SMW AUTOBLOK

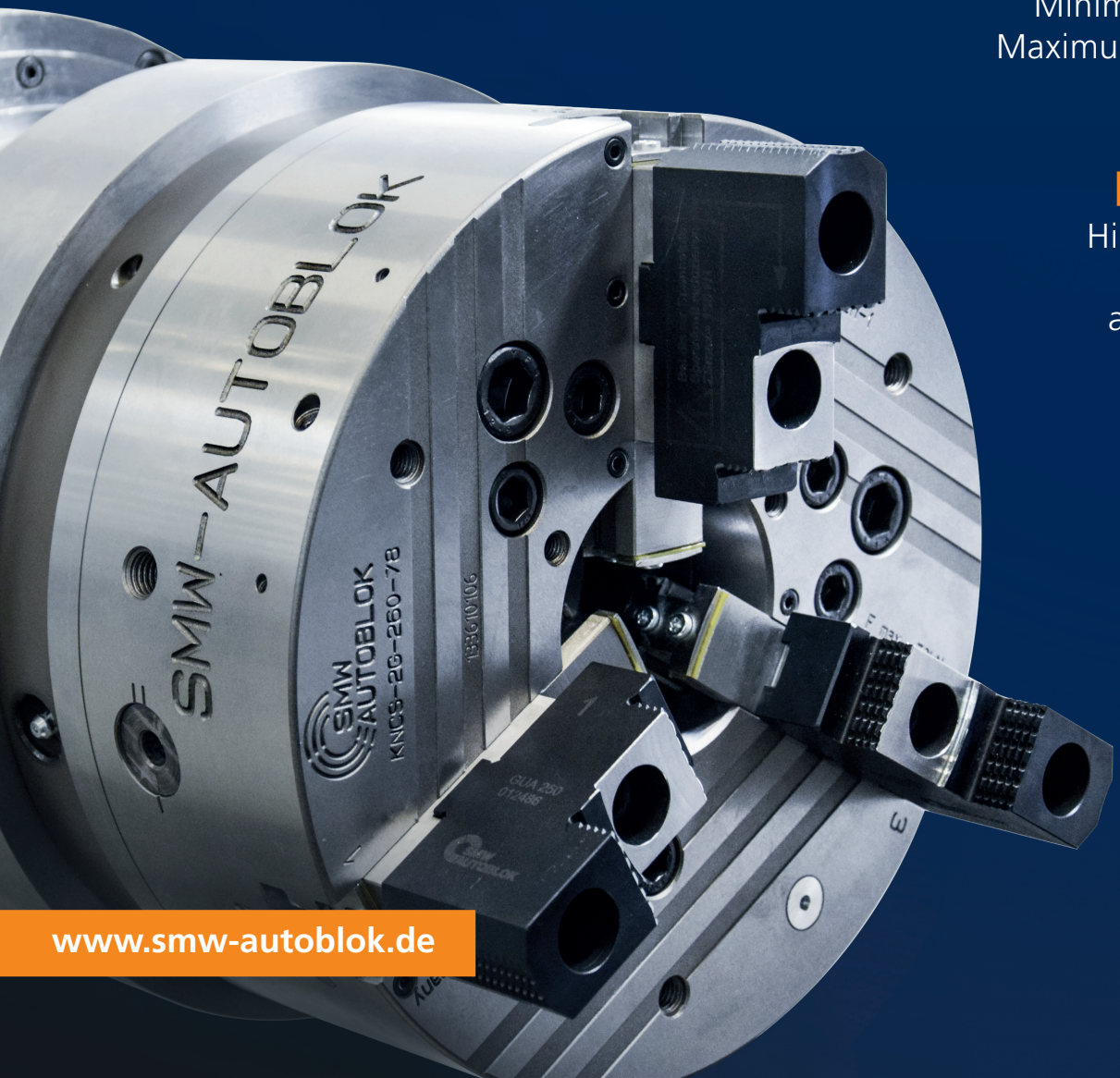
**STANDARD**

# POWER CHUCKS
## with quick jaw change

**SEALED**
now as 2G-version:
Sealed – low maintenance

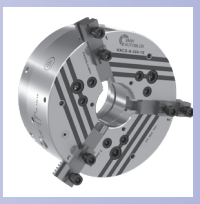
**EFFICIENT + FLEXIBLE**
Minimum set up times
Maximum cost-efficiency
and flexibility

**PRECISE**
Highest precision –
no reboring of
already machined
jaws necessary




www.smw-autoblok.de

# Quick jaw change power chucks

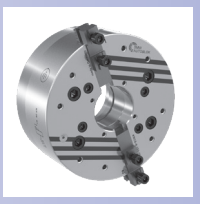


Page 4

## KNCS®-N
**QUICK JAW CHANGE**

**Quick jaw change power chucks**
**Ø 140 - 630 mm**

- Large through hole
- High speed
- High flexibility: jaws radially adjustable/reversible
- 3 jaws



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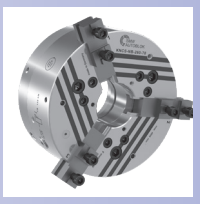
## KNCS®-N
**QUICK JAW CHANGE**

**Quick jaw change power chucks**
**Ø 210 - 325 mm**

- Large through hole
- High speed
- High flexibility: jaws radially adjustable/reversible
- 2 jaws



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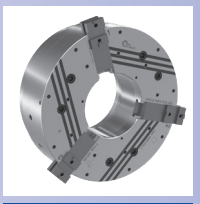
## KNCS®-NB
**QUICK JAW CHANGE**
**Wide master jaws**

**Quick jaw change power chucks**
**Ø 210 - 800 mm**

- Large through hole
- High flexibility: jaws radially adjustable/reversible
- 3 jaws
- Suitable to take any type of existing top jaws



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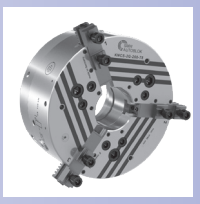
## KNCS®-NBX
**QUICK JAW CHANGE**
**Wide master jaws – extra large through hole**

**Quick jaw change power chucks**
**Ø 425 - 1000 mm**

- EXTRA large through hole
- EXTRA long piston guide
- High flexibility: jaws radially adjustable/reversible
- 3 jaws
- Suitable to take any type of existing top jaws



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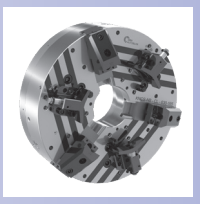
## KNCS-2G
NEW

**QUICK JAW CHANGE**
**Fully sealed**

**Quick jaw change power chucks**
**Ø 170 - 630 mm**

- Large through hole
- Protection against dust and swarf
- High flexibility: jaws radially adjustable/reversible
- 3 Jaws



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## KNCS-NB-CL
**QUICK JAW CHANGE**
**Wide master jaws – Radial fine adjustment**

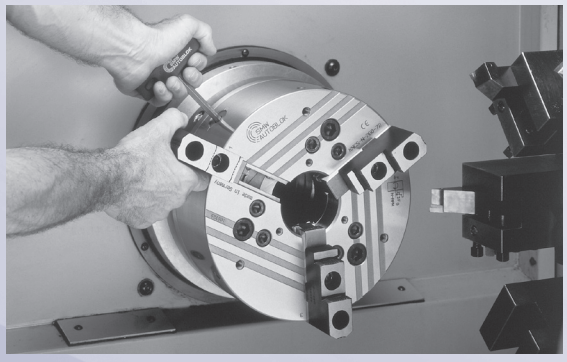
**Quick jaw change power chucks**
**Ø 630 mm**

- Large through hole
- High flexibility: jaws radially adjustable/reversible
- Integrated fine adjustment
- Suitable to take any type of existing top jaws

# Fast changeover, fast payback:

# The original quick jaw change power chuck

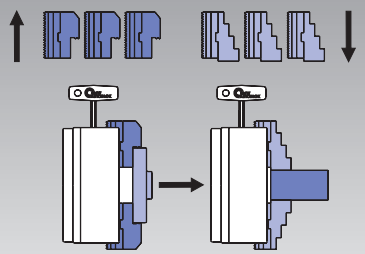
# KNCS®-N



Easy lubrication even on vertical machines with 3 radial built-in grease fittings

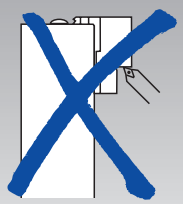
## Minimal set-up times

Jaw change in less than 1 minute



## High repeatability when changing jaws

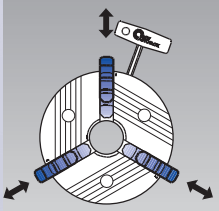
No reboring of already machined jaws necessary, because runout < 0.02 mm (KNCS-N 210)



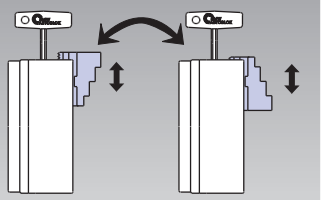
Extra long, symmetrical jaw guides. Ideal for O.D. or I.D. clamping

Unique **wedge bar drive for high speed**. Minimum loss in gripping force because of tangentially supported wedge bars. Minimum increase of gripping force **(hysteresis)** after quick spindle stop. **High efficiency** of the wedge bar drive ensures highest concentricity and **repeatability.** Suitable for **high-low clamping**

## Flexibility jaws can be radially adjusted and are reversible = **less jaw sets**

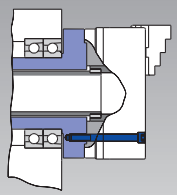


Jaws radially adjustable



Jaws 180° reversed

## Direct mounting



Recess and bolt circle to DIN 55026

Original SMW-AUTOBLOK quick **jaw change**. **Jaw change accuracy** with patented **jaw safety interlock**

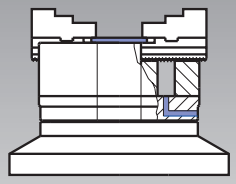
## Profitability

Example set-up times/costs

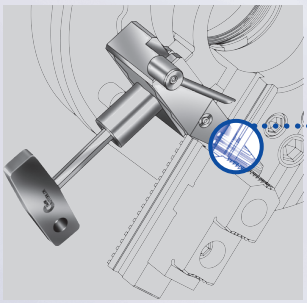
| | Conventional chuck | KNCS®-N |
|---|---|---|
| Jaw change | 10 Min. | 1 Min. |
| Reboring of jaws | 20 Min. | 0 Min. |
| Ø jaw changes / day | 2 | 2 |
| Working days / year | 230 | 230 |
| Machine costs / hour | $ 60.– | $ 60.– |
| Total costs / year | $ 13800.– | $ 460.– |
| **Profit*** | | **$ 13340.–** |

* If jaws are changed more often, the profitability is increased accordingly

## Vertical application



Version for vertical application with cover and drain holes for coolant available.



If serration is not fully engaged – jaw safety interlock is active

# Clamping glossary

**Case hardening:** The surface of the components is hardened (60 HRC) to a depth of about 1 mm (0.04”). The core shows a high tensile strength and toughness. Compared to partial inductive hardened and nitrited parts the rigidity and the resistance against wear is greatly increased.

**Efficiency:** The ratio between the calculated theoretical gripping force (disregarding friction) and the actual (measured) gripping force.

**High-low clamping:** For easily deformable components. High gripping forces for the rough cut are reduced to low gripping forces for the finish cut without unchucking. This means less deformation on the finished components. Contrarily to wedge hook chucks the **KNCS-N** wedge bar drive is suitable for high-low clamping.

**Hysteresis:** At high speeds the chuck body “grows” due to centrifugal force. The draw-pull of the clamping cylinder causes an increase in gripping force which cannot be decreased at a quick spindle stop (or change in speed). This can cause deformation at easily deformed parts. **KNCS-N** chucks with wedge bar drive have a very low hysteresis.

**Jaw change accuracy:** The centering accuracy after a jaw change with once already bored/ground jaws on the chuck. The clamping force on the **KNCS-N** is transmitted via the wedge bar drive.

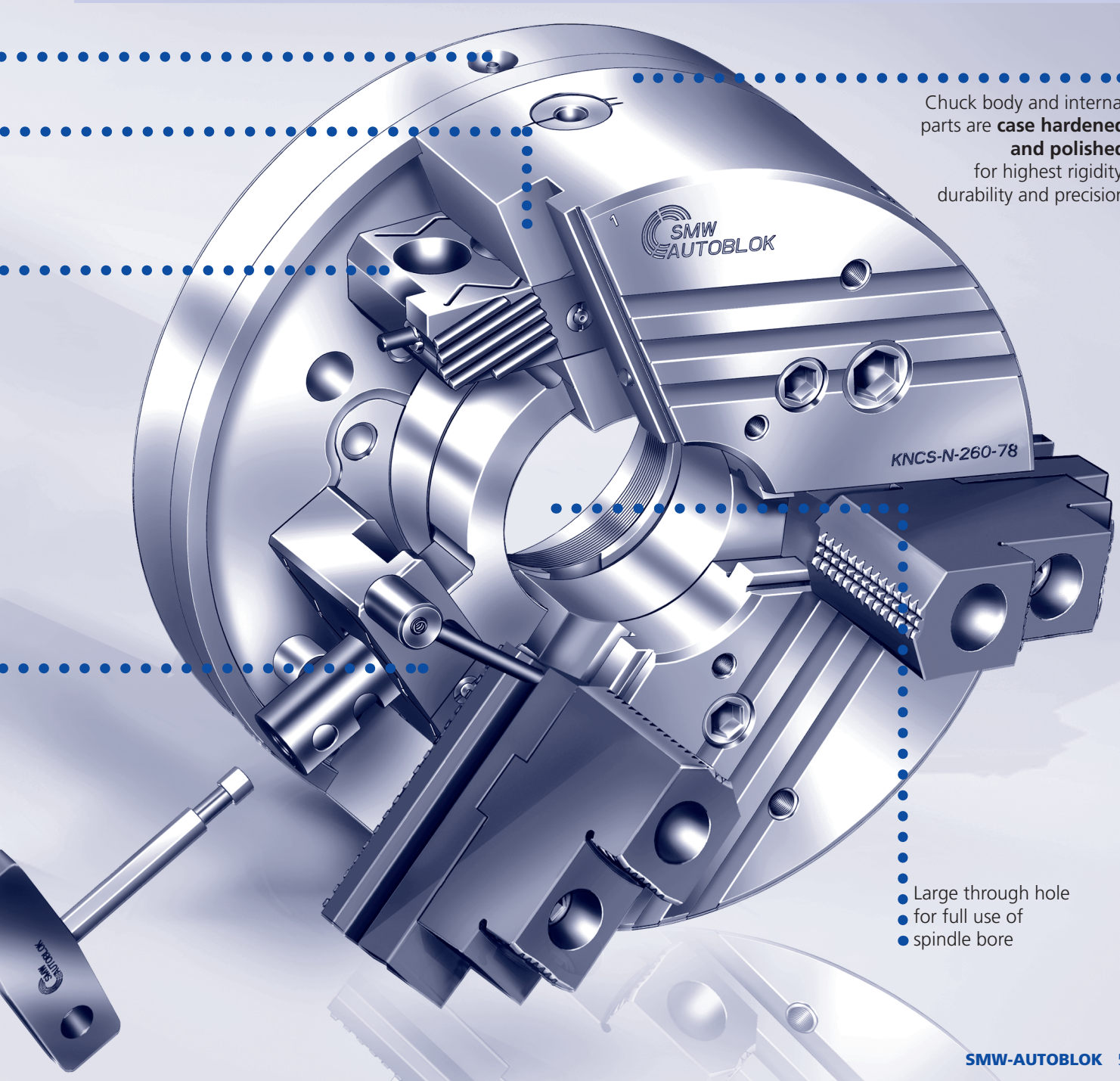
The engaging / disengaging of the jaws is done by an additional tangential movement of the wedge bars. This proven and patented design with self-acting cleaning of the serration offers a constant high jaw change accuracy after jaw changing.

**Jaw safety interlock:** At quick jaw change chucks the transmission of the gripping force to the interchangeable clamping jaws is done via a serration. With existing chuck designs misoperation by the operator can cause danger to man and machine if the jaw is not inserted correctly i.e. the serration is not fully engaged.

The **KNCS-N** is equipped with a unique safety interlock:
The built-in safety interlock eliminates misoperation.

**Repeatability:** The centering accuracy of the chuck equipped with one set of jaws starting from the first up to the last component of a batch. Due to the wedge bar drive **KNCS-N** chucks offer a much higherrepeatability compared to wedge hook chucks.

**Wedge bar drive:** The chuck is driven by tangentially mounted wedge bars. This design allows highest repeatability and rigidity. These chucks have very low loss in gripping force due to centrifugal force. The design does not require counterbalance weights which allows highest speeds without vibration.




Chuck body and internal parts are **case hardened and polished** for highest rigidity, durability and precision

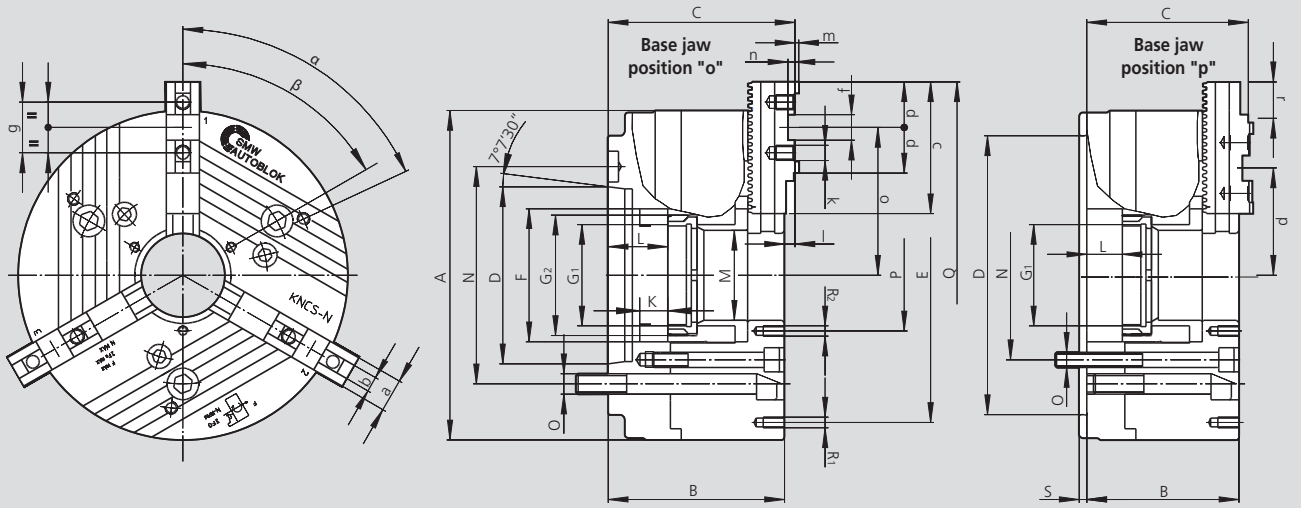
Large through hole for full use of spindle bore

# KNCS®-N

**QUICK JAW CHANGE 3-JAW-CHUCK**

## Main dimensions and technical data

**Jaw position: open position for external clamping**

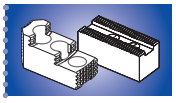



Subject to technical changes.
For more detailed information please ask our customer service.

| Type KNCS-N | | 140-35 | | 170-43 | | | 210-52 | | | 225-66 | | | 260-78 | | | | 275-86 | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **Mounting** | **Size** | **Z120** | **A5** | **Z140** | **A5** | **A6** | **Z170** | **A6** | **A8** | **Z170** | **A6** | **A8** | **Z170** | **Z220** | **A6** | **A8** | **Z220** | **A6*** | **A8** |
| | **A** | 145 | | 175 | | | 215 | | | 225 | | | 260 | | | | 275 | | |
| | **B** | 87 | 103 | 98 | 113 | 115 | 105 | 122 | 124 | 105 | 122 | 124 | 120 | 120 | 137 | 139 | 120 | 144 | 139 |
| | **C** | 93.9 | 109.9 | 104.9 | 119.9 | 121.9 | 109.9 | 126.9 | 128.9 | 109.9 | 126.9 | 128.9 | 128.3 | 128.3 | 145.3 | 147.3 | 128.3 | 152.3 | 147.3 |
| | **D** H6 | 120 | 82.57 | 140 | 82.57 | 106.39 | 170 | 106.39 | 139.73 | 170 | 106.39 | 139.73 | 170 | 220 | 106.39 | 139.73 | 220 | 106.39 | 139.73 |
| | **E** | 122 | | 152 | | | 168 | | | 180 | | | 210 | | | | 210 | | |
| | **F** | 52 | | 67 | | | 85 | | | 95 | | | 111 | | | | 122 | | |
| Rotating ring nut / depth | **G1** | - ** | | M50 x 1.5 / 18** | | | M60 x 1.5 / 16 | | | M75 x 1.5 / 16 | | | M90 x 2 / 20 | | | | M95 x 2 / 20 | | |
| Piston thread / depth | **G2** | M45 x 1.5 / 18 | | M60 x 1.5 / 18 | | | M75 x 2 / 19 | | | M85 x 2 / 19 | | | M102 x 2 / 23 | | | | M110 x 2 / 23 | | |
| Piston stroke | **K** | 20 | | 20 / 25 | | | 22 / 25 | | | 22 / 25 | | | 25 / 28 | | | | 25 / 28 | | |
| Max. | **L** | 20 | 36 | 25 | 40 | 42 | 25 | 42 | 44 | 25 | 42 | 44 | 28 | 28 | 45 | 47 | 28 | 52 | 47 |
| | **M** | 35 | | 43 | | | 52 | | | 66 | | | 78 | | | | 86 | | |
| Fixing bolt circle | **N** | 104.8 | 104.8 | 104.8 | 104.8 | 133.4 | 133.4 | 133.4 | 171.4 | 133.4 | 133.4 | 171.4 | 133.4 | 171.4 | 133.4 | 171.4 | 171.4 | 133.4 | 171.4 |
| Fixing bolt | **O** | M10 | M10 | M10 | M10 | M12 | M12 | M12 | M16 | M12 | M12 | M16 | M12 | M16 | M12 | M16 | M16 | M12 | M16 |
| | **P** | 65 | | 75 | | | 72 | | | 82 | | | 95 | | | | 105 | | |
| | **Q** | 166 | | 195 | | | 261 | | | 271 | | | 307 | | | | 321 | | |
| Thread / thread depth | **R1** | M8 / 12 | | M8 / 12 | | | M10 / 12 | | | M10 / 12 | | | M10 / 12 | | | | M10 / 18 | | |
| Thread / thread depth | **R2** | M5 / 10 | | M5 / 10 | | | M6 / 10 | | | M6 / 10 | | | M8 / 16 | | | | M8 / 14 | | |
| | **S** | 6 | | 6 | | | 6 | | | 6 | | | 6 | | | | 6 | | |
| | **a** | 20 | | 20 | | | 22 | | | 22 | | | 26 | | | | 26 | | |
| | **b** f7 | 8 | | 8 | | | 10 | | | 10 | | | 12 | | | | 12 | | |
| | **c** | 56 | | 65 | | | 85 | | | 85 | | | 104 | | | | 104 | | |
| | **d** | 28 | | 28 | | | 33 | | | 33 | | | 36 | | | | 36 | | |
| | **f** H7 | 18 | | 18 | | | 20 | | | 20 | | | 20 | | | | 20 | | |
| | **g** | 32 | | 32 | | | 40 | | | 40 | | | 40 | | | | 40 | | |
| Thread / thread depth | **k** | M8 / 12 | | M8 / 12 | | | M8 / 13 | | | M8 / 13 | | | M12 / 15 | | | | M12 / 15 | | |
| | **l** | 6.9 | | 6.9 | | | 4.9 | | | 4.9 | | | 8.3 | | | | 8.3 | | |
| | **m** | 2.5 | | 2.5 | | | 2.5 | | | 2.5 | | | 3 | | | | 3 | | |
| | **n** | 5 | | 5 | | | 4.5 | | | 4.5 | | | 5.5 | | | | 5.5 | | |
| Max. / min. | **o** | 54/39.9 | | 69 / 50.2 | | | 96.6 / 68.3 | | | 102 / 69 | | | 116.6 / 83.6 | | | | 124 / 85.5 | | |
| Max. / min. | **p** | 54/39.9 | | 60 / 41.2 | | | 77.6 / 49.3 | | | 83 / 50 | | | 84.6 / 51.6 | | | | 92 / 53.5 | | |
| Base jaw tooth pitch | **-** | 4.7 | | 4.7 | | | 4.7 | | | 4.7 | | | 5.5 | | | | 5.5 | | |
| Base jaw offset | **r** | 14.1 | | 18.8 | | | 28.3 | | | 33 | | | 33 | | | | 38.5 | | |
| Base jaw offset | teeth | 3 | | 4 | | | 6 | | | 7 | | | 6 | | | | 7 | | |
| α | deg. | 95 | | 90 | | | 60 | | | 60 | | | 60 | | | | 60 | | |
| β | deg. | 60 | | 60 | | | 60 | | | 60 | | | 60 | | | | 60 | | |
| Stroke per jaw at piston stroke **K** | mm | | | 5.1 | | 20 | 6.0 | | 22 | 6.0 | | 22 | 7.0 | | | 25 | 7.0 | | 25 |
| Stroke per jaw at piston stroke **K** max. | mm | 5.1 | 20 | 6.8 | | 25 | 7.0 | | 25 | 7.0 | | 25 | 8.0 | | | 28 | 8.0 | | 28 |
| Max. actuating force 3-jaw chuck | kN | 25 | | 32 | | | 53 | | | 53 | | | 70 | | | | 70 | | |
| Max. total gripping force 3-jaw chuck | kN | 47 | | 60 | | | 100 | | | 100 | | | 135 | | | | 135 | | |
| Max. speed 3-jaw chuck | r.p.m. | 6500 | | 6300 | | | 6000 | | | 5500 | | | 4700 | | | | 4700 | | |
| Weight without jaws | kg | 9 | 9.6 | 14 | 15 | 15 | 24 | 26 | 26 | 26 | 29 | 29 | 40 | 40 | 43 | 43 | 48 | 53 | 50.7 |
| Moment of inertia | kg·m² | 0.024 | | 0.06 | | | 0.11 | | | 0.2 | | | 0.38 | | | | 0.41 | | |
| **Rec. closed center cyl.** **Rec. open center cyl.** | **Type** **Type** | **SIN-S 100** **VNK-T2 70-32** | | **SIN-S 100 / 125** **VNK-T2 102-46** | | | **SIN-S 125 / 150** **VNK-T2 130-52** | | | **SIN-S 125 / 150** **VNK-T2 150-67** | | | **SIN-S 150 / 175** **VNK-T2 170-77** | | | | **SIN-S 150 / 175** **VNK-T2 225-95** | | |

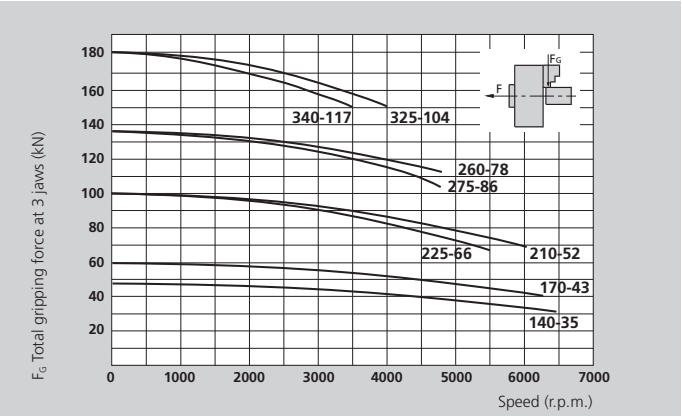
* Indirect mounting.
** KNCS-N 140-35 and KNCS-N 170-43 are available with fixed ring nut only.

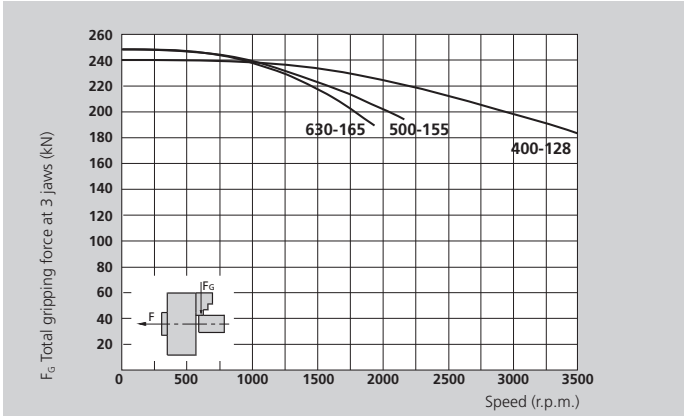
SMW-AUTOBLOK 438


SMW-AUTOBLOK 9

SMW-AUTOBLOK 297

## For highest speeds: flat gripping force curve




The data in the diagrams refer to 3 jaw chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K05 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.

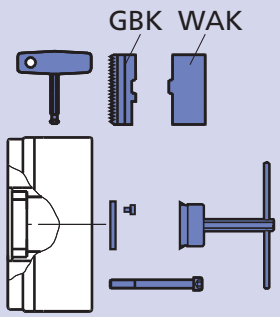
| Type KNCS-N | | 325-104 | | | | 340-117 | | | 400-128 | | | | 500-155 | | | | 630-165 | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **Mounting** | **Size** | **Z220** | **Z300** | **A8** | **A11** | **Z300** | **A8*** | **A11** | **Z300** | **Z380** | **A11** | **A15** | **Z300** | **Z380** | **A11** | **A15** | **Z380** | **A15** |
| | **A** | 324 | | | | 340 | | | 400 | | | | 500 | | | | 630 | |
| | **B** | 130 | 130 | 149 | 151 | 130 | 160 | 151 | 140 | 140 | 161 | 163 | 174 | 174 | 195 | 197 | 174 | 197 |
| | **C** | 139.2 | 139.2 | 158.2 | 160.2 | 139.3 | 169.3 | 160.4 | 149.2 | 149.2 | 170.2 | 172.2 | 184 | 184 | 205 | 207 | 184 | 207 |
| | **D** H6 | 220 | 300 | 139.73 | 196.88 | 300 | 139.73 | 196.88 | 300 | 380 | 196.88 | 285.77 | 300 | 380 | 196.88 | 285.77 | 380 | 285.77 |
| | **E** | 268 | | | | 270 | | | 330 | | | | 420 | | | | 585 | |
| | **F** | 144 | | | | 160 | | | 180 | | | | 207 | | | | 217 | |
| Rotating ring nut / depth | **G1** | M115 x 2 / 22 | | | | M125 x 2 / 22 | | | M138 x 2 / 22 | | | | M165 x 2 / 25 | | | | M175 x 2 / 25 | |
| Piston thread / depth | **G2** | M132 x 2 / 25 | | | | M146 x 2 / 25 | | | M160 x 2 / 25 | | | | M185 x 2 / 28 | | | | M195 x 2 / 28 | |
| Piston stroke | **K** | 25/28 | | | | 25/28 | | | 32 | | | | 42 | | | | 42 | |
| Max. | **L** | 28 | 28 | 47 | 49 | 28 | 58 | 49 | 32 | 32 | 53 | 55 | 42 | 42 | 63 | 65 | 42 | 65 |
| | **M** | 104 | | | | 117 | | | 128 | | | | 155 | | | | 165 | |
| Fixing bolt circle | **N** | 171.4 | 235 | 171.4 | 235 | 235 | 171.4 | 235 | 235 | 330.2 | 235 | 330.2 | 235 | 330.2 | 235 | 330.2 | 330.2 | 330.2 |
| Fixing bolt | **O** | M16 | M20 | M16 | M20 | M20 | M16 | M20 | M20 | M24 | M20 | M24 | M20 | M24 | M20 | M24 | M24 | |
| | **P** | 130 | | | | 140 | | | 152 | | | | 180 | | | | 195 | |
| | **Q** | 385 | | | | 400 | | | 452 | | | | 552 | | | | 643 | |
| Thread / thread depth | **R1** | M10 / 16 | | | | M10 / 16 | | | M12 / 18 | | | | M16 / 25 | | | | M16 / 25 | |
| Thread / thread depth | **R2** | M10 / 16 | | | | M10 / 16 | | | M12 / 18 | | | | M12 / 18 | | | | M12 / 18 | |
| | **S** | 6 | | | | 6 | | | 8 | | | | 8 | | | | 8 | |
| | **a** | 32 | | | | 32 | | | 32 | | | | 45 | | | | 45 | |
| | **b** f7 | 12 | | | | 12 | | | 12 | | | | 18 | | | | 18 | |
| | **c** | 115 | | | | 115 | | | 125 | | | | 160 | | | | 200 | |
| | **d** | 36 | | | | 36 | | | 43 | | | | 50 | | | | 50 | |
| | **f** H7 | 20 | | | | 20 | | | 26 | | | | 30 | | | | 30 | |
| | **g** | 40 | | | | 40 | | | 54 | | | | 60 | | | | 60 | |
| Thread / thread depth | **k** | M12 / 17 | | | | M12 / 17 | | | M12 / 17 | | | | M16 / 34 | | | | M16 / 34 | |
| | **l** | 9.3 | | | | 9.3 | | | 9.3 | | | | 10 | | | | 10 | |
| | **m** | 3 | | | | 3 | | | 3 | | | | 4 | | | | 4 | |
| | **n** | 6 | | | | 6 | | | 7 | | | | 9 | | | | 9 | |
| Max. / min. | **o** | 155.7 / 106.2 | | | | 163.2 / 113.7 | | | 182.3 / 121.8 | | | | 225 / 141 | | | | 270.5 / 179.5 | |
| Max. / min. | **p** | 111.7 / 62.2 | | | | 119.2 / 69.7 | | | 143.3 / 82.2 | | | | 164 / 80 | | | | 170.5 / 79.5 | |
| Base jaw tooth pitch | **-** | 5.5 | | | | 5.5 | | | 5.5 | | | | 7 | | | | 7 | |
| Base jaw offset | **r** | 49.5 | | | | 49.5 | | | 60.5 | | | | 84 | | | | 91 | |
| Base jaw offset | teeth | 9 | | | | 9 | | | 11 | | | | 12 | | | | 13 | |
| α | deg. | 60 / 35 | | | | 60 / 35 | | | 20 / 9 x 40 | | | | 20 / 9 x 40 | | | | 20 / 9 x 40 | |
| β | deg. | 60 / 35 | | | | 60 / 35 | | | 20 / 9 x 40 | | | | 20 / 9 x 40 | | | | 20 / 9 x 40 | |
| Stroke per jaw at piston stroke **K** | mm | 7.0 | | | 25 | 7.0 | | 25 | | | | | | | | | | |
| Stroke per jaw at piston stroke **K** max. | mm | 8.0 | | | 28 | 8.0 | | 28 | 8.0 | | | 32 | 10.0 | | | 42 | 10.0 | 42 |
| Max. actuating force 3-jaw chuck | kN | 95 | | | | 95 | | | 115 | | | | 120 | | | | 120 | |
| Max. total gripping force 3-jaw chuck | kN | 180 | | | | 180 | | | 240 | | | | 250 | | | | 250 | |
| Max. speed 3-jaw chuck | r.p.m. | 4000 | | | | 3500 | | | 3500 | | | | 2200 | | | | 1700 | |
| Weight without jaws | kg | 65 | 65 | 68 | 68 | 77 | 88.5 | 82.5 | 111 | 111 | 116 | 116 | 225 | 225 | 231 | 231 | 390 | 398 |
| Moment of inertia | kg·m² | 1.2 | | | | 1.24 | | | 2.5 | | | | 6.5 | | | | 18 | |
| **Rec. closed center cyl.** **Rec. open center cyl.** | **Type** **Type** | **SIN-S 150 / 175 / 200** **VNK-T2 250-110** | | | | **SIN-S 150 / 175 / 200** **VNK-T2 320-127** | | | **SIN-S 175 / 200** **VNK-T2 320-127** | | | | **SIN-S 175 / 200** **VSG 450-165** | | | | **SIN-S 175 / 200** **VSG 450-165** | |

* Indirect mounting.

# KNCS®-N

**QUICK JAW CHANGE 3-JAW-CHUCK**

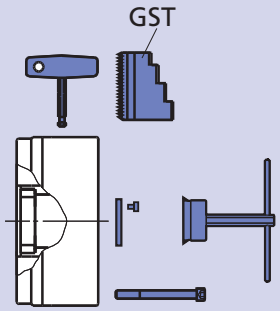
**Ordering review**




## Supply range:

Chuck + key + mounting bolts + mounting key (from diameter 210)
+ 1 set hardened base jaws type GBK + 1 set soft top jaws type WAK
+ 1 set of coverplates

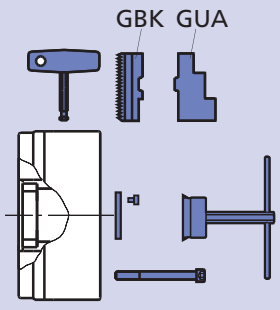
| Size / Spindle mounting | KNCS-N 140-35 | KNCS-N 170-43 | KNCS-N 210-52 | KNCS-N 225-66 | KNCS-N 260-78 | KNCS-N 275-86 | KNCS-N 325-104 | KNCS-N 340-117 | KNCS-N 400-128 | KNCS-N 500-155 | KNCS-N 630-165 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Centering rim small | | | | | Z 170 088900 | | Z 220 088912 | | Z 300 088822 | Z 300 088889 | |
| Centering rim large | Z 120 088800 | Z 140 088802 | Z 170 088806 | Z 170 088809 | Z 220 088901 | Z 220 067910 | Z 300 088913 | Z 300 067920 | Z 380 088823 | Z 380 088826 | Z380 088829 |
| A 05 | 088801 | 088803 | | | | | | | | | |
| A 06 | | 088804 | 088807 | 088810 | 088902 | 067911 | | | | | |
| A 08 | | | 088808 | 088811 | 088903 | 067912 | 088914 | 067921 | | | |
| A 11 | | | | | | | 088915 | 067922 | 088824 | 088827 | |
| A 15 | | | | | | | | | 088825 | 088828 | 088830 |




## Supply range:

Chuck + key + mounting bolts + mounting key (from diameter 210)
+ 1 set hardened, reversible stepped monoblock jaws type GST, ground on chuck
+ 1 set of coverplates

| Size / Spindle mounting | KNCS-N 140-35 | KNCS-N 170-43 | KNCS-N 210-52 | KNCS-N 225-66 | KNCS-N 260-78 | KNCS-N 275-86 | KNCS-N 325-104 | KNCS-N 340-117 | KNCS-N 400-128 | KNCS-N 500-155 | KNCS-N 630-165 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Centering rim small | | | | | Z 170 088904 | | Z 220 088916 | | Z 300 088850 | Z 300 088859 | |
| Centering rim large | Z 120 088831 | Z 140 088833 | Z 170 088836 | Z 170 088839 | Z 220 088905 | Z 220 067913 | Z 300 088917 | Z 300 067923 | Z 380 088851 | Z 380 088854 | Z380 088857 |
| A 05 | 088832 | 088834 | | | | | | | | | |
| A 06 | | 088835 | 088837 | 088840 | 088906 | 067914 | | | | | |
| A 08 | | | 088838 | 088841 | 088907 | 067915 | 088918 | 067924 | | | |
| A 11 | | | | | | | 088919 | 067925 | 088852 | 088855 | |
| A 15 | | | | | | | | | 088853 | 088856 | 088858 |

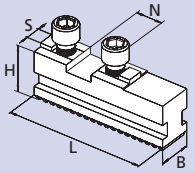



## Supply range:

Chuck + key + mounting bolts + mounting key (from diameter 210)
+ 1 set hardened base jaws type GBK
+ 1 set hardened, reversible top jaws type GUA ground on chuck
+ 1 set of coverplates

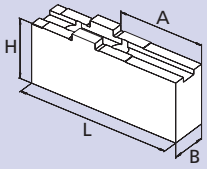
| Size / Spindle mounting | KNCS-N 140-35 | KNCS-N 170-43 | KNCS-N 210-52 | KNCS-N 225-66 | KNCS-N 260-78 | KNCS-N 275-86 | KNCS-N 325-104 | KNCS-N 340-117 | KNCS-N 400-128 | KNCS-N 500-155 | KNCS-N 630-165 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Centering rim small | | | | | Z 170 088908 | | Z 220 088920 | | Z 300 088879 | Z 300 088888 | |
| Centering rim large | Z 120 088860 | Z 140 088862 | Z 170 088865 | Z 170 088868 | Z 220 088909 | Z 220 067916 | Z 300 088921 | Z 300 067926 | Z 380 088880 | Z 380 088883 | Z380 088886 |
| A 05 | 088861 | 088863 | | | | | | | | | |
| A 06 | | 088864 | 088866 | 088869 | 088910 | 067917 | | | | | |
| A 08 | | | 088867 | 088870 | 088911 | 067918 | 088922 | 067927 | | | |
| A 11 | | | | | | | 088923 | 067928 | 088881 | 088884 | |
| A 15 | | | | | | | | | 088882 | 088885 | 088887 |

## GBK
### Hardened base jaws



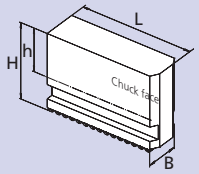

| KNCS-N | 140 | 170 | 210 | 225 | 260 | 275 | 325 | 340 | 400 | 500 | 630 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Jaw type | GBK 140 | GBK 160 | GBK 200 | GBK 200 | GBK 250 | GBK 250 | GBK 315 | GBK 315 | GBK 400 | GBK 500 | GBK 630 |
| Id. No. | 012438 | 012439 | 012440 | 012440 | 012441 | 012441 | 012442 | 012442 | 012443 | 012444 | 012445 |
| B | 20 | 20 | 22 | 22 | 26 | 26 | 32 | 32 | 32 | 45 | 45 |
| H | 27.5 | 27.5 | 29.5 | 29.5 | 37 | 37 | 43 | 43 | 43 | 57 | 57 |
| L | 56 | 65 | 85 | 85 | 104 | 104 | 115 | 115 | 125 | 160 | 200 |
| N | 18 | 18 | 20 | 20 | 20 | 20 | 20 | 20 | 26 | 30 | 30 |
| S | 8 | 8 | 10 | 10 | 12 | 12 | 12 | 12 | 12 | 18 | 18 |
| kg / set | 0.6 | 0.7 | 1.0 | 1.0 | 1.8 | 1.8 | 2.7 | 2.7 | 3.0 | 7.1 | 9.0 |

## WAK
### Soft top jaws



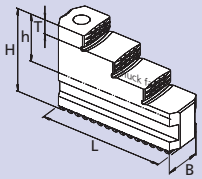

| KNCS-N | 140 | 170 | 210 | 225 | 260 | 275 | 325 | 340 | 400 | 500 | 630 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Jaw type | WAK 140-10 | WAK 160-10 | WAK 200-10 | WAK 200-10 | WAK 250-10 | WAK 250-10 | WAK 250-10 | WAK 250-10 | WAK 400-10 | WAK 500-10 | WAK 500-10 |
| Id. No. | 012490 | 012491 | 012492 | 012492 | 012493 | 012493 | 012493 | 012493 | 012494 | 012495 | 012495 |
| B | 20 | 20 | 22 | 22 | 30 | 30 | 30 | 30 | 35 | 50 | 50 |
| H | 35.5 | 35.5 | 42 | 42 | 50 | 50 | 50 | 50 | 54 | 73 | 73 |
| L | 69 | 85 | 105 | 105 | 125 | 125 | 125 | 125 | 145 | 180 | 180 |
| A | 26 | 42 | 50 | 50 | 70 | 70 | 70 | 70 | 74 | 100 | 100 |
| kg / set | 0.9 | 1.2 | 2.0 | 2.0 | 3.6 | 3.6 | 3.6 | 3.6 | 5.8 | 13.7 | 13.7 |

## UVB
### Soft monoblock jaws

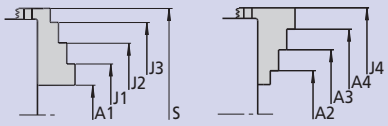



| KNCS-N | 140 | 170 | 210 | 225 | 260 | 275 | 325 | 340 | 400 | 500 | 630 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Jaw type | UVB 140 | UVB 160 | UVB 200 | UVB 200 | UVB 250 | UVB 250 | UVB 315 | UVB 315 | UVB 400 | UVB 500 | UVB 630 |
| Id. No. | 012446 | 012447 | 012448 | 012448 | 012449 | 012449 | 012450 | 012450 | 012451 | 012452 | 012453 |
| B | 20 | 20 | 22 | 22 | 26 | 26 | 32 | 32 | 32 | 45 | 45 |
| H | 60 | 60 | 70 | 70 | 90 | 90 | 100 | 100 | 100 | 134 | 134 |
| h | 39.4 | 39.4 | 45 | 45 | 61 | 61 | 66 | 66 | 66 | 87 | 87 |
| L | 59.5 | 69 | 83 | 83 | 108 | 108 | 119 | 119 | 146.5 | 175 | 230 |
| kg / set | 1.5 | 1.8 | 2.8 | 2.8 | 5.5 | 5.5 | 8.2 | 8.2 | 10 | 23 | 30 |

## GST
### Hardened stepped monoblock jaws




### Gripping ranges




| KNCS-N | 140 | 170 | 210 | 225 | 260 | 275 | 325 | 340 | 400 | 500 | 630 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Jaw type | GST 160-2 | GST 170 | GST 210 | GST 210 | GST 260 | GST 260 | GST 315 | GST 315 | GST 400 | GST 500 | GST 500 |
| Id. No. | 012454 | 035867 | 035863 | 035863 | 037623 | 037623 | 012457 | 012457 | 012458 | 012459 | 012459 |
| B | 20 | 20 | 22 | 22 | 26 | 26 | 32 | 32 | 32 | 45 | 45 |
| H | 43.5 | 43.5 | 51 | 51 | 60 | 60 | 66 | 66 | 70 | 93 | 93 |
| h | 23 | 23 | 26 | 26 | 31 | 31 | 32 | 32 | 36 | 46 | 46 |
| L | 58 | 65 | 84 | 84 | 100 | 100 | 117 | 117 | 137 | 175 | 175 |
| T | 7 | 7 | 8 | 8 | 10 | 10 | 10 | 10 | 11 | 20 | 20 |
| kg / set | 0.6 | 0.7 | 1.3 | 1.3 | 1.9 | 1.9 | 3.4 | 3.4 | 4.4 | 11.7 | 11.7 |
| A1 | 5-40 | 6-59 | 10-85 | 12-96 | 10-98 | 14-113 | 37-148 | 46-141 | 48-173 | 70-225 | 38-220 |
| A2 | 35-70 | 42-89 | 56-121 | 57-132 | 62-150 | 66-165 | 104-215 | 111-206 | 116-238 | 170-320 | 133-328 |
| A3 | 66-101 | 73-120 | 96-161 | 97-172 | 111-200 | 115-215 | 160-271 | 166-261 | 184-308 | 315-470 | 276-458 |
| A4 | 97-132 | 104-151 | 136-201 | 137-212 | 161-250 | 165-265 | 217-328 | 221-316 | 252-378 | - | - |
| J1 | 39-72 | 44-78 | 60-134 | 62-144 | 63-149 | 67-164 | 91-202 | 106-196 | 118-243 | - | - |
| J2 | 69-103 | 74-110 | 100-174 | 101-185 | 112-199 | 116-214 | 148-259 | 161-251 | 186-310 | 180-330 | 149-342 |
| J3 | 99-134 | 105-141 | 140-214 | 141-225 | 161-249 | 165-264 | 205-316 | 216-308 | 253-378 | 325-475 | 297-492 |
| J4 | 131-163 | 135-182 | 185-250 | 186-261 | 212-300 | 216-315 | 272-383 | 281-376 | 328-448 | 425-560 | 385-581 |
| S | 166 | 198 | 255 | 266 | 303 | 318 | 385 | 376 | 456 | 585 | - |

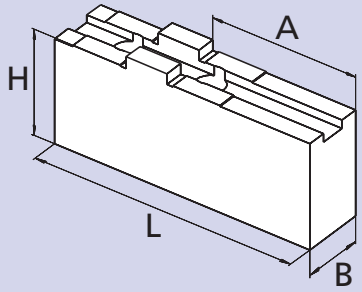
# KNCS®-N

QUICK JAW CHANGE
3-JAW-CHUCK

■ Soft top jaws wide version
■ Accessories

## WAKS

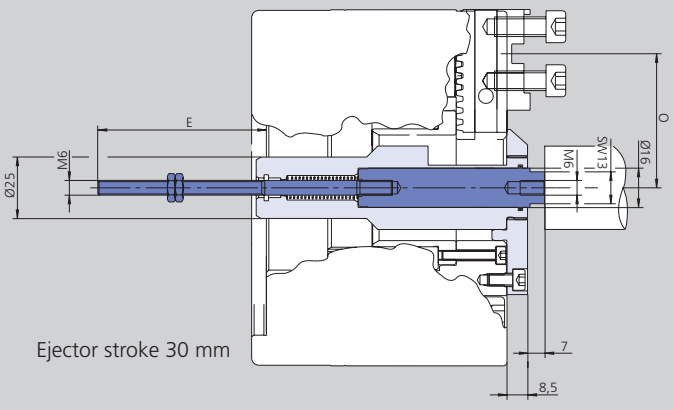
**Soft top jaws**
**Wide version**




| Type | Id. No. | B | H | L | A | kg / set | SMW-AUTOBLOK Chuck type |
|---|---|---|---|---|---|---|---|
| WAKS 140-10 | 012496 | 35 | 35.5 | 63 | 25 | 1.5 | KNCS-N 140 |
| WAKS 160-10 | 080931 | 25 | 45.5 | 85 | 42 | 1.8 | KNCS-N 170 |
| WAKS 160-20 | 080932 | 30 | 50.5 | 75 | 35 | 2.2 | |
| WAKS 160-30 | 080933 | 35 | 75.5 | 70 | 26 | 3.4 | |
| WAKS 200-10 | 080934 | 30 | 51 | 100 | 57 | 2.9 | KNCS-N 210 |
| WAKS 200-20 | 080935 | 30 | 66 | 100 | 45 | 3.4 | KNCS-N 225 |
| WAKS 200-30 | 012497 | 40 | 36 | 70 | 27 | 1.9 | |
| WAKS 200-31 | 080936 | 40 | 56 | 85 | 43 | 3.9 | |
| WAKS 200-32 | 036733 | 40 | 76 | 95 | 52 | 5.8 | |
| WAKS 250-10 | 080937 | 40 | 55 | 125 | 70 | 3.9 | KNCS-N 260 |
| WAKS 250-11 | 080938 | 40 | 75 | 125 | 70 | 7.5 | KNCS-N 275 |
| WAKS 250-12 | 080939 | 40 | 95 | 125 | 70 | 9.6 | KNCS-N 325 |
| WAKS 250-13 | 080940 | 40 | 115 | 125 | 70 | 11.5 | KNCS-N 340 |
| WAKS 250-20 | 012498 | 60 | 55 | 90 | 44 | 6.2 | |
| WAKS 250-21 | 080942 | 60 | 55 | 110 | 60 | 7.6 | |
| WAKS 250-22 | 080943 | 60 | 75 | 90 | 44 | 9.4 | |
| WAKS 250-23 | 080944 | 60 | 75 | 110 | 60 | 11.5 | |
| WAKS 250-30 | 012499 | 80 | 55 | 90 | 44 | 8.5 | |
| WAKS 250-31 | 080945 | 80 | 75 | 110 | 60 | 14.1 | |
| WAKS 400-10 | 080946 | 40 | 54 | 110 | 54 | 4.9 | KNCS-N 400 |
| WAKS 400-11 | 080947 | 40 | 54 | 145 | 89 | 6.7 | |
| WAKS 400-12 | 080948 | 40 | 94 | 145 | 89 | 11.1 | |
| WAKS 400-13 | 080949 | 40 | 114 | 145 | 89 | 13.5 | |
| WAKS 400-14 | 080950 | 40 | 146 | 145 | 89 | 16.9 | |
| WAKS 400-20 | 080951 | 60 | 54 | 110 | 54 | 7.6 | |
| WAKS 400-21 | 080952 | 60 | 74 | 110 | 54 | 10.3 | |
| WAKS 400-22 | 080953 | 60 | 94 | 110 | 54 | 14.1 | |
| WAKS 400-30 | 012500 | 80 | 64 | 100 | 44 | 11.0 | |
| WAKS 500-10 | 080954 | 60 | 73 | 155 | 90 | 13.8 | KNCS-N 500 |
| WAKS 500-12 | 080956 | 60 | 113 | 155 | 90 | 19.5 | KNCS-N 630 |
| WAKS 500-20 | 080957 | 80 | 73 | 155 | 90 | 15.5 | |
| WAKS 500-21 | 080958 | 80 | 93 | 155 | 90 | 26.3 | |
| WAKS 500-30 | 012501 | 90 | 73 | 130 | 65 | 16.4 | |
| WAKS 500-31 | 012502 | 100 | 73 | 150 | 85 | 20.0 | |

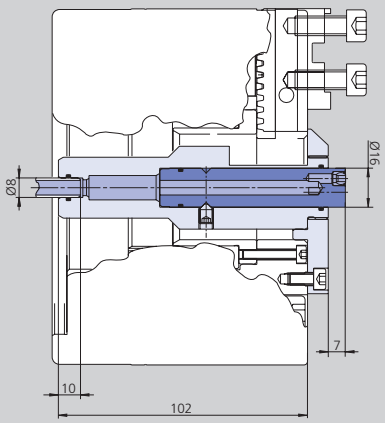
## Accessories for KNCS-N / KNCS-NB chucks

**Ejector / axial stop**




Ejector stroke 30 mm

**Coolant flush**




## Technical data

| SMW-AUTOBLOK Type | | | | KNCS-N 170-43 | KNCS-N 210-52 | KNCS-N 225-66 | KNCS-N 260-78 | KNCS-N 275-86 |
|---|---|---|---|---|---|---|---|---|
| | | | | | KNCS-NB 210-52 | KNCS-NB 225-66 | KNCS-NB 260-78 | KNCS-NB 275-86 |
| Ejector | | E | mm | 68.5 | 61.5 | 61.5 | 46.5 | 46.5 |
| Ejector | min. / max. | O | mm | 69 | 68.3 / 77.8 | 73.7 / 83.1 | 88.6 / 105.1 | 91 / 113 |
| Ejector / axial flush | | | Id. No. | 174140 | 174142 | 273530 | 274140 | 175000 |
| Coolant flush basic kit | min. / max. | O | mm | 69 | 68.3 / 77.8 | 73.7 / 83.1 | 88.6 / 105.1 | 91 / 113 |
| Coolant flush basic kit | | | Id. No. | 175001 | 175002 | 273531 | 274141 | 175005 |
| Coolant flush premium kit | min. / max. | O | mm | 59.6 / 69 | 68.3 / 96.6 | 73.8 / 120 | 89.1 / 116.6 | 91 / 124 |
| Coolant flush premium kit | | | Id. No. | 176021 | 176022 | 273532 | 274142 | 176025 |

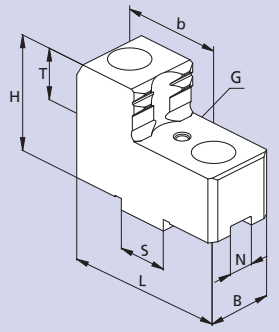
# KNCS®-N

■ Hard roughing top jaws
■ Stop pins

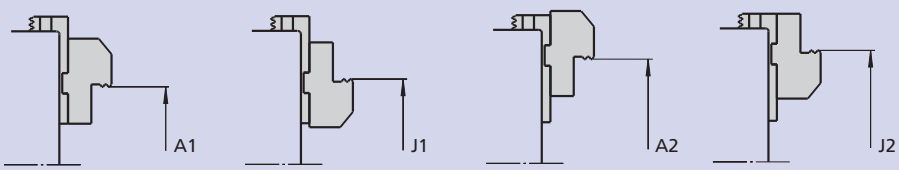
QUICK JAW CHANGE
3-JAW-CHUCK

| Type | Id. No. | B | H | T | G | N | S | b | L | kg / set | SMW-AUTOBLOK Chuck type | Clamping range Ø external $A_1$ | Clamping range Ø internal $J_1$ | Clamping range Ø external $A_2$ | Clamping range Ø internal $J_2$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **GGK 1751** | **012464** | 25 | 40 | 16 | M5 | 8 | 18 | 32 | 64 | 0.91 | **KNCS-N 140** | 25-53 | 125-162 | - | - |
| **GGK 1752** | **012465** | | | | | | | | 68 | 0.92 | | 36-56 | 128-168 | - | - |
| **GGK 1753** | **012466** | | | | | | | | 60 | 0.88 | | 55-81 | 101-135 | - | - |
| **GGK 1754** | **012467** | | | | | | | | 56 | 0.80 | | 80-105 | 75-109 | - | - |
| **GGK 1751** | **012464** | 25 | 40 | 16 | M5 | 8 | 18 | 32 | 64 | 0.91 | **KNCS-N 170** | 25-62 | 133-171 | 33-80 | 155-190 |
| **GGK 1752** | **012465** | | | | | | | | 68 | 0.92 | | 32-61 | 134-172 | 42-79 | 153-181 |
| **GGK 1753** | **012466** | | | | | | | | 60 | 0.88 | | 52-89 | 107-145 | 70-107 | 125-163 |
| **GGK 1754** | **012467** | | | | | | | | 56 | 0.80 | | 77-115 | 81-118 | 95-133 | 99-137 |
| **GGK 2001** | **012469** | 28 | 45 | 20 | M5 | 10 | 20 | 40 | 88 | 1.52 | **KNCS-N 210** | 29-59 | 187-252 | 36-87 | - |
| **GGK 2002** | **012470** | | | | | | | | 66 | 1.28 | | 57-122 | 121-186 | 94-150 | 158-215 |
| **GGK 2003** | **012471** | | | | | | | | 66 | 1.19 | | 93-149 | 85-140 | 131-187 | 122-178 |
| **GGK 2004** | **012472** | | 40 | 15 | | | | | 87 | 1.39 | | 152-208 | 62-100 | 189-246 | 72-137 |
| **GGK 2001** | **012469** | 28 | 45 | 20 | M5 | 10 | 20 | 40 | 88 | 1.52 | **KNCS-N 225** | 30-69 | - | 45-106 | - |
| **GGK 2002** | **012470** | | | | | | | | 66 | 1.28 | | 67-132 | 131-197 | 105-170 | 169-235 |
| **GGK 2003** | **012471** | | | | | | | | 66 | 1.19 | | 104-169 | 95-160 | 141-207 | 134-199 |
| **GGK 2004** | **012472** | | 40 | 15 | | | | | 87 | 1.39 | | 150-216 | 68-110 | 190-255 | 74-148 |
| **GGK 2501** | **012473** | 40 | 50 | 22 | M6 | 12 | 20 | 40 | 94 | 2.38 | **KNCS-N 260** | 45-85 | 197-274 | 61-148 | 254-342 |
| **GGK 2502** | **012474** | | | | | | | | 72 | 2.08 | | 78-154 | 132-208 | 141-218 | 195-272 |
| **GGK 2503** | **012475** | | | | | | | | 78 | 2.19 | | 107-184 | 109-175 | 159-247 | 152-238 |
| **GGK 2504** | **012476** | | | | | | | | 110 | 2.88 | | - | - | - | 80-156 |
| **GGK 2501** | **012473** | 40 | 50 | 22 | M6 | 12 | 20 | 40 | 94 | 2.38 | **KNCS-N 275** | 49-100 | 201-289 | 65-163 | 258-357 |
| **GGK 2502** | **012474** | | | | | | | | 72 | 2.08 | | 82-169 | 136-223 | 145-233 | 199-287 |
| **GGK 2503** | **012475** | | | | | | | | 78 | 2.19 | | 111-199 | 113-190 | 163-262 | 156-253 |
| **GGK 2504** | **012476** | | | | | | | | 110 | 2.88 | | - | - | - | 84-171 |
| **GGK 2501** | **012473** | 40 | 50 | 22 | M6 | 12 | 20 | 40 | 94 | 2.38 | **KNCS-N 325** | 40-126 | 207-320 | 104-214 | 295-406 |
| **GGK 2502** | **012474** | | | | | | | | 72 | 2.08 | | 86-196 | 138-248 | 173-284 | 225-336 |
| **GGK 2503** | **012475** | | | | | | | | 78 | 2.19 | | 115-226 | 109-218 | 203-314 | 196-306 |
| **GGK 2505** | **012477** | | 43 | 15 | | | | | 98 | 2.49 | | 197-285 | 78-164 | 261-371 | 139-249 |
| **GGK 2501** | **012473** | 40 | 50 | 22 | M6 | 12 | 20 | 40 | 94 | 2.38 | **KNCS-N 340** | 60-126 | 236-326 | - | 326-396 |
| **GGK 2502** | **012474** | | | | | | | | 72 | 2.08 | | 116-201 | - | 196-288 | - |
| **GGK 2503** | **012475** | | | | | | | | 78 | 2.19 | | - | 136-236 | 232-318 | - |
| **GGK 2504** | **012476** | | | | | | | | 110 | 2.88 | | - | 108-186 | - | - |
| **GGK 4001** | **012478** | 50 | 55 | 25 | M8 | 12 | 26 | 54 | 104 | 4.01 | **KNCS-N 400** | 78-188 | 258-378 | 143-263 | 333-453 |
| **GGK 4002** | **012479** | | | | | | | | 91 | 3.58 | | - | 140-263 | 258-378 | - |
| **GGK 4003** | **012480** | | | | | | | | 147 | 5.50 | | - | 118-243 | - | - |
| **GGK 5001** | **012481** | 60 | 74 | 35 | M8 | 18 | 30 | 60 | 125 | 7.58 | **KNCS-N 500** | 100-210 | 280-420 | 210-350 | 415-560 |
| **GGK 5002** | **012482** | | | | | | | | 108 | 6.67 | | - | 155-295 | 330-470 | - |
| **GGK 5003** | **012483** | 50 | 56 | 25 | M8 | 18 | 30 | 60 | 136 | 4.96 | | - | 100-240 | - | - |
| **GGK 5001** | **012481** | 60 | 74 | 35 | M8 | 18 | 30 | 60 | 125 | 7.58 | **KNCS-N 630** | 80-240 | 265-450 | 240-440 | 460-650 |
| **GGK 5002** | **012482** | | | | | | | | 108 | 6.67 | | - | 140-320 | 380-560 | - |

## GGK
### Hard roughing jaw



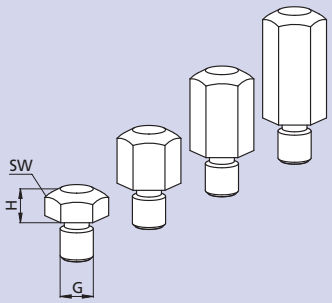

## GGK
### Clamping ranges




Base jaw position „p“

Base jaw position „o“

## ALB
### Stop pins




| SMW-AUTOBLOK Type | Id. No. | G | H | SW |
|---|---|---|---|---|
| **ALB 505** | **016510** | M5 | 5 | 10 |
| **ALB 510** | **016508** | | 10 | |
| **ALB 515** | **016509** | | 15 | |
| **ALB 605** | **016513** | M6 | 5 | 10 |
| **ALB 610** | **016511** | | 10 | |
| **ALB 615** | **016512** | | 15 | |
| **ALB 620** | **017602** | | 20 | |
| **ALB 805** | **017603** | | 5 | 13 |
| **ALB 810** | **016514** | | 10 | |
| **ALB 815** | **016515** | M8 | 15 | |
| **ALB 820** | **016516** | | 20 | |
| **ALB 825** | **081191** | | 25 | |

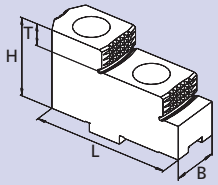
# KNCS®-N

QUICK JAW CHANGE
3-JAW-CHUCK

## Hard reversible top jaws

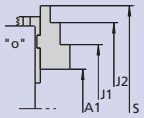
## GUA

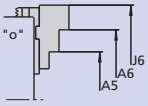
### Hardened reversible top jaws



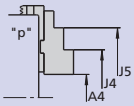

### Gripping ranges

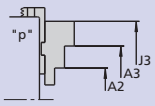
Base jaw position "o"




Base jaw position "p"




| KNCS-N | 140 | 170 | 210 | 225 | 260 | 275 | 325 | 340 | 400 | 500 | 630 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Jaw type | GUA 160 | GUA 160 | GUA 200 | GUA 200 | GUA 250 | GUA 250 | GUA 250 | GUA 250 | GUA 400 | GUA 500 | GUA 500 |
| Id. No. | 012484 | 012484 | 012485 | 012485 | 012486 | 012486 | 012486 | 012486 | 012487 | 012488 | 012488 |
| B | 20 | 20 | 22 | 22 | 30 | 30 | 30 | 30 | 36 | 45 | 45 |
| H | 32.5 | 32.5 | 39 | 38 | 50 | 50 | 50 | 50 | 56 | 73 | 70 |
| L | 63 | 63 | 72 | 72 | 90 | 90 | 90 | 90 | 105 | 130 | 130 |
| T | 7.5 | 7.5 | 10 | 10 | 14 | 14 | 14 | 14 | 15 | 20 | 20 |
| kg / set | 0.6 | 0.6 | 0.8 | 0.8 | 1.9 | 1.9 | 1.9 | 1.9 | 3.2 | 10.8 | 10.8 |
| A1 | 17-42 | 32-69 | 55-111 | 65-131 | 73-150 | 77-165 | 118-228 | 146-231 | 138-258 | 153-339 | 232-430 |
| A2 | 63-89 | 60-98 | 69-125 | 79-145 | 45-90 | 49-105 | 43-143 | 74-146 | 78-188 | 65-209 | 68-224 |
| A3 | 88-115 | 85-123 | 96-152 | 106-172 | 125-170 | 129-185 | 124-223 | 156-226 | 186-298 | 185-329 | 188-344 |
| A4 | 17-42 | 13-51 | 17-73 | 27-93 | 20-86 | 24-161 | 30-141 | 62-214 | 60-183 | 31-217 | 34-323 |
| A5 | 63-89 | 78-116 | 104-163 | 117-183 | 76-154 | 80-169 | 120-230 | 146-231 | 143-268 | 145-331 | 224-422 |
| A6 | 88-115 | 103-141 | 131-190 | 144-210 | 156-234 | 160-249 | 200-310 | 231-311 | 253-378 | 265-451 | 344-542 |
| J1 | 77-101 | 91-129 | 117-174 | 128-194 | 152-229 | 156-244 | 198-308 | 228-311 | 218-338 | 258-444 | 337-535 |
| J2 | 101-126 | 116-154 | 144-201 | 155-221 | 233-310 | 237-325 | 278-388 | 306-391 | 328-448 | 378-564 | 457-655 |
| J3 | 146-172 | 144-181 | 158-215 | 169-235 | 204-249 | 208-264 | 202-302 | 234-306 | 263-380 | 290-434 | 293-449 |
| J4 | 77-101 | 74-111 | 80-136 | 90-156 | 101-166 | 105-181 | 111-221 | 136-226 | 138-263 | 136-322 | 139-337 |
| J5 | 101-126 | 99-136 | 107-163 | 117-183 | 180-246 | 184-261 | 191-301 | 224-306 | 248-373 | 256-442 | 259-457 |
| J6 | 146-172 | 162-200 | 193-253 | 207-273 | 235-312 | 239-327 | 279-389 | 302-391 | 333-458 | 370-556 | 449-647 |
| S | 167 | 197 | 264 | 275 | 331 | 347 | 409 | 424 | 481 | 552 | 643 |

JAWS-CATALOG

Request or download:
www.smw-autoblok.de

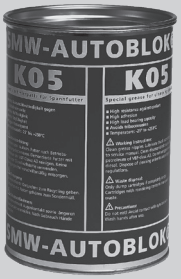
# Important for maintenance and safe operation, to be ordered with the chuck

## Grease K05®

**Special grease for manual and power chucks**

**Cartridge 14 Oz. (DIN 1284)**
**Grease content 500 g**
**Id. No. 016440**

**Can 1000 g**
**Id. No. 011881**




- High adhesion
- High resistance against coolant
- High load bearing capacity
- Low friction coefficient
- High gripping force
- Avoids tribocorrosion

## Grease gun

**Grease gun (DIN 1283) for cartridges 14 Oz. (DIN 1284)**
**■ Also refillable from grease can 1000 g.**

**Lubrication set Id. No. 083726**
Supply range
- Grease gun
- 1 Adapter flexible for high pressure grease nipple
- 1 Adapter for cone grease nipple

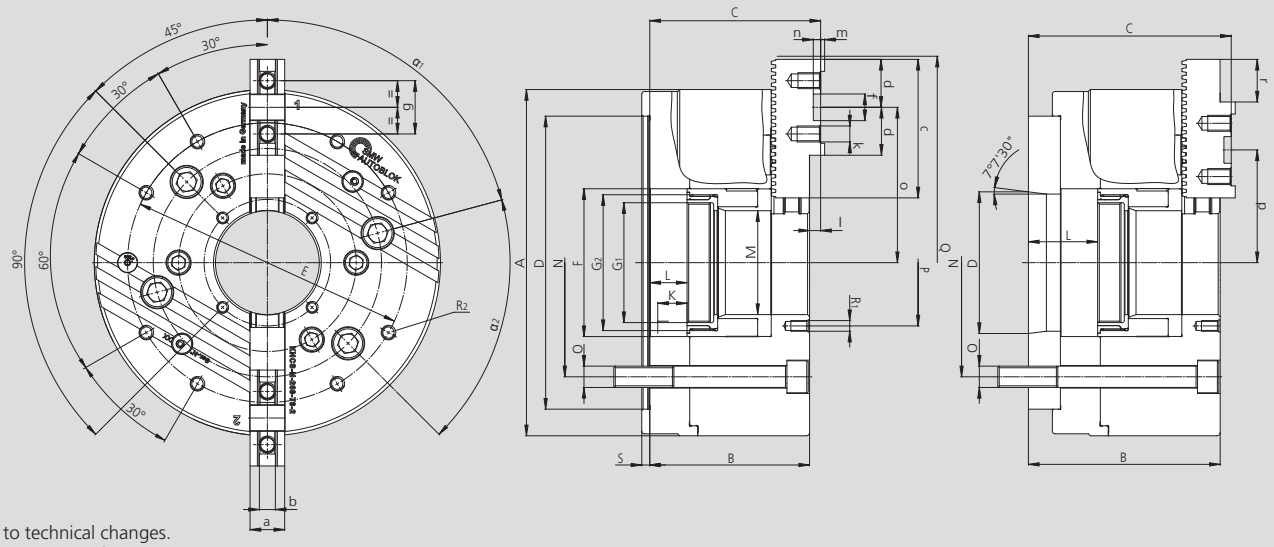
# KNCS®-N

**QUICK JAW CHANGE**
**2-JAW-CHUCK**

## Main dimensions and technical data

**Jaw position: open position for external clamping**

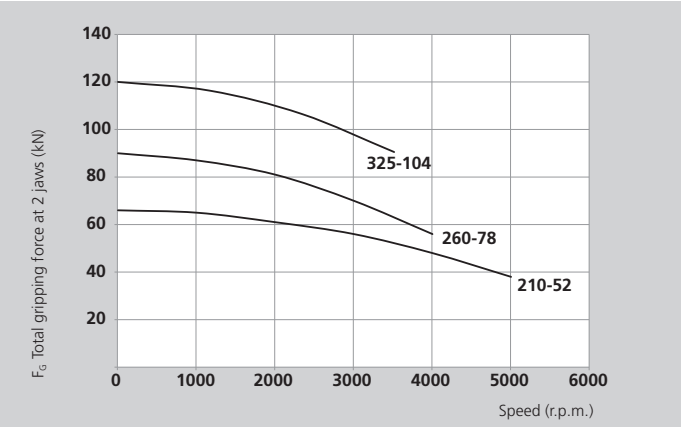
**Base jaw position „o"** **Base jaw position „p"**




Subject to technical changes.
For more detailed information please ask our customer service.

| **Type KNCS-N** | | **KNCS-N-210-52-2** | | | **KNCS-N-260-78-2** | | | | **KNCS-N-325-104-2** | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **Mounting** | | **Z170** | **A06** | **A08** | **Z170** | **Z220** | **A06** | **A08** | **Z220** | **Z300** | **A08** | **A11** |
| | **A** | 215 | | | 260 | | | | 324 | | | |
| | **B** | 105 | 122 | 124 | 120 | 120 | 137 | 139 | 129.9 | 129.9 | 148.9 | 150.9 |
| | **C** | 109.9 | 126.9 | 128.9 | 128.3 | 128.3 | 145.3 | 147.3 | 139.2 | 139.2 | 158.2 | 160.2 |
| | **D** H6 | 170 | 106.375 | 139.719 | 170 | 220 | 106.375 | 139.719 | 220 | 300 | 139.719 | 196.869 |
| | **E** | 168 | | | 210 | | | | 268 | | | |
| | **F** | 85 | | | 111 | | | | 144 | | | |
| Rotating ring nut / depth | **G1** | M60 x 1.5 / 16 | | | M90 x 2.0 / 20 | | | | M115 x 2.0 / 22 | | | |
| Piston thread / depth | **G2** | M75 x 2.0 / 19 | | | M102 x 2.0 / 23 | | | | M132 x 2.0 / 25 | | | |
| Piston stroke | **K** | 25 | | | 28 | | | | 28 | | | |
| Max. | **L** | 25 | 42 | 44 | 28 | 28 | 45 | 47 | 28.1 | 28.1 | 47.1 | 49.1 |
| | **M** | 52 | | | 78 | | | | 104 | | | |
| Fixing bolt circle | **N** | 133.4 | | 171.4 | 133.4 | 171.4 | 133.4 | 171.4 | 171.4 | 235.0 | 171.4 | 235.0 |
| Fixing bolt | **O** | M12 | | M16 | M12 | M16 | M12 | M16 | M16 | M20 | M16 | M20 |
| | **P** | 72 | | | 95 | | | | 130 | | | |
| Max. Ø | **Q** | 261 | | | 307 | | | | 385 | | | |
| Thread / thread depth | **R1** | M6 / 10 | | | M8 / 14 | | | | M10 / 16 | | | |
| Thread / thread depth | **R2** | M10 / 12 | | | M10 / 18 | | | | M10 / 16 | | | |
| | **S** | 6 | | | 6 | | | | 6 | | | |
| | **a** | 22 | | | 26 | | | | 32 | | | |
| | **b** f7 | 10 | | | 12 | | | | 12 | | | |
| | **c** | 85 | | | 104 | | | | 115 | | | |
| | **d** | 33 | | | 36 | | | | 36 | | | |
| | **f** H7 | 20 | | | 20 | | | | 20 | | | |
| | **g** | 40 | | | 40 | | | | 40 | | | |
| Thread / thread depth | **k** | M8 / 13 | | | M12 / 17 | | | | M12 / 17 | | | |
| | **l** | 4.9 | | | 8.3 | | | | 9.3 | | | |
| | **m** | 2.5 | | | 3 | | | | 3 | | | |
| | **n** | 4.5 | | | 5.5 | | | | 6 | | | |
| Max. / min. | **o** | 96.72 / 68.45 | | | 116.65 / 83.65 | | | | 155.783 / 106.301 | | | |
| Max. / min. | **p** | 77.74 / 49.47 | | | 84.66 / 51.66 | | | | 111.781 / 62.299 | | | |
| Base jaw tooth pitch | **-** | 4.7 | | | 5.5 | | | | 5.5 | | | |
| Base jaw offset | **r** | 28.27 | | | 32.988 | | | | 49.482 | | | |
| Base jaw offset | teeth | 6 | | | 6 | | | | 9 | | | |
| **α1 / α2** (for fixing bolts) | deg. | 73.5 / 60 | | | 75 / 60 | | | | 75 / 60 | | | |
| Stroke per jaw at piston stroke **K** | mm | 7 / 25 | | | 8 / 28 | | | | 8 / 28 | | | |
| Max. actuating force | kN | 35 | | | 47 | | | | 63 | | | |
| Max. total gripping | kN | 66 | | | 90 | | | | 120 | | | |
| Max. speed | r.p.m. | 5000 | | | 4000 | | | | 3500 | | | |
| Weight without jaws | kg | 27.8 | 29.3 | 30.0 | 45.1 | 44.5 | 46.6 | 47.3 | 72.3 | 77.3 | 75.2 | 82.8 |
| Moment of inertia | kg·m² | 0.17 | 0.18 | 0.19 | 0.41 | 0.41 | 0.43 | 0.44 | 1.09 | 1.17 | 1.11 | 1.26 |
| **Rec. closed center cylinder** | **Type** | **SIN-S 125 / 150** | | | **SIN-S 150 / 175** | | | | **SIN-S 150 / 175 / 200** | | | |
| **Rec. open center cylinder** | **Type** | **VNK-T2 130-52** | | | **VNK-T2 170-77** | | | | **VNK-T2 250-110** | | | |

## Gripping force diagram




The data in the diagrams refer to 2 jaw chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K05 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.

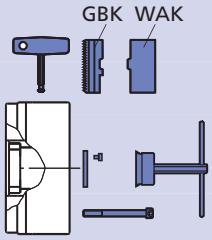
⚠ **Safety advice / danger of damage:**
When using taller / heavier jaws and / or clamping on a bigger diameter reduce draw pull / rotating speed accordingly.

## Ordering review

### KNCS-N + GBK + WAK

**Supply range:**
Chuck + key + mounting bolts + mounting key + 1 set hardened base jaws type GBK + 1 set soft top jaws type WAK + 1 set of coverplates

| Size / Spindle mounting | KNCS-N 210-52 | KNCS-N 260-78 | KNCS-N 325-104 |
|---|---|---|---|
| Centering rim small | - | Z 170 162014 | Z 220 161859 |
| Centering rim large | Z 170 162034 | Z 220 162015 | Z 300 161860 |
| A 06 | 162037 | 162020 | - |
| A 08 | 162040 | 162021 | 161861 |
| A 11 | - | - | 161862 |



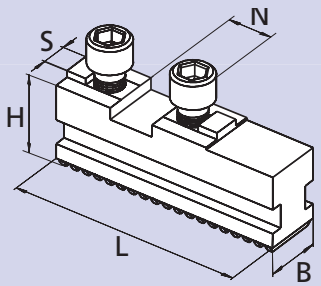
# KNCS®-N

QUICK JAW CHANGE
2-JAW-CHUCK

## Base jaws and top jaws

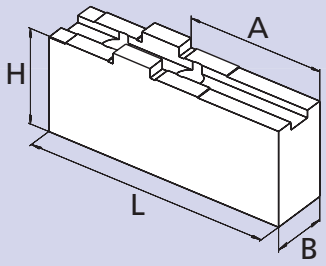
### GBK
**Hardened base jaws**

| KNCS-N | 210 | 260 | 325 |
|---|---|---|---|
| Jaw type | GBK 200 | GBK 250 | GBK 315 |
| Id. No. | 012440-2 | 012441-2 | 012442-2 |
| B | 22 | 26 | 32 |
| H | 29.5 | 37 | 43 |
| L | 85 | 104 | 115 |
| N | 20 | 20 | 20 |
| S | 10 | 12 | 12 |
| kg / set | 0.7 | 1.3 | 1.9 |



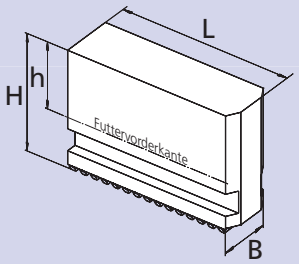

### WAK
**Soft top jaws**

| KNCS-N | 210 | 260 | 325 |
|---|---|---|---|
| Jaw type | WAK 200-10 | WAK 250-10 | WAK 250-10 |
| Id. No. | 012492-2 | 012493-2 | 012493-2 |
| B | 22 | 30 | 30 |
| H | 42 | 50 | 50 |
| L | 105 | 125 | 125 |
| A | 50 | 70 | 70 |
| kg / set | 1.3 | 2.5 | 2.5 |




### UVB
**Soft monoblock jaws**

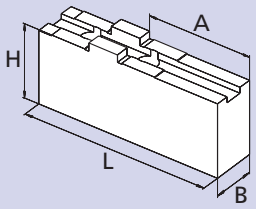
| KNCS-N | 210 | 260 | 325 |
|---|---|---|---|
| Jaw type | UVB 200 | UVB 250 | UVB 315 |
| Id. No. | 012448-2 | 012449-2 | 012450-2 |
| B | 22 | 26 | 32 |
| H | 70 | 90 | 100 |
| h | 45 | 61 | 66 |
| L | 83 | 108 | 119 |
| kg / set | 1.8 | 3.7 | 5.5 |



## Soft top jaws wide version

### WAKS
**Soft top jaws**
**Wide version**

| Type | Id. No. | B | H | L | A | kg / set | SMW-AUTOBLOK Chuck type |
|---|---|---|---|---|---|---|---|
| **WAKS 200-10** | 080934-2 | 30 | 51 | 100 | 57 | 2.1 | |
| **WAKS 200-20** | 080935-2 | 30 | 66 | 100 | 45 | 2.7 | |
| **WAKS 200-30** | 012497-2 | 40 | 36 | 70 | 27 | 1.4 | KNCS-N 210 |
| **WAKS 200-31** | 080936-2 | 40 | 56 | 85 | 43 | 2.7 | |
| **WAKS 200-32** | 036733-2 | 40 | 76 | 95 | 52 | 4.1 | |
| **WAKS 250-10** | 080937-2 | 40 | 55 | 125 | 70 | 3.8 | |
| **WAKS 250-11** | 080938-2 | 40 | 75 | 125 | 70 | 5.1 | |
| **WAKS 250-12** | 080939-2 | 40 | 95 | 125 | 70 | 6.5 | |
| **WAKS 250-13** | 080940-2 | 40 | 115 | 125 | 70 | 7.9 | |
| **WAKS 250-20** | 012498-2 | 60 | 55 | 90 | 44 | 4.2 | KNCS-N 260 |
| **WAKS 250-21** | 080942-2 | 60 | 55 | 110 | 60 | 3.2 | KNCS-N 325 |
| **WAKS 250-22** | 080943-2 | 60 | 75 | 90 | 44 | 5.7 | |
| **WAKS 250-23** | 080944-2 | 60 | 75 | 110 | 60 | 7.0 | |
| **WAKS 250-30** | 012499-2 | 80 | 55 | 90 | 44 | 5.8 | |
| **WAKS 250-31** | 080945-2 | 80 | 75 | 110 | 60 | 9.7 | |

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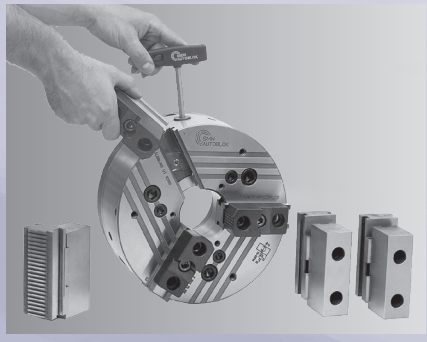
# Fast changeover, fast payback:

# The original quick jaw change power chuck

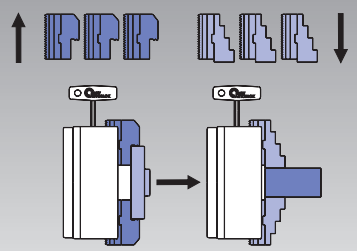


## KNCS®-NB LARGE THROUGH HOLE

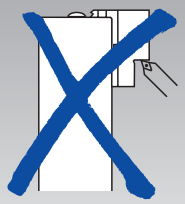
## KNCS®-NBX EXTRA LARGE THROUGH HOLE

**>> ALL EXISTING TOP JAWS CAN BE USED**

### Minimal set-up times
Jaw change in less than 1 minute



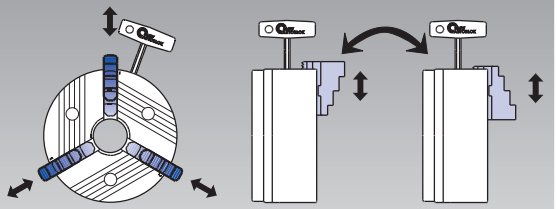
### High repeatability when changing jaws
No reboring of already machined jaws necessary, because runout < 0.02 mm (KNCS-NB 210)



Extra long, symmetrical and wide jaw guides.
Ideal for O.D. or I.D. gripping

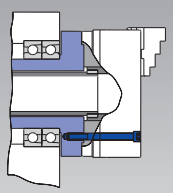
Unique **wedge bar drive for high speed**.
Minimum loss of gripping force because of tangentially supported wedge bars.
Minimum increase of gripping force **(hysteresis)** after quick spindle stop.
**High efficiency** of the wedge bar drive ensures highest concentricity and **repeatability**.
Suitable for **high-low clamping**

### Flexibility jaws can be radially adjusted and are reversible = **less jaw sets**



Jaws radially adjustable — Jaws 180° reversed

### Direct mounting



Recess and bolt circle to DIN 55026

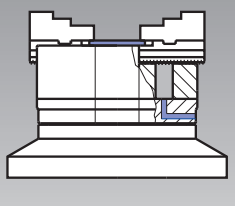
Original SMW-AUTOBLOK quick **jaw change**.
**Jaw change accuracy** with patented **jaw safety interlock**

### Profitability
Example set-up times/costs

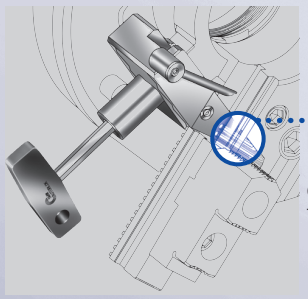
| | Conventional chuck | KNCS®-NB |
|---|---|---|
| Jaw change | 10 Min. | 1 Min. |
| Reboring of jaws | 20 Min. | 0 Min. |
| Ø jaw changes / day | 2 | 2 |
| Working days / year | 230 | 230 |
| Machine costs / hour | $ 60.– | $ 60.– |
| Total costs / year | $ 13800.– | $ 460.– |
| **Profit*** | | **$ 13340.–** |

* If jaws are changed more often, the profitability is increased accordingly.

### Vertical application



Version for vertical application with cover and drain holes for coolant available

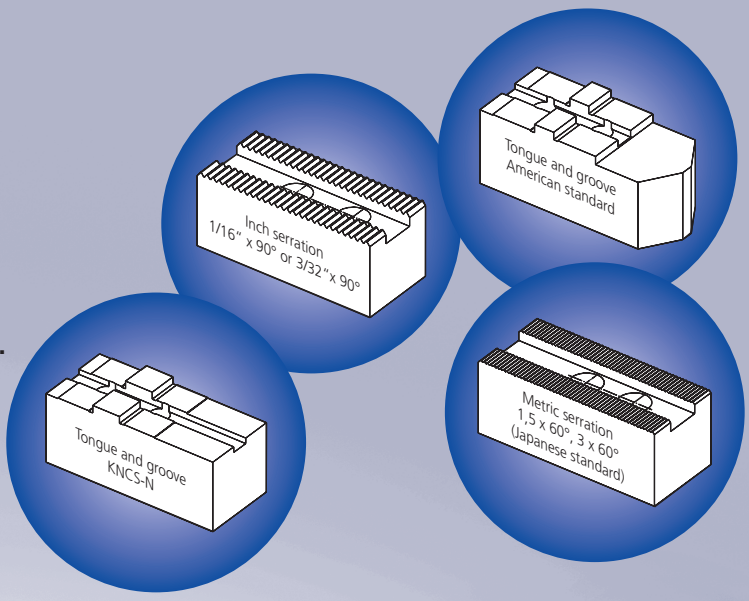


If the serration is not fully engaged – the jaw safety interlock is active

# Less costs by using all existing top jaws from:

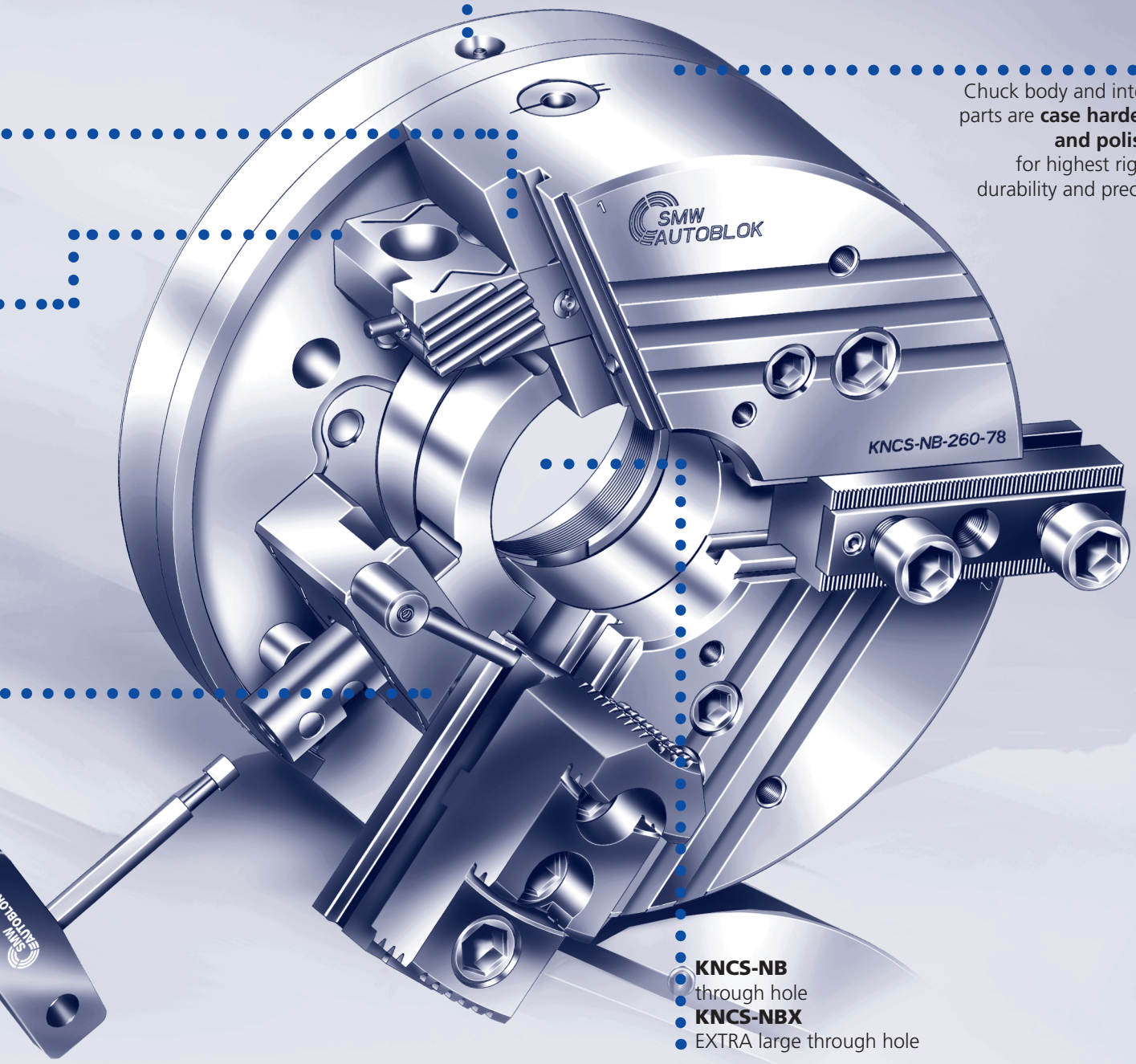
- SMW-AUTOBLOK
- Autoblok
- Buck
- Forkardt
- Gamet
- Howa
- Kitagawa
- Logansport
- Mario Pinto
- Matsumoto
- Pratt Burnerd
- Röhm
- Rotomors
- Schunk
- Berg
- Woodworth

**If your jaw type is not included, please contact us.**




Easy lubrication even on vertical machines with 3 radial built-in grease fittings

Chuck body and internal parts are **case hardened and polished** for highest rigidity, durability and precision

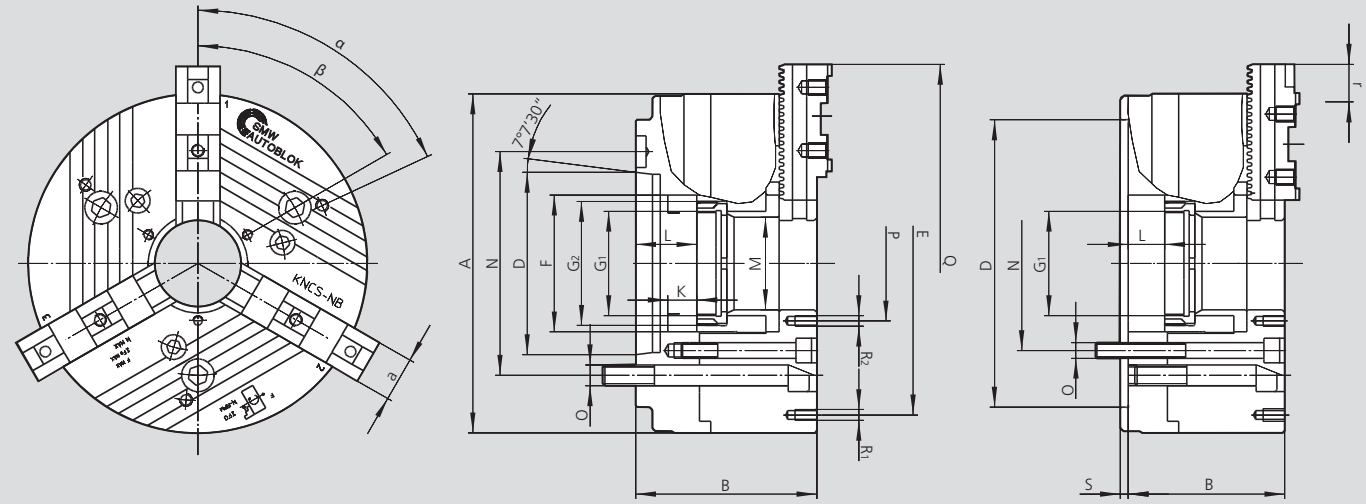



**KNCS-NB**
through hole
**KNCS-NBX**
EXTRA large through hole

# KNCS®-NB

**QUICK JAW CHANGE**
**Wide master jaws**

## Main dimensions and technical data

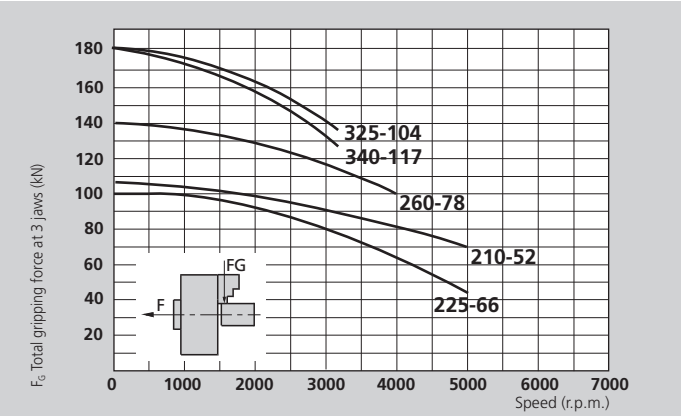


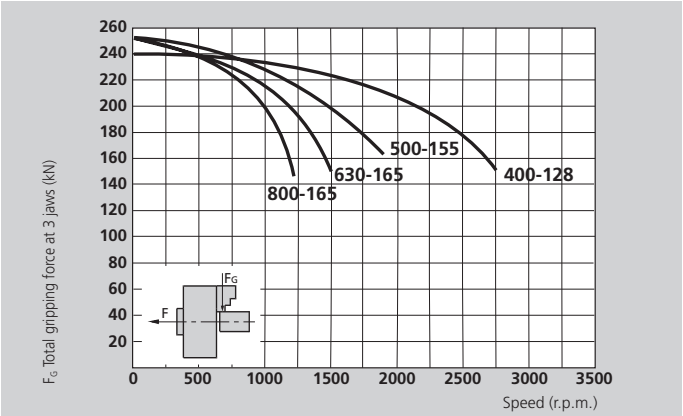

Subject to technical changes.
Dimensions and position of base jaws are depending on top jaw type.
For more detailed information please ask our customer service

| SMW-AUTOBLOK Type | | KNCS-NB 210-52 | | | KNCS-NB 225-66 | | | KNCS-NB 260-78 | | | | KNCS-NB 275-86 | | | KNCS-NB 325-104 | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **Mounting** | **Size** | **Z170** | **A6** | **A8** | **Z170** | **A6** | **A8** | **Z170** | **Z220** | **A6** | **A8** | **Z220** | **A6*** | **A8** | **Z220** | **Z300** | **A8** | **A11** |
| | **A** | 215 | | | 225 | | | 260 | | | | 275 | | | 324 | | | |
| | **B** | 105 | 122 | 124 | 105 | 122 | 124 | 120 | 120 | 137 | 139 | 120 | 144 | 139 | 130 | 130 | 149 | 151 |
| | **D** H6 | 170 | 106.39 | 139.73 | 170 | 106.39 | 139.73 | 170 | 220 | 106.39 | 139.73 | 220 | 106.39 | 139.73 | 220 | 300 | 139.73 | 196.88 |
| | **E** | 168 | | | 180 | | | 210 | | | | 210 | | | 268 | | | |
| | **F** | 85 | | | 95 | | | 111 | | | | 122 | | | 144 | | | |
| Threaded ring / depth | **G1** | M60 x 1.5 / 16 | | | M75 x 1.5 / 16 | | | M90 x 2 / 20 | | | | M95 x 2 / 20 | | | M115 x 2 / 22 | | | |
| Piston thread / depth | **G2** | M75 x 2 / 19 | | | M85 x 2 / 19 | | | M102 x 2 / 23 | | | | M110 x 2 / 23 | | | M132 x 2 / 25 | | | |
| Piston stroke | **K** | 22 | | | 22 | | | 25 | | | | 25 | | | 25 | | | |
| Max. | **L** | 25 | 42 | 44 | 25 | 42 | 44 | 28 | 28 | 45 | 47 | 28 | 52 | 47 | 28 | 28 | 47 | 49 |
| | **M** | 52 | | | 66 | | | 78 | | | | 86 | | | 104 | | | |
| Fixing bolt circle | **N** | 133.4 | 133.4 | 171.4 | 133.4 | 133.4 | 171.4 | 133.4 | 171.4 | 133.4 | 171.4 | 171.4 | 133.4 | 171.4 | 171.4 | 235 | 171.4 | 235 |
| Fixing bolt | **O** | M12 | M12 | M16 | M12 | M12 | M16 | M12 | M16 | M12 | M16 | M16 | M12 | M16 | M16 | M20 | M16 | M20 |
| | **P** | 72 | | | 82 | | | 95 | | | | 105 | | | 130 | | | |
| | **Q** | 261 | | | 271 | | | 318 | | | | 322 | | | 376 | | | |
| Thread / thread depth | **R1** | M10 / 12 | | | M10 / 12 | | | M10 / 12 | | | | M10 / 18 | | | M10 / 12 | | | |
| Thread / thread depth | **R2** | M6 / 10 | | | M6 / 10 | | | M8 / 14 | | | | M8 / 14 | | | M10 / 12 | | | |
| | **S** | 6 | | | 6 | | | 6 | | | | 6 | | | 6 | | | |
| | **a** | 28 | | | 28 | | | 35 | | | | 35 | | | 50 | | | |
| Base jaw tooth pitch | **-** | 4.7 | | | 4.7 | | | 5.5 | | | | 5.5 | | | 5.5 | | | |
| Base jaw offset | **r** | 28.3 | | | 33 | | | 33 | | | | 38.5 | | | 49.5 | | | |
| Base jaw offset | teeth | 6 | | | 7 | | | 6 | | | | 7 | | | 9 | | | |
| α | deg. | 60 | | | 60 | | | 60 | | | | 60 | | | 60 | | | |
| β | deg. | 60 | | | 60 | | | 60 | | | | 60 | | | 60 | | | |
| Stroke per jaw at piston stroke **K** max. | mm | 6.0 | | 22 | 6.0 | | 22 | 7.0 | | | 25 | 7.0 | | 25 | 7.0 | | | 25 |
| Max. actuating force 3-jaw chuck | kN | 53 | | | 53 | | | 70 | | | | 70 | | | 95 | | | |
| Max. total gripping force 3-jaw chuck | kN | 100 | | | 100 | | | 135 | | | | 135 | | | 180 | | | |
| Max. speed 3-jaw chuck | r.p.m. | 5000 | | | 5000 | | | 4000 | | | | 4000 | | | 3300 | | | |
| Weight without jaws | kg | 24 | 26 | 26 | 26 | 29 | 29 | 40 | 40 | 43 | 43 | 48 | 53 | 50.7 | 65 | 65 | 68 | 68 |
| Moment of inertia | kg·m² | 0.11 | | | 0.21 | | | 0.38 | | | | 0.41 | | | 0.85 | | | |
| Rec. closed center cylinder | Type | **SIN-S 125 / 150** | | | **SIN-S 125 / 150** | | | **SIN-S 150 / 175** | | | | **SIN-S 150 / 175** | | | **SIN-S 150 / 175 / 200** | | | |
| Rec. open center cylinder | Type | **VNK-T2 130-52** | | | **VNK-T2 150-67** | | | **VNK-T2 170-77** | | | | **VNK-T2 225-95** | | | **VNK-T2 250-110** | | | |

* Indirect mounting by reducing flange.

## For highest speeds: flat gripping force curve




The data in the diagrams refer to 3 jaw chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K05 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.

| SMW-AUTOBLOK Type | | KNCS-NB340-117 | | | KNCS-NB 400-128 | | | | KNCS-NB 500-155 | | | | KNCS-NB 630-165 | | | KNCS-NB 800-165 | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **Mounting** | **Size** | **Z300** | **A8*** | **A11** | **Z300** | **Z380** | **A11** | **A15** | **Z300** | **Z380** | **A11** | **A15** | **Z380** | **A11*** | **A15** | **Z520** | **A15*** | **A20** |
| | **A** | 340 | | | 400 | | | | 500 | | | | 630 | | | 800 | | |
| | **B** | 130 | 160 | 151 | 140 | 140 | 161 | 163 | 174 | 174 | 195 | 197 | 174 | 214 | 197 | 174 | 214 | 199 |
| | **D**H6 | 300 | 139.73 | 196.88 | 300 | 380 | 196.88 | 285.77 | 300 | 380 | 196.88 | 285.77 | 380 | 196.88 | 285.77 | 520 | 285.77 | 412.8 |
| | **E** | 270 | | | 330 | | | | 420 | | | | 420 / 585 | | | 420 / 585 / 750 | | |
| | **F** | 160 | | | 180 | | | | 207 | | | | 217 | | | 217 | | |
| Threaded ring / depth | **G1** | M125 x 2 / 22 | | | M138 x 2 / 22 | | | | M165 x 2 / 25 | | | | M175 x 2 / 25 | | | M175 x 2 / 25 | | |
| Piston thread / depth | **G2** | M146 x 2 / 25 | | | M160 x 2 / 25 | | | | M185 x 2 / 28 | | | | M195 x 2 / 28 | | | M195 x /2 / 28 | | |
| Piston stroke | **K** | 25 | | | 32 | | | | 42 | | | | 42 | | | 42 | | |
| Max. | **L** | 28 | 58 | 49 | 32 | 32 | 53 | 55 | 42 | 42 | 63 | 65 | 42 | 82 | 65 | 42 | 82 | 67 |
| | **M** | 117 | | | 128 | | | | 155 | | | | 165 | | | 165 | | |
| Fixing bolt circle | **N** | 235 | 171.4 | 235 | 235 | 330.2 | 235 | 330.2 | 235 | 330.2 | 235 | 330.2 | 330.2 | 235* | 330.2 | 463.6 | 330.2* | 463.6 |
| Fixing bolt | **O** | M20 | M16 | M20 | M20 | M24 | M20 | M24 | M20 | M24 | M20 | M24 | M24 | M20* | M24 | M24 | M24* | M24 |
| | **P** | 140 | | | 152 | | | | 180 | | | | 195 | | | 195 | | |
| | **Q** | 380 | | | 455 | | | | 554 | | | | 650 | | | 817 | | |
| Thread / thread depth | **R1** | M10 / 16 | | | M12 / 18 | | | | M16 / 25 | | | | M16 / 25 | | | M16 / 25 | | |
| Thread / thread depth | **R2** | M10 / 16 | | | M12 / 18 | | | | M12 / 18 | | | | M12 / 18 | | | M12 / 18 | | |
| | **S** | 6 | | | 8 | | | | 8 | | | | 8 | | | 8 | | |
| | **a** | 50 | | | 50 | | | | 62 | | | | 75 | | | 75 | | |
| Base jaw tooth pitch | **-** | 5.5 | | | 5.5 | | | | 7 | | | | 7 | | | 7 | | |
| Base jaw offset | **r** | 49.5 | | | 60.5 | | | | 77 | | | | 91 | | | 91 | | |
| Base jaw offset | teeth | 9 | | | 11 | | | | 11 | | | | 13 | | | 13 | | |
| α | deg. | 60 / 35 | | | 60 / 35 | | | | 20 / 9 x 40 | | | | 20 / 9 x 40 | | | 20 / 9 x 40 | | |
| β | deg. | 60 / 35 | | | 60 / 35 | | | | 20 / 9 x 40 | | | | 20 / 9 x 40 | | | 20 / 9 x 40 | | |
| Stroke per jaw at piston stroke **K** max. | mm | 7.0 | | 25 | 8.0 | | | 32 | 10.0 | | | 42 | 10.0 | | 42 | 10.0 | | 42 |
| Max. actuating force 3-jaw chuck | kN | 95 | | | 115 | | | | 120 | | | | 120 | | | 120 | | |
| Max. total gripping force 3-jaw chuck | kN | 180 | | | 240 | | | | 250 | | | | 250 | | | 250 | | |
| Max. speed 3-jaw chuck | r.p.m. | 3300 | | | 2750 | | | | 1800 | | | | 1500 | | | 1200 | | |
| Weight without jaws | kg | 77 | 88.5 | 82.5 | 111 | 111 | 116 | 116 | 225 | 225 | 231 | 231 | 390 | 411 | 398 | 620 | 660 | 635 |
| Moment of inertia | kg·m² | 1.24 | | | 2.5 | | | | 6.5 | | | | 18 | | | 27 | | |
| Rec. closed center cylinder | Type | **SIN-S 150 / 175 / 200** | | | **SIN-S 175 / 200** | | | | **SIN-S 175 / 200** | | | | **SIN-S 175 / 200** | | | **SIN-S 175 / 200** | | |
| Rec. open center cylinder | Type | **VNK-T2 320-127** | | | **VNK-T2 320-127** | | | | **VSG 450-165** | | | | **VSG 450-165** | | | **VSG 450-165** | | |

* Indirect mounting by reducing flange.

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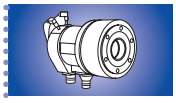
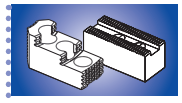
SMW-AUTOBLOK 438


SMW-AUTOBLOK 297

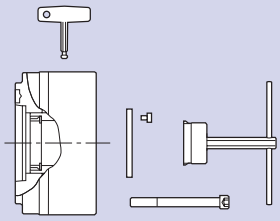
SMW-AUTOBLOK 22


SMW-AUTOBLOK 440

# KNCS®-NB

## QUICK JAW CHANGE
## Wide master jaws

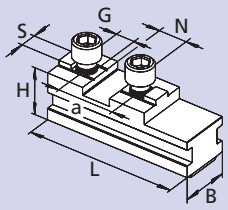
## Ordering review



| Size / Spindle mounting | KNCS-NB 210-52 | KNCS-NB 225-66 | KNCS-NB 260-78 | KNCS-NB 275-86 | KNCS-NB 325-104 | KNCS-NB 340-117 | KNCS-NB 400-128 | KNCS-NB 500-155 | KNCS-NB 630-165 | KNCS-NB 800-165 |
|---|---|---|---|---|---|---|---|---|---|---|
| Centering rim small | | | Z170 064645 | | Z220 064695 | | Z300 064303 | Z300 064306 | | |
| Centering rim large | Z170 064334 | Z170 069790 | Z220 064646 | Z220 069660 | Z300 064715 | Z300 069665 | Z380 063950 | Z380 064307 | Z380 064548 | Z520 064579 |
| A 05 | | | | | | | | | | |
| A 06 | 064610 | 069791 | 064669 | 069661 | | | | | | |
| A 08 | 064611 | 069792 | 064670 | 069662 | 064716 | 069666 | | | | |
| A 11 | | | | | 064723 | 069667 | 064304 | 064308 | 064577 | |
| A 15 | | | | | | | 064305 | 064309 | 064549 | 064615 |
| A 20 | | | | | | | | | | 064616 |

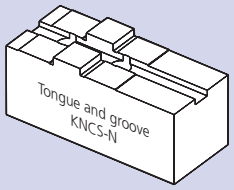
### Supply range
Chuck + disengaging key + mounting bolts + mounting key + 1 set of coverplates
without base jaws, without top jaws

**Base jaw type**



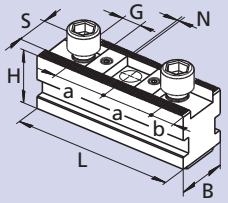

## GBK-B
TONGUE & GROOVE KNCS-N standard

**Existing top jaw**



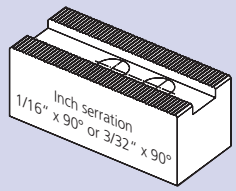

| KNCS-NB | 210-52/225-66 | 260-78/275-86 | 325-104/340-117 | 400-128 | 500-155 | 630-165 | 800-165 |
|---|---|---|---|---|---|---|---|
| Id. No. | 138494 | 039624 | 039626 | 039629 | 035565 | 035902 | 064604 |
| B | 28 | 35 | 50 | 50 | 62 | 75 | 75 |
| H | 32 | 40 | 45.8 | 45.8 | 57 | 57 | 57 |
| L | 85 | 104 | 115 | 125 | 160 | 200 | 287 |
| N | 20 | 20 | 20 | 26 | 30 | 30 | 30 (2x) |
| S | 10 | 12 | 12 | 12 | 18 | 18 | 18 |
| G (metric) | M8 | M12 | M12 | M12 | M16 | M16 | M16 |
| a | 40 | 40 | 40 | 54 | 60 | 60 | 2 x 60 |

**Base jaw type**




## GBK-BD
INCH SERRATED (for SMW-AUTOBLOK standard jaws)

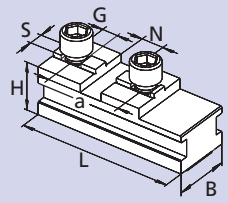
**Existing top jaw**




| KNCS-NB | 210-52/225-66 | 260-78/275-86 | 325-104/340-117 | 400-128 | 500-155 | 630-165 | 800-165 |
|---|---|---|---|---|---|---|---|
| Id. No. | 036292 | 035704 | 036167 | 036293 | 036294 | 036295 | 036296 |
| B | 28 | 35 | 50 | 50 | 62 | 75 | 75 |
| H | 32 | 40 | 45.8 | 45.8 | 61 | 61 | 61 |
| L | 85 | 104 | 115 | 125 | 160 | 200 | 287 |
| N | 1/16" x 90° | 1/16" x 90° | 1/16" x 90° | 3/32" x 90° | 3/32" x 90° | 3/32" x 90° | 3/32" x 90° |
| S (ridge) | 17 | 21 | 21 | 25.5 | 25.5 | 25.5 | 25.5 |
| G | M12 | M16 | M16 | M20 | M20 | M20 | M20 |
| a | 2 x 23 | 30 / 28* | 30 / 28* | 2 x 38 | 38 / 49 / 38 | 38/38/52/38 | 3x38/60.7/2x38 |
| b | 11 | 14 | 14 | 17 | 17 | 18 | 17.5 |

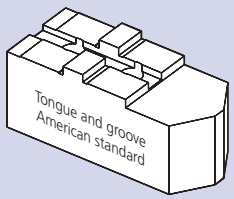
* 30 / 30 on request.

**Base jaw type**



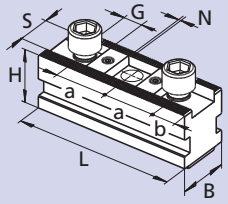

## GBK-BA
TONGUE & GROOVE American standard

**Existing top jaw**



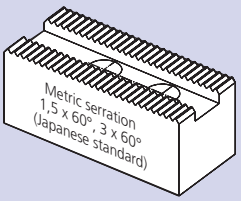

| KNCS-NB | 210-52/225-66 | 260-78/275-86 | 325-104/340-117 | 400-128 | 500-155 | 630-165 | 800-165 |
|---|---|---|---|---|---|---|---|
| Id. No. | - | - | 039628 | 039631 | 060561 | 060562 | 064590 |
| B | - | - | 50 | 50 | 62 | 75 | 75 |
| H | - | - | 45.8 | 45.8 | 57 | 57 | 57 |
| L | - | - | 120 | 146 | 168 | 203 | 287 |
| N | - | - | 19.02 | 19.02 | 19.02 | 19.02 | 19.02 (2x) |
| S | - | - | 12.7 | 12.7 | 12.7 | 12.7 | 12.7 |
| G (inch) | - | - | 5/8-11 | 3 / 4-10 | 3 / 4-10 | 3 / 4-10 | 3 / 4-10 |
| a | - | - | 63.5 | 76.2 | 76.2 | 76.2 | 2 x 76.2 |

**Base jaw type**



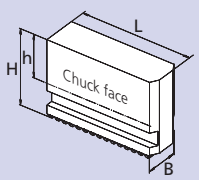

## GBK-BM
METRIC SERRATION

**Existing top jaw**




| KNCS-NB | 210-52/225-66 | 260-78/275-86 | 325-104/340-117 | 400-128 | 500-155 | 630-165 | 800-165 |
|---|---|---|---|---|---|---|---|
| Id. No. | 035566 | 035567 | 035568 | 035569 | 035570 | 035917 | 036708 |
| B | 28 | 35 | 50 | 50 | 62 | 75 | 75 |
| H | 32 | 40 | 45.8 | 45.8 | 61 | 61 | 61 |
| L | 85 | 104 | 115 | 125 | 160 | 200 | 287 |
| N | 1.5 x 60° | 1.5 x 60° | 1.5 x 60° | 1.5 x 60° | 3 x 60° | 3 x 60° | 3 x 60° |
| S | 14 | 16 | 21 | 22 | 25 | 25 | 25 |
| G (metric) | M12 | M12 | M16 | M20 | M20 | M20 | M20 |
| a | 2 x 25 | 2 x 30 | 2 x 30 | 2 x 43 | 50/ 60 | 60/60/70.5/60 | 4 x 60 |
| b | 11 | 11 | 14 | 17 | 17 | 17 | 17.5 |

**Jaw type**




## UVB-B
Soft wide monoblock jaws

| KNCS-NB | 210/225 | 260/275 | 325/340 | 400 | 500 | 630/800 |
|---|---|---|---|---|---|---|
| Jaw type | UVB-B 210 | UVB-B 250 | UVB-B 315 | UVB-B 400 | UVB-B 500 | UVB-B 630 |
| Id. No. | 534337 | 238910 | 238911 | 238740 | 238912 | 5301060 |
| B | 28 | 35 | 50 | 50 | 62 | 75 |
| H | 80 | 110 | 115 | 125 | 160 | 160 |
| h | 55 | 81 | 60 | 60 | 105 | 105 |
| L | 85 | 109.5 | 120.5 | 148 | 175 | 230 |
| kg / set | 4.2 | 9.4 | 18.5 | 20.7 | 38.8 | 61.5 |

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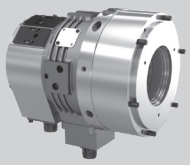
# Actuating cylinders with and without through hole

## VNK-T2

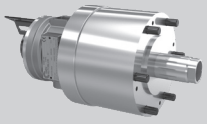


Hydraulic open center cylinder with built-in safety valves, piston stroke control and coolant collector (pmax. = 45 bar)

## SIN-S

Hydraulic closed center cylinder with built-in safety valves and piston stroke control. Central through hole for air or coolant (pmax. = 70 bar)

## SIN-HL



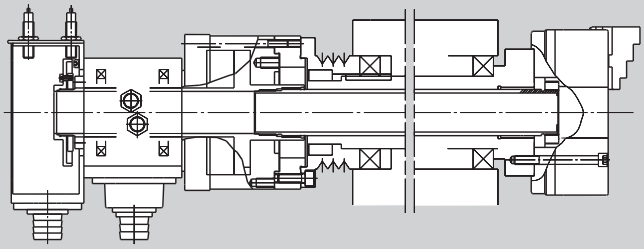
Hydraulic closed center cylinder for high-low clamping with built-in safety valves and piston stroke control. Central through hole for air, oil or coolant (pmax. = 70 bar)

| SMW-AUTOBLOK Type | | VNK-T2 130/52 | VNK-T2 170/77 | VNK-T2 225/95 | VNK-T2 320/127 | VSG 450/165 | SIN-S 125 | SIN-S 150 | SIN-S 175 | SIN-S 200 | SIN-HL 100 | SIN-HL 125 | SIN-HL 150 | SIN-HL 175 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Draw pull max. | kN | 58 | 76 | 100 | 123 | 138 | 71 | 108 | 150 | 196 | 49 | 77 | 108 | 154 |
| $n_{max.}$ | r.p.m. | 6300 | 5000 | 4000 | 3200 | 2000 | 6000 | 6000 | 5000 | 4000 | 7000 | 6000 | 6000 | 5000 |
| Through hole | mm | 52.5 | 77 | 95.5 | 127.5 | 165 | - | - | - | - | - | - | - | - |

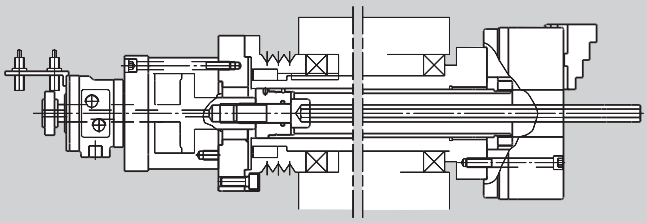
For more technical information see general catalog page 297.

# Examples for assembly

## Open center with VNK-T2

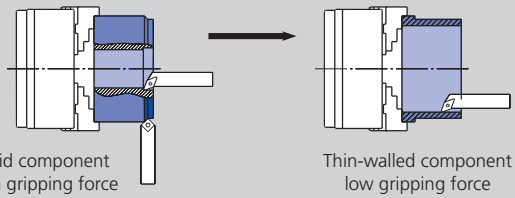


## Partial open center with SIN-S / SIN-HL



# High-low clamping for thin-walled components

## Principle



Solid component high gripping force

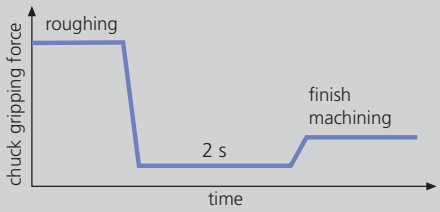
Thin-walled component low gripping force

For easily deformable components SMW-AUTOBLOK offers "high-low" clamping.

The gripping force of the chuck can be reduced from a large amount of gripping force used in roughing, to a smaller amount of gripping force for a finishing cut without unclamping the component.

The SMW-AUTOBLOK closed center cylinder type SIN-HL and a modification of the machine hydraulic are necessary.

## Function




In combination with a SMW-AUTOBLOK "high-low" hydraulic cylinder SIN-HL and suitable machine hydraulics, the KNCS-NB / KNCS-NBX wedge bar system allows a monitored reduction of gripping force.

The component remains clamped in the chuck, however, the stress of the component can be released.
The "high-low" cycle is programmable and is finished completely within 2 - 4 sec.

## Result

Without "high-low" clamping

With "high-low" clamping

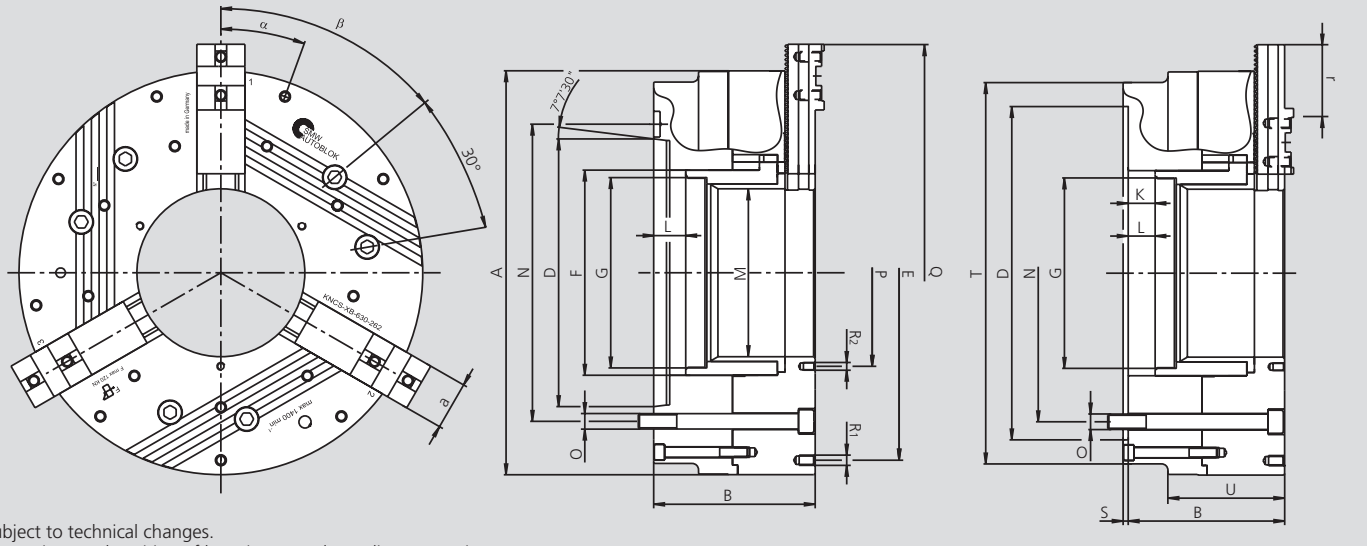
The result are round components with a minimum of deformation.

**For additional information please ask our engineers.**

# KNCS®-NBX

**QUICK JAW CHANGE**
**Wide master jaws**

- **Main dimensions and technical data**
- **EXTRA large through hole**




Subject to technical changes.
Dimensions and position of base jaws are depending on top jaw type.
For more detailed information please ask our customer service.

| SMW-AUTOBLOK Type | | KNCS-NBX 425-170 | | | KNCS-NBX 530-210 | | | KNCS-NBX 630-262 | | | KNCS-NBX 800-262 | | | KNCS-NBX 1000-262 | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **Mounting** | **Size** | **Z380** | **A11** | **A15** | **Z380** | **A11** | **A15** | **Z520** | **A15** | **A20** | **Z520** | **A15** | **A20** | **Z520** | **A15*** | **A20** |
| | **A** | 425 | | | 530 | | | 630 | | | 800 | | | 1000 | | |
| | **B** | 197 | 237 | 220 | 244 | 284 | 267 | 244 | 284* | 269 | 244 | 284* | 269 | 244 | 284* | 269 |
| | **D** H6 | 380 | 196.88 | 285.77 | 380 | 196.88 | 285.77 | 520 | 285.77 | 412.77 | 520 | 285.77 | 412.77 | 520 | 285.77 | 412.77 |
| | **E** | 330.2 | | | 420 | | | 420 / 585 | | | 420 / 585 / 750 | | | 420 / 585 / 750 / 915 | | |
| | **F** | 222 | | | 262 | | | 320 | | | 320 | | | 320 | | |
| Piston thread / depth | **G** | M202 x 2 / 25 | | | M240 x 2 / 28 | | | M297 x 2 / 33 | | | M297 x 2 / 33 | | | M297 x 2 / 33 | | |
| Piston stroke | **K** | 32 | | | 42 | | | 42 | | | 42 | | | 42 | | |
| Max. | **L** | 32 | 72 | 55 | 42 | 82 | 55 | 42 | 82 | 67 | 42 | 82 | 67 | 42 | 82 | 67 |
| | **M** | 170 | | | 210 | | | 262 | | | 262 | | | 262 | | |
| Fixing bolt circle | **N** | 330.2 | 235.0 | 330.2 | 330.2 | 235.0 | 30.2 | 463.6 | 330.2* | 463.6 | 463.6 | 330.2* | 463.6 | 463.6 | 330.2* | 463.6 |
| Fixing bolt | **O** | M24 | M20 | M24 | M24 | M20 | M24 | M24 | M24* | M24 | M24 | M24* | M24 | M24 | M24* | M24 |
| | **P** | 195 | | | 235 | | | 292 | | | 292 | | | 292 | | |
| | **Q** | 487 | | | 598 | | | 745 | | | 915 | | | 1107 | | |
| Thread / thread depth | **R1** | M12 /16 | | | M16 / 25 | | | M16 / 25 | | | M16 / 25 | | | M16 / 25 | | |
| Thread / thread depth | **R2** | M12 / 16 | | | M16 / 25 | | | M12 / 18 | | | M12 / 18 | | | M12 / 18 | | |
| | **S** | 8 | | | 8 | | | 8 | | | 8 | | | 8 | | |
| | **T** | 412 | | | 490 | | | 595 | | | 600 | | | 600 | | |
| | **U** | 137 | | | 167 | | | 182 | | | 182 | | | 182 | | |
| | **a** | 50 | | | 62 | | | 75 | | | 75 | | | 75 | | |
| Base jaw tooth pitch | **-** | 5.5 | | | 7 | | | 7 | | | 7 | | | 7 | | |
| Base jaw offset | **r** | 49.5 | | | 70 | | | 119 | | | 133 | | | 133 | | |
| Base jaw offset | teeth | 9 | | | 10 | | | 17 | | | 19 | | | 19 | | |
| α | deg. | 15° / 12 x 30° | | | 20° / 9 x 40° | | | 20° / 9 x 40° | | | 20° / 9 x 40° | | | 20° / 9 x 40° | | |
| β | deg. | 60 | | | 60 | | | 60 | | | 60 | | | 60 | | |
| Stroke per jaw at piston stroke **K** max. | mm | 8 | | 32 | 10 | | 42 | 10 | | 42 | 10 | | 42 | 10 | | 42 |
| Max. actuating force 3-jaw chuck | kN | 115 | | | 120 | | | 120 | | | 120 | | | 120 | | |
| Max. total gripping force 3-jaw chuck | kN | 240 | | | 250 | | | 250 | | | 250 | | | 250 | | |
| Max. speed 3-jaw chuck | r.p.m. | 2500 | | | 1500 | | | 1400 | | | 1000 | | | 850 | | |
| Weight without jaws | kg | 164 | | | 320 | | | 395 | | | 635 | | | 985 | | |
| Moment of inertia | kg·m² | 4.3 | | | 13 | | | 23 | | | 54 | | | 125 | | |
| Rec. closed center cylinder | Type | **SIN-S 175 / 200** | | | **SIN-S 175 / 200** | | | **SIN-S 175 / 200** | | | **SIN-S 175 / 200** | | | **SIN-S 175 / 200** | | |
| Rec. open center cylinder | Type | **VSG 450-165** | | | **VSG 550-205** | | | **VSG 550-205** | | | **VSG 550-205** | | | **VSG 550-205** | | |

* Indirect mounting by reducing flange.

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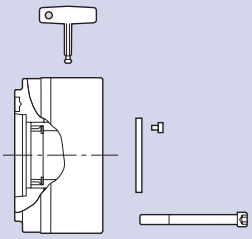
# KNCS®-NBX

**QUICK JAW CHANGE**
**Wide master jaws**

## ■ Ordering review

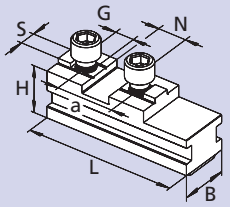


| Spindle mounting \ Size | KNCS-NBX 425-170 | KNCS-NBX 530-210 | KNCS-NBX 630-262 | KNCS-NBX 800-262 | KNCS-NBX 1000-262 |
|---|---|---|---|---|---|
| Centering rim | Z380 | Z380 | Z520 | Z520 | Z520 |
| large | 160080 | 160090 | 069760 | 069770 | 069780 |
| A 11 | 160081 | 160091 | | | |
| A 15 | 160082 | 160092 | 069768 | 069778 | 069788 |
| A 20 | | | 069769 | 069779 | 069789 |

### Supply range

Chuck + disengaging key + mounting bolts + mounting key + set of coverplates, without base jaws, without top jaws

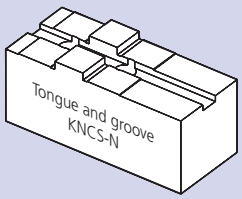
**Base jaw type**




## GBK-B

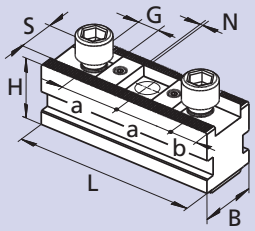
TONGUE & GROOVE KNCS-N standard

**Existing top jaw**




| KNCS-NBX | 425-170 | 530-210 | 630-262 | 800-262 | 1000-262 |
|---|---|---|---|---|---|
| Id. No. | 039629 | 035565 | 035902 | 064604 | 069806 |
| B | 50 | 62 | 75 | 75 | 75 |
| H | 45.8 | 57 | 57 | 57 | 57 |
| L | 125 | 160 | 200 | 286 | 384 |
| N | 26 | 30 | 30 | 30 (2x) | 30 (3x) |
| S | 12 | 18 | 18 | 18 | 18 |
| G (metric) | M12 | M16 | M16 | M16 | M16 |
| a | 54 | 60 | 60 | 2 x 60 | 60 |

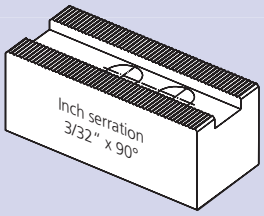
**Base jaw type**




## GBK-BD

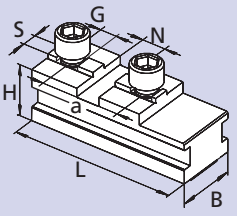
INCH SERRATED (for SMW-AUTOBLOK standard jaws)

**Existing top jaw**




| KNCS-NBX | 425-170 | 530-210 | 630-262 | 800-262 | 1000-262 |
|---|---|---|---|---|---|
| Id. No. | 036293 | 036294 | 036295 | 036296 | - |
| B | 50 | 62 | 75 | 75 | - |
| H | 45.8 | 61 | 61 | 61 | - |
| L | 125 | 160 | 200 | 287 | - |
| N | 3/32" x 90° | 3/32" x 90° | 3/32" x 90° | 3/32" x 90° | - |
| S (ridge) | 25.5 | 25.5 | 25.5 | 25.5 | - |
| G | M20 | M20 | M20 | M20 | - |
| a | 2 x 38 | 38 / 49 / 38 | 38 / 38 / 52 / 38 | 3 x 38/60.7/2 x 38 | - |
| b | 17 | 17 | 18 | 17.5 | - |

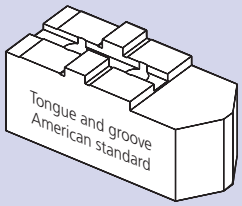
**Base jaw type**




## GBK-BA

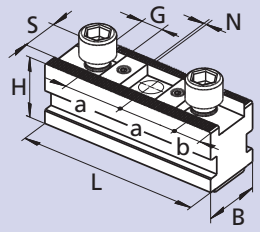
TONGUE & GROOVE American standard

**Existing top jaw**




| KNCS-NBX | 425-170 | 530-210 | 630-262 | 800-262 | 1000-262 |
|---|---|---|---|---|---|
| Id. No. | 039631 | 060561 | 060562 | 064590 | 069807 |
| B | 50 | 62 | 75 | 75 | 75 |
| H | 45.8 | 57 | 57 | 57 | 57 |
| L | 146 | 168 | 203 | 286 | 384 |
| N | 19.02 | 19.02 | 19.02 | 19.02 / (2x) | 19.02 / (3x) |
| S | 12.7 | 12.7 | 12.7 | 12.7 | 12.7 |
| G (inch) | 3/4-10 | 3/4-10 | 3/4-10 | 3/4-10 | 3/4-10 / (4x) |
| a | 76.2 | 76.2 | 76.2 | 2 x 76.2 | 76.2 / (3x) |

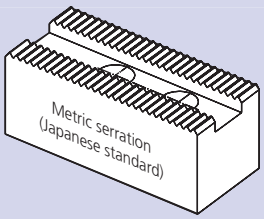
**Base jaw type**




## GBK-BM

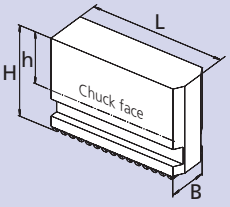
METRIC SERRATION

**Existing top jaw**




| KNCS-NBX | 425-170 | 530-210 | 630-262 | 800-262 | 1000-262 |
|---|---|---|---|---|---|
| Id. No. | 035569 | 035570 | 035917 | 036708 | - |
| B | 50 | 62 | 75 | 75 | - |
| H | 45.8 | 61 | 61 | 61 | - |
| L | 125 | 160 | 200 | 287 | - |
| N | 1.5 x 60° | 3 x 60° | 3 x 60° | 3 x 60° | - |
| S | 22 | 25 | 25 | 25 | - |
| G (metric) | M20 | M20 | M20 | M20 | - |
| a | 2 x 43 | 50 / 60 | 60/60/70.5/60 | 4 x 60 | - |
| b | 17 | 17 | 17 | 17.5 | - |

**Jaw type**




## UVB-B

Soft wide monoblock jaws

| KNCS-NBX | 425 | 530 | 630 / 800 / 1000 |
|---|---|---|---|
| Jaw type | UVB-B 400 | UVB-B 500 | UVB-B 630 |
| Id. No. | 238740 | 238912 | 5301060 |
| B | 50 | 62 | 75 |
| H | 125 | 160 | 160 |
| h | 60 | 105 | 105 |
| L | 148 | 175 | 230 |
| kg / set | 20.7 | 38.8 | 61.5 |

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# NEW GENERATION

# The most flexible production chuck in the world

# KNCS-2G

## Customer Benefits

| | KNCS-N | KNCS-2G |
|---|---|---|
| Minimized set up times due to the quick jaw change system | ■ | ■ |
| Highest accuracy of the jaw change | ■ | ■ |
| Universal | ■ | ■ |
| Vertical mounting of chuck possible | ■ | ■ |
| Case hardened parts | ■ | ■ |
| Wedge bar drive | ■ | ■ |
| Jaw safety interlock | ■ | ■ |
| Sealed wedge bars and base jaws | | ■ |
| Optimized lubrication in the jaw guides | | ■ |
| Low maintenance | | ■ |

## Economic and Efficiency

Example: Maintenance costs at high accumulation of dirt / coolant

| | | KNCS-N | KNCS-2G |
|---|---|---|---|
| Lubrication interval | | every shift | every 3rd shift |
| Required time for lubricating | | 10 Min. | 10 Min. |
| Working days / year | | 230 | 230 |
| Required time / year | | 2.300 Min. | 767 Min. |
| Machine costs / hour | | € 60.– | € 60.– |
| Total costs / year | | € 2.300.– | € 767.– |
| **Profit / year** | **at 1-shift operation** | | **€ 1.533.–** |
| | **at 2-shift operation** | | **€ 3.066.–** |
| | **at 3-shift operation** | | **€ 4.599.–** |

# Clamping glossary

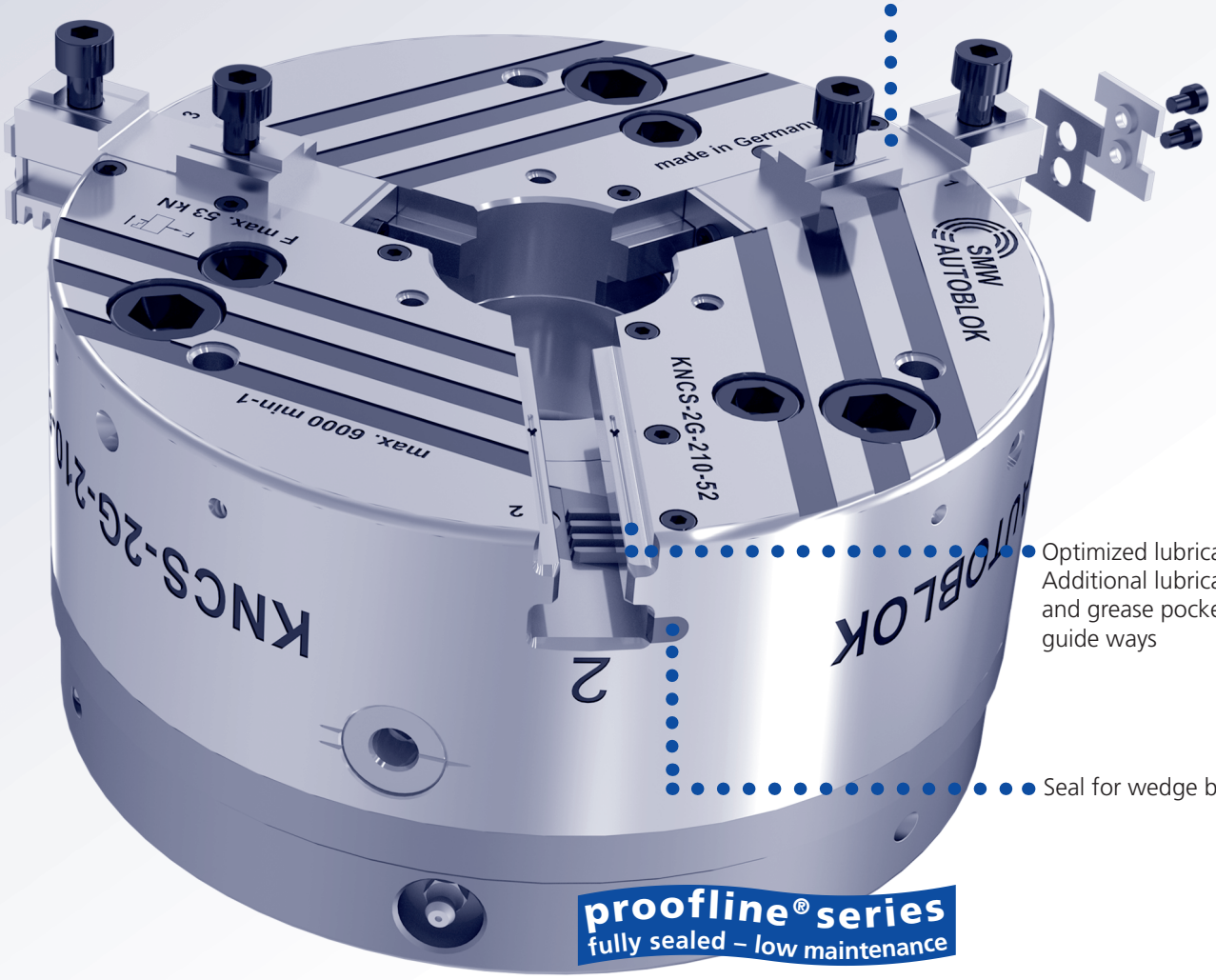
**KNCS-2G:** Evolution of the quick jaw change power chuck KNCS-N. The KNCS-2G features additional seals and an improved lubrication system for low maintenance. **The chuck still offers all the advantages same as the KNCS-N.** The proven wedge bar drive guarantees unmatched accuracy and rigidity. A low loss of grip force due to centrifugal force makes the chuck ideal for high speed applications. This design does not require any counterbalance weights which allows highest speeds without vibration.

**Sealing:** The KNCS-2G is sealed by seals attached to both faces of the base jaws. Also the wedge bars are protected by mechanical seals. The seals protect the chuck against **penetration of dirt and swarf.**

**Low Maintenance: The lubrication system of the KNCS-2G is optimized.** Additional lubrication channels and grease pockets integrated in the jaw guide ways ensure constant clamping force. The lubrication intervals are significantly longer reducing down times and cost for maintenance.

**Mass production:** The sealing and the new lubrication system make the KNCS-2G also suitable for mass production.

**Compatibility:** The KNCS-2G is interchangeable with the standard series of quick jaw change chucks KNCS-N. Existing master jaws still can be used without sealing.
A small modification made to the master jaws and a **mounting kit** can upgrade existing master jaws to become 2G master jaws.

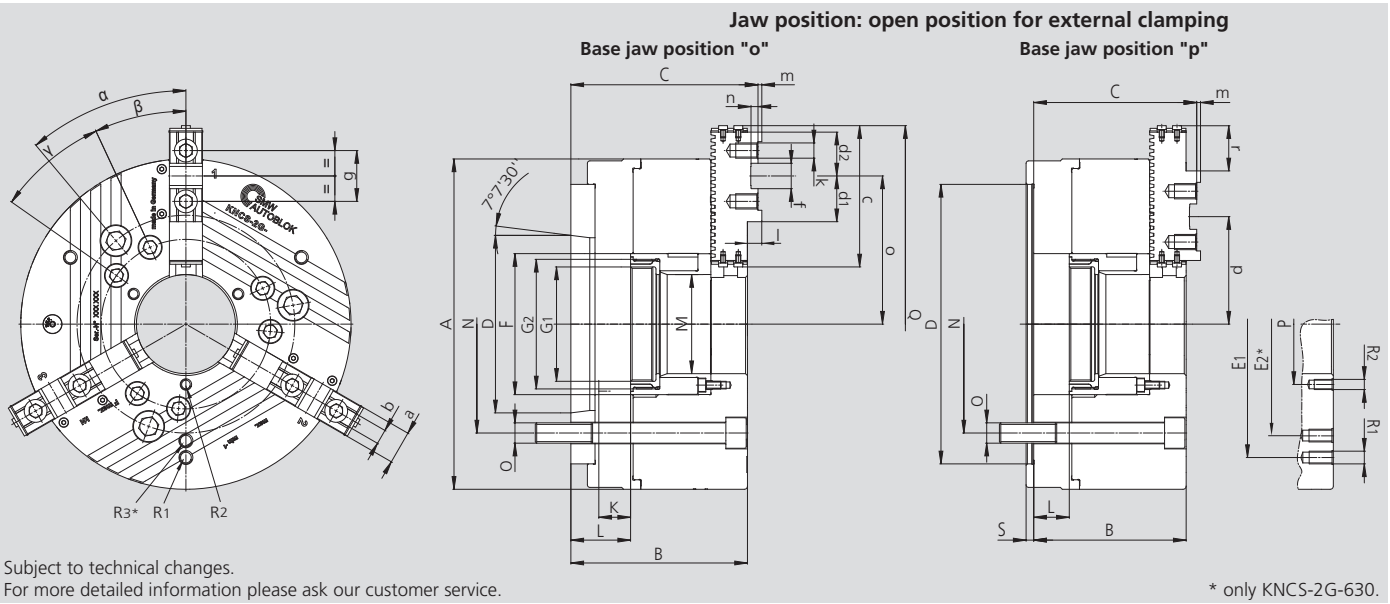


# KNCS-2G

QUICK JAW CHANGE

## Sealed, low maintenance and flexible

- Sealed
- Quick jaw change




Subject to technical changes.
For more detailed information please ask our customer service.

* only KNCS-2G-630.

| Type KNCS-2G | | 170-43 | | | 210-52 | | | 225-66 | | | 260-78 | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **Mounting** | **Size** | **Z140** | **A5** | **A6** | **Z170** | **A6** | **A8** | **Z170** | **A6** | **A8** | **Z170** | **Z220** | **A6** | **A8** |
| | **A** | | 175 | | | 215 | | | 225 | | | 260 | | |
| | **B** | 98 | 113 | 115 | 105 | 122 | 124 | 105 | 122 | 124 | 120 | 120 | 137 | 139 |
| | **C** | 104.9 | 119.9 | 121.9 | 109.9 | 126.9 | 128.9 | 109.9 | 126.9 | 128.9 | 128.3 | 128.3 | 145.3 | 147.3 |
| | **D** H6 | 140 | 82.57 | 106.39 | 170 | 106.39 | 139.73 | 170 | 106.39 | 139.73 | 170 | 220 | 106.39 | 139.73 |
| | **E1/E2** | | 152 | | | 168 | | | 180 | | | 210 | | |
| | **F** | | 67 | | | 85 | | | 95 | | | 111 | | |
| Rotating ring nut / depth | **G1** | | M50 x 1.5 / 18* | | | M60 x 1.5 / 16 | | | M75 x 1.5 / 16 | | | M90 x 2 / 20 | | |
| Piston thread / depth | **G2** | | M60 x 1.5 / 18 | | | M75 x 2 / 19 | | | M85 x 2 / 19 | | | M102 x 2 / 23 | | |
| Piston stroke | **K** | | 20 / 25 | | | 22 / 25 | | | 22 / 25 | | | 25 / 28 | | |
| Max. | **L** | 25 | 40 | 42 | 25 | 42 | 44 | 25 | 42 | 44 | 28 | 28 | 45 | 47 |
| | **M** | | 43 | | | 52 | | | 66 | | | 78 | | |
| Fixing bolt circle | **N** | 104.8 | 104.8 | 133.4 | 133.4 | 133.4 | 171.4 | 133.4 | 133.4 | 171.4 | 133.4 | 171.4 | 133.4 | 171.4 |
| Fixing bolt | **O** | M10 | M10 | M12 | M12 | M12 | M16 | M12 | M12 | M16 | M12 | M16 | M12 | M16 |
| | **P** | | 75 | | | 72 | | | 82 | | | 95 | | |
| | **Q** | | 203 | | | 268 | | | 278 | | | 313 | | |
| Thread / thread depth | **R1** | | M8 / 12 | | | M10 / 12 | | | M10 / 12 | | | M10 / 12 | | |
| Thread / thread depth | **R2** | | M5 / 8 | | | M6 / 10 | | | M6 / 10 | | | M8 / 16 | | |
| | **S** | | 6 | | | 6 | | | 6 | | | 6 | | |
| | **a** | | 20 | | | 22 | | | 22 | | | 26 | | |
| | **b** f7 | | 8 | | | 10 | | | 10 | | | 12 | | |
| | **c** | | 73.8 | | | 92.2 | | | 92.2 | | | 111.2 | | |
| | **d1** | | 28 | | | 33 | | | 33 | | | 36 | | |
| | **d2** | | 27.25 | | | 31.5 | | | 31.5 | | | 34.5 | | |
| | **f** H7 | | 18 | | | 20 | | | 20 | | | 20 | | |
| | **g** | | 32 | | | 40 | | | 40 | | | 40 | | |
| Thread / thread depth | **k** | | M8 / 13 | | | M8 / 13 | | | M8 / 13 | | | M12 / 15 | | |
| | **l** | | 6.9 | | | 4.9 | | | 4.9 | | | 8.3 | | |
| | **m** | | 2.5 | | | 2.5 | | | 2.5 | | | 3 | | |
| | **n** | | 5 | | | 4.5 | | | 4.5 | | | 5.5 | | |
| Max. / min. | **o** | | 69 / 50.2 | | | 96.6 / 68.3 | | | 102 / 69 | | | 116.6 / 83.6 | | |
| Max. / min. | **p** | | 60 / 41.2 | | | 77.6 / 49.3 | | | 83 / 50 | | | 84.6 / 51.6 | | |
| Base jaw tooth pitch | **-** | | 4.7 | | | 4.7 | | | 4.7 | | | 5.5 | | |
| Base jaw offset | **r** | | 18.8 | | | 28.3 | | | 33 | | | 33 | | |
| Base jaw offset | teeth | | 4 | | | 6 | | | 7 | | | 6 | | |
| α | deg. | | 53 | | | 46 | | | 46 | | | 40 | | |
| β | deg. | | 39 | | | 34 | | | 34 | | | 25 | | |
| γ | | | - | | | - | | | - | | | 30 | | |

| | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Stroke per jaw at piston stroke **K** | mm | 5.1 | | 20 | 6.0 | | 22 | 6.0 | | 22 | 7.0 | | | 25 |
| Stroke per jaw at piston stroke **K** max. | mm | 6.8 | | 25 | 7.0 | | 25 | 7.0 | | 25 | 8.0 | | | 28 |
| Max. actuating force 3-jaw chuck | kN | | 32 | | | 53 | | | 53 | | | 70 | | |
| Max. total gripping force 3-jaw chuck | kN | | 60 | | | 100 | | | 100 | | | 135 | | |
| Max. speed 3-jaw chuck | r.p.m. | | 6300 | | | 6000 | | | 5500 | | | 4700 | | |
| Weight without jaws | kg | 14 | 15 | 15 | 24 | 26 | 26 | 26 | 29 | 29 | 40 | 40 | 43 | 43 |
| Moment of inertia | kg·m² | | 0.06 | | | 0.11 | | | 0.2 | | | 0.38 | | |

| | | | | |
|---|---|---|---|---|
| **Rec. closed center cyl.** | **Type** | **SIN-S 100 / 125** | **SIN-S 125 / 150** | **SIN-S 125 / 150** | **SIN-S 150 / 175** |
| **Rec. open center cyl.** | **Type** | **VNK-T2 102-46** | **VNK-T2 130-52** | **VNK-T2 150-67** | **VNK-T2 170-77** |

* KNCS-2G-170-43 are available with fixed ring nut only.

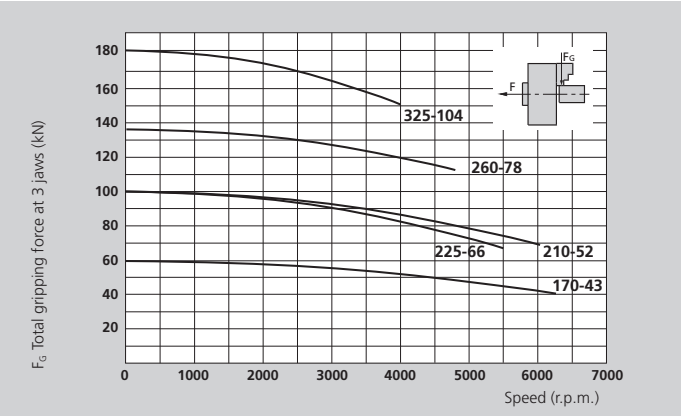
# Sealed, low maintenance and flexible

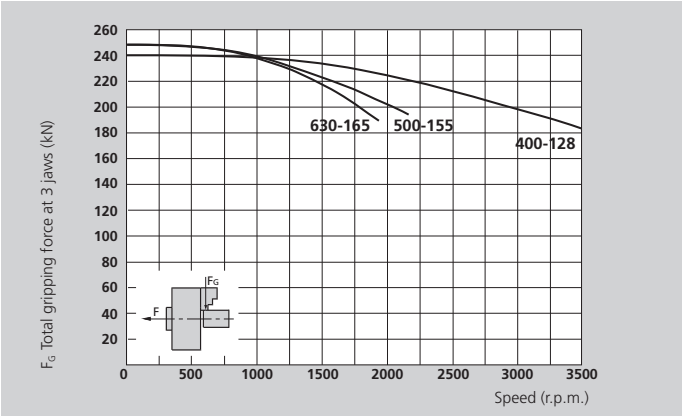
■ Sealed
■ Quick jaw change

# KNCS-2G

QUICK JAW CHANGE

## For highest speeds: flat gripping force curve




The data in the diagrams refer to 3-jaw-chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K05 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.

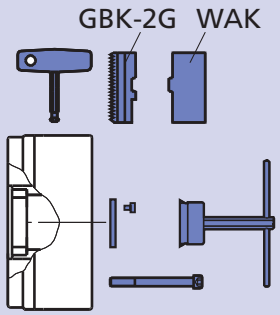
⚠ **Safety advice / danger of damage:**
When using taller / heavier jaws and / or clamping on a bigger diameter reduce draw pull / rotating speed accordingly.

| Type KNCS-2G | | 325-104 | | | | 400-128 | | | | 500-155 | | | | 630-165 | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **Mounting** | **Size** | **Z220** | **Z300** | **A8** | **A11** | **Z300** | **Z380** | **A11** | **A15** | **Z300** | **Z380** | **A11** | **A15** | **Z380** | **A15** |
| | **A** | 324 | | | | 400 | | | | 500 | | | | 630 | |
| | **B** | 130 | 130 | 149 | 151 | 140 | 140 | 161 | 163 | 174 | 174 | 195 | 197 | 174 | 197 |
| | **C** | 139.2 | 139.2 | 158.2 | 160.2 | 149.2 | 149.2 | 170.2 | 172.2 | 184 | 184 | 205 | 207 | 184 | 207 |
| | **D** H6 | 220 | 300 | 139.73 | 196.88 | 300 | 380 | 196.88 | 285.77 | 300 | 380 | 196.88 | 285.77 | 380 | 285.77 |
| | **E1/E2** | 268 | | | | 330 | | | | 420 | | | | 585 | 420 |
| | **F** | 144 | | | | 180 | | | | 207 | | | | 217 | |
| Rotating ring nut /depth | **G1** | M115 x 2 / 22 | | | | M138 x 2 / 22 | | | | M165 x 2 / 25 | | | | M175 x 2 / 25 | |
| Piston thread / depth | **G2** | M132 x 2 / 25 | | | | M160 x 2 / 25 | | | | M185 x 2 / 28 | | | | M195 x 2 / 28 | |
| Piston stroke | **K** | 25/28 | | | | 32 | | | | 42 | | | | 42 | |
| Max. | **L** | 28 | 28 | 47 | 49 | 32 | 32 | 53 | 55 | 42 | 42 | 63 | 65 | 42 | 65 |
| | **M** | 104 | | | | 128 | | | | 155 | | | | 165 | |
| Fixing bolt circle | **N** | 171.4 | 235 | 171.4 | 235 | 235 | 330.2 | 235 | 330.2 | 235 | 330.2 | 235 | 330.2 | 330.2 | 330.2 |
| Fixing bolt | **O** | M16 | M20 | M16 | M20 | M20 | M24 | M20 | M24 | M20 | M24 | M20 | M24 | M24 | |
| | **P** | 130 | | | | 152 | | | | 180 | | | | 195 | |
| | **Q** | 391 | | | | 461 | | | | 552 | | | | 650 | |
| Thread / thread depth | **R1/R3** | M10 / 16 | | | | M12 / 18 | | | | M16 / 25 | | | | M16 / 25 | |
| Thread / thread depth | **R2** | M10 / 16 | | | | M12 / 18 | | | | M12 / 18 | | | | M12 / 18 | |
| | **S** | 6 | | | | 8 | | | | 8 | | | | 8 | |
| | **a** | 32 | | | | 32 | | | | 45 | | | | 45 | |
| | **b** f7 | 12 | | | | 12 | | | | 18 | | | | 18 | |
| | **c** | 122.2 | | | | 133.2 | | | | 167.1 | | | | 209.7 | |
| | **d1** | 36 | | | | 43 | | | | 53 | | | | 53 | |
| | **d2** | 34 | | | | 42 | | | | 48.2 | | | | 49.75 | |
| | **f** H7 | 20 | | | | 26 | | | | 30 | | | | 30 | |
| | **g** | 40 | | | | 54 | | | | 60 | | | | 60 | |
| Thread / thread depth | **k** | M12 / 17 | | | | M12 / 17 | | | | M16 / 34 | | | | M16 / 34 | |
| | **l** | 9.3 | | | | 9.3 | | | | 10 | | | | 10 | |
| | **m** | 3 | | | | 3 | | | | 4 | | | | 4 | |
| | **n** | 6 | | | | 7 | | | | 9 | | | | 9 | |
| Max. / min. | **o** | 155.7 / 106.2 | | | | 182.3 / 121.8 | | | | 225 / 141 | | | | 270.5 / 179.5 | |
| Max. / min. | **p** | 111.7 / 62.2 | | | | 143.3 / 82.2 | | | | 164 / 80 | | | | 170.5 / 79.5 | |
| Base jaw tooth pitch | **-** | 5.5 | | | | 5.5 | | | | 7 | | | | 7 | |
| Base jaw offset | **r** | 49.5 | | | | 60.5 | | | | 84 | | | | 91 | |
| Base jaw offset | teeth | 9 | | | | 11 | | | | 12 | | | | 13 | |
| α | deg. | 40 | | | | 40 | | | | 40 | | | | 40 | |
| β | deg. | 25 | | | | 25 | | | | 25 | | | | - | |
| γ | deg. | 30 | | | | 30 | | | | 30 | | | | - | |
| Stroke per jaw at piston stroke **K** | mm | 7.0 | | | 25 | | | | | | | | | | |
| Stroke per jaw at piston stroke **K** max. | mm | 8.0 | | | 28 | 8.0 | | | 32 | 10.0 | | | 42 | 10.0 | 42 |
| Max. actuating force 3-jaw chuck | kN | 95 | | | | 115 | | | | 120 | | | | 125 | |
| Max. total gripping force 3-jaw chuck | kN | 180 | | | | 240 | | | | 250 | | | | 250 | |
| Max. speed 3-jaw chuck | r.p.m. | 4000 | | | | 3500 | | | | 2200 | | | | 1700 | |
| Weight without jaws | kg | 65 | 65 | 68 | 68 | 111 | 111 | 116 | 116 | 225 | 225 | 231 | 231 | 390 | 398 |
| Moment of inertia | kg·m² | 1.2 | | | | 2.5 | | | | 6.5 | | | | 18 | |
| **Rec. closed center cyl.** | **Type** | **SIN-S 150 / 175 / 200** | | | | **SIN-S 175 / 200** | | | | **SIN-S 175 / 200** | | | | **SIN-S 175 / 200** | |
| **Rec. open center cyl.** | **Type** | **VNK-T2 250-110** | | | | **VNK-T2 320-127** | | | | **VSG 450-165** | | | | **VSG 450-165** | |

# KNCS-2G

QUICK JAW CHANGE

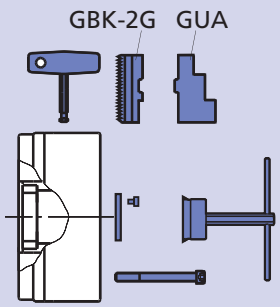
■ Ordering review




## Supply range:

Chuck + key + mounting bolts + mounting key (from diameter 210)
+ 1 set hardened base jaws type GBK-2G
+ 1 set soft top jaws type WAK
+ 1 set of coverplates

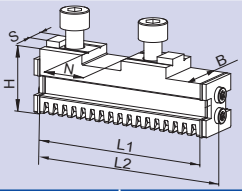
| Size / Spindle mounting | KNCS-2G 170-43 | KNCS-2G 210-52 | KNCS-2G 225-66 | KNCS-2G 260-78 | KNCS-2G 325-104 | KNCS-2G 400-128 | KNCS-2G 500-155 | KNCS-2G 630-165 |
|---|---|---|---|---|---|---|---|---|
| Centering rim small | | | | Z 170<br>161551 | Z 220<br>161571 | Z 300<br>161591 | Z 300<br>162106 | |
| Centering rim large | Z 140<br>162400 | Z 170<br>161180 | Z 170<br>161582 | Z 220<br>161550 | Z 300<br>161500 | Z 380<br>161592 | Z 380<br>161980 | Z 380<br>162120 |
| A 05 | 162401 | | | | | | | |
| A 06 | 162402 | 161563 | 161583 | 161553 | | | | |
| A 08 | | 161564 | 161584 | 161554 | 161572 | | | |
| A 11 | | | | | 161573 | 161593 | 162107 | |
| A 15 | | | | | | 161594 | 162108 | 162121 |




## Supply range:

Chuck + key + mounting bolts + mounting key (from diameter 210)
+ 1 set hardened base jaws type GBK-2G
+ 1 set hardened, reversible top jaws type GUA ground on chuck
+ 1 set of coverplates

| Size / Spindle mounting | KNCS-2G 170-43 | KNCS-2G 210-52 | KNCS-2G 225-66 | KNCS-2G 260-78 | KNCS-2G 325-104 | KNCS-2G 400-128 | KNCS-2G 500-155 | KNCS-2G 630-165 |
|---|---|---|---|---|---|---|---|---|
| Centering rim small | | | | Z 170<br>161559 | Z 220<br>161578 | Z 300<br>161599 | Z 300<br>162109 | |
| Centering rim large | Z 140<br>162403 | Z 170<br>161568 | Z 170<br>161588 | Z 220<br>161560 | Z 300<br>161579 | Z 380<br>161600 | Z 380<br>162110 | Z 380<br>162122 |
| A 05 | 162404 | | | | | | | |
| A 06 | 162405 | 161569 | 161589 | 161561 | | | | |
| A 08 | | 161570 | 161590 | 161562 | 161580 | | | |
| A 11 | | | | | 161581 | 161601 | 162111 | |
| A 15 | | | | | | 161602 | 162112 | 162123 |



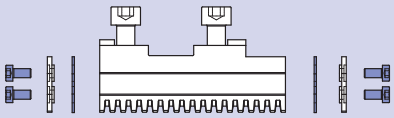

## GBK-2G

### Harte Grundbacken

Bestehend aus 1 Satz (3 Stück) Grundbacken GBK-2G mit Abdichtung und Befestigungsschrauben für Aufsatzbacken (6 Stück).

| KNCS-2G | 170 | 210 | 225 | 260 | 325 | 400 | 500 | 630 |
|---|---|---|---|---|---|---|---|---|
| Backen Typ | GBK-2G 170 | GBK-2G 200 | GBK-2G 200 | GBK-2G 250 | GBK-2G 315 | GBK-2G 400 | GBK-2G 500 | GBK-2G 630 |
| Id.-Nr. | 162390 | 161520 | 161520 | 161540 | 161329 | 161605 | 161843 | 161846 |
| B | 20 | 22 | 22 | 26 | 32 | 32 | 45 | 45 |
| H | 27.5 | 29.5 | 29.5 | 37 | 43 | 43 | 57 | 57 |
| L1 | 63.5 | 82 | 82 | 101 | 112 | 123 | 157.5 | 199.5 |
| L2 * | 73.6 | 92.2 | 92.2 | 111.2 | 122.2 | 133.2 | 167.1 | 209.7 |
| N | 20 | 20 | 20 | 20 | 20 | 26 | 30 | 30 |
| S | 10 | 10 | 10 | 12 | 12 | 12 | 18 | 18 |
| kg / Satz | 0.7 | 1.0 | 1.0 | 1.8 | 2.7 | 3.0 | 7.7 | 9.5 |

* Maß inkl. Dichtungen, Dichtbleche und Schrauben.

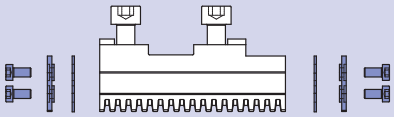


## Dichtsatz

### für harte Grundbacken GBK-2G

Bestehend aus Dichtelementen (6 Stück) und Befestigungsschrauben (12 Stück).

| KNCS-2G | 170 | 210 | 225 | 260 | 325 | 400 | 500 | 600 |
|---|---|---|---|---|---|---|---|---|
| Backen Typ | GBK-2G 170 | GBK-2G 200 | GBK-2G 200 | GBK-2G 250 | GBK-2G 315 / 400 | GBK-2G 315 / 400 | GBK-2G 500 | GBK-2G 630 |
| Id.-Nr. | 207495 | 205382 | 205382 | 205383 | 205384 | 205384 | 206915 | 206915 |



## Montage Kit

### für harte Grundbacken GBK-2G

Bestehend aus Dichtelementen (6 Stück), Dichthalter (6 Stück) und Befestigungsschrauben (12 Stück).

| KNCS-2G | 170 | 210 | 225 | 260 | 325 | 400 | 500 | 630 |
|---|---|---|---|---|---|---|---|---|
| Backen Typ | GBK-2G 170 | GBK-2G 200 | GBK-2G 200 | GBK-2G 250 | GBK-2G 315/400 | GBK-2G 315/400 | GBK-2G 500 | GBK-2G 630 |
| Id.-Nr. | 207496 | 205386 | 205386 | 205387 | 205388 | 205388 | 206916 | 206916 |

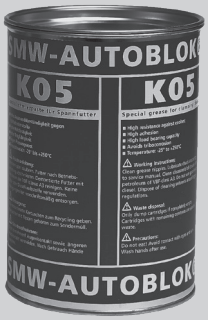
**Hinweis:** Montage Kit auch für kundenseitige Umarbeit vorhandender Grundbacken GBK auf die abgedichtete Version GBK-2G verwendbar (Anleitung zur Umarbeit auf Anfrage erhältlich).

# Gleitpaste K05®

**Speziell für die Schmierung von Hand- und Kraftspannfuttern entwickelt**

**Kartusche 14 Oz. (DIN 1284)**
**Fettinhalt 500 g**
**Id.-Nr. 016440**

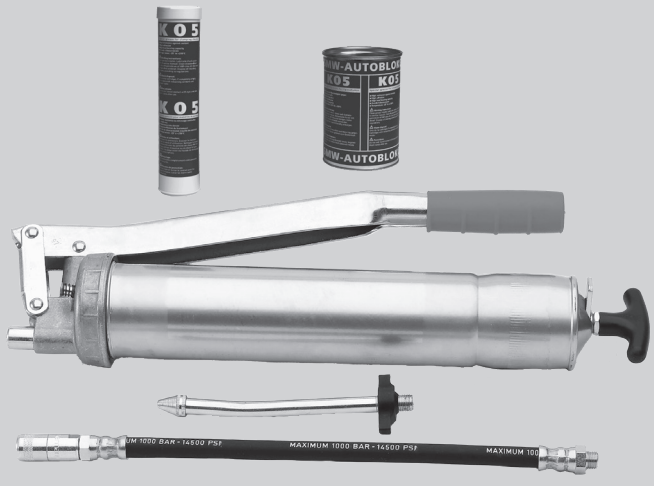
**Dose 1000 g**
**Id.-Nr. 011881**




- Hohe Haftfestigkeit
- Hohe Auswaschbeständigkeit bei Einsatz von Kühlschmieremulsion
- Hohe Tragfähigkeit
- Niedriger Reibungskoeffizient
- Hohe Spannkraft
- Verhindert Passungsrost

# Fettpresse

**Fettpresse (DIN 1283) für Kartuschen 14 Oz. (DIN 1284)**
**■ Auch für Befüllung mit losem Fett geeignet.**



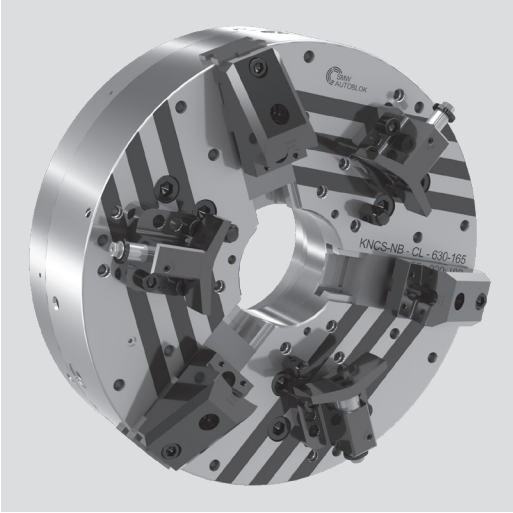

**Abschmierset Id.-Nr. 083726**
Lieferumfang
- Fettpresse
- 1 Adapter flexibel für Kegelschmiernippel
- 1 Adapter für Trichterschmiernippel

# KNCS-NB-CL

CENTER LINE

## High precision power chucks Ø 630

- Quick jaw change
- Large through hole
- Wide master jaws – Radial fine adjustment
- High flexibility: jaws radially adjustable / reversible




## Application/customer benefits

- For workpieces with high concentricity callout
- For radial readjustment of workpieces with big changes in weight during machining
- To apply additional grip force to the workpiece by the adjustment screws
- Readjustment of the centerline of the workpiece in process

## Technical features

- Integrated fine adjustment to center the workpiece
- Fine adjustment is radially displaceable for different workpiece diameters
- Concentricities higher than the repeatability of the chuck can be reached

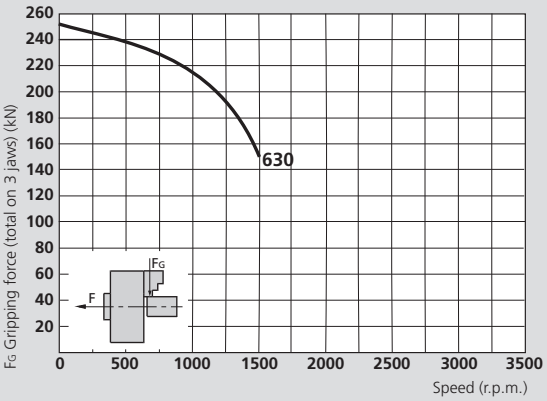
## Standard equipment

3 jaw chuck with disengaging key
Mounting key
Set of coverplates
Fine adjustment

## Ordering example

3 jaw chuck KNCS-NB-CL 630

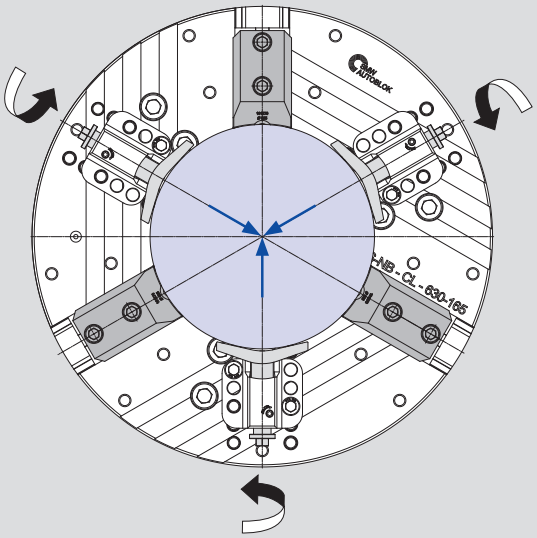
## Actual gripping force diagrams




The data in the diagrams refer to 3 jaw chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K05 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.

## Radial fine adjustment CL




The centerline is affected by changes of weight of the workpiece and the mechanic repeatability of the chuck itself. The center of the workpiece can be fine adjusted even more accurate than the repeatability of the chuck, using the CL fine adjustment. Integrated CL fine adjustment devices allow to bring any workpiece into the exact rotation center of the machine while clamped. This is ideal for high accurate tubine shafts, aerospace parts etc.

## Technical data

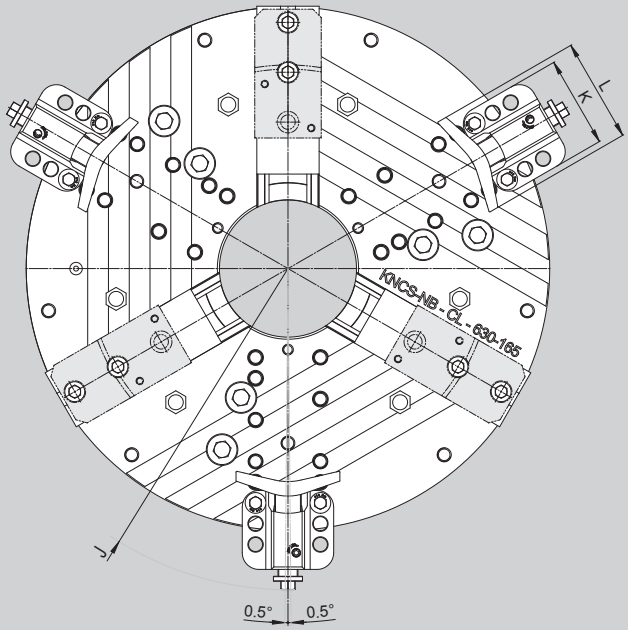
| SMW-AUTOBLOK Type | | KNCS-NB-CL 630 |
|---|---|---|
| **Id. No.** | | **161250** |
| **Number of jaws** | | **3** |
| **Radial jaw stroke** | mm | 10 |
| **Axial piston stroke** | mm | 42 |
| **Max. draw-pull** | kN | 120 |
| **Max. gripping force** | kN | 250 |
| **Max. speed** | r.p.m. | 1500 |
| **Weight** (without top jaws) | kg | 390 |
| **Moment of inertia** | kg·m² | 18 |
| | | |
| **Recommended closed center cylinder** | | **SIN-S 175 / 200** |
| **Recommended open center cylinder** | | **VSG 450-165** |

# High precision power chucks Ø 630

- Quick jaw change
- Large through hole
- Wide master jaws - Radial fine adjustment
- High flexibility: jaws radially adjustable / reversible

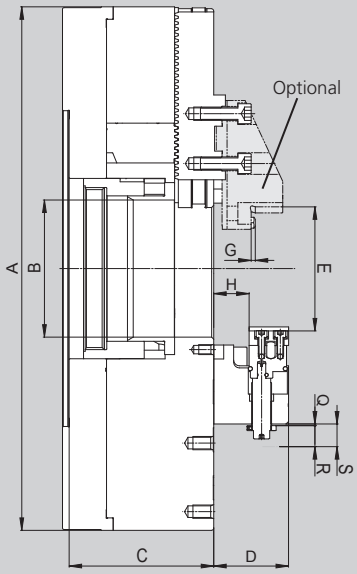
# KNCS-NB-CL

## CENTER LINE



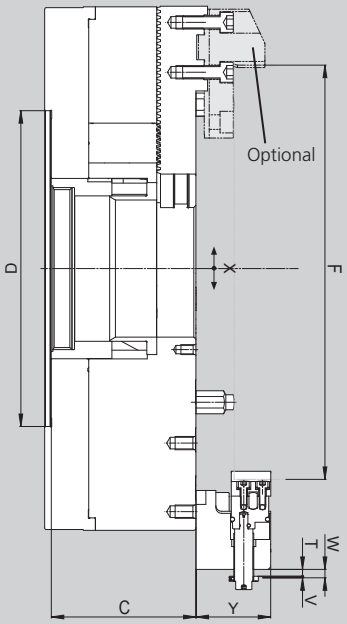

Max. radial swivelling
~±0.5° = ±0.5 mm

**Base jaw position „p“**




Min. position of adjustment
(CL)

**Base jaw position „o“**




Max. position of adjustment
(CL)

Subject to technical changes.
For more detailed information please ask our customer service or see the technical data of KNCS-NB.

| SMW-AUTOBLOK Type | | | KNCS-NB-CL 630 |
|---|---|---|---|
| Id. No. | | | 161250 |
| | A | mm | 630 |
| Chuck bore | B | mm | 165 |
| | C | mm | 174 |
| | D | mm | 380 |
| Min. clamping diameter | E | mm | 150 |
| Max. clamping diameter | F | mm | 540 |
| | G | mm | 5 |
| | H | mm | 42.6 |
| Swing diameter max. | J | mm | 812 |
| | K | mm | 110 |
| | L | mm | 125 |
| | M | mm | 60 |
| Residual stroke CL (min. position) | Q | mm | 2 |
| Approach stroke CL (min. position) | R | mm | 27 |
| Total stroke CL (min. position) | S | mm | 29 |
| Residual stroke CL (max. position) | T | mm | 1.8 |
| Approach stroke CL (max. position) | V | mm | 27.2 |
| Total stroke CL (max. position) | W | mm | 29 |
| Radial adjustment range CL to the center line | X | mm | ~ ± 0.05 |
| | Y | mm | 90 |

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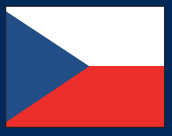

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