

**NT-D**

INCH serration

**NT-M**

METRIC serration

**High precision power chucks Ø 170 - 400 mm**

- centrifugal force compensation
- closed center
- 3 jaws
- **proofline®** chucks = fully sealed – low maintenance



**Application/customer benefits**

- For mid to large batch production/high speed machining and for fragile parts
- Fully sealed, ideal for dry machining of castings and forgings or if high pressure coolant is used

**NT-D:** Master jaws with INCH serration (1/16" x 90°, 3/32" x 90°)

**NT-M:** Master jaws with METRIC serration (1.5 mm x 60°)  
(suitable for japanese chuck top jaws)

**Technical features**

- Centrifugal force compensation
- Constant gripping force with permanent grease lubrication
- Center bore for coolant and/or air
- Chuck body and internal parts case hardened
- **proofline®** chucks = fully sealed – low maintenance

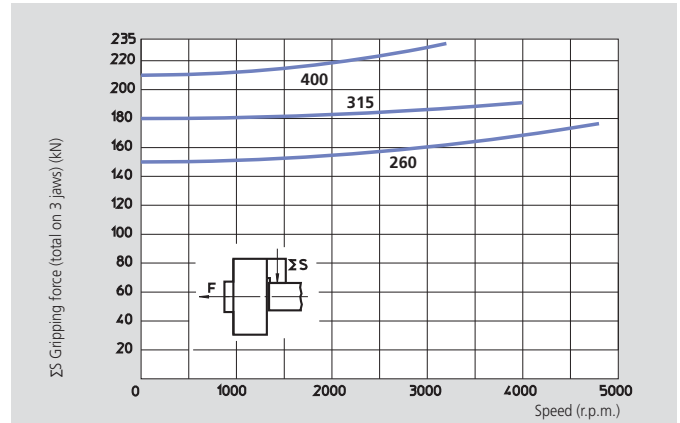
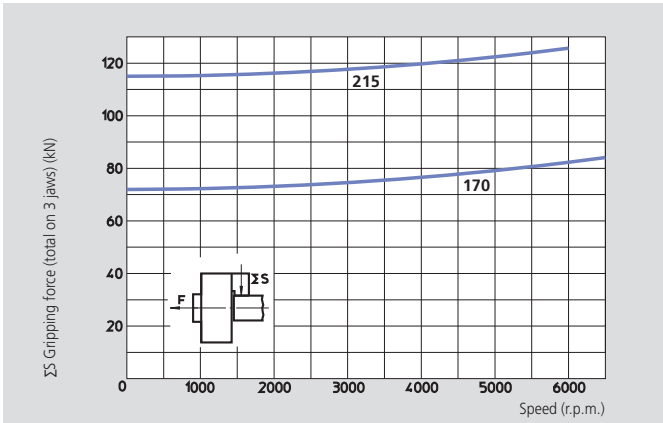
**Standard equipment**

- 3 jaw chuck
- 1 set T-nuts and bolts
- 1 set soft top jaws

**Ordering example**

- 3 jaw chuck NT-D 215/A6
- or
- 3 jaw chuck NT-M 260/Z220

**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:**

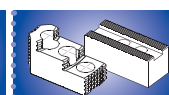
When using taller/heavier jaws and/or clamping on a bigger diameter reduce draw pull/rotating speed accordingly.

**Technical data**

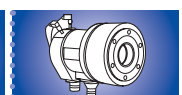
SMW-AUTOBLOK Type		NT-D 170 NT-M 170	NT-D 215 NT-M 215	NT-D 260 NT-M 260	NT-D 315 NT-M 315	NT-D 400 NT-M 400
<b>Number of jaws</b>		<b>3</b>	<b>3</b>	<b>3</b>	<b>3</b>	<b>3</b>
<b>Radial jaw stroke</b>	mm	3.6	4.6	5	6.3	7
<b>Axial piston stroke</b>	mm	17	22	24	30	33
<b>Max. draw pull</b>	kN	30	42	55	65	75
<b>Max. gripping force</b>	kN	72	112	150	180	210
<b>Max. speed</b>	r.p.m.	6500	6000	4800	4000	3200
<b>Mass (without top jaws)</b>	kg	13	25	40	68	112
<b>Moment of inertia</b>	kg·m <sup>2</sup>	0.048	0.146	0.34	0.84	2.15
<b>Recommended actuating cylinders</b>		<b>SIN-S 100</b>	<b>SIN-S 100/125</b>	<b>SIN-S 125/150</b>	<b>SIN-S 125/150</b>	<b>SIN-S 150/175</b>



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