



## **ROTA NCF *plus 2***

**Power lathe chuck with  
centrifugal force com-  
pensation and large  
through-hole**

# Weight-optimized power lathe chuck with integrated centrifugal force compensation for reducing the loss of clamping force under speed of rotation

High speeds mean high centrifugal forces of the jaws and thus high clamping force losses in turning applications. The ROTA NCF plus 2 with integrated centrifugal force compensation effectively counteracts this loss of clamping force. As a result, significantly higher speeds can be run than with conventional lathe chucks. The modular sealed center sleeve system also increases flexibility.



## Advantages – Your benefits

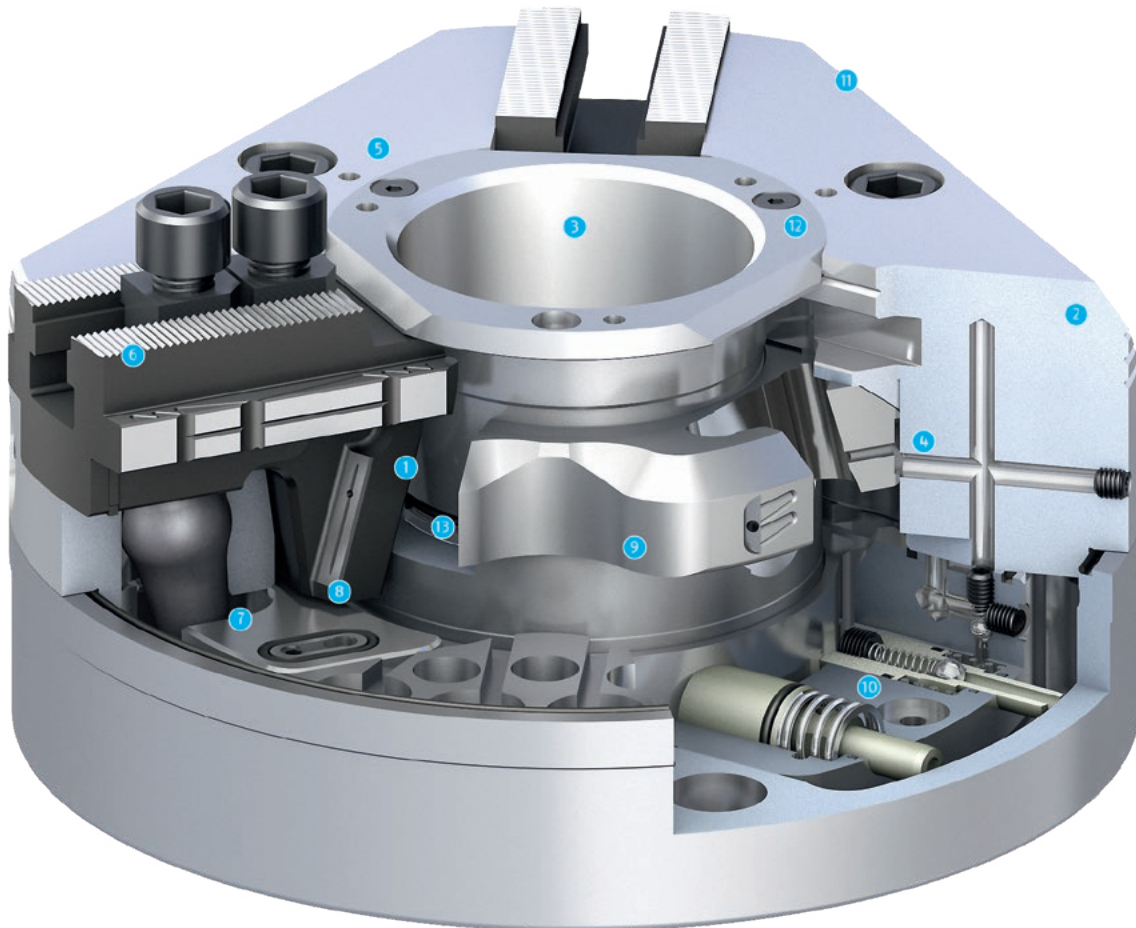
- + Precision wedge-hook power lathe chuck for highest quality requirements**  
Allows excellent machining results
- + Very high RPM without essential clamping force reduction**  
Optimum utilization of the lathe chuck performance due to high economic efficiency
- + With integrated centrifugal force compensation**  
Thereby high machining speeds are possible
- + Large through-hole**  
Machining all standard pipe diameters
- + High efficiency of the wedge hook system**  
Process-reliable clamping due to high clamping forces
- + Optimized lubrication system**  
Consistently high clamping forces ensured
- + Modular center sleeve system**  
Optimal adjustment to new clamping tasks thanks to the exchangeable center sleeves
- + Double-guided chuck piston**  
For highest run-out and repeat accuracy
- + Low chuck weight**  
Fast acceleration and deceleration operations shorten the cycle times
- + All sides of the functional parts are hardened and ground**  
Ensures a long service life

## Technical data

Description	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke [mm]	Through-hole [mm]
ROTA NCF plus 2 185-52	6000	72	30	5.3	20	52
ROTA NCF plus 2 215-66	6000	100	42	5.3	20	66
ROTA NCF plus 2 260-86	4500	140	60	5.3	20	86
ROTA NCF plus 2 315-104	4000	160	70	5.3	20	104
ROTA NCF 400-120	3300	187.5	77	8	30	120
ROTA NCF 500-160	2200	200	75	8	30	160
ROTA NCF 630-180	1800	300	122	11.2	42	180

## Function of ROTA NCF plus 2

The axially movable piston transfers the force to the base jaw and generates a radial jaw movement synchronized with the rotational axis. The jaws are coupled to a compensating weight via a lever, which leads to a constant clamping force when the lathe chuck rotates.

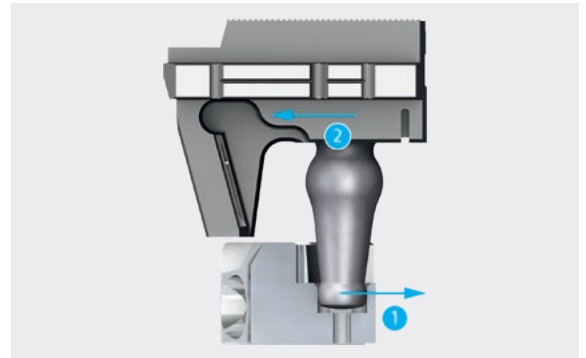


- 1 Wedge hook drive**  
Offers constantly high clamping forces in operation
- 2 Hardened and extremely rigid base body**  
Therefore a longer service life at highest precision. Even with maximum clamping force
- 3 Large through-hole**  
For machining of all standard raw material diameters
- 4 Optimized lubrication system**  
For a high level of efficiency
- 5 Mounting thread**  
For workpiece stops or cover plates
- 6 Base jaw serration**  
Available in inch or metric sizes
- 7 Integrated centrifugal force compensation**  
For constant clamping force even at top speeds
- 8 Robust and advanced wedge-hook**  
For excellent power transmission
- 9 Innovative piston guidance**  
Optimizes the force flow and provides optimal rigidity
- 10 Integrated, patented grease pump system**  
For permanent grease circulation during every clamping stroke. Extended maintenance intervals can be realized as a result
- 11 Weight-optimized design**  
For great economy in daily use
- 12 Modular center sleeve system**  
Therefore optimal adjustment to new clamping tasks
- 13 Additional seals**  
For sealing against coolants and chips

### Integrated centrifugal force compensation

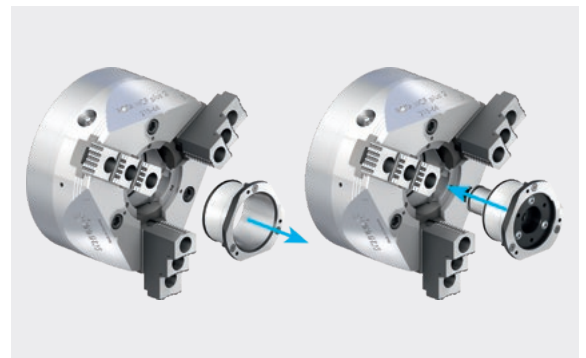
Compared to conventional lathe chucks, the loss of clamping force is compensated by the integrated centrifugal force compensation. Due to the speed, the centrifugal force balancing weight is pressed to the outside. The lever directly transmits the force onto the base jaw.

- ❶ Centrifugal force via compensation weight
- ❷ Clamping force support for O.D. clamping



### Changing the center sleeve

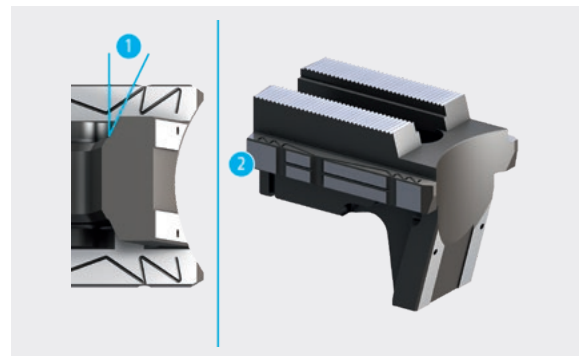
The modular center sleeves can be changed quickly and easily while the chuck remains mounted. When the three screws are undone, all the protection sleeves can be pulled off from the front and replaced.



### Optimized wedge hook and precision jaw guidance

For longer life time and high repeat accuracy, fine serration 1/16" x 90° or 1.5 mm x 60°.

- ❶ Trapezoidal angle  
Between the base jaw and piston
- ❷ Precision flat guidance



### Additional sealing inside of the center sleeve and optimized greasing system

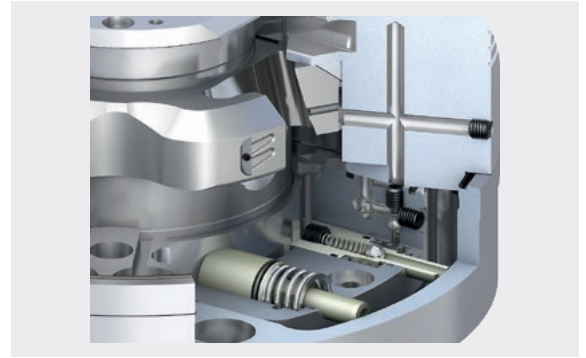
Therefore the maintenance intervals are longer and permanent supply to all function and friction surfaces is ensured.

- ❶ Modular center sleeve  
Also exchangeable in built-in condition from the front chuck face
- ❷ Long piston guidance  
For more accuracy



## Integrated, patented grease-pump system in the centrifugal force compensation

For permanent grease circulation during every clamping stroke. Extended maintenance intervals can be realized as a result



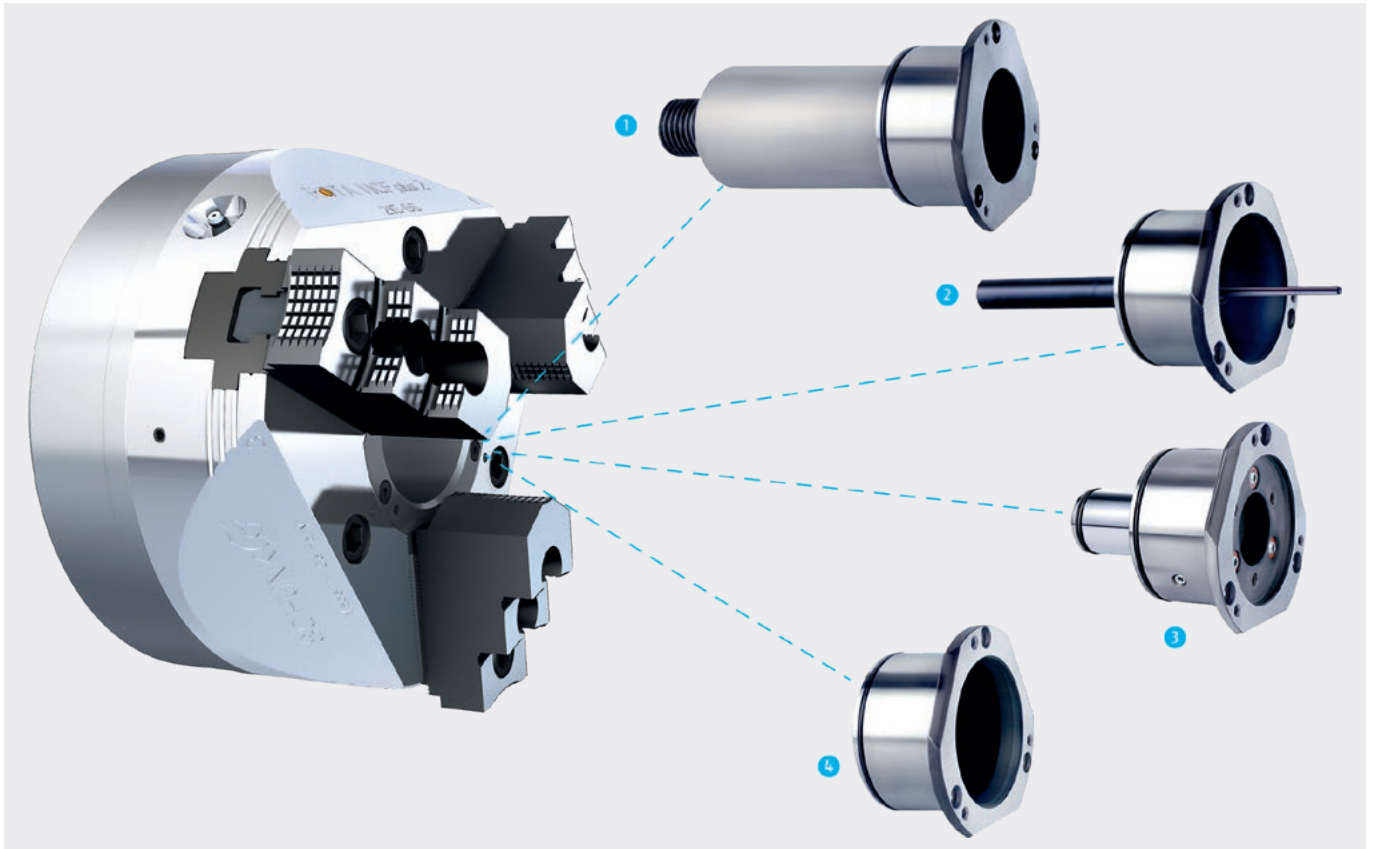
## Very rigid and hardened chuck body

With direct short taper mounting without intermediate flange.

- ① Chuck body
- ② Piston



## Modular center sleeve system

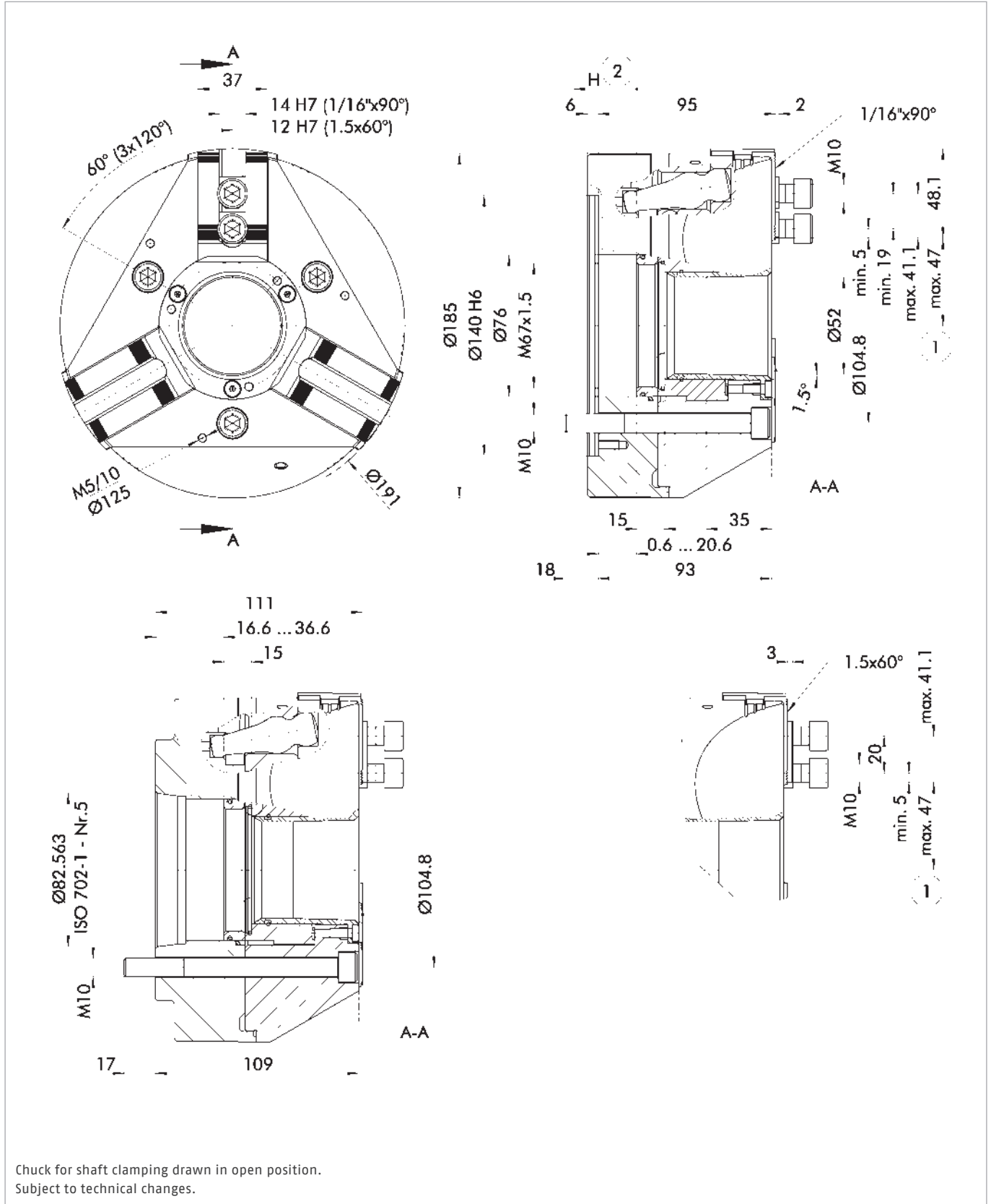


The modular center sleeve system increases flexibility for the most various applications in everyday life.

- ❶ **Adjustable stop in the center sleeve**  
The adjustable stop ensures that all workpieces are stopped with high repeat accuracy in the same selectable position. This makes handling quick and easy.
- ❷ **Part ejector in the center sleeve**  
An optimum addition for automatic loading. The part ejector disposes of a gas spring, which will eject your workpiece safely out of the chuck.
- ❸ **Coolant nozzles in the center sleeve**  
Ideal as an additional component if your machine is equipped with a central coolant supply. For I.D. machining, coolant will be fed directly to the tool.
- ❹ **Closed center sleeve**  
The closed center sleeve prevents penetration of chips and coolant into the through-hole.

❶ Modular center sleeve system up to size 315 possible.





① Distance to center of first tooth

② Piston stroke direction

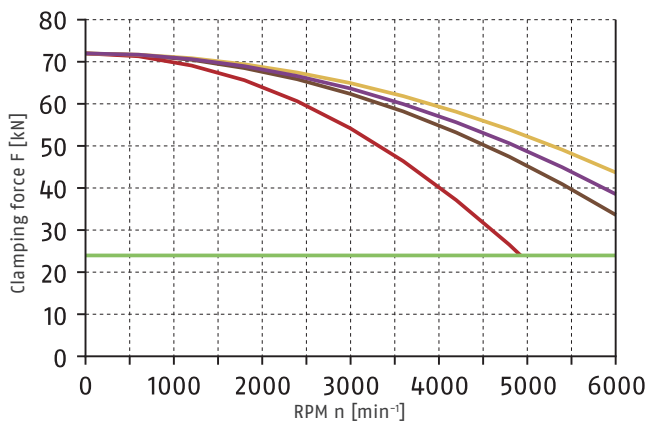
Technical data

Spindle type	Spindle size	ID	Serration	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm <sup>2</sup> ]	Weight [kg]
ISO 702-4	Nr. 5 (Z140)	0854106	1/16" x 90°	6000	72	30	5.3	20	0.063	14
ISO 702-1	Nr. 5	0854107	1/16" x 90°	6000	72	30	5.3	20	0.067	15
ISO 702-4	Nr. 5 (Z140)	0854108	1.5 mm x 60°	6000	72	30	5.3	20	0.063	14
ISO 702-1	Nr. 5	0854109	1.5 mm x 60°	6000	72	30	5.3	20	0.067	15

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

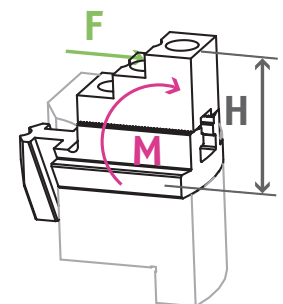
SWB 165  
2.5 kg

SHB-J 60  
0.8 kg

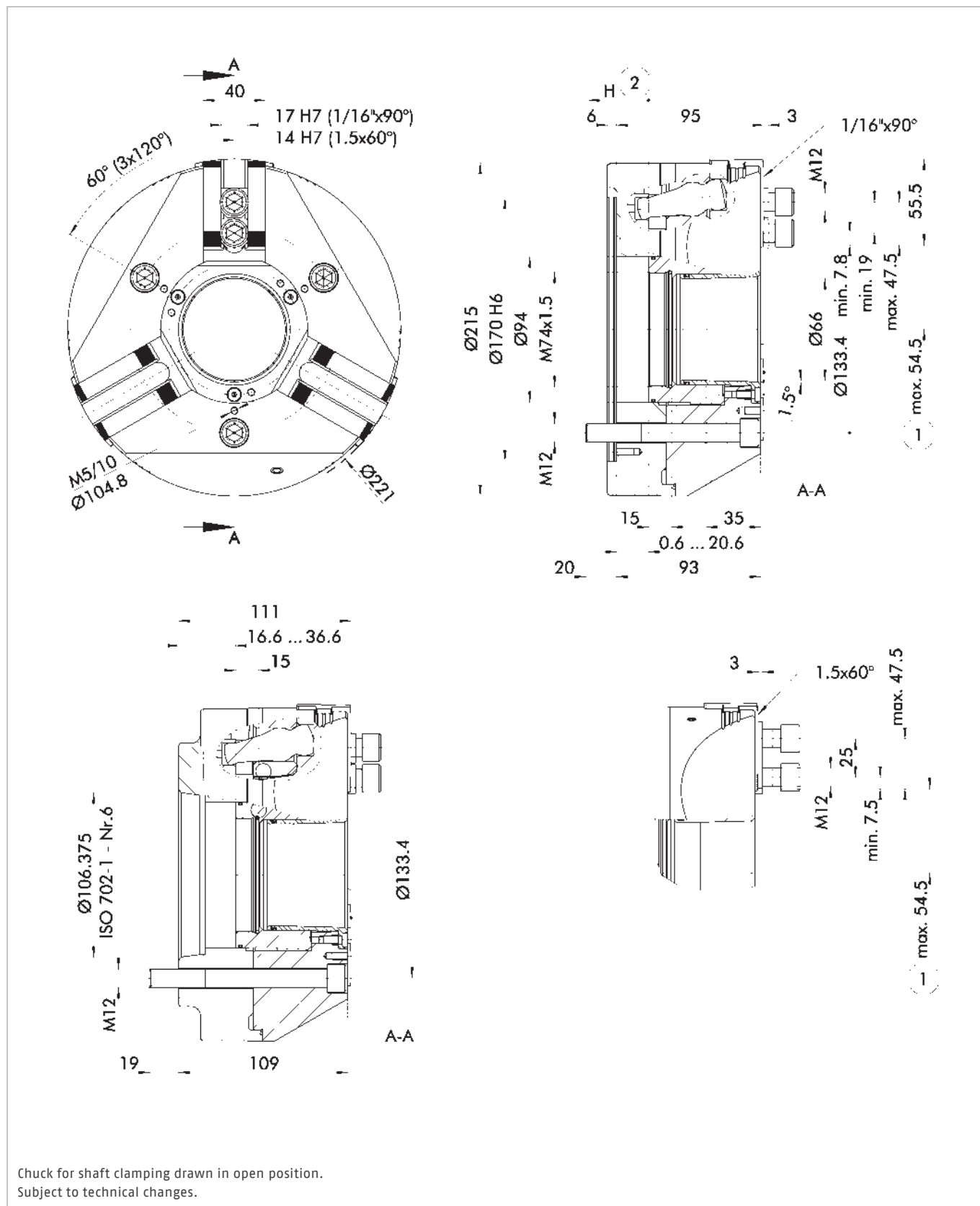
KM-WB 66  
1.4 kg



Load of base jaw guidance



$M_{max} = 1404 \text{ Nm}$



① Distance to center of first tooth

② Piston stroke direction

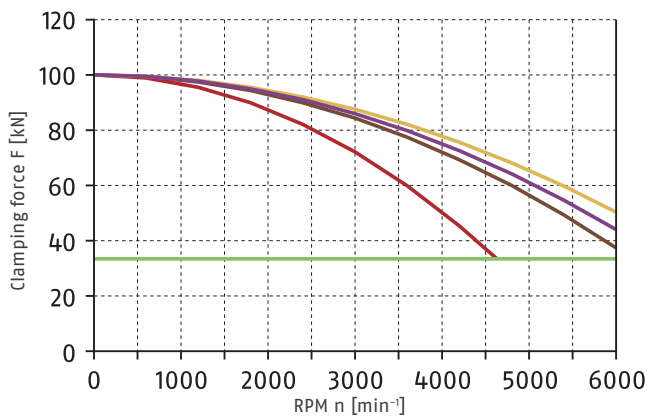
Technical data

Spindle type	Spindle size	ID	Serration	Max. rotational speed [ $\text{min}^{-1}$ ]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [ $\text{kgm}^2$ ]	Weight [kg]
ISO 702-4	Nr. 6 (Z170)	0854116	1/16" x 90°	6000	100	42	5.3	20	0.12	19
ISO 702-1	Nr. 6	0854117	1/16" x 90°	6000	100	42	5.3	20	0.12	20
ISO 702-4	Nr. 6 (Z170)	0854118	1.5 mm x 60°	6000	100	42	5.3	20	0.12	19
ISO 702-1	Nr. 6	0854119	1.5 mm x 60°	6000	100	42	5.3	20	0.12	20

Scope of delivery

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

Clamping force-RPM-diagram



Required minimum clamping force  $F_{\text{spmin}} 33\%$

SHB 210  
2 kg



SWB 200  
4.1 kg



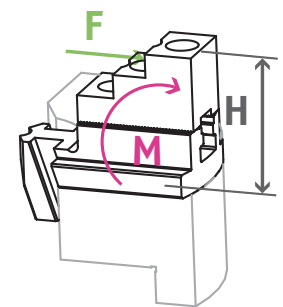
SHB-J 80  
1.85 kg



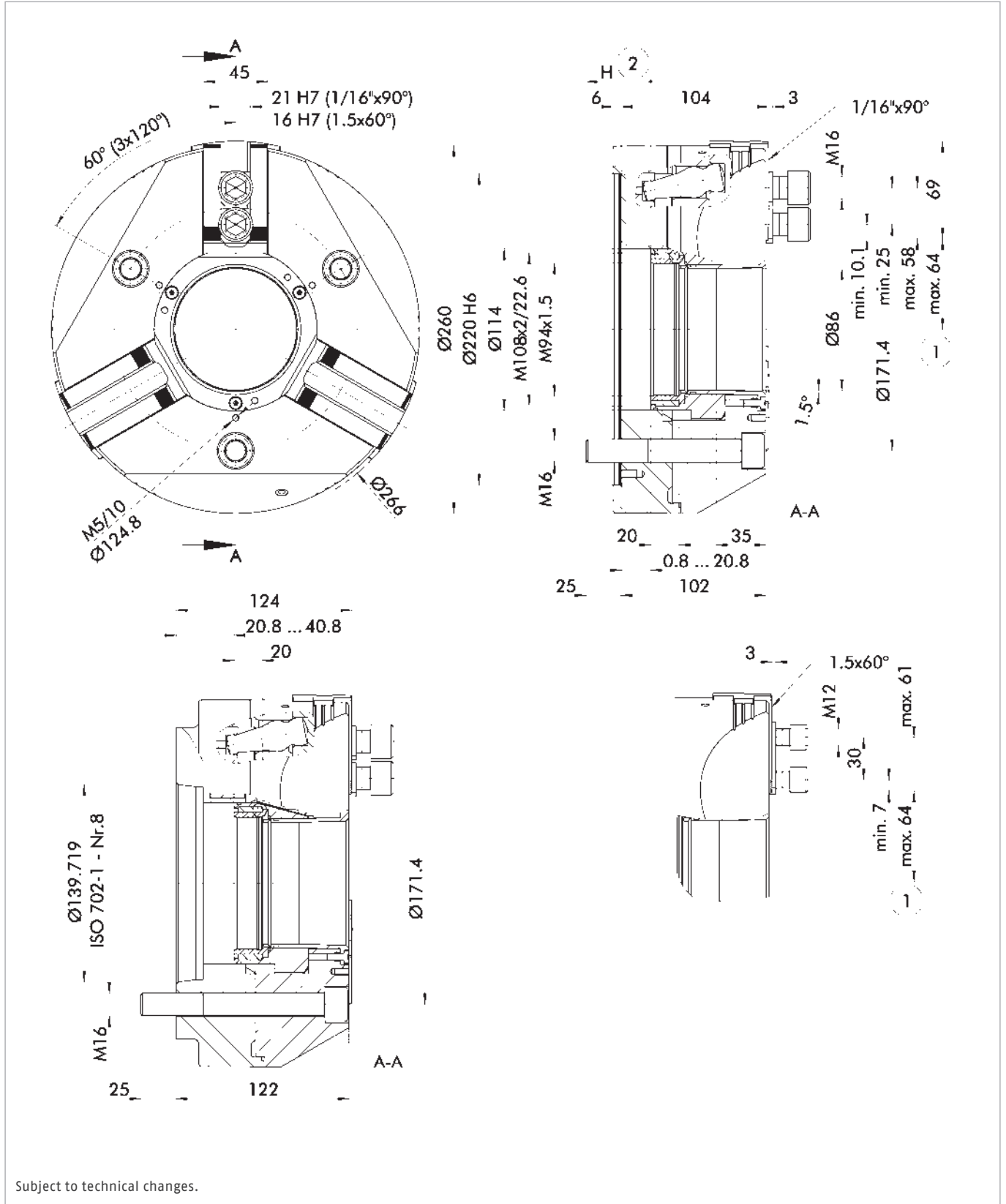
KM-WB 88  
2.7 kg



Load of base jaw guidance



$M_{\text{max}} = 2050 \text{ Nm}$



Subject to technical changes.

① Distance to center of first tooth

② Piston stroke direction

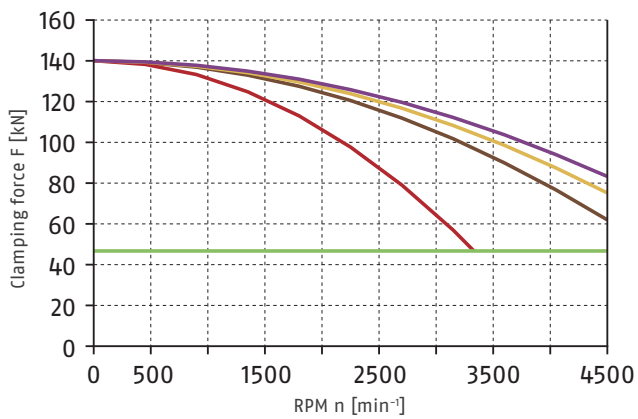
Technical data

Spindle type	Spindle size	ID	Serration	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm <sup>2</sup> ]	Weight [kg]
ISO 702-4	Nr. 8 (Z220)	0854126	1/16" x 90°	4500	140	60	5.3	20	0.27	30
ISO 702-1	Nr. 8	0854127	1/16" x 90°	4500	140	60	5.3	20	0.3	33
ISO 702-4	Nr. 8 (Z220)	0854128	1.5 mm x 60°	4500	140	60	5.3	20	0.27	30
ISO 702-1	Nr. 8	0854129	1.5 mm x 60°	4500	140	60	5.3	20	0.3	33

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

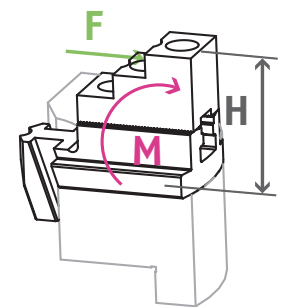
SWB 250  
9.2 kg

SHB-J 100  
2.8 kg

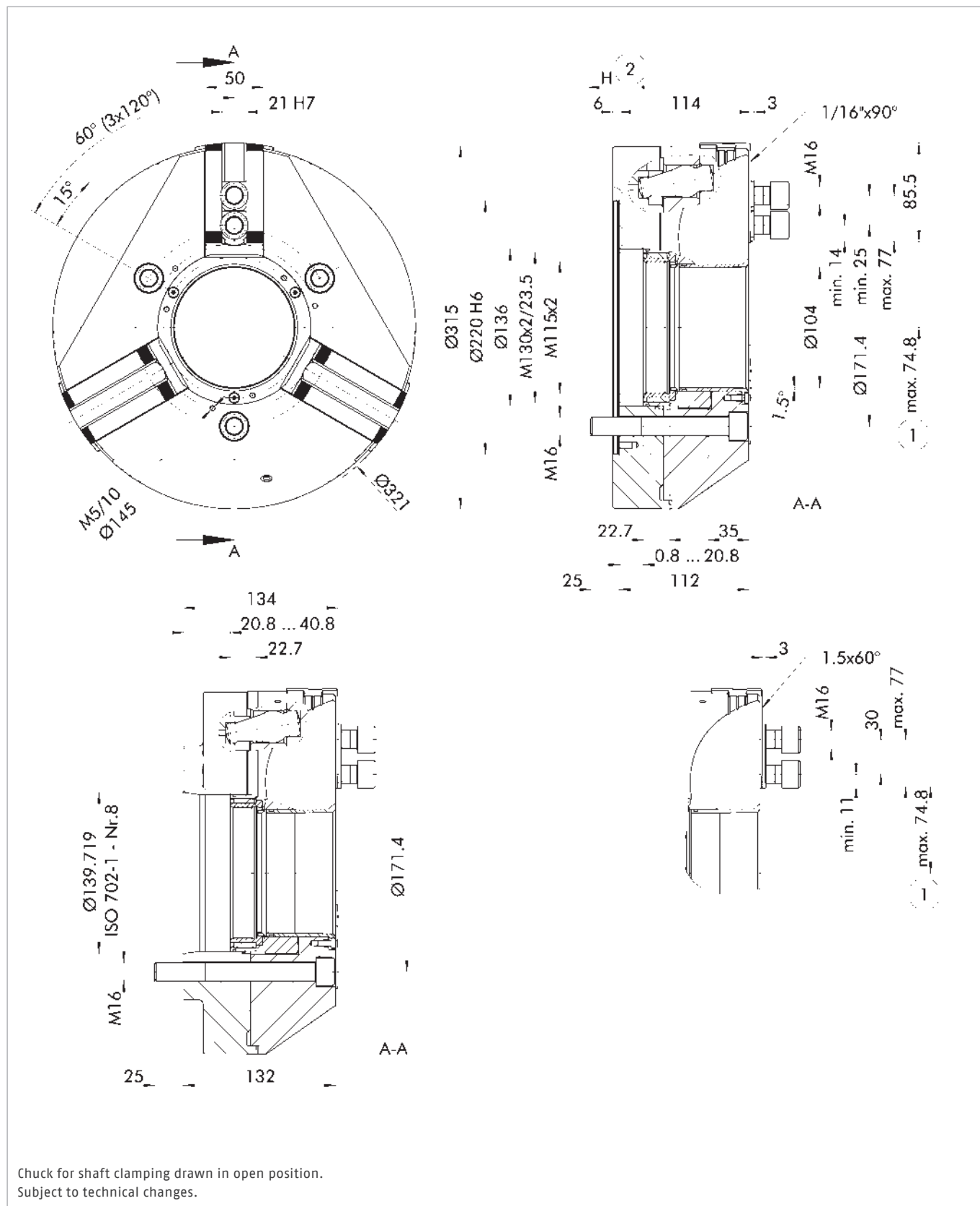
KM-WB 110  
3.8 kg



Load of base jaw guidance



$M_{max} = 3407 \text{ Nm}$



① Distance to center of first tooth

② Piston stroke direction

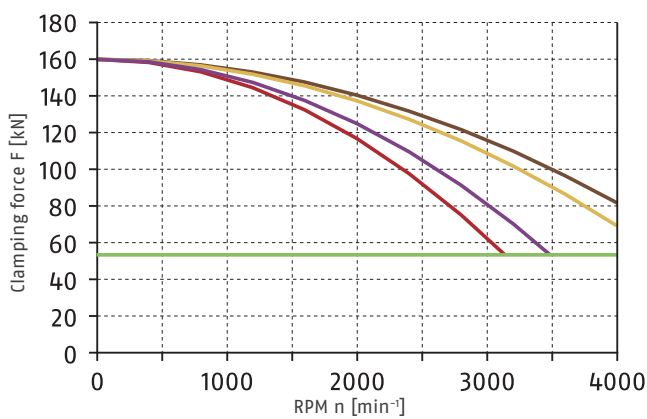
Technical data

Spindle type	Spindle size	ID	Serration	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm <sup>2</sup> ]	Weight [kg]
ISO 702-4	Nr. 8 (Z220)	0854136	1/16" x 90°	4000	160	70	5.3	20	0.61	47
ISO 702-1	Nr. 8	0854137	1/16" x 90°	4000	160	70	5.3	20	0.63	49
ISO 702-4	Nr. 8 (Z220)	0854138	1.5 mm x 60°	4000	160	70	5.3	20	0.61	47
ISO 702-1	Nr. 8	0854139	1.5 mm x 60°	4000	160	70	5.3	20	0.63	49

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

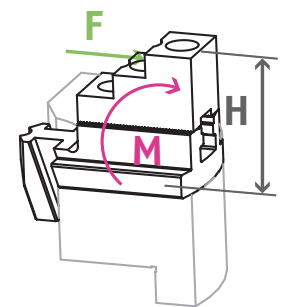
SWB 250  
9.2 kg

SHB-J 126  
5.15 kg

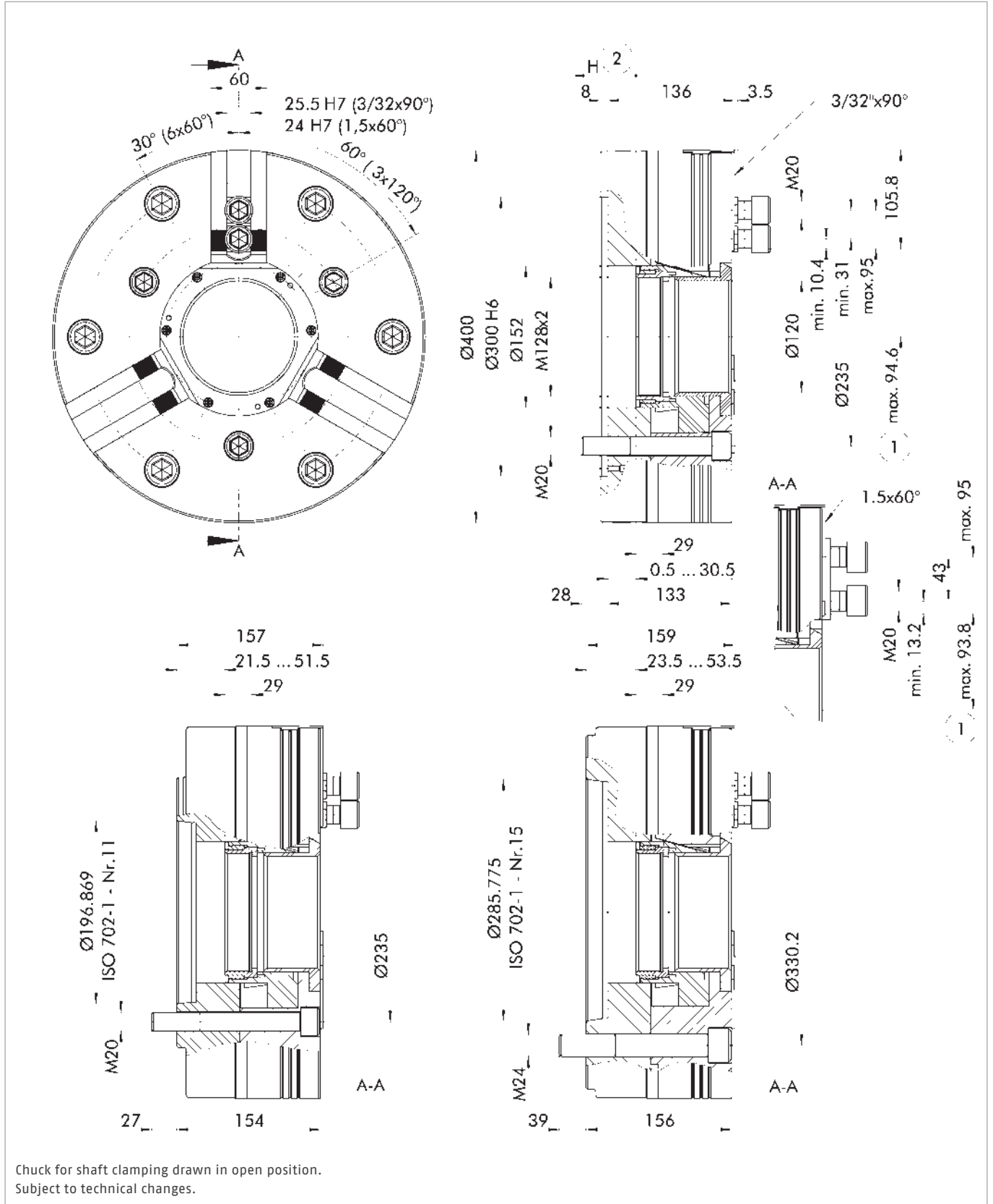
KM-WB 126  
7.56 kg



Load of base jaw guidance



$M_{max} = 3973 \text{ Nm}$



① Distance to center of first tooth

② Piston stroke direction

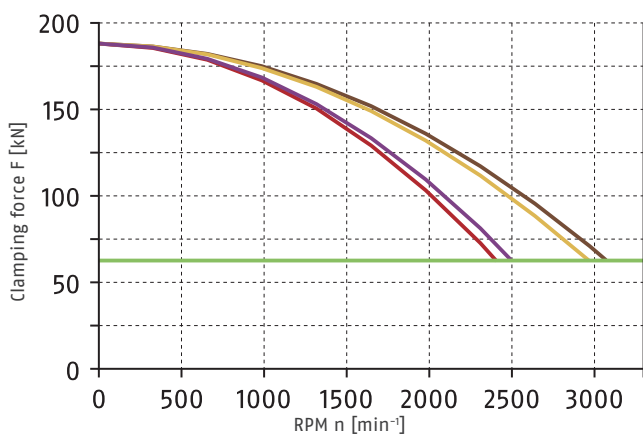
Technical data

Spindle type	Spindle size	ID	Serration	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm <sup>2</sup> ]	Weight [kg]
ISO 702-4	Nr. 11 (Z300)	0854040	3/32" x 90°	3300	187.5	77	8	30	0.95	110
ISO 702-1	Nr. 11	0854041	3/32" x 90°	3300	187.5	77	8	30	0.95	114
ISO 702-1	Nr. 15	0854042	3/32" x 90°	3300	187.5	77	8	30	0.95	117
ISO 702-4	Nr. 11 (Z300)	0854043	1.5 mm x 60°	3300	187.5	77	8	30	0.95	110
ISO 702-1	Nr. 11	0854044	1.5 mm x 60°	3300	187.5	77	8	30	0.95	114

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 400  
7.8 kg

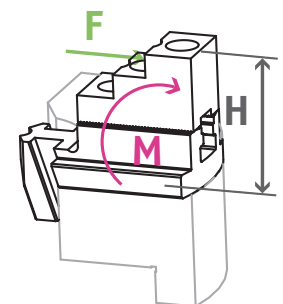
SWB 400  
16 kg

SHB-J 150  
8.64 kg

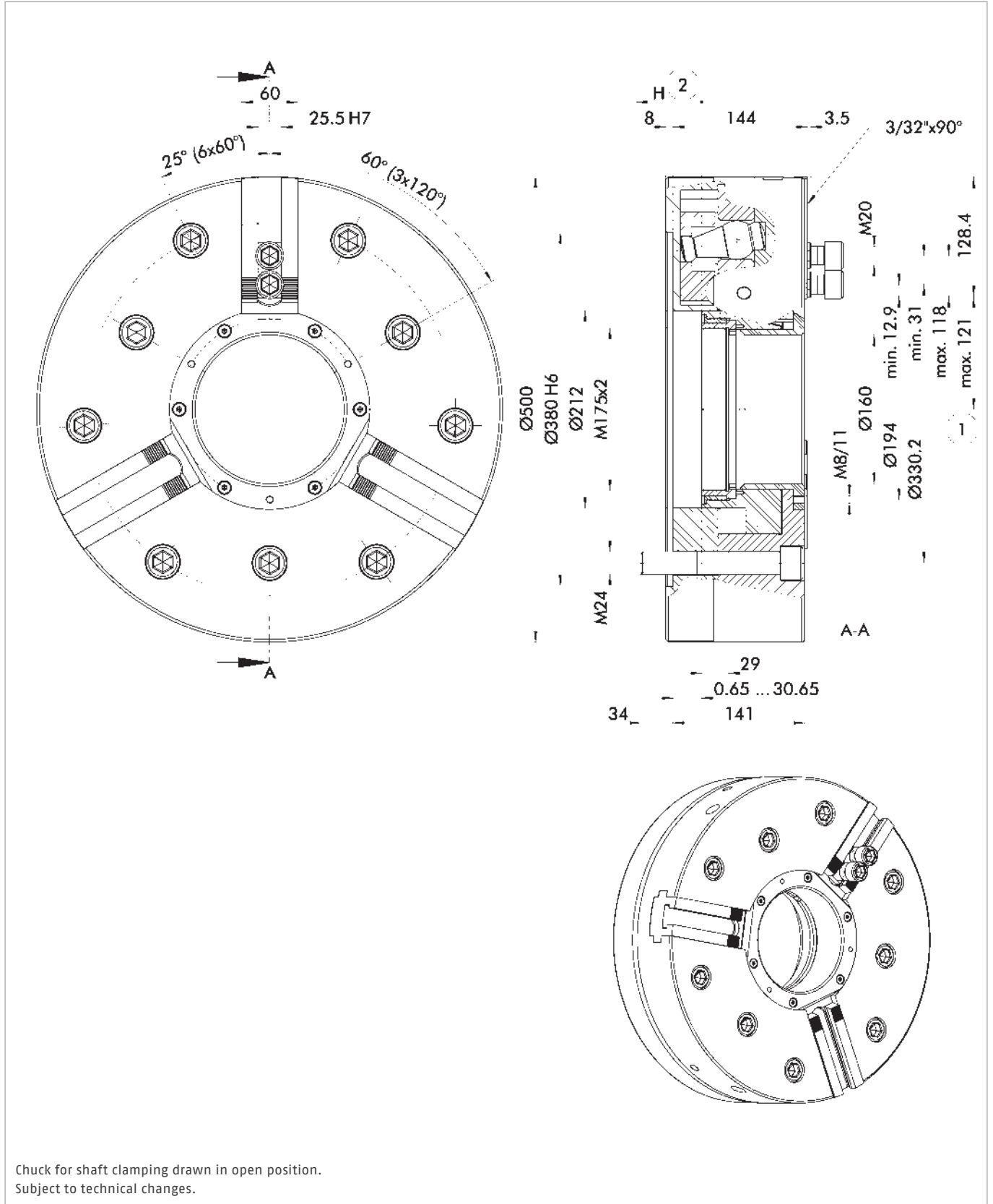
KM-WB 153  
15.51 kg



Load of base jaw guidance



$M_{max} = 6607 \text{ Nm}$



① Distance to center of first tooth

② Piston stroke direction

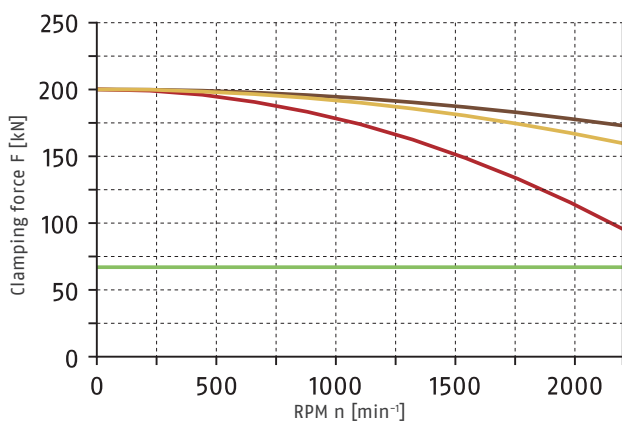
Technical data

Spindle type	Spindle size	ID	Serration	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm <sup>2</sup> ]	Weight [kg]
ISO 702-4	Nr. 15 (Z380)	0854050	3/32" x 90°	2200	200	75	8	30	6.1	170

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%

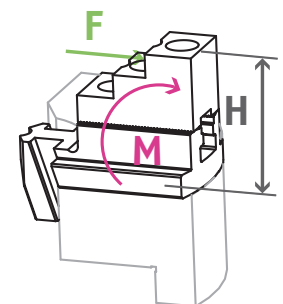
SHB 400  
7.8 kg

SWB 400  
16 kg

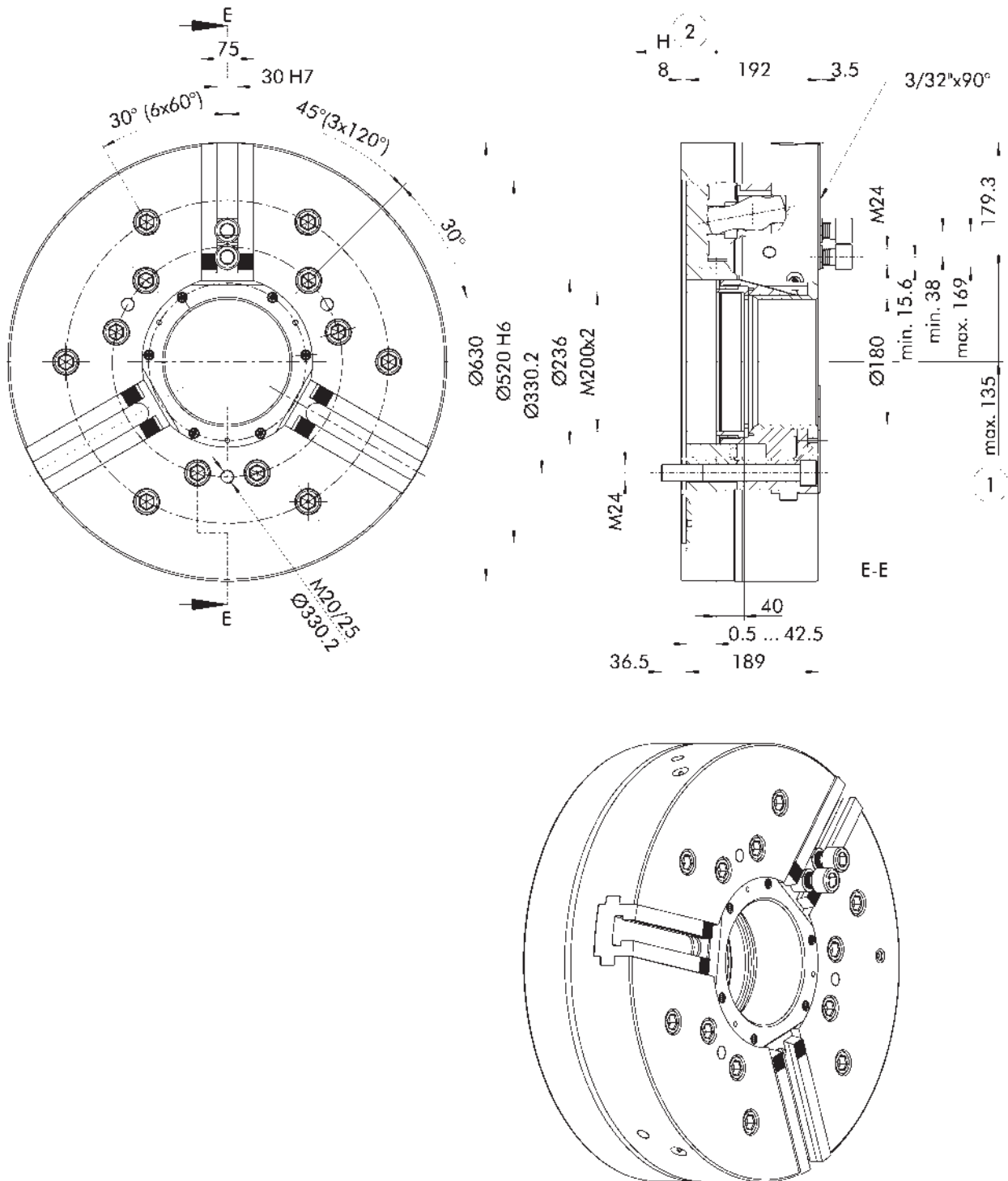
SWB-AL 400  
6.4 kg



Load of base jaw guidance



$M_{max} = 7133 \text{ Nm}$



① Distance to center of first tooth

② Piston stroke direction

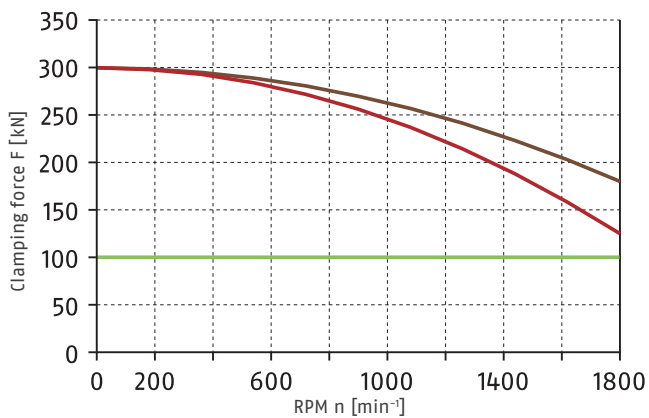
Technical data

Spindle type	Spindle size	ID	Serration	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm <sup>2</sup> ]	Weight [kg]
-	Z520	0854060	3/32" x 90°	1800	300	122	11.2	42	19.8	365.5

Scope of delivery

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

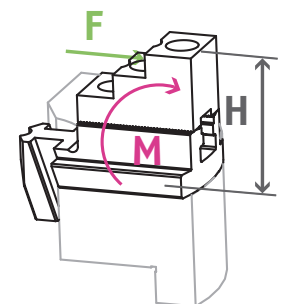
Clamping force-RPM-diagram



- Required minimum clamping force F<sub>spmin</sub> 33%
- SP-HB 630  
15.46 kg
- SP-WB 630  
32.35 kg



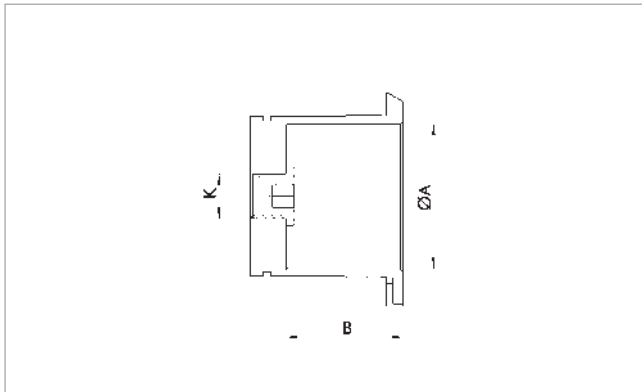
Load of base jaw guidance



M<sub>max</sub> = 11550 Nm

## Center sleeves

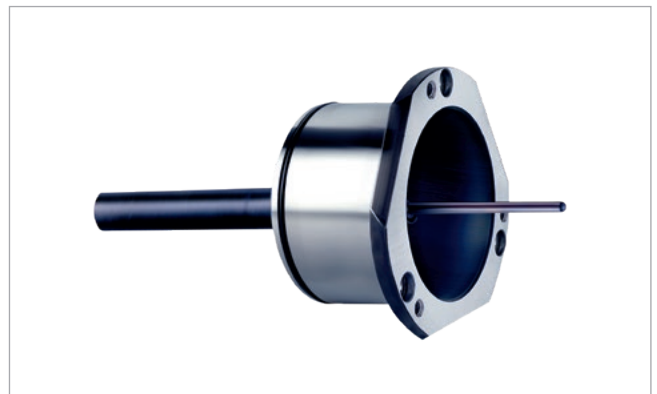
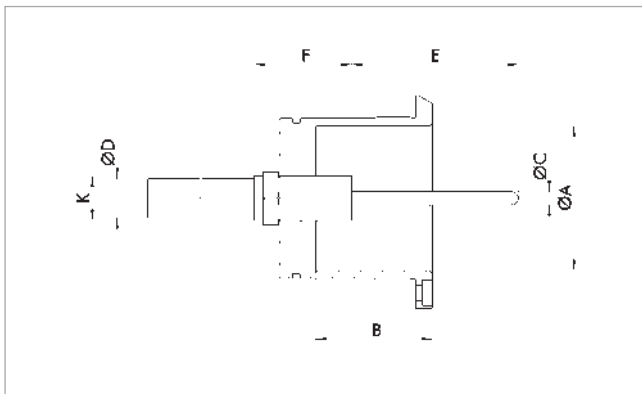
### Center sleeve closed



### Technical data

Description	ID	Suitable for	ØA [mm]	B [mm]	K	Weight [kg]
SBS-G-C 185	8703865	ROTA NCF plus 2 185-52	52	42	M16x1.5	0.6
SBS-G-C 215	8703755	ROTA NCF plus 2 215-66	66	37	M16x1.5	0.8
SBS-G-C2 260	8705191	ROTA NCF plus 2 260-86	86	38	M16x1.5	0.8
SBS-G-C2 315	8705198	ROTA NCF plus 2 315-104	104	44	M16x1.5	1.6
SBS-G-C 400	8704560	ROTA NCF 400-120	120	41	-	4
SBS-G-C 500	8704561	ROTA NCF 500-160	160	49	-	5.9
SBS-G-C 630	8704562	ROTA NCF 630-180	180	74	-	8.4

### Protection sleeve with ejector

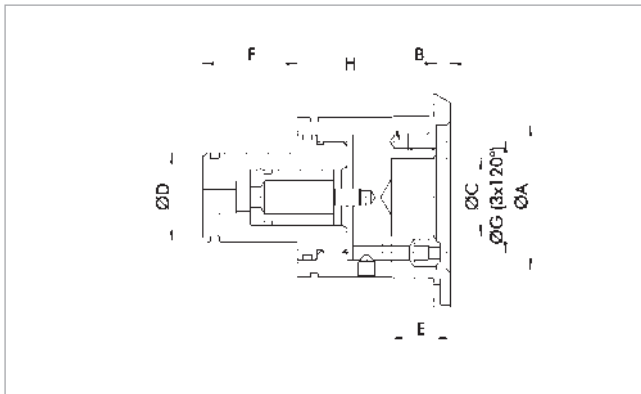


### Technical data

Description	Suitable for	ØA [mm]	B [mm]	ØC [mm]	ØD [mm]	E [mm]	F [mm]	K
SBS-A-C 185	ROTA NCF plus 2 185-52	52	42	4.8	14	10 - 100	35	M16x1.5
SBS-A-C 215	ROTA NCF plus 2 215-66	66	37	4.8	14	10 - 100	35	M16x1.5
SBS-A-C2 260	ROTA NCF plus 2 260-86	86	38	4.8	14	10 - 100	35	M16x1.5
SBS-A-C2 315	ROTA NCF plus 2 315-104	104	44	4.8	14	10 - 100	35	M16x1.5

- Center sleeves with ejector are available on request
- The ejector stroke is selectable in increments of 10 from 10 - 100 mm
- The ejection force is selectable with 40, 100, 150, 200, 250, or 300 N

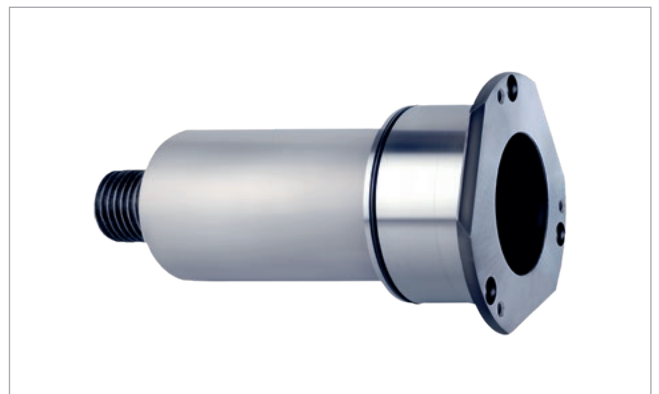
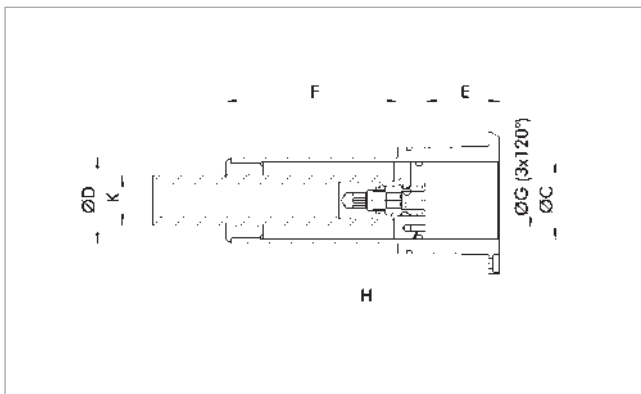
Protection sleeve with spray nozzles



Technical data

Description	ID	Suitable for	ØA [mm]	B [mm]	ØC [mm]	ØD [mm]	F [mm]	ØG [mm]	H	Weight [kg]
SBS-S-C 185	8703863	ROTA NCF plus 2 185-52	52	5	28	32	34	41	M6x10	1.2
SBS-S-C 215	8703753	ROTA NCF plus 2 215-66	66	5	32	32	47	49	M6x10	1.6
SBS-S-C2 260	8705189	ROTA NCF plus 2 260-86	86	5	48	32	47	67	M6x10	2.7
SBS-S-C2 315	8705196	ROTA NCF plus 2 315-104	104	5	48	32	47	76	M6x10	4.2

Center sleeve with adjustable stop



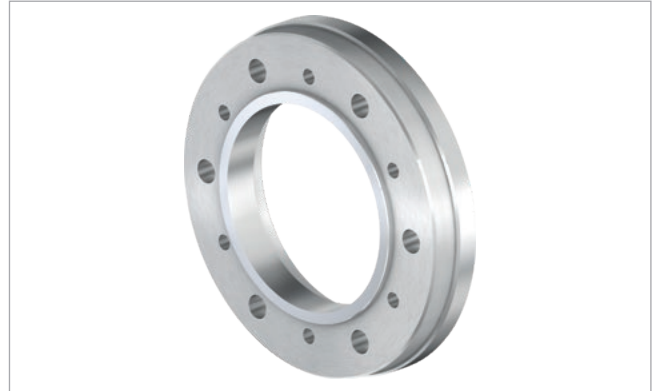
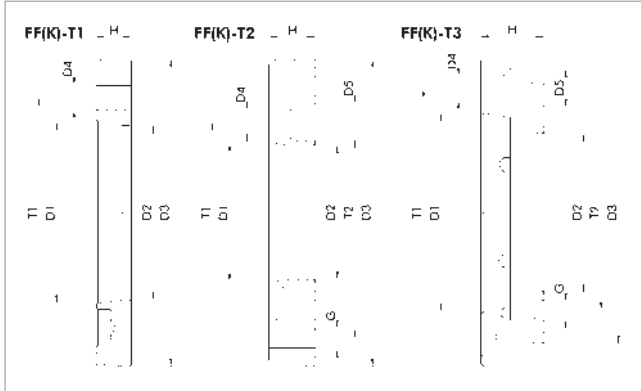
Technical data

Description	ID	Suitable for	ØC [mm]	ØD [mm]	E [mm]	F [mm]	ØG [mm]	H	K	Weight [kg]
SBS-T-C 185	8703859	ROTA NCF plus 2 185-52	42	46.5	0 - 110.8	92.8	30	M4x8	M27	1.5
SBS-T-C 215	8703749	ROTA NCF plus 2 215-66	51	55.5	0 - 110.8	97.8	35	M5x10	M27	2
SBS-T-C2 260	8705185	ROTA NCF plus 2 260-86	61	65.5	0 - 110.8	96.8	40	M5x10	M27	3.2
SBS-T-C2 315	8705192	ROTA NCF plus 2 315-104	75	80.5	0 - 110.8	104.8	50	M6x12	M27	4.9

- Important: Check the spindle/draw tube through-hole
- The spindle through-hole must be at least  $\text{Ø D} + 0.5 \text{ mm}$

## 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]	[mm]	[mm]
FF-T2 Z140-A4	FF-T2	0805000	ROTA NCF plus 2 185-52	Nr. 4	61	Z140	11 (6x60°)	17	M10 (6x60°)	21	82.6	104.8	
FF-T1 Z140-A5	FF-T1	0803000	ROTA NCF plus 2 185-52	Nr. 5	79.6	Z140	11 (6x60°)			16	104.8		
FF-T3 Z140-A6	FF-T3	0801000	ROTA NCF plus 2 185-52	Nr. 6	85	Z140	13 (6x60°)	20	M10 (6x60°)	34	133.4	104.8	
FF-T2 Z170-A5	FF-T2	0805001	ROTA NCF plus 2 215-66	Nr. 5	79.6	Z170	11 (6x60°)	18	M12 (12 x 30°)	25	104.8	133.4	
FF-T1 Z170-A6	FF-T1	0803001	ROTA NCF plus 2 215-66	Nr. 6	103.2	Z170	13 (6x60°)			17	133.4		
FF-T3 Z170-A8	FF-T3	0801001	ROTA NCF plus 2 215-66	Nr. 8	113	Z170	17 (6x60°)	26	M12 (6x60°) M12 (2x180°)	40	171.4	133.4	
FF-T2 Z220-A5	FF-T2	0805002	ROTA NCF plus 2 260-86 ROTA NCF plus 2 315-104	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 NCF plus 2 260-86 ROTA NCF plus 2 315-104	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 NCF plus 2 260-86 ROTA NCF plus 2 315-104	Nr. 8	136.2	Z220	17 (6x60°) 17 (2x180°)			19	171.4		
FF-T3 Z220-A11	FF-T3	0803003	ROTA NCF plus 2 260-86 ROTA NCF plus 2 315-104	Nr. 11	130	Z220	21 (6x60°)	32	M16 (12 x 30°)	50	235	171.4	
FF-T3 Z220-A15-1	FF-T3	0803020	ROTA NCF plus 2 260-86 ROTA NCF plus 2 315-104	Nr. 15	145	Z220	26 (6x60°)	38	M16 (6x60°)	55	330.2	171.4	
FF-T3 Z220-A15-2	FF-T3	0803021	ROTA NCF plus 2 260-86 ROTA NCF plus 2 315-104	Nr. 15	145	Z220	23 (6x60°)	35	M16 (6x60°)	55	330.2	171.4	
FF-T2 Z300-A6	FF-T2	0805004	ROTA NCF 400-120	Nr. 6	103.2	Z300	14 (6x60°)	20	M20 (6x60°) M20 (3x120°)	30	133.4	235	
FF-T2 Z300-A8	FF-T2	0805005	ROTA NCF 400-120	Nr. 8	136.2	Z300	17 (6x60°) 22 (6x60°)	26	M20 (6x60°) M20 (3x120°)	30	171.4	235	
FF-T1 Z300-A11	FF-T1	0803004	ROTA NCF 400-120	Nr. 11	192.9	Z300	22 (3x120°)			21	235		
FF-T3 Z300-A15-1	FF-T3	0803005	ROTA NCF 400-120	Nr. 15	190	Z300	26 (6x60°)	38	M20 (6x60°)	55	330.2	235	
FF-T3 Z300-A15-2	FF-T3	0803022	ROTA NCF 400-120	Nr. 15	190	Z300	23 (6x60°)	35	M20 (6x60°)	55	330.2	235	
FF-T2 Z380-A8	FF-T2	0805010	ROTA NCF 500-160	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 NCF 500-160	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 NCF 500-160	Nr. 15	281.5	Z380	26 (6x60°)			47	330.2		
FF-T2 Z520-A11	FF-T2	0801003	ROTA NCF 630-180	Nr. 11	192.9	Z520	21 (6x60°)	33	M24 (12 x 30°)	40	235	330.2	463.6
FF-T1 Z520-A15	FF-T1	0805007	ROTA NCF 630-180	Nr. 15	281.5	Z520	26 (6x60°)			28	330.2		
FF-T2 Z520-A20	FF-T2	0805008	ROTA NCF 630-180	Nr. 20	290	Z520	26 (6x60°)	40	M24 (12 x 30°)	62	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.

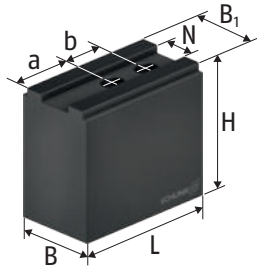
#### Expansion adapter plates FF-T3

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.

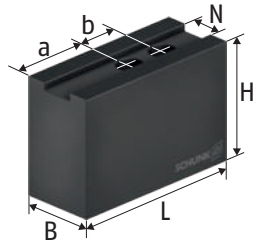


## Soft top jaws

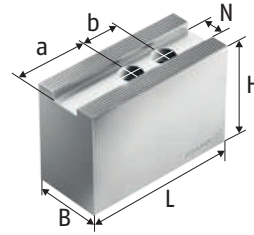
with fine serration 60°



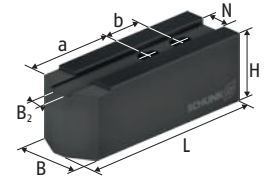
SKN  
Soft top jaws



KM-WB  
Soft top jaws



KM-WBAL  
Soft top jaws



KM-WBL  
Soft top jaws

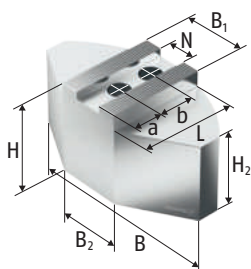
## Technical data

Chuck type	Description	ID	N [mm]	B [mm]	B1 [mm]	H [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA NCF plus 2 185-52	KM-WBL 60	0132600	12	32		32	82	47	20	M10	1.5
ROTA NCF plus 2 185-52	KM-WBL 62	0132606	12	35		60	82	47	20	M10	3.1
ROTA NCF plus 2 185-52	KM-WB 61	0130128	12	35		60	72	37	20	M10	2.9
ROTA NCF plus 2 185-52	KM-WB 66	0132138	12	32		32	72	37	20	M10	1.4
ROTA NCF plus 2 185-52	KM-WBAL 70	0132521	12	35		50	72	37	20	M10	0.9
ROTA NCF plus 2 215-66	KM-WBL 80	0132601	14	35		40	102	57	25	M12	2.7
ROTA NCF plus 2 215-66	KM-WBL 81	0132607	14	40		80	102	57	25	M12	6.0
ROTA NCF plus 2 215-66	KM-WBL 82	0132615	14	40		100	102	57	25	M12	7.6
ROTA NCF plus 2 215-66	KM-WB 84	0132126	14	35		60	95	46	25	M12	3.9
ROTA NCF plus 2 215-66	KM-WB 85	0132127	14	40		80	95	46	25	M12	6.1
ROTA NCF plus 2 215-66	KM-WB 88	0132139	14	35		40	95	46	25	M12	2.7
ROTA NCF plus 2 215-66	KM-WBAL 80	0132522	14	40		60	90	45	25	M12	1.5
ROTA NCF plus 2 260-86	KM-WBL 100	0132602	16	40		42	125	65	30	M12	4.1
ROTA NCF plus 2 260-86	KM-WBL 101	0132608	16	40		100	125	65	30	M12	9.8
ROTA NCF plus 2 260-86	KM-WBL 103	0132609	16	40		60	125	65	30	M12	5.7
ROTA NCF plus 2 260-86	KM-WB 102	0132104	16	40		60	90	45	30	M12	4.3
ROTA NCF plus 2 260-86	KM-WB 103	0132105	16	40		60	110	50	30	M12	5.2
ROTA NCF plus 2 260-86	KM-WB 104	0132106	16	50		80	90	45	30	M12	7.3
ROTA NCF plus 2 260-86	KM-WB 105	0132129	16	40		80	110	50	30	M12	7.2
ROTA NCF plus 2 260-86	KM-WB 106	0132152	16	40		100	120	60	30	M12	9.7
ROTA NCF plus 2 260-86	KM-WB 110	0132140	16	40		42	110	50	30	M12	3.8
ROTA NCF plus 2 260-86	KM-WB 111	0132147	16	50		50	120	60	30	M12	6.2
ROTA NCF plus 2 260-86	KM-WBAL 100	0132523	16	40		60	110	55	30	M12	1.9
ROTA NCF plus 2 315-104	KM-WBL 121	0132604	21	50		50	145	85	30	M16	6.9
ROTA NCF plus 2 315-104	KM-WBL 125	0132618	21	50		100	145	85	30	M16	13.9
ROTA NCF plus 2 315-104	H-WB 125	0130124	21	50		60	111	51	35	M16	6.2
ROTA NCF plus 2 315-104	KM-WB 126	0132131	21	50		60	129	60	30	M16	7.6
ROTA NCF plus 2 315-104	KM-WB 127	0132148	21	50		100	140	71	30	M16	13.8
ROTA NCF plus 2 315-104	KM-WB 128	0132154	21	50		80	129	60	30	M16	10.1
ROTA NCF plus 2 315-104	KM-WBAL 121	0132525	21	50		80	130	60	30	M16	3.8
ROTA NCF plus 2 315-104	SKN 350	0127107	21	50	49	80	120	67	28	M16	9.1
ROTA NCF 400-120	KM-WBL 150	0132605	22	60		60	185	112	43	M20	12.6
ROTA NCF 400-120	KM-WB 153	0132132	22	60		80	165	85	43	M20	15.5
ROTA NCF 400-120	KM-WB 155	0132156	22	60		120	165	85	43	M20	23.3
ROTA NCF 400-120	KM-WBAL 150	0132526	22	60		80	145	72	43	M20	4.8

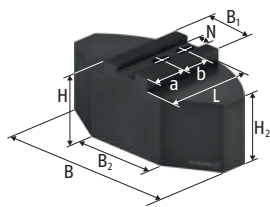
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## Hard stepped top jaws, Full grip jaws

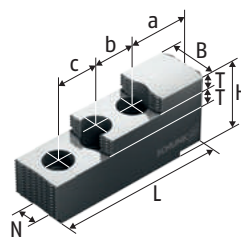
with fine serration 60°



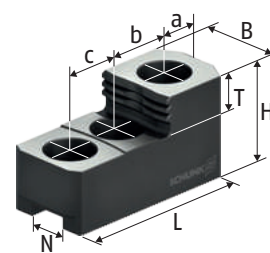
KMWB-SA  
Full grip jaws



KMWB-SM  
Full grip jaws



SHB-J  
Hard stepped top jaws



SHB-J  
Hard stepped top jaws

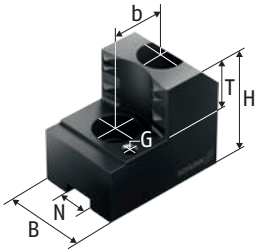
### Technical data

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 NCF plus 2 185-52	KMWB-SA 165	0132800	12	120	32	58	48	59.5		25	20		M10	2.2
ROTA NCF plus 2 185-52	KMWB-SM 165	0132700	12	120	32	50	40	60		24	20		M10	4.9
ROTA NCF plus 2 185-52	SHB-J 60	0133100	12	28		36		67	12	14	20	20	M10	0.8
ROTA NCF plus 2 215-66	KMWB-SA 210	0132801	14	140	35	58	48	72.5		35	25		M12	3.1
ROTA NCF plus 2 215-66	KMWB-SA 211	0132805	14	140	35	80	70	72.5		35	25		M12	4.5
ROTA NCF plus 2 215-66	KMWB-SM 210	0132701	14	140	35	60	50	70		30	25		M12	8.8
ROTA NCF plus 2 215-66	KMWB-SM 211	0132705	14	140	35	80	70	70		30	25		M12	12.3
ROTA NCF plus 2 215-66	SHB-J 80	0133109	14	35		51		87	12	15.5	25	25	M12	1.8
ROTA NCF plus 2 215-66	SHB-J 82	0133110	14	32		38		79	12	16	25	25	M12	1.2
ROTA NCF plus 2 260-86	KMWB-SA 250	0132802	16	180	40	58	43	87.5		40	30		M12	4.5
ROTA NCF plus 2 260-86	KMWB-SA 251	0132806	16	180	40	80	65	87.5		40	30		M12	6.6
ROTA NCF plus 2 260-86	KMWB-SM 250	0132702	16	180	40	60	45	80		29	30		M12	12.0
ROTA NCF plus 2 260-86	KMWB-SM 251	0132706	16	180	40	80	70	80		29	30		M12	18.0
ROTA NCF plus 2 260-86	SHB-J 100	0133111	16	40		54		101.5	13	25.5	30	30	M12	2.8
ROTA NCF plus 2 260-86	SHB-J 102	0131109	16	35		42		83	15	19	25	25	M12	1.5
ROTA NCF plus 2 315-104	KMWB-SA 301	0132804	21	240	50	78	63	117		45	30		M16	10.9
ROTA NCF plus 2 315-104	KMWB-SM 301	0132704	21	240	50	70	55	110		45	30		M16	26.4
ROTA NCF plus 2 315-104	SHB-J 126	0133105	21	50		62		128	14	46	30	30	M16	5.2
ROTA NCF plus 2 315-104	SHB-J 122	0133113	21	50		52		104	18	20	30	30	M16	3.3
ROTA NCF 400-120	SHB-J 150	0133114	22	60		86		143	20	27	43	43	M20	8.6

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## Claw jaws

with fine serration 60°



SZAJ  
Claw jaws

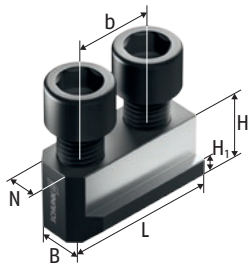
### Technical data

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 NCF plus 2 185-52	41 - 77	202	SZAJ 16-6	0176100	12	30	47	20	M6	20	M10	1.2
ROTA NCF plus 2 185-52	57 - 93	201	SZAJ 16-7	0176101	12	30	47	20	M6	20	M10	1.0
ROTA NCF plus 2 185-52	73 - 110	201	SZAJ 16-8	0176102	12	30	47	20	M6	20	M10	1.1
ROTA NCF plus 2 185-52	87 - 123	202	SZAJ 16-9	0176103	12	30	47	20	M6	20	M10	1.1
ROTA NCF plus 2 185-52	103 - 139	203	SZAJ 16-10	0176104	12	40	47	20	M6	20	M10	1.2
ROTA NCF plus 2 215-66	46 - 81	230	SZAJ 20-1	0138110	14	35	53	25	M6	25	M12	1.9
ROTA NCF plus 2 215-66	74 - 109	231	SZAJ 20-2	0138112	14	35	53	25	M6	25	M12	1.6
ROTA NCF plus 2 215-66	104 - 139	231	SZAJ 20-3	0138114	14	40	53	25	M6	25	M12	1.7
ROTA NCF plus 2 215-66	134 - 169	233	SZAJ 20-4	0138116	14	40	53	25	M6	25	M12	1.6
ROTA NCF plus 2 215-66	156 - 191	250	SZAJ 20-16	0138143	14	40	53	25	M6	25	M12	1.9
ROTA NCF plus 2 260-86	50 - 102	281	SZAJ 25-1	0138117	16	40	58	25	M6	30	M12	2.9
ROTA NCF plus 2 260-86	92 - 144	283	SZAJ 25-2	0138119	16	40	58	25	M6	30	M12	2.3
ROTA NCF plus 2 260-86	136 - 189	287	SZAJ 25-3	0138121	16	40	58	25	M6	30	M12	2.1
ROTA NCF plus 2 260-86	181 - 234	301	SZAJ 25-4	0138123	16	40	58	25	M6	30	M12	2.3
ROTA NCF plus 2 260-86	216 - 269	333	SZAJ 25-15	0138118	16	40	58	25	M6	30	M12	2.8
ROTA NCF plus 2 315-104			SZAJ 30-5	0138131	21	50	65	25	M8	30	M16	3.8
ROTA NCF plus 2 315-104	118 - 194	364	SZAJ 30-6	0138132	21	50	65	25	M8	30	M16	4.1
ROTA NCF plus 2 315-104	185 - 261	353	SZAJ 30-7	0138133	21	50	65	25	M8	30	M16	3.4
ROTA NCF plus 2 315-104	249 - 326	397	SZAJ 30-8	0138134	21	50	65	25	M8	30	M16	4.8
ROTA NCF 400-120	46 - 141	424	SZAJ 38-1	0138135	22	60	85	33	M8	43	M20	10.6
ROTA NCF 400-120	102 - 198	429	SZAJ 38-2	0138136	22	60	85	33	M8	43	M20	9.2
ROTA NCF 400-120	161 - 258	429	SZAJ 38-3	0138137	22	60	85	33	M8	43	M20	7.5
ROTA NCF 400-120	222 - 320	450	SZAJ 38-4	0138138	22	60	85	33	M8	43	M20	7.5
ROTA NCF 400-120	282 - 380	467	SZAJ 38-5	0138139	22	60	85	33	M8	43	M20	8.2
ROTA NCF 400-120	342 - 400	478	SZAJ 38-6	0138140	22	60	85	33	M8	43	M20	9.5

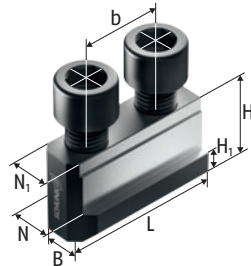
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## T-nut

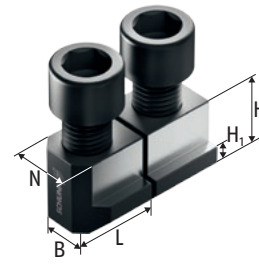
with fine serration 60°



NJ  
T-nut



NJ  
T-nut



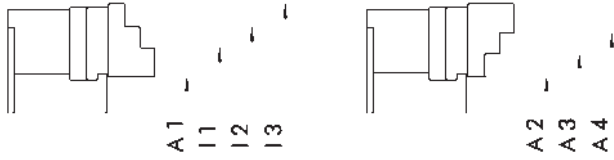
NJ sawn  
T-nut

Chuck type	Description	ID	H	H1	b	G	Cyl.-screw	Max. adm. tightening torque
			[mm]	[mm]	[mm]			[Nm]
ROTA NCF plus 2 185-52	NJ 62	0146133	18.5	7.5	20	M10	M10 x 25	50
ROTA NCF plus 2 215-66	NJ 82 gesägt/sawn	0146005	20.5	8.5		M12	M12 x 30	70
ROTA NCF plus 2 215-66	NJ 82	0146131	20.5	8.5	25	M12	M12 x 30	70
ROTA NCF plus 2 260-86	NJ 103 gesägt/sawn	0146002	21.5	8.5		M12	M12 x 30	70
ROTA NCF plus 2 260-86	NJ 103	0146132	21.5	8.5	30	M12	M12 x 30	70
ROTA NCF plus 2 315-104	NJ 124 gesägt/sawn	0146000	28	11.5		M16	M16 x 40	150
ROTA NCF plus 2 315-104	NJ 124	0146123	28	11.5	30	M16	M16 x 40	150
ROTA NCF 400-120	NJ 152	0146125	45.5	16.5	43	M20	M20 x 60	300

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## Hard stepped top jaws

with fine serration 60°



Jaw position I

Jaw position II

### O.D. clamping

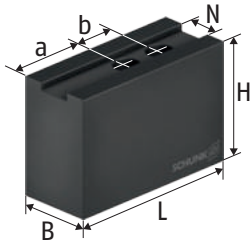
Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]
ROTA NCF plus 2 185-52	SHB-J 60	0133100	27 - 107	28 - 110	107 - 185	
ROTA NCF plus 2 215-66	SHB-J 80	0133109	33 - 105	22 - 90	84 - 140	134 - 215
ROTA NCF plus 2 260-86	SHB-J 100	0133111	21 - 134	39 - 130	125 - 164	159 - 247
ROTA NCF plus 2 315-104	SHB-J 126	0133105	16 - 149	51 - 148	143 - 240	235 - 315
ROTA NCF 400-120	SHB-J 150	0133114	55 - 234	35 - 166	159 - 233	226 - 400

### I.D. clamping

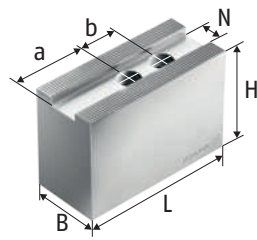
Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA NCF plus 2 185-52	SHB-J 60	0133100	85 - 165	160 - 225	
ROTA NCF plus 2 215-66	SHB-J 80	0133109	97 - 152	147 - 213	208 - 265
ROTA NCF plus 2 260-86	SHB-J 100	0133111	107 - 146	141 - 230	225 - 330
ROTA NCF plus 2 315-104	SHB-J 126	0133105	88 - 185	180 - 276	271 - 380
ROTA NCF 400-120	SHB-J 150	0133114	146 - 219	212 - 401	

## Soft top jaws

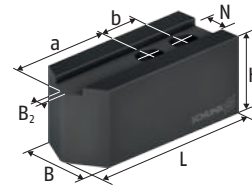
with fine serration 90°



SWB  
Soft top jaws



SWB-AL  
Soft top jaws



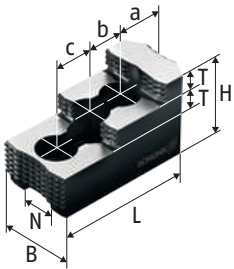
SWBL  
Soft top jaws

### Technical data

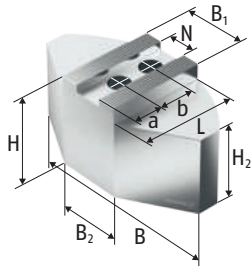
Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA NCF plus 2 185-52	SWBL 165	0120152	14	35	40	80	45	20	M10	2.1
ROTA NCF plus 2 185-52	SWB 165	0120101	14	35	60	68	33	20	M10	2.5
ROTA NCF plus 2 185-52	SWB-FF 160	0120302	14	35	40	72	36	21	M12	1.8
ROTA NCF plus 2 185-52	SWB-AL 165	0168105	14	35	60	80	45	20	M10	1.2
ROTA NCF plus 2 215-66	SWBL 200	0120153	17	35	40	98	61	22	M12	2.6
ROTA NCF plus 2 215-66	CWB 200	0100006	17	40	40	90	43	22	M12	2.7
ROTA NCF plus 2 215-66	SWB 200	0120104	17	40	60	90	43	22	M12	4.1
ROTA NCF plus 2 215-66	SWB-AL 200	0168101	17	40	60	90	43	22	M12	1.5
ROTA NCF plus 2 260-86	SWBL 250-21	0120155	21	50	50	120	72	28	M16	5.4
ROTA NCF plus 2 260-86	CWB 251	0100012	21	50	60	95	52	28	M16	5.2
ROTA NCF plus 2 260-86	SWB 250	0120105	21	50	80	120	62	28	M16	9.2
ROTA NCF plus 2 260-86	SWB-AL 250	0168102	21	50	80	120	62	28	M16	3.3
ROTA NCF plus 2 315-104	SWBL 250-21	0120155	21	50	50	120	72	28	M16	5.4
ROTA NCF plus 2 315-104	CWB 251	0100012	21	50	60	95	52	28	M16	5.2
ROTA NCF plus 2 315-104	SWB 250	0120105	21	50	80	120	62	28	M16	9.2
ROTA NCF plus 2 315-104	SWB-AL 250	0168102	21	50	80	120	62	28	M16	3.3
ROTA NCF 400-120	SWB-AL 400	0168103	25.5	60	100	155	90	35	M20	6.4
ROTA NCF 400-120	SWB 400	0120107	25.5	60	90	155	90	35	M20	16.0
ROTA NCF 400-120	CWB 400	0100008	25.5	60	80	140	75	35	M20	12.6
ROTA NCF 500-160	SWB-AL 400	0168103	25.5	60	100	155	90	35	M20	6.4
ROTA NCF 500-160	SWB 400	0120107	25.5	60	90	155	90	35	M20	16.0
ROTA NCF 500-160	SP-WB 400	0124105	25.5	60	100	155	80	40	M18	18.6
ROTA NCF 500-160	SP-WB 500	0124106	25.5	60	100	195	118	40	M18	24.0
ROTA NCF 500-160	CWB 400	0100008	25.5	60	80	140	75	35	M20	12.6
ROTA NCF 630-180	SWB-AL 400	0168103	25.5	60	100	155	90	35	M20	6.4
ROTA NCF 630-180	SWB 400	0120107	25.5	60	90	155	90	35	M20	16.0
ROTA NCF 630-180	SP-WB 630	0124107	30	75	90	240	133	65	M24	32.4
ROTA NCF 630-180	SP-WB 800	0124108	30	75	90	300	167	65	M24	41.0
ROTA NCF 630-180	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](http://schunk.com)

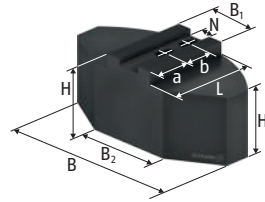
## Hard stepped top jaws, Full grip jaws with fine serration 90°



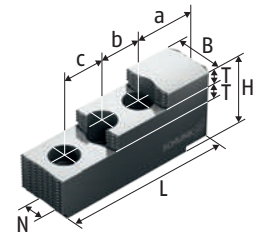
SHB  
Hard stepped top jaws



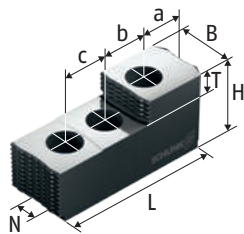
SWB-SA  
Full grip jaws



SWB-SM  
Full grip jaws



SP-HB  
Hard stepped top jaws



SP-HB  
Hard stepped top jaws

### Technical data

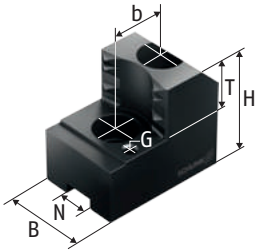
Chuck type	Description	ID	N [mm]	B [mm]	B1 [mm]	H [mm]	H2 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	c [mm]	Screws	m/SET [kg]
ROTA NCF plus 2 185-52	SWB-SA 165	0170099	14	120	40	58	48	59.5		25	20		M10	2.2
ROTA NCF plus 2 185-52	SWB-SM 165	0169099	14	120	40	60	50	59.5		24.5	20		M10	6.0
ROTA NCF plus 2 185-52	SHB 165	0121101	14	30		46		79.7	11	16.6	22	22	M10	1.3
ROTA NCF plus 2 215-66	SWB-SA 200	0170101	17	140	40	58	48	72.5		35	22		M12	3.1
ROTA NCF plus 2 215-66	SWB-SA 201	0170106	17	140	40	75	65	72.5		35	22		M12	4.2
ROTA NCF plus 2 215-66	SWB-SM 200	0169101	17	140	40	60	50	69.5		35	22		M12	8.6
ROTA NCF plus 2 215-66	SWB-SM 201	0169106	17	140	40	75	65	69.5		35	22		M12	11.5
ROTA NCF plus 2 215-66	SHB 200	0121104	17	40		49		72.5	12	18	19	19	M12	1.6
ROTA NCF plus 2 215-66	SHB 210	0121102	17	40		49		84.3	12	28.7	19	19	M12	2.0
ROTA NCF plus 2 260-86	SWB-SA 250-21	0170103	21	180	50	78	63	87.5		40	28		M16	6.3
ROTA NCF plus 2 260-86	SWB-SA 251	0170107	21	180	50	100	85	87.5		40	28		M16	8.3
ROTA NCF plus 2 260-86	SWB-SM 250-21	0169103	21	180	50	70	55	80		29	28		M16	14.5
ROTA NCF plus 2 260-86	SWB-SM 251	0169107	21	180	50	100	85	80		30	28		M16	22.0
ROTA NCF plus 2 260-86	SHB 250	0121105	21	50		58		103.5	14	34	25	25	M16	3.5
ROTA NCF plus 2 315-104	SWB-SA 315	0170104	21	240	50	78	63	117		70	28		M16	11.0
ROTA NCF plus 2 315-104	SWB-SM 315	0169104	21	240	50	70	55	110		60	28		M16	26.6
ROTA NCF plus 2 315-104	SHB 250	0121105	21	50		58		103.5	14	34	25	25	M16	3.5
ROTA NCF plus 2 315-104	SHB 315	0121111	21	50		58		128	14	46	30	30	M16	4.6
ROTA NCF 400-120	SWB-SA 400	0170105	25.5	330	150	98	68	160		84.5	35		M20	24.4
ROTA NCF 400-120	SWB-SM 400	0169105	25.5	330	60	85	55	155		83.5	35		M20	53.8
ROTA NCF 400-120	SHB 400	0121107	25.5	60		75		140	18	53	31	31	M20	7.8
ROTA NCF 500-160	SWB-SA 400	0170105	25.5	330	150	98	68	160		84.5	35		M20	24.4
ROTA NCF 500-160	SWB-SM 400	0169105	25.5	330	60	85	55	155		83.5	35		M20	53.8
ROTA NCF 500-160	SHB 400	0121107	25.5	60		75		140	18	53	31	31	M20	7.8
ROTA NCF 500-160	SP-HB 400-500	0125105	25.5	57.5		73		160	22	43.1	42	42	M18	9.8
ROTA NCF 630-180	SWB-SA 400	0170105	25.5	330	150	98	68	160		84.5	35		M20	24.4
ROTA NCF 630-180	SWB-SM 400	0169105	25.5	330	60	85	55	155		83.5	35		M20	53.8
ROTA NCF 630-180	SP-HB 630	0125106	30	75		88		174.5	30	44.5	50	50	M24	15.5

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 NCF 630-180	SP-HB 800	0125108	30	75		105		250	22	91.8	60	60	M24	29.1

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

## Claw jaws

with fine serration 90°



SZA  
Claw jaws

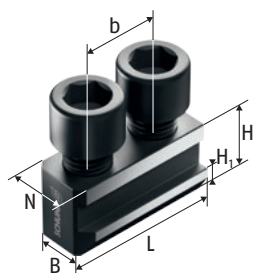
### Technical data

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 NCF plus 2 185-52	40 - 76	200	SZA 17-1	0122260	14	30	47	20	M6	20	M10	1.2
ROTA NCF plus 2 185-52	62 - 99	200	SZA 17-2	0122261	14	30	47	20	M6	20	M10	1.0
ROTA NCF plus 2 185-52	89 - 126	202	SZA 17-3	0122262	14	30	47	20	M6	20	M10	1.0
ROTA NCF plus 2 185-52	115 - 152	210	SZA 17-4	0122263	14	35	47	20	M6	20	M10	1.2
ROTA NCF plus 2 215-66	40 - 79	233	SZA 20-14	0138195	17	35	50	25	M6	22	M12	1.8
ROTA NCF plus 2 215-66	67 - 107	233	SZA 20-15	0138196	17	35	50	25	M6	22	M12	1.5
ROTA NCF plus 2 215-66	97 - 137	234	SZA 20-16	0138197	17	40	50	25	M6	22	M12	1.5
ROTA NCF plus 2 215-66	124 - 164	235	SZA 20-17	0138198	17	40	50	25	M6	22	M12	1.6
ROTA NCF plus 2 215-66	154 - 194	258	SZA 20-18	0138199	17	40	50	25	M6	22	M12	1.8
ROTA NCF plus 2 260-86	61 - 105	278	SZA 25-37	0138180	21	50	58	25	M8	28	M16	3.3
ROTA NCF plus 2 260-86	101 - 145	278	SZA 25-38	0138181	21	50	58	25	M8	28	M16	2.9
ROTA NCF plus 2 260-86	150 - 195	281	SZA 25-39	0138182	21	50	58	25	M8	28	M16	2.7
ROTA NCF plus 2 260-86	197 - 242	317	SZA 25-40	0138183	21	50	58	25	M8	28	M16	3.2
ROTA NCF plus 2 315-104	59 - 136	341	SZA 31-10	0138184	21	50	58	25	M8	28	M16	3.4
ROTA NCF plus 2 315-104	117 - 194	343	SZA 31-11	0138185	21	50	58	25	M8	28	M16	3.4
ROTA NCF plus 2 315-104	183 - 260	341	SZA 31-12	0138186	21	50	58	25	M8	28	M16	3.2
ROTA NCF plus 2 315-104	246 - 324	401	SZA 31-13	0138187	21	50	58	25	M8	28	M16	4.7
ROTA NCF 400-120	70 - 169	433	SZA 40-11	0138300	25.5	60	78	33	M8	35	M20	8.0
ROTA NCF 400-120	144 - 244	469	SZA 40-13	0138302	25.5	60	78	33	M8	35	M20	8.0
ROTA NCF 400-120	227 - 320	449	SZA 40-14	0138303	25.5	60	78	33	M8	35	M20	8.0
ROTA NCF 400-120	298 - 392	487	SZA 40-15	0138304	25.5	60	78	33	M8	35	M20	9.3
ROTA NCF 500-160	104 - 238	588	SZA 40-12	0138301	25.5	60	78	33	M8	35	M20	11.5
ROTA NCF 500-160	202 - 338	564	SZA 40-13	0138302	25.5	60	78	33	M8	35	M20	8.0
ROTA NCF 500-160	287 - 423	544	SZA 40-14	0138303	25.5	60	78	33	M8	35	M20	8.0
ROTA NCF 500-160	357 - 492	587	SZA 40-15	0138304	25.5	60	78	33	M8	35	M20	9.3
ROTA NCF 500-160	437 - 524	624	SZA 40-16	0138305	25.5	60	78	33	M8	35	M20	11.0
ROTA NCF 630-180	134 - 360	705	SZA 40-12	0138301	25.5	60	78	33	M8	35	M20	11.5
ROTA NCF 630-180	233 - 460	686	SZA 40-13	0138302	25.5	60	78	33	M8	35	M20	8.0
ROTA NCF 630-180	317 - 544	666	SZA 40-14	0138303	25.5	60	78	33	M8	35	M20	8.0
ROTA NCF 630-180	388 - 615	710	SZA 40-15	0138304	25.5	60	78	33	M8	35	M20	9.3
ROTA NCF 630-180	467 - 655	755	SZA 40-16	0138305	25.5	60	78	33	M8	35	M20	11.0

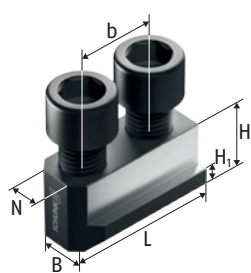
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](http://schunk.com)

## T-nut

with fine serration 90°



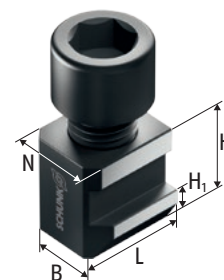
NKA  
T-nut



NK  
T-nut



NS  
T-nut



NKS  
T-nut



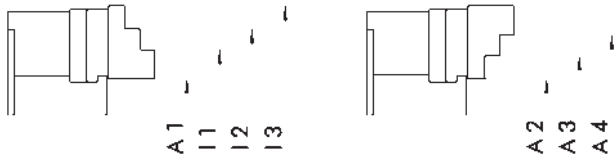
NS  
T-nut

Chuck type	Description	ID	H	H1	b	G	Cyl.-screw	Max. adm. tightening torque
			[mm]	[mm]	[mm]			[Nm]
ROTA NCF plus 2 185-52	NKA 1	0145103	18.5	6.5	20	M10	M10 x 25	50
ROTA NCF plus 2 185-52	NKS 1	0143104	18.5	6.5		M10	M10 x 25	50
ROTA NCF plus 2 215-66	NKA 2	0145104	20.5	7.5	22	M12	M12 x 25	70
ROTA NCF plus 2 215-66	NKS 2	0143106	20.5	7.5		M12	M12 x 25	70
ROTA NCF plus 2 260-86	NKA 3	0145105	26.5	10	28	M16	M16 x 35	150
ROTA NCF plus 2 260-86	NKS 3	0143107	26.5	10		M16	M16 x 35	150
ROTA NCF plus 2 315-104	NKA 3	0145105	26.5	10	28	M16	M16 x 35	150
ROTA NCF plus 2 315-104	NKS 3	0143107	26.5	10		M16	M16 x 35	150
ROTA NCF 400-120	NK 200	0145102	29	11	35	M20	M20 x 40	220
ROTA NCF 400-120	NS 200	0140103	29	11		M20	M20 x 40	220
ROTA NCF 500-160	NK 200	0145102	29	11	35	M20	M20 x 40	220
ROTA NCF 500-160	NS 200	0140103	29	11		M20	M20 x 40	220
ROTA NCF 630-180	NS 240-2	0140124	41	15		M24	M24 x 60	450
ROTA NCF 630-180	NS 242	0140121	41	15		M20	M20 x 50	220

Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](http://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 NCF plus 2 185-52	SHB 165	0121101	17 - 80	20 - 75	70 - 119	114 - 175
ROTA NCF plus 2 215-66	SHB 210	0121102	19 - 109	45 - 100	95 - 146	141 - 204
ROTA NCF plus 2 260-86	SHB 250	0121105	23 - 128	48 - 135	130 - 208	203 - 260
ROTA NCF plus 2 315-104	SHB 250	0121105	44 - 183	69 - 156	151 - 229	224 - 315
ROTA NCF 400-120	SHB 400	0121107	30 - 214	83 - 192	185 - 294	287 - 400
ROTA NCF 500-160	SHB 400	0121107	88 - 313	141 - 250	243 - 352	345 - 500
ROTA NCF 630-180	SP-HB 630	0125106	94 - 422	116 - 330	319 - 630	

### I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA NCF plus 2 185-52	SHB 165	0121101	83 - 132	127 - 182	177 - 225
ROTA NCF plus 2 215-66	SHB 210	0121102	94 - 145	140 - 194	188 - 265
ROTA NCF plus 2 260-86	SHB 250	0121105	76 - 153	148 - 233	228 - 330
ROTA NCF plus 2 315-104	SHB 250	0121105	97 - 175	170 - 255	250 - 380
ROTA NCF 400-120	SHB 400	0121107	105 - 214	207 - 315	308 - 480
ROTA NCF 500-160	SHB 400	0121107	163 - 271	264 - 373	366 - 590
ROTA NCF 630-180	SP-HB 630	0125106	237 - 446	435 - 730	

## 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 NCF plus 2 185-52		
ROTA NCF plus 2 215-66		
ROTA NCF plus 2 260-86		
ROTA NCF plus 2 315-104		
ROTA NCF 400-120		
ROTA NCF 500-160		
ROTA NCF 630-180	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 NCF 400-120		
ROTA NCF 500-160		
ROTA NCF 630-180	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	Weight [kg]	Description	ID
Cartridge	0.5	LINOMAX plus cartridge	1342585
Can	1	LINOMAX plus can	1342586
Bucket	21.5	LINOMAX plus bucket	1342587

### Mounting wrench

For power lathe chucks with a turnable threaded ring in pipe design with two actuation tabs.



Suitable for	Description	ID
ROTA NCF plus 2 260-86	SSH-MR Ø86-150	8703837
ROTA NCF plus 2 315-104	SSH-MR Ø104-150-3	8703808

### 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 NCF 400-120	SSH-MN Ø120-228	8700302
ROTA NCF 500-160	SSH-MN Ø160-228	8700320
ROTA NCF 630-180	SSH-MS Ø180-200	8700956

### 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	Weight [kg]	Description	ID
Cartridge	1.46	Grease gun	9900543



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