	140	75	35	M20	12.6

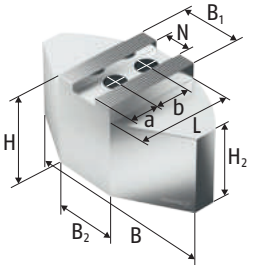
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Hard stepped top jaws, Full grip jaws

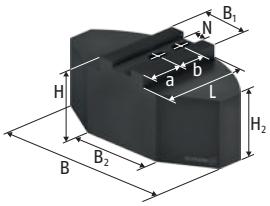
with fine serration 90°



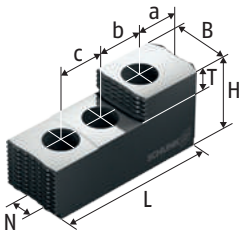
SHB
Hard stepped top jaws



SWB-SA
Full grip jaws



SWB-SM
Full grip jaws



SP-HB
Hard stepped top jaws

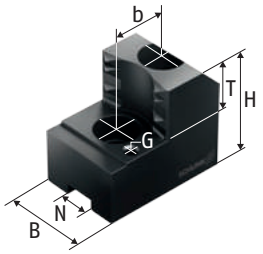
Technical data

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 NCR-A 250	SWB-SA 165	0170099	14	120	40	58	48	59.5		25	20		M10	2.2
ROTA NCR-A 250	SWB-SM 165	0169099	14	120	40	60	50	59.5		24.5	20		M10	6.0
ROTA NCR-A 250	SHB 165	0121101	14	30		46		79.7	11	16.6	22	22	M10	1.3
ROTA NCR-A 315	SWB-SA 165	0170099	14	120	40	58	48	59.5		25	20		M10	2.2
ROTA NCR-A 315	SWB-SM 165	0169099	14	120	40	60	50	59.5		24.5	20		M10	6.0
ROTA NCR-A 315	SHB 165	0121101	14	30		46		79.7	11	16.6	22	22	M10	1.3
ROTA NCR-A 400	SWB-SA 250-21	0170103	21	180	50	78	63	87.5		40	28		M16	6.3
ROTA NCR-A 400	SWB-SA 251	0170107	21	180	50	100	85	87.5		40	28		M16	8.3
ROTA NCR-A 400	SWB-SA 315	0170104	21	240	50	78	63	117		70	28		M16	11.0
ROTA NCR-A 400	SWB-SM 251	0169107	21	180	50	100	85	80		30	28		M16	22.0
ROTA NCR-A 400	SWB-SM 315	0169104	21	240	50	70	55	110		60	28		M16	26.6
ROTA NCR-A 400	SHB 250	0121105	21	50		58		103.5	14	34	25	25	M16	3.5
ROTA NCR-A 500	SWB-SA 250-21	0170103	21	180	50	78	63	87.5		40	28		M16	6.3
ROTA NCR-A 500	SWB-SA 251	0170107	21	180	50	100	85	87.5		40	28		M16	8.3
ROTA NCR-A 500	SWB-SM 250-21	0169103	21	180	50	70	55	80		29	28		M16	14.5
ROTA NCR-A 500	SWB-SM 251	0169107	21	180	50	100	85	80		30	28		M16	22.0
ROTA NCR-A 500	SHB 250	0121105	21	50		58		103.5	14	34	25	25	M16	3.5
ROTA NCR-A 630	SWB-SA 250-21	0170103	21	180	50	78	63	87.5		40	28		M16	6.3
ROTA NCR-A 630	SWB-SA 251	0170107	21	180	50	100	85	87.5		40	28		M16	8.3
ROTA NCR-A 630	SWB-SM 250-21	0169103	21	180	50	70	55	80		29	28		M16	14.5
ROTA NCR-A 630	SWB-SM 251	0169107	21	180	50	100	85	80		30	28		M16	22.0
ROTA NCR-A 630	SHB 315	0121111	21	50		58		128	14	46	30	30	M16	4.6
ROTA NCR-A 800	SWB-SA 250-21	0170103	21	180	50	78	63	87.5		40	28		M16	6.3
ROTA NCR-A 800	SWB-SA 251	0170107	21	180	50	100	85	87.5		40	28		M16	8.3
ROTA NCR-A 800	SWB-SM 250-21	0169103	21	180	50	70	55	80		29	28		M16	14.5
ROTA NCR-A 800	SWB-SM 251	0169107	21	180	50	100	85	80		30	28		M16	22.0
ROTA NCR-A 800	SHB 315	0121111	21	50		58		128	14	46	30	30	M16	4.6
ROTA NCR-A 1000	SWB-SA 400	0170105	25.5	330	150	98	68	160		84.5	35		M20	24.4
ROTA NCR-A 1000	SWB-SM 400	0169105	25.5	330	60	85	55	155		83.5	35		M20	53.8
ROTA NCR-A 1000	SHB 400	0121107	25.5	60		75		140	18	53	31	31	M20	7.8
ROTA NCR-A 1000	SP-HB 400-500	0125105	25.5	57.5		73		160	22	43.1	42	42	M18	9.8

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

Claw jaws

with fine serration 90°



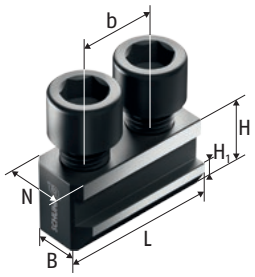
SZA
Claw jaws

Technical data

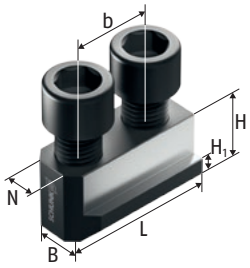
Chuck type	Clamping range ØD	Swing diameter SDmax	Description	ID	N	B	H	T	G	b	Screws	m/SET
	[mm]	[mm]			[mm]	[mm]	[mm]	[mm]		[mm]		[kg]
ROTA NCR-A 250	71 - 137	261	SZA 17-1	0122260	14	30	47	20	M6	20	M10	1.2
ROTA NCR-A 250	94 - 160	263	SZA 17-2	0122261	14	30	47	20	M6	20	M10	1.0
ROTA NCR-A 250	121 - 187	264	SZA 17-3	0122262	14	30	47	20	M6	20	M10	1.0
ROTA NCR-A 250	147 - 213	272	SZA 17-4	0122263	14	35	47	20	M6	20	M10	1.2
ROTA NCR-A 315	72 - 207	331	SZA 17-1	0122260	14	30	47	20	M6	20	M10	1.2
ROTA NCR-A 315	95 - 230	333	SZA 17-2	0122261	14	30	47	20	M6	20	M10	1.0
ROTA NCR-A 315	121 - 257	334	SZA 17-3	0122262	14	30	47	20	M6	20	M10	1.0
ROTA NCR-A 315	147 - 283	342	SZA 17-4	0122263	14	35	47	20	M6	20	M10	1.2
ROTA NCR-A 400	109 - 251	421	SZA 25-37	0138180	21	50	58	25	M8	28	M16	3.3
ROTA NCR-A 400	149 - 291	421	SZA 25-38	0138181	21	50	58	25	M8	28	M16	2.9
ROTA NCR-A 400	199 - 340	422	SZA 25-39	0138182	21	50	58	25	M8	28	M16	2.7
ROTA NCR-A 400	246 - 388	460	SZA 25-40	0138183	21	50	58	25	M8	28	M16	3.2
ROTA NCR-A 400	87 - 229	430	SZA 31-10	0138184	21	50	58	25	M8	28	M16	3.4
ROTA NCR-A 400	145 - 286	431	SZA 31-11	0138185	21	50	58	25	M8	28	M16	3.4
ROTA NCR-A 400	210 - 352	429	SZA 31-12	0138186	21	50	58	25	M8	28	M16	3.2
ROTA NCR-A 400	274 - 400	473	SZA 31-13	0138187	21	50	58	25	M8	28	M16	4.7
ROTA NCR-A 500	109 - 351	521	SZA 25-37	0138180	21	50	58	25	M8	28	M16	3.3
ROTA NCR-A 500	149 - 391	521	SZA 25-38	0138181	21	50	58	25	M8	28	M16	2.9
ROTA NCR-A 500	199 - 440	523	SZA 25-39	0138182	21	50	58	25	M8	28	M16	2.7
ROTA NCR-A 500	246 - 488	560	SZA 25-40	0138183	21	50	58	25	M8	28	M16	3.2
ROTA NCR-A 500	87 - 328	530	SZA 31-10	0138184	21	50	58	25	M8	28	M16	3.4
ROTA NCR-A 500	145 - 385	531	SZA 31-11	0138185	21	50	58	25	M8	28	M16	3.4
ROTA NCR-A 500	210 - 451	529	SZA 31-12	0138186	21	50	58	25	M8	28	M16	3.2
ROTA NCR-A 500	274 - 500	574	SZA 31-13	0138187	21	50	58	25	M8	28	M16	4.7
ROTA NCR-A 630	182 - 481	651	SZA 25-37	0138180	21	50	58	25	M8	28	M16	3.3
ROTA NCR-A 630	222 - 520	651	SZA 25-38	0138181	21	50	58	25	M8	28	M16	2.9
ROTA NCR-A 630	272 - 570	653	SZA 25-39	0138182	21	50	58	25	M8	28	M16	2.7
ROTA NCR-A 630	319 - 617	690	SZA 25-40	0138183	21	50	58	25	M8	28	M16	3.2
ROTA NCR-A 630	160 - 458	660	SZA 31-10	0138184	21	50	58	25	M8	28	M16	3.4
ROTA NCR-A 630	217 - 515	661	SZA 31-11	0138185	21	50	58	25	M8	28	M16	3.4
ROTA NCR-A 630	283 - 580	659	SZA 31-12	0138186	21	50	58	25	M8	28	M16	3.2
ROTA NCR-A 630	347 - 630	704	SZA 31-13	0138187	21	50	58	25	M8	28	M16	4.7
ROTA NCR-A 800	160 - 626	828	SZA 31-10	0138184	21	50	58	25	M8	28	M16	3.4
ROTA NCR-A 800	217 - 682	829	SZA 31-11	0138185	21	50	58	25	M8	28	M16	3.4
ROTA NCR-A 800	283 - 748	827	SZA 31-12	0138186	21	50	58	25	M8	28	M16	3.2
ROTA NCR-A 800	347 - 800	875	SZA 31-13	0138187	21	50	58	25	M8	28	M16	4.7
ROTA NCR-A 1000	182 - 771	1117	SZA 40-12	0138301	25.5	60	78	33	M8	35	M20	11.5
ROTA NCR-A 1000	366 - 956	1079	SZA 40-14	0138303	25.5	60	78	33	M8	35	M20	8.0
ROTA NCR-A 1000	516 - 1000	1099	SZA 40-16	0138305	25.5	60	78	33	M8	35	M20	11.0

T-nut

with fine serration 90°



NKA
T-nut



NK
T-nut



NS
T-nut



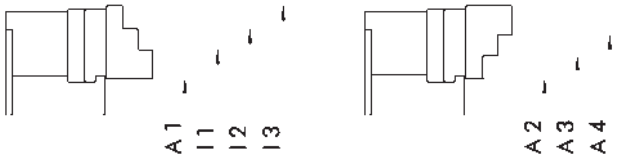
NKS
T-nut

Chuck type	Description	ID	H [mm]	H1 [mm]	b [mm]	G	Cyl.-screw	Max. adm. tightening torque [Nm]
ROTA NCR-A 250	NKA 1	0145103	18.5	6.5	20	M10	M10 x 25	50
ROTA NCR-A 250	NKS 1	0143104	18.5	6.5		M10	M10 x 25	50
ROTA NCR-A 315	NKA 1	0145103	18.5	6.5	20	M10	M10 x 25	50
ROTA NCR-A 315	NKS 1	0143104	18.5	6.5		M10	M10 x 25	50
ROTA NCR-A 400	NKA 3	0145105	26.5	10	28	M16	M16 x 35	150
ROTA NCR-A 400	NKS 3	0143107	26.5	10		M16	M16 x 35	150
ROTA NCR-A 500	NKA 3	0145105	26.5	10	28	M16	M16 x 35	150
ROTA NCR-A 500	NKS 3	0143107	26.5	10		M16	M16 x 35	150
ROTA NCR-A 630	NS 160	0140102	27	11		M16	M16 x 35	150
ROTA NCR-A 630	NK 160	0145101	27	11	28	M16	M16 x 35	150
ROTA NCR-A 800	NS 160	0140102	27	11		M16	M16 x 35	150
ROTA NCR-A 800	NK 160	0145101	27	11	28	M16	M16 x 35	150
ROTA NCR-A 1000	NK 200	0145102	29	11	35	M20	M20 x 40	220
ROTA NCR-A 1000	NS 200	0140103	29	11		M20	M20 x 40	220

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

Hard stepped top jaws

with fine serration 90°



Jaw position I

Jaw position II

O.D. clamping

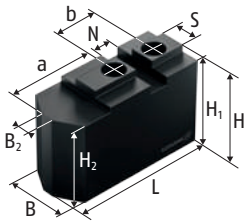
Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]
ROTA NCR-A 250	SHB 165	0121101	50 - 161	44 - 101	94 - 145	138 - 248
ROTA NCR-A 315	SHB 165	0121101	50 - 231	44 - 101	94 - 145	138 - 315
ROTA NCR-A 400	SHB 250	0121105	72 - 275	97 - 190	179 - 263	252 - 400
ROTA NCR-A 500	SHB 250	0121105	72 - 375	97 - 190	179 - 263	252 - 500
ROTA NCR-A 630	SHB 315	0121111	112 - 471	155 - 263	247 - 355	339 - 630
ROTA NCR-A 800	SHB 315	0121111	92 - 639	143 - 250	235 - 342	327 - 800
ROTA NCR-A 1000	SHB 400	0121107	173 - 830	229 - 355	331 - 457	433 - 1000

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA NCR-A 250	SHB 165	0121101	116 - 167	160 - 217	210 - 321
ROTA NCR-A 315	SHB 165	0121101	116 - 167	160 - 217	210 - 380
ROTA NCR-A 400	SHB 250	0121105	125 - 209	197 - 289	277 - 480
ROTA NCR-A 500	SHB 250	0121105	125 - 209	197 - 289	277 - 581
ROTA NCR-A 630	SHB 315	0121111	183 - 290	275 - 382	367 - 726
ROTA NCR-A 800	SHB 315	0121111	161 - 269	254 - 360	345 - 880
ROTA NCR-A 1000	SHB 400	0121107	246 - 371	347 - 473	449 - 1100

Soft top jaws

with tongue and groove



SRK
Soft top jaws

Technical data

Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	H [mm]	H1 [mm]	H2 [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA NCR-A 190	SRK 132	0136112	8	10	25	30	27.5	26	60	29	22	M8	0.8

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

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 NCR-A 190 ROTA NCR-A 250 ROTA NCR-A 315 ROTA NCR-A 400 ROTA NCR-A 500 ROTA NCR-A 630 ROTA NCR-A 800 ROTA NCR-A 1000	IFT Set	1404235

Extension set for large chucks

For use as an extension of the IFT measuring head for measuring the jaw clamping force of large chucks of Ø 400 mm and more.



Suitable for	Description	ID
ROTA NCR-A 400 ROTA NCR-A 500 ROTA NCR-A 630 ROTA NCR-A 800 ROTA NCR-A 1000	IFT adapter set	1498512

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

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