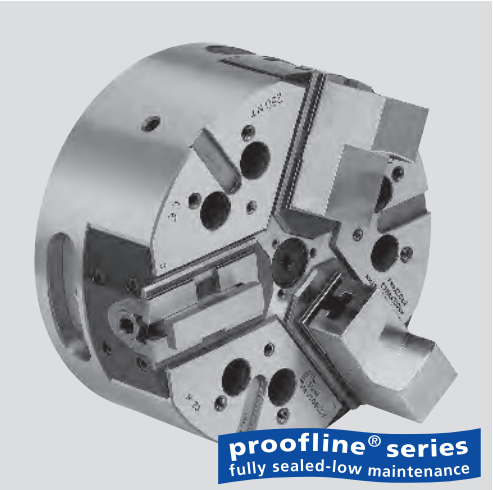
NT-RC
QUICK JAW CHANGE
Tongue & groove

NT-RD
QUICK JAW CHANGE
serrated master jaws

Quick jaw change high precision power chucks Ø 170 - 400 mm
- centrifugal force compensation
- proofline® chucks = fully sealed – low maintenance
- 3 jaws, closed center



Application/customer benefits
- For mid to large batches flexible production/high speed machining and for fragile parts
- Quick jaw change = short set up time
- Fully sealed, ideal for dry machining of castings and forgings or if high pressure coolant is used
- Ideal for vertical, pick up and horizontal machines

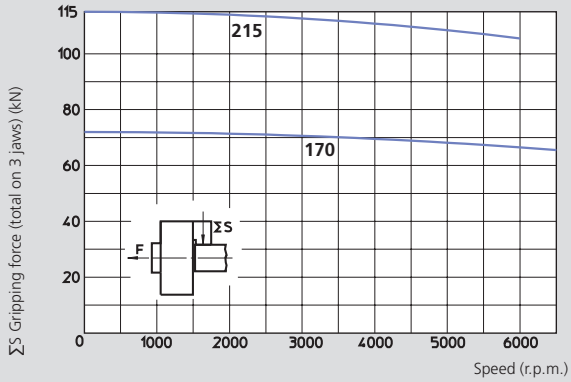
NT-RC: quick jaw change with tongue & groove master jaws
NT-RD: quick jaw change with serrated master jaws (2.5 mm x 60°) (radially adjustable)

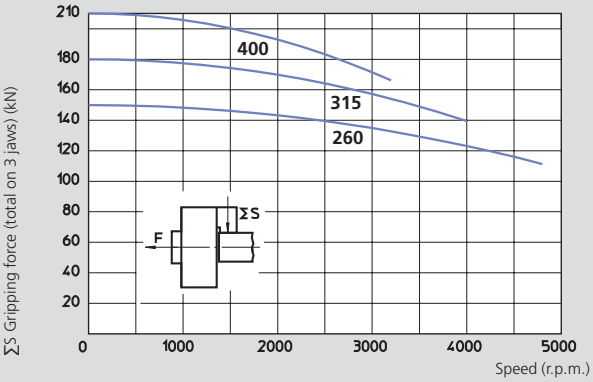
Technical features
- High accuracy patented quick jaw change
- Centrifugal force compensation
- Constant gripping force with permanent grease lubrication
- Central bore for coolant and/or air
- Chuck body and internal parts case hardened
- **proofline® chucks** = fully sealed – low maintenance

Standard equipment
3 jaw chuck
1 set soft top jaws
1 quick jaw change T wrench
mounting bolts

Ordering example
3 jaw chuck NT-RC 215/A6
or
3 jaw chuck NT-RD 260/FL220

Actual gripping force diagrams





The data in the diagrams refer to 3-jaw-chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K67 grease.The static and dynamic gripping forces have been measured using standard soft top jaws, placed in a position not exceeding the outer diameter of the chuck.

⚠ **Safety advice/danger of damage:**
When using taller/heavier jaws and/or clamping on a bigger diameter reduce draw pull/rotating speed accordingly.

Technical data

SMW-AUTOBLOK Type		NT-RD 170 NT-RC 170	NT-RD 215 NT-RC 215	NT-RD 260 NT-RC 260	NT-RD 315 NT-RC 315	NT-RD 400 NT-RC 400
Number of jaws		**3**	**3**	**3**	**3**	**3**
Radial jaw stroke	mm	3.6	4.6	5	6.3	7
Axial piston stroke	mm	17	22	24	30	33
Max. draw-pull	kN	30	42	55	65	75
Max. gripping force	kN	72	112	150	180	210
Max. speed	r.p.m.	6500	6000	4800	4000	3200
Weight (without top jaws)	kg	13	25	40	68	112
Moment of inertia	kg·m²	0.048	0.146	0.34	0.84	2.15
Recommended actuating cylinders		**SIN-S 100**	**SIN-S 100/125**	**SIN-S 125/150**	**SIN-S 125/150**	**SIN-S 150/175**

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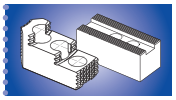
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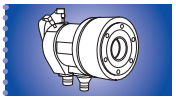
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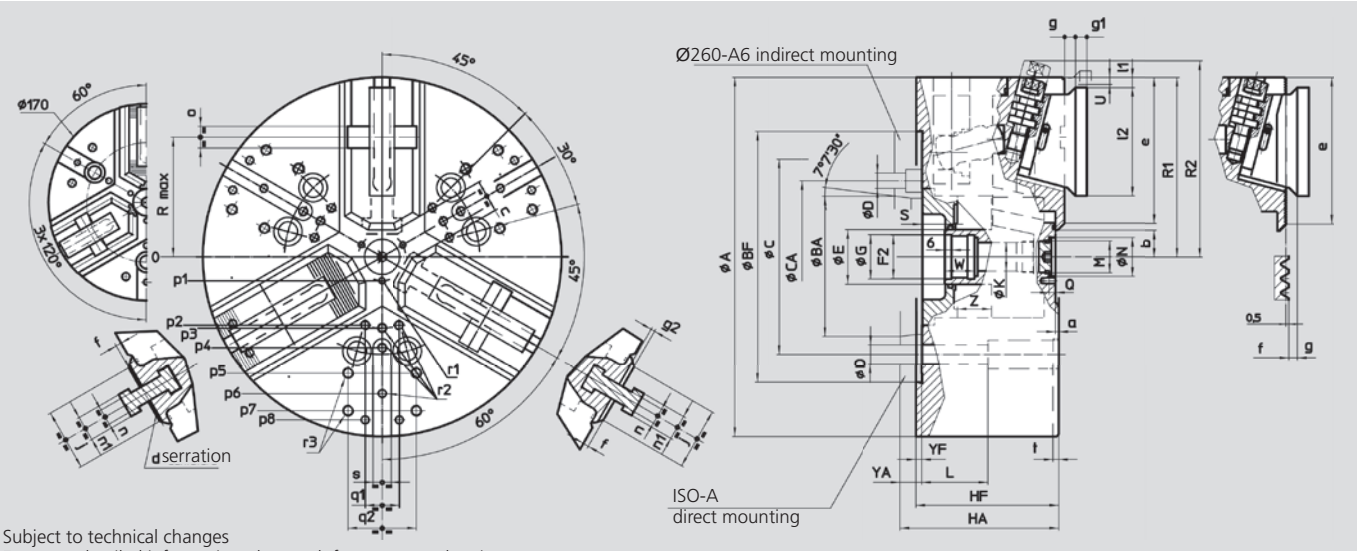

Subject to technical changes
For more detailed information please ask for customer drawing

SMW-AUTOBLOK Type				NT-RD 170 NT-RC 170		NT-RD 215 NT-RC 215		NT-RD 260 NT-RC 260			NT-RD 315 NT-RC 315		NT-RD 400 NT-RC 400	
Mounting				Z140	A5	Z170	A6	Z220	A6	A8	Z220	A8	Z300	A11
	A		mm	172		216		262			315		390	
	BF/BA	H6	mm	140	82.563	170	106.375	220	106.375	139.719	220	139.719	300	196.869
	C		mm	104.8		133.4		171.4	-	171.4	171.4		235	
	CA		mm	-	-	-	-	-	133.4	-	-	-	-	-
	D		mm	11.5		13.5		17	13.5	17	17		21	
	E		mm	32		42		48			48		75	
	F2		mm	M24 x 2		M32 x 1.5		M38 x 1.5			M38 x 1.5		M60 x 1.5	
	G	H8	mm	25		33		39			39		61	
	HF/HA		mm	92	102	104	116	118	137	132	125	139	149	164
	K		mm	18.5		20		25			25		48	
	L		mm	43		52		58			58		74	
	M		mm	M22 x 1.5		M22 x 1.5		M28 x 1.5			M28 x 1.5		M52 x 1.5	
	N	H9	mm	24		24		34			34		60	
	Q		mm	5.5		5.5		5.5			5.5		9	
max.	R		mm	56		72		88			105		133.5	
Chuck open	R1		mm	86.5		108		131			157.5		195	
	R2 *		mm	99		122.5		145.5			172		217.5	
max./min.	S		mm	20/3		19/-3		22/-2			20/-10		33/0	
Chuck fully closed	T		mm	175		220		-			-		-	
Radial jaw stroke	U		mm	3.6		4.6		5			6.3		7	
	W		mm	22		26		26			26		38	
	YF/YA		mm	5	15	5	17	5	24	19	5	19	6	21
max./min.	Z		mm	17/0		22/0		24/0			30/0		33/0	
	a		mm	3		3		3			3		3	
min.	b		mm	8.5		12		14			16.5		31	
min.	c		mm	9		13		14			16		38	
	d		mm	2.5 x 60°		2.5 x 60°		2.5 x 60°			2.5 x 60°		2.5 x 60°	
	e		mm	68		85		106			128.5		150	
	f		mm	5		5		5			5		7	
	g		mm	7.5		7.5		8.5			9.5		11.5	
	g1		mm	8		8		9			10		12	
	g2		mm	3.5		3.5		3.5			3.5		5.5	
	j		mm	30		38		44			54		63	
	l1		mm	2.5		2.5		9			9		8.5	
	l2		mm	52		66		78			95		118	
	n	h8	mm	10		10		12			14		18	
	n1		mm	16		16		19			22		28	
	o	H7	mm	12.68		12.68		19.03			19.03		19.03	
	p1		mm	16		16		21			21		37.5	
	p2		mm	-		-		-			60		80	
	p3		mm	38		49		55			62.5		83	
	p4		mm	-		80		70			80		110	
	p5		mm	65		80		102			102		140	
	p6		mm	70		-		102			120		155	
	p7		mm	-		-		-			135		170	
	p8		mm	-		-		-			-		170	
	q1		mm	-		-		-			30		36	
	q2		mm	36		45		60			60		80	
	r1		mm	M5/7		M5/8		M6/10			M6/10		M6/12	
	r2		mm	M6/14		M8/17		M8/17			M8/17		M10/19	
	r3		mm	M8/17		M8/17		M10/19			M10/19		M12/22	
	s		mm	16		16		16			16		20	
	t		mm	5		5		5			5		5	

*quick jaw change position