Workholding Systems NC
clamping against the fixed jaw, mechanically operated with hydraulic force transmission
jaw widths 100, 125 and 160 mm

Advantages
- Steel base resistant to deformation
- Hydraulic force transmission
- Hardened and ground guideways
- Extensive range of jaws
- Easy clamping range adjustment by quick socket pin adjustment
- Angle drive or clamping force preselection can be retrofitted (accessories)
- Optional clamping force display
- Minimum set-up times
- Tapped hole in the fixed jaw for workpiece stop
- Clamping edge for clamping claws
- Quick cleaning by simple removal of the slide
- Longitudinal and crosswise keyways 20 H7 for quick positioning in accordance with NC requirements
- Different overall lengths for optimum adaptation to the machine table and the interfering edges in the machining centre

Technical data
- Clamping principle: clamping against the fixed jaw
- Operation: mechanical by crank handle with hydraulic force transmission

<table>
<thead>
<tr>
<th>Model</th>
<th>Jaw width:</th>
<th>Clamping force:</th>
<th>Lengths of the base: Max. jaw opening:</th>
</tr>
</thead>
<tbody>
<tr>
<td>NC 100</td>
<td>100 mm</td>
<td>25 kN</td>
<td>380 and 540 mm</td>
</tr>
<tr>
<td>NC 125</td>
<td>125 mm</td>
<td>40 kN</td>
<td>430, 560 and 720 mm</td>
</tr>
<tr>
<td>NC 160</td>
<td>160 mm</td>
<td>50 kN</td>
<td>550 and 750 mm</td>
</tr>
</tbody>
</table>

Description
The workholding systems of the series NC can be flexibly and quickly adapted to the most varied clamping ranges because of their socket pin adjustment.

By means of the longitudinal and crosswise keyways 20 H7, the NC can be positioned quickly and in accordance with NC requirements.

Step jaw inserts are available as accessories, to extend the clamping range.

The workholding system can be easily and quickly cleaned by pulling out the socket pin and removing the clamping slide from the base. Thus cost intensive downtimes will be reduced.

Version with clamping force display
The version with clamping force display allows a continuous and precise clamping force application. This offers enormous advantages for roughing and finishing operations, for example.

The high-precision reproducibility of the clamping forces guarantees a maximum possible repetitive accuracy of the clamping processes.

Furthermore, the clamping force display ensures a high degree of safety even when using grip jaws due to the permanent clamping and system control.

Application example
Workholding systems NC 125 with clamping force display

Application video
www.youtube.com/watch?v=H6jrOdDE1Ww

Consultation
Our experts will be pleased to advise you also on site, and work with you to find the optimum clamping solution.

Extensive information such as drawings and CAD models are available on request.

Application
Workholding systems NC are advantageously used in vertical machining for die, mould and fixture construction.

Accessories
See data sheet WS 1.300Z
- Top jaws
- Clamping and quick-change jaws
- Clamping force preselection
  The clamping force preselection enables the force to be applied in 6 stages up to the maximum.
- Angle drive
  An angle drive that can also be retrofitted facilitates the operation, e.g. in the case of longitudinal clamping on the machine table.
- Workpiece stops
- Accessories for fixation

Delivery
- Standard jaws smooth/serrated
- Crank handle

Application video
www.youtube.com/watch?v=H6jrOdDE1Ww

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Application video
www.youtube.com/watch?v=H6jrOdDE1Ww
**NC 100**

**Length of the base 380 mm**

- Standard jaws smooth/serrated (included in the delivery)
- Clamping range S
- Clamping range S1
- Clamping range S2
- Length of the base
- Weight with clamping jaws

**View from above**

**NC 100**

**Length of the base 540 mm**

- Standard jaws smooth/serrated (included in the delivery)
- Clamping range S
- Clamping range S1
- Clamping range S2
- Length of the base
- Weight with clamping jaws

**Series** | **NC 100** | **NC 100**
---|---|---
Clamping principle | fixed jaw | fixed jaw
Operation | mechanical | mechanical
Clamping force | [kN] | 25 | 25
Clamping range S | [mm] | 0–205 | 0–365
Clamping range S1 | [mm] | 125–330 | 125–490
Clamping range S2 | [mm] | 181–386 | 181–546
Length of the base | [mm] | 380 | 540
Weight with clamping jaws | [kg] | 18.5 | 28.5
Part no. | 930720203 | 930720303
Part no. with clamping force display | 930720213 | 930720313

* with the clamping jaws shown. Further clamping jaws and accessories on data sheet WS 1.300Z.
### Technical data • Dimensions

**NC 125**

**Length of the base 430 mm**

- **Fixed jaw**
- **Standard jaws smooth/serrated** (included in the delivery)
- **Accessory:** Step jaw insert
- **Option:** Clamping force display

**NC 125**

**Length of the base 560 mm**

- **Fixed jaw**
- **Standard jaws smooth/serrated** (included in the delivery)
- **Accessory:** Step jaw insert
- **Option:** Clamping force display

**NC 125**

**Length of the base 720 mm**

- **Fixed jaw**
- **Standard jaws smooth/serrated** (included in the delivery)
- **Accessory:** Step jaw insert
- **Option:** Clamping force display

### Series

<table>
<thead>
<tr>
<th>Series</th>
<th>NC 125</th>
<th>NC 125</th>
<th>NC 125</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Clamping principle</strong></td>
<td>fixed jaw</td>
<td>fixed jaw</td>
<td>fixed jaw</td>
</tr>
<tr>
<td><strong>Operation</strong></td>
<td>mechanical</td>
<td>mechanical</td>
<td>mechanical</td>
</tr>
<tr>
<td><strong>Clamping force</strong></td>
<td>[kN]</td>
<td>40</td>
<td>40</td>
</tr>
<tr>
<td><strong>Clamping range S&lt;sup&gt;1)&lt;/sup&gt;</strong></td>
<td>[mm]</td>
<td>0 – 225</td>
<td>0 – 355</td>
</tr>
<tr>
<td><strong>Clamping range S1&lt;sup&gt;1)&lt;/sup&gt;</strong></td>
<td>[mm]</td>
<td>138 – 363</td>
<td>138 – 493</td>
</tr>
<tr>
<td><strong>Clamping range S2&lt;sup&gt;1)&lt;/sup&gt;</strong></td>
<td>[mm]</td>
<td>206 – 431</td>
<td>206 – 561</td>
</tr>
<tr>
<td><strong>Length of the base</strong></td>
<td>[mm]</td>
<td>430</td>
<td>560</td>
</tr>
<tr>
<td><strong>g on both sides</strong></td>
<td>[mm]</td>
<td>M12 x 18</td>
<td>M12 x 18</td>
</tr>
<tr>
<td><strong>Weight with clamping jaws</strong></td>
<td>[kg]</td>
<td>31.5</td>
<td>41.5</td>
</tr>
<tr>
<td><strong>Part no.</strong></td>
<td>930730203</td>
<td>930730303</td>
<td>930730403</td>
</tr>
<tr>
<td><strong>Part no. with clamping force display</strong></td>
<td>930730213</td>
<td>930730313</td>
<td>930730413</td>
</tr>
</tbody>
</table>

* Tolerance ± 0.01 mm
** Tolerance ± 0.02 mm

All dimensions in [mm]

* with the clamping jaws shown. Further clamping jaws and accessories on data sheet WS 1.300Z.
NC 160
Length of the base 550 mm

NC 160
Length of the base 750 mm

Series | NC 160 | NC 160
--- | --- | ---
Clamping principle | fixed jaw | fixed jaw
Operation | mechanical | mechanical
Clamping force | [kN] | 50 | 50
Clamping range S | [mm] | 0 – 308 | 0 – 508
Clamping range S1 | [mm] | 194 – 502 | 194 – 702
Clamping range S2 | [mm] | 264 – 572 | 264 – 772
Length of the base | [mm] | 550 | 750
g on both sides | [mm] | M20 x 27 | M20 x 27
Weight with clamping jaws | [kg] | 58.5 | 75.6
Part no. | 930740203 | 930740303
Part no. with clamping force display | 930740213 | 930740313

1) with the clamping jaws shown. Further clamping jaws and accessories on data sheet WS 1.300Z.

* Tolerance ± 0.01 mm
** Tolerance ± 0.02 mm
All dimensions in [mm]

View from above