



**CHUCK**

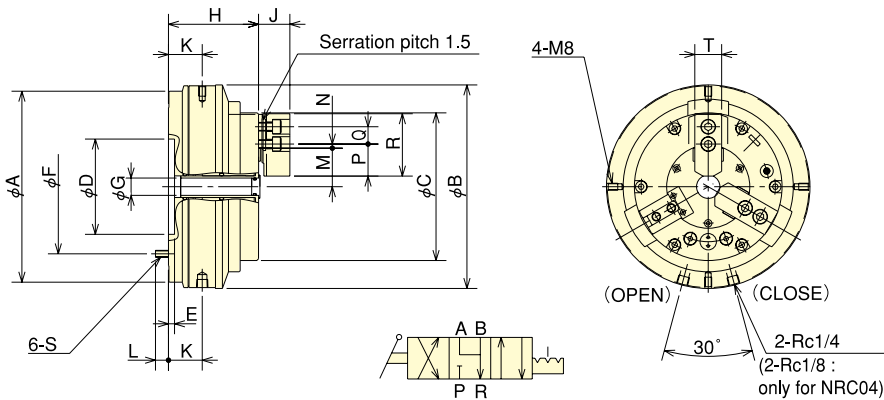
# Rotary Chuck NRC series

**Only Kitagawa can offer a complete NC Rotary Table and workholding solution**

- Exclusive air-operated chuck
- Integrated pneumatic cylinder  
Can easily be fitted to TBX range of tables.



## Dimensions



Note) Exhaust centre Solenoid Valve to be used.  
See page 86.

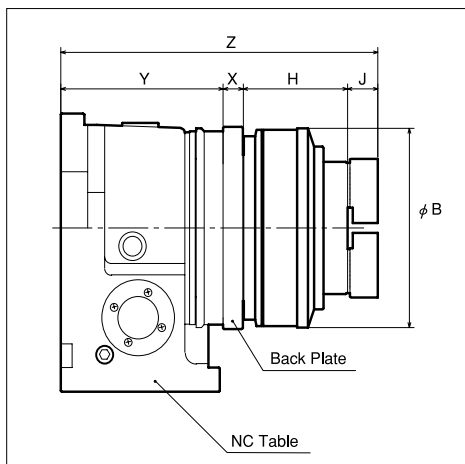
## Dimensions

Dimensions Model	A	B	C	D(H7)	E	F	G	H	J	K	L	M max.	M min.	N max.	N min.	P	Q	R	S	T
NRC04	157	170	113	80	6	100	—	93	27	33	14	25.5	22.9	9.75	6.75	28	14	55	M6	23
NRC06	220.5	235	170.5	110	7	155	20	104	36	39	15	44.5	41.9	9.25	4.75	37	20	72	M8	31
NRC08	266	280	216	110	8	200	30	117	42	41.5	17	53	49.85	14.75	8.75	46	25	95	M8	35
NRC10	303	305	253	140	8	235	43	120	46	41.5	21	66	62.85	19	8.5	50	30	110	M10	40

## Specifications

Specifications Model	Plunger Stroke (mm)	Jaw stroke (in Dia.) (mm)	Gripping force per Jaw kN Air pressure at 0.6MPa	Max. air pressure (MPa)	Matching soft top jaw	Gripping Dia. (mm)		Max. rotation (min <sup>-1</sup> )	Rotary torque (N·m)	Mass of Product (kg) (With Standard Soft Jaw)
						Max.	Min.			
NRC04	15	5.2	2.5	0.7	SB04B1	110	10	100	9.8	10
NRC06	15	5.2	7	0.7	SB06B1	165	23	72	9.8	22
NRC08	15	6.3	10.8	0.7	SB08B1	210	30	60	9.8	27.7
NRC10	15	6.3	16	0.7	SB10A1	254	50	53	9.8	42.5

## Rotary Chuck Fitting Dimensions



Rotary Table Model	Chuck model	B	H	J	X	Y	Z
RS100	NRC04	170	93	27	15	140	275
MR120	NRC04	170	93	27	18	136	274
MR160	NRC04	170	93	27	18	145	283
	NRC06	235	104	36	20	145	305 (Note1)
MR200	NRC04	170	93	27	18	173	311
	NRC06	235	104	36	20	173	333 (Note1)
MR250	NRC06	235	104	36	20	180	340
	NRC08	280	117	42	21	180	360 (Note1)
MR320	NRC10	315	120	46	22	210	398
TMX (THX, TBX) 160	NRC04	170	93	27	18	145	283
	NRC06	235	104	36	20	145	305
TMX (THX, TBX, TUX) 200	NRC04	170	93	27	20	176	486
	NRC06	235	104	36	20	176	336
TMX (TLX, TBX, TUX) 250	NRC06	235	104	36	20	210	370
	NRC08	280	117	42	21	210	390
TRX (TLX, TBX, TUX) 320	NRC10	305	120	46	22	225	413

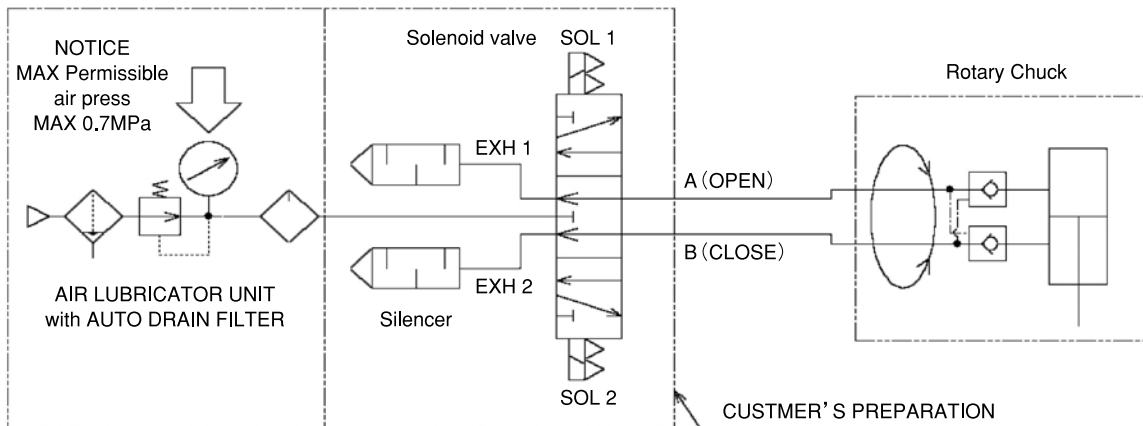
- Note) 1. The dimensions above are without stoppers. Consult for fitting positions of stoppers and others separately.  
2. Since clammer may interfere with the chuck by a clammer position, confer with Kitagawa on it.  
3. When installing the chuck at a horizontally-installed spec., contact to Kitagawa separately.

**Piping and operation details for NRC chuck.**

The specified solenoid must have 4 positions and 3 directions with a centre exhaust. After the solenoid valve has been switched and the chuck jaws opened or closed the solenoid valve must return to the centre, neutral position. Jaw movement occurs immediately after the solenoid is switched however, it will take a short amount of time before full gripping force is achieved. The amount of time required can be checked by fitting a pressure gauge to the chuck surface. For normal operation the pressure gauge can be removed and the required amount of time set as a dwell in the machine program. The solenoid valve must always be returned to the neutral position when the part has been gripped or removed. The NC Rotary Table should only be indexed when the solenoid valve is in the neutral position.

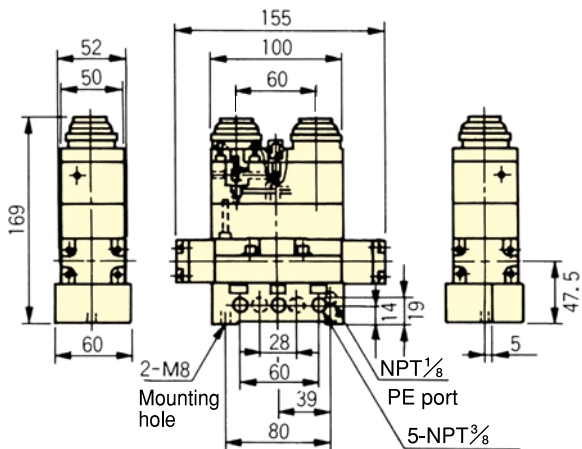


(NRC08 is installed on TMX250)

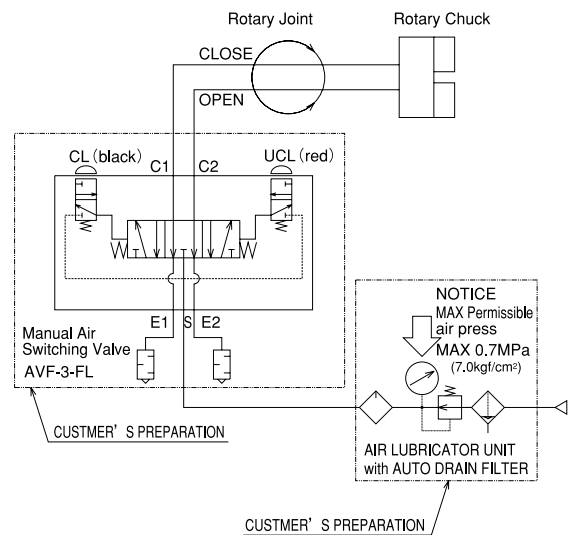


**AIR DIAGRAM**

■ Manual air switching valve AVF-3-FL (made-to-order)



Light weight compact push button valve designed exclusively to simplify pipe layout for NRC chuck operation.



**AIR DIAGRAM**

Service pressure	0~1MPa
Withstanding pressure	1.5MPa
Push button controlling force	4kg
Connecting bore size	NPT <sup>3</sup> / <sub>8</sub>

Note) An adpoter plug is required to have Rc connecting bore.