

## **ROTA-S** *plus 2.0*

**Jaw quick-change chuck with  
angled serrated base jaw  
interface**

# Versatile useable manual lathe chuck with jaw quick-change system for jaw change in 60 seconds.

The ROTA-S plus 2.0 manual lathe chuck is specifically designed for storage solutions and conventional lathes without hydraulic or pneumatic cylinders. The jaw quick-change system makes the chucks suitable for flexible production starting from batch size 1. There is no need to rebores the jaws on the chuck. The angled jaw interface makes the manual lathe chucks compatible with the predecessor ROTA-S ROTA-S plus as well as the "F" system (Forkardt).



## Advantages – Your benefits

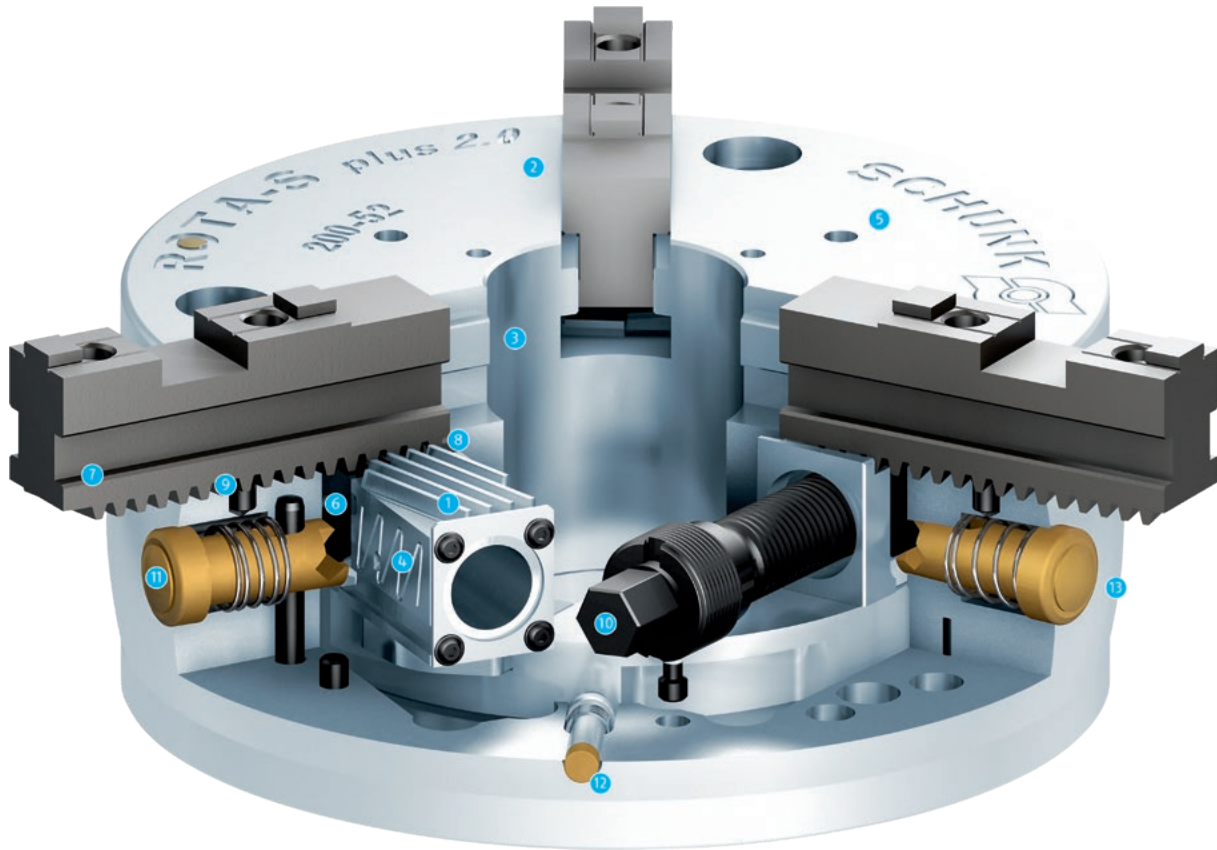
- + Convenient jaw quick-change system**  
Minimizing set-up times and costs
- + Large through-hole**  
Machining all standard pipe diameters
- + High efficiency of the wedge bar system**  
Process-reliable clamping due to high clamping forces
- + High jaw quick-change repeat accuracy**  
No reboring of already machined jaws necessary
- + Visual safety devices**  
Maximum operating safety
- + Optimized lubrication system**  
Consistently high clamping forces ensured
- + Modular center sleeve system**  
Optimal adjustment to new clamping tasks thanks to the exchangeable center sleeves
- + Excellent clamping force/torque ratio**  
Perfect use of the machine performance
- + Angled serrated base jaws SFG**  
Compatible with the ROTA-S plus and "F" system (Forkardt)
- + Ergonomic, light safety spanner wrench**  
Ensures easy operation
- + All sides of the functional parts are hardened and ground**  
High run-out and jaw change repeat accuracy

## Technical data

Description	Number of chuck jaws	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Through-hole [mm]
ROTA-S plus 2.0 160-42	3	5400	65	80	6.5	42
ROTA-S plus 2.0 160-42/2	2	5400	40	55	6.5	42
ROTA-S plus 2.0 200-52	3	4800	100	120	7	52
ROTA-S plus 2.0 200-52/2	2	4800	65	80	7	52
ROTA-S plus 2.0 250-62	3	4200	160	210	7.7	62
ROTA-S plus 2.0 250-62/2	2	4200	105	140	7.7	62
ROTA-S plus 2.0 315-92	3	3400	180	220	9.8	92
ROTA-S plus 2.0 315-92/2	2	3400	120	150	9.7	92
ROTA-S plus 400-102	3	2200	230	280	12	102
ROTA-S plus 500-162	3	1500	270	320	12	162
ROTA-S plus 630-252	3	1000	270	350	15	252
ROTA-S plus 800-252	3	1000	270	350	15	252
ROTA-S plus 1000-402	3	900	270	350	15	402

## Function ROTA-S plus 2.0

The tangentially movable wedge bars in the chuck are driven by turning the thread spindle. The wedge bars transmit the force to the base jaws, generating a jaw movement that is synchronous and radial to the axis of rotation.



- 1 Wedge bar actuation system**  
It offers high run-out accuracies even at high speeds
- 2 Hardened and extremely rigid base body**  
Therefore a longer service life at highest precision.  
Even with maximum clamping force
- 3 Large through-hole**  
For machining all conventional bar diameters (optionally: with enlarged through-hole)
- 4 Optimized lubrication system**  
For a high level of efficiency
- 5 Mounting thread**  
For workpiece stops or cover plates
- 6 Jaw quick-change system**  
Shortest set-up times due to individual unlocking of jaws
- 7 Base jaws with diagonal serration (SFG)**  
Compatible with the ROTA-S plus and "F" system (Forkardt)
- 8 Locking mechanism**  
Ensures secure intermeshing of the base jaw serration with the wedge bar serration
- 9 Plunger pin**  
For pre-positioning the base jaw
- 10 Actuation via hexagon connection**  
This ensures easy operation
- 11 Push button for jaw change**  
For shortest set-up times
- 12 Indicator pin**  
For visual stroke monitoring of the manual lathe chuck
- 13 Special shaping with "edge profile for coolant run-off"**  
Therefore less coolant is in the spindle bearing or machine spindle

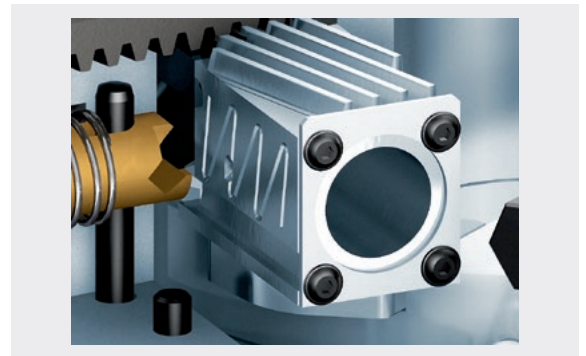
### Spindel with hexagon connection

The vise can be easily actuated via a standard hexagon connection using either conventional socket wrenches, extensions or torque wrenches.



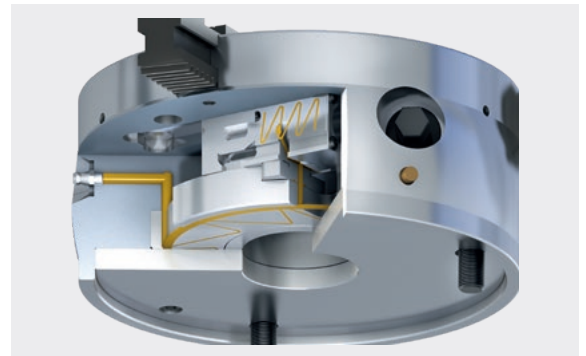
### Wedge bar system with wiper

Wipers at the end of the wedge bars prevent dirt and fine chips from penetrating into the lathe chuck and the chuck mechanism.



### Central lubrication system

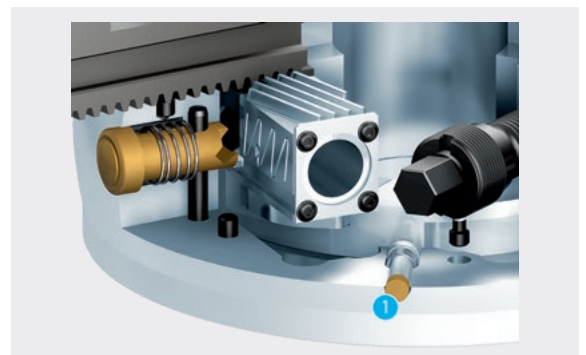
Two lubrication nipples positioned on the chuck body facilitate lubrication of all functional surfaces. The special shape of the grease grooves ensures constant lubrication of the friction surfaces. This improves the clamping behavior during operation.



### Maximum operating safety

To ensure safe working, an indicator pin shows when the chuck mechanism is close to the stroke end position. As soon as the indicator pin moves outwards, the workpiece is no longer clamped correctly and machining must not be started.

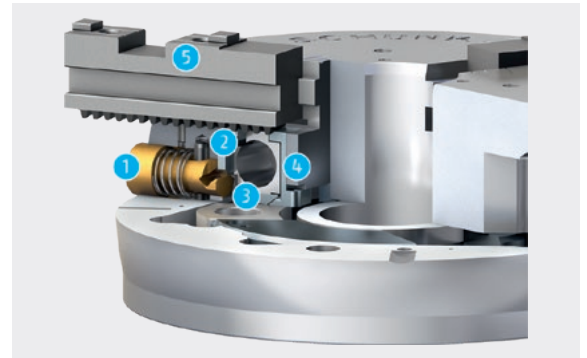
- 1 Indicator pin



### Correct jaw change

When the base jaw is fully inserted into the guideway, the slide positions the base jaw serration for the wedge bar. The base jaw holds the locking slide in the release position. The chuck can now be actuated.

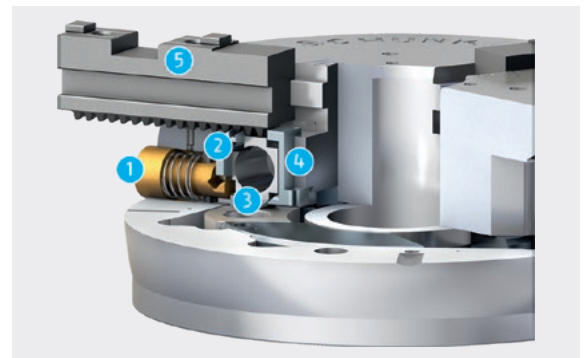
- ① Push button
- ② Slide
- ③ Traverse slide
- ④ Locking slide
- ⑤ Base jaw



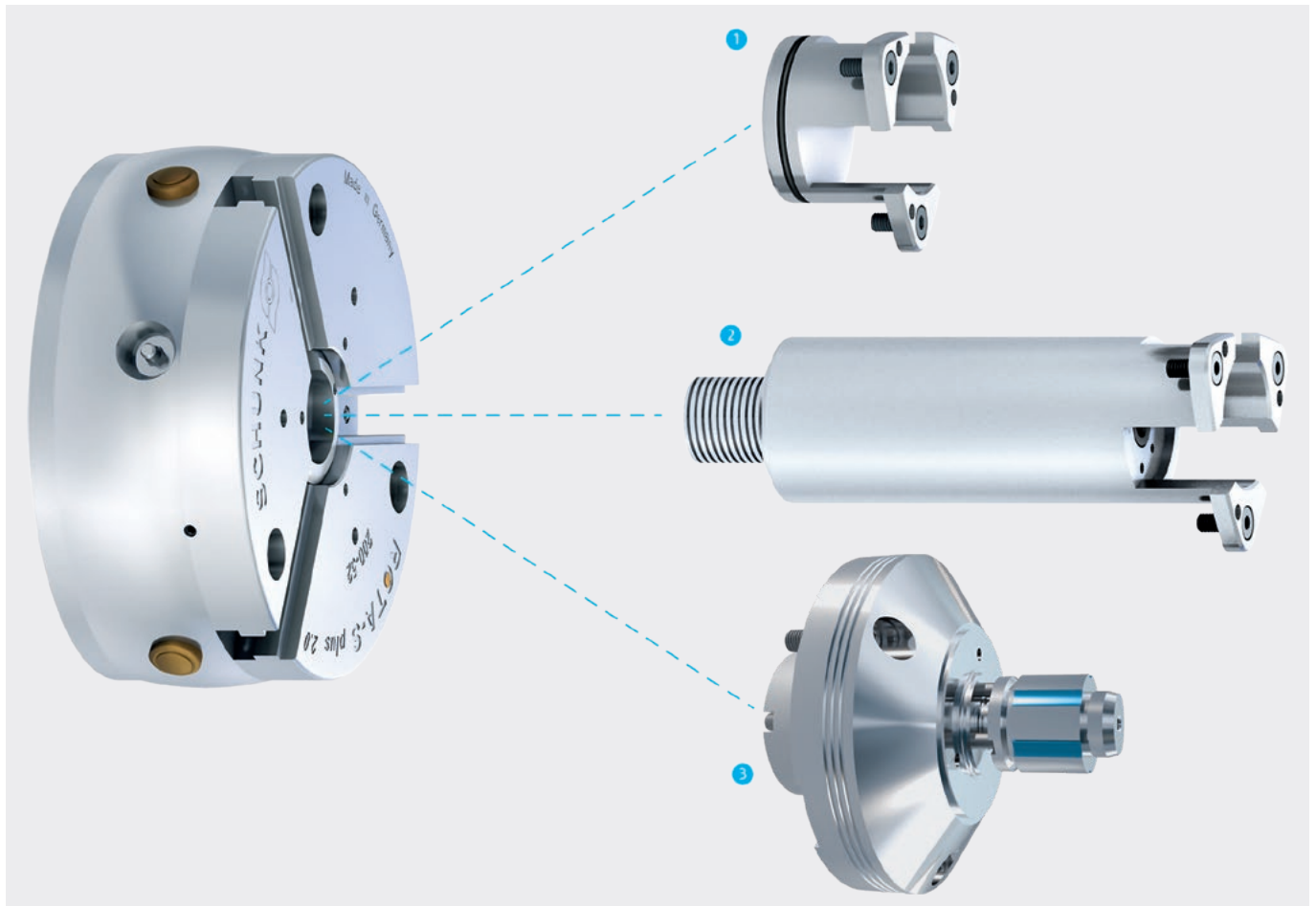
### Incorrect jaw change

If the base jaw is not fully inserted into the guideway, the locking slide prevents the chuck being clamped.

- ① Push button
- ② Slide
- ③ Traverse slide
- ④ Locking slide
- ⑤ Base jaw



## Modular center sleeve system

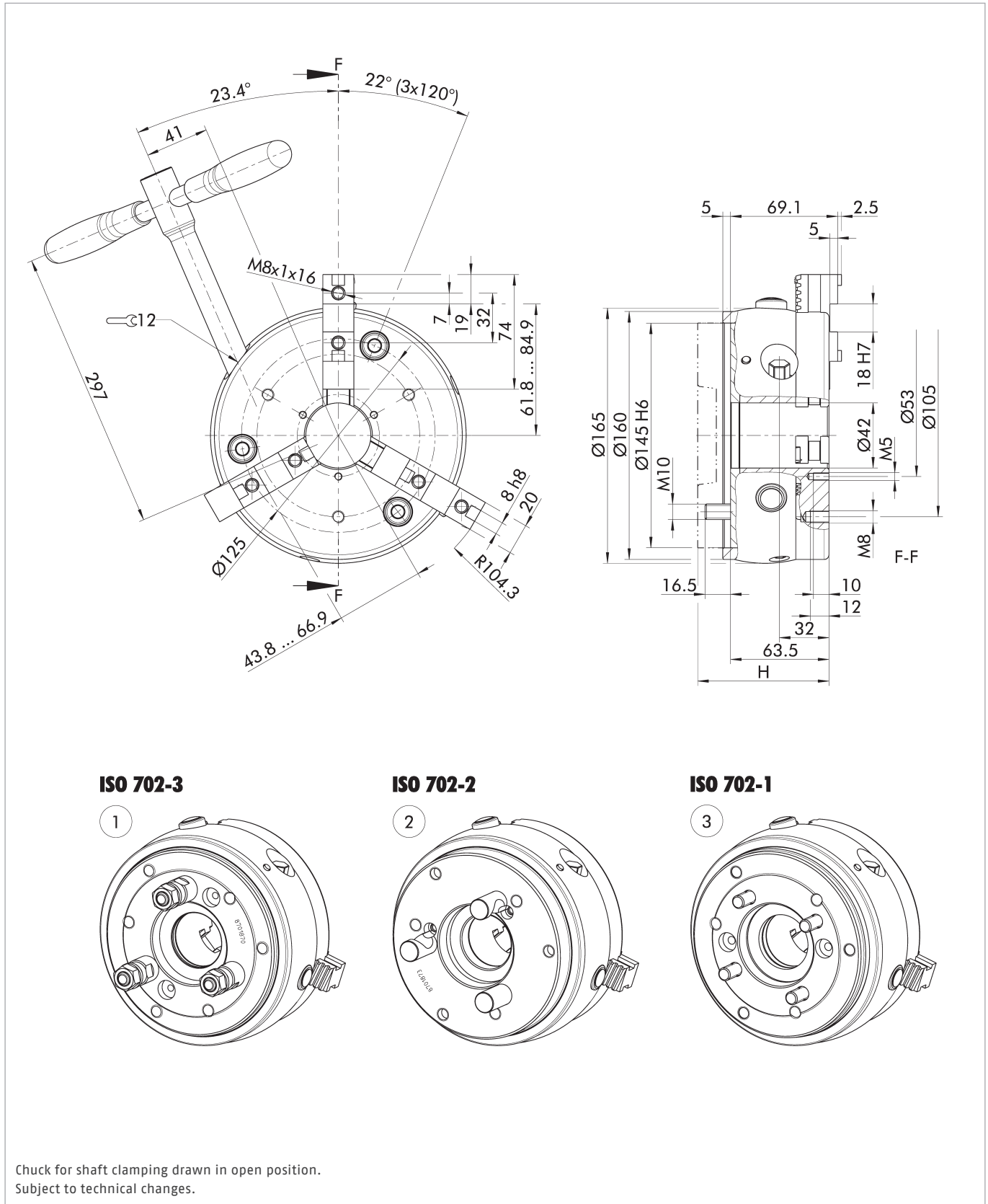


The modular center sleeve system increases flexibility for the most various applications in everyday life.

- ❶ **Closed center sleeve**  
The closed center sleeve prevents penetration of chips and coolant into the through-hole.
- ❷ **Adjustable stop in the center sleeve**  
The adjustable stop ensures that all workpieces are stopped with high repeat accuracy in the same selectable position. This makes handling quick and easy.
- ❸ **Expansion arbor**  
To clamp small inner clamping diameters, the ROTA-S plus 2.0 in sizes  $\varnothing$  200 mm and  $\varnothing$  250 mm can be retrofitted with an expansion arbor. However, a taper must be ground into the chuck body in order to do this.

❶ Modular center sleeve system up to size 315 possible.





① For short taper bayonet mount ISO 702-3 (similar DIN 55027)

③ With intermediate flange for short taper ISO 702-1 (similar DIN 55026)

② For short taper camlock mount ISO 702-2 (similar DIN 55029)



Technical data

Spindle type	Spindle size	Standard	Special Offer Package 1	Special Offer Package 2	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Tooth pitch [mm]	Height H with flange [mm]	Weight [kg]
		ID	ID	ID							
-	Z145	0819001	0819201	0819101	5400	65	80	6.5	4.8		7.9
ISO 702-3	Nr. 4	0819011	0819211	0819111	5400	65	80	6.5	4.8	75.5	9.3
ISO 702-3	Nr. 5	0819021	0819221	0819121	5400	65	80	6.5	4.8	79.5	9.6
ISO 702-3	Nr. 6	0819031	0819231	0819131	5400	65	80	6.5	4.8	85.5	10.4
ISO 702-2	Nr. 4	0819041	0819241	0819141	5400	65	80	6.5	4.8	85.5	10.3
ISO 702-2	Nr. 5	0819051	0819251	0819151	5400	65	80	6.5	4.8	87.5	10.6
ISO 702-2	Nr. 6	0819061	0819261	0819161	5400	65	80	6.5	4.8	103.5	14.4
ISO 702-1	Nr. 4	0819071	0819271	0819171	5400	65	80	6.5	4.8	81.5	9.8
ISO 702-1	Nr. 5	0819081	0819281	0819181	5400	65	80	6.5	4.8	83.5	9.8

Scope of delivery – Standard version

Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key and operating manual

Scope of delivery – Special offer package 1

Chuck, 1 set of stepped block jaws with screws (ground on the chuck), chuck mounting screws, actuation key and operating manual

Scope of delivery – Special offer package 2

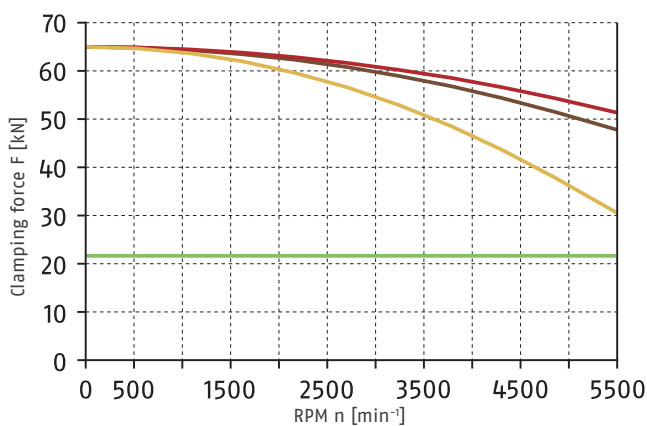
Chuck, 1 set of base jaws with screws, 1 set of hard top jaws (ground on the chuck), chuck mounting screws, actuation key and operating manual

Note

Enlargement of the through-hole

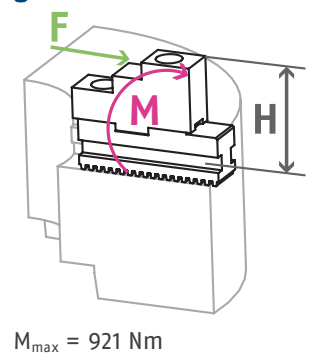
Enlargement of the through-hole to a maximum  $\varnothing$  45 mm available upon request.

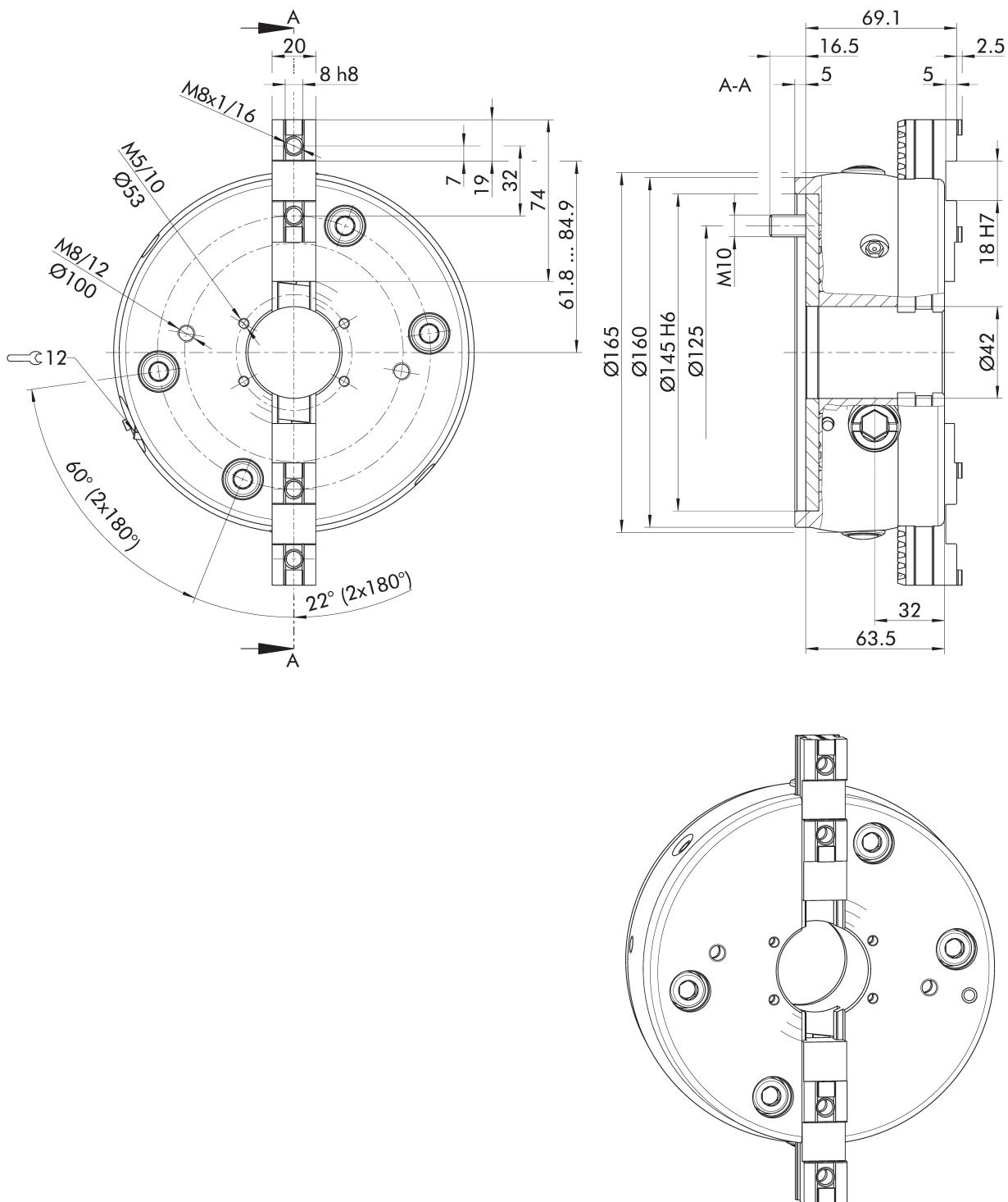
Clamping force-RPM-diagram



- Required minimum clamping force  $F_{spmin}$  33%
- SHF 160 0.6 kg
- STF 160 1.1 kg
- SFA 160 1.2 kg

Load of base jaw guidance





Chuck for shaft clamping drawn in open position.  
Subject to technical changes.

### Technical data

Spindle type	Spindle size	ID	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Tooth pitch [mm]	Weight [kg]
-	Z145	0819100	5400	40	55	6.5	4.8	8.5

### Scope of delivery

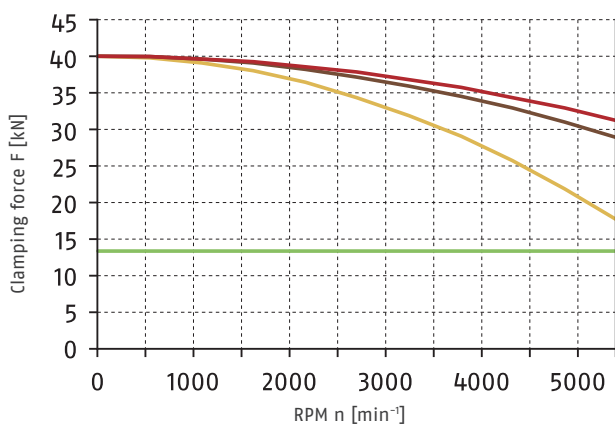
Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key and operating manual

### Note

#### Enlargement of the through-hole

Enlargement of the through-hole to a maximum  $\varnothing$  45 mm available upon request.

### Clamping force-RPM-diagram

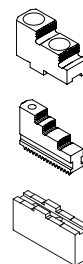


Required minimum clamping force  $F_{spmin}$  33%

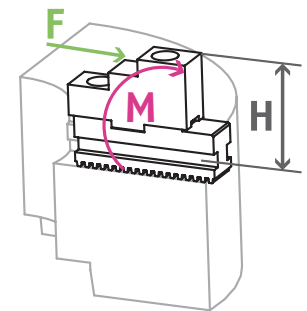
SHF 160  
0.6 kg

STF 160  
1.1 kg

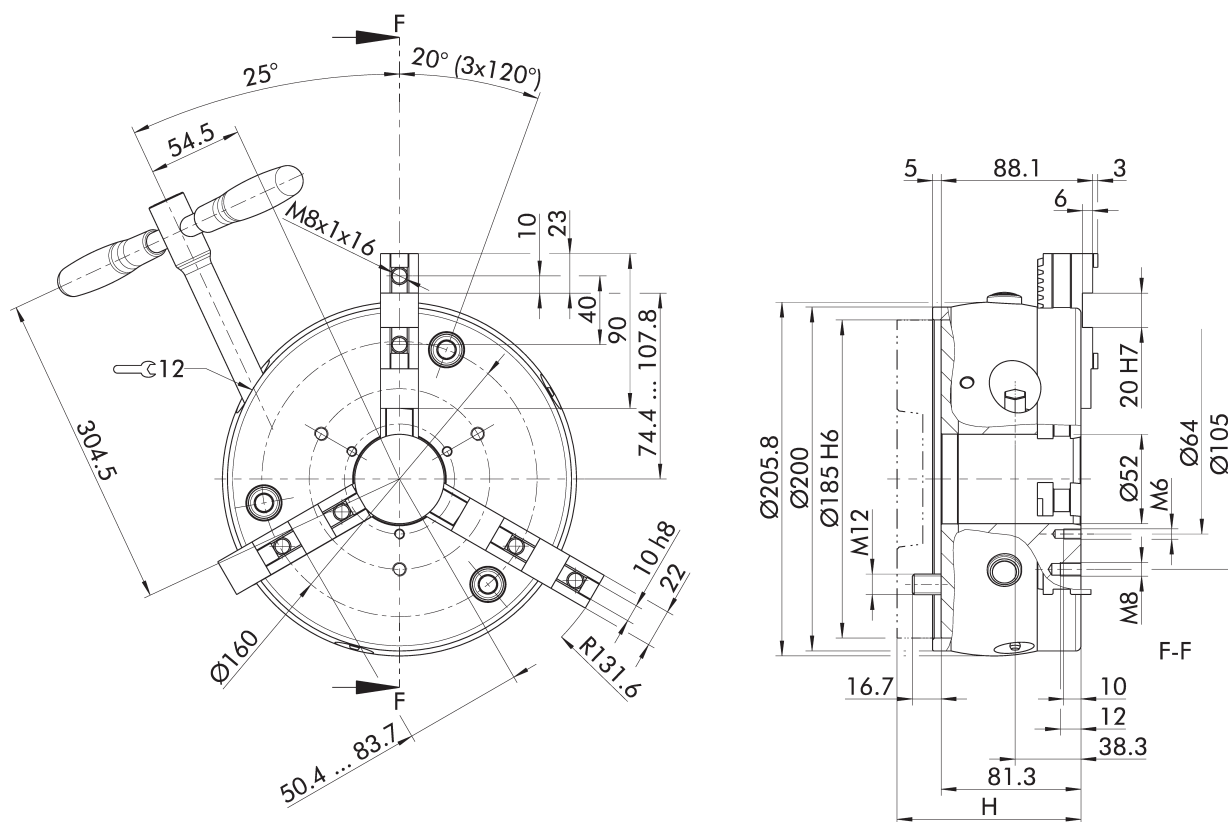
SFA 160  
1.2 kg



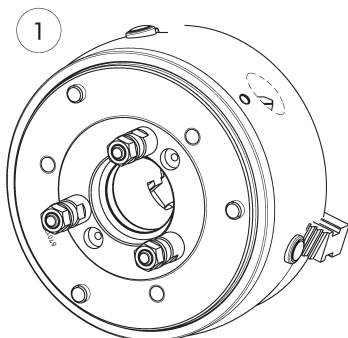
### Load of base jaw guidance



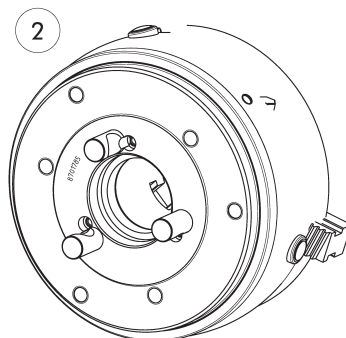
$M_{max} = 567$  Nm



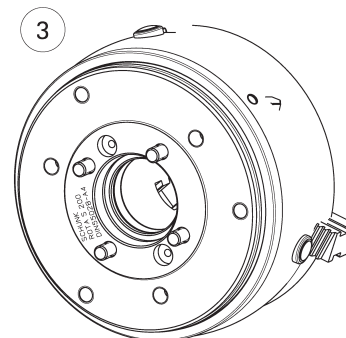
**ISO 702-3**



**ISO 702-2**



**ISO 702-1**



Chuck for shaft clamping drawn in open position.  
Subject to technical changes.

- ① For short taper bayonet mount ISO 702-3 (similar DIN 55027)
- ② For short taper camlock mount ISO 702-2 (similar DIN 55029)

- ③ With intermediate flange for short taper ISO 702-1 (similar DIN 55026)

### Technical data

Spindle type	Spindle size	Standard	Special Offer Package 1	Special Offer Package 2	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Tooth pitch [mm]	Height H with flange [mm]	Weight [kg]
		ID	ID	ID							
-	Z185	0819002	0819202	0819102	4800	100	120	7	4.8		16.2
ISO 702-3	Nr. 4	0819012	0819212	0819112	4800	100	120	7	4.8	93.3	18.4
ISO 702-3	Nr. 5	0819022	0819222	0819122	4800	100	120	7	4.8	95.3	18.6
ISO 702-3	Nr. 6	0819032	0819232	0819132	4800	100	120	7	4.8	97.3	18.6
ISO 702-3	Nr. 8	0819042	0819242	0819142	4800	100	120	7	4.8	108.3	22
ISO 702-2	Nr. 4	0819052	0819252	0819152	4800	100	120	7	4.8	99.3	19.4
ISO 702-2	Nr. 5	0819062	0819262	0819162	4800	100	120	7	4.8	101.3	19.8
ISO 702-2	Nr. 6	0819072	0819272	0819172	4800	100	120	7	4.8	106.3	20.6
ISO 702-1	Nr. 4	0819082	0819282	0819182	4800	100	120	7	4.8	99.3	19.3
ISO 702-1	Nr. 5	0819092	0819292	0819192	4800	100	120	7	4.8	100.3	19.3
ISO 702-1	Nr. 6	0819091	0819291	0819191	4800	100	120	7	4.8	103.3	19.5

### Scope of delivery – Standard version

Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key, eye bolt and operating manual

### Scope of delivery – Special offer package 1

Chuck, 1 set of stepped block jaws with screws (ground on the chuck), chuck mounting screws, actuation key, eye bolt, and operating manual

### Scope of delivery – Special offer package 2

Chuck, 1 set of base jaws with screws, 1 set of hard top jaws (ground on the chuck), chuck mounting screws, actuation key, eye bolt, and operating manual

### Notes

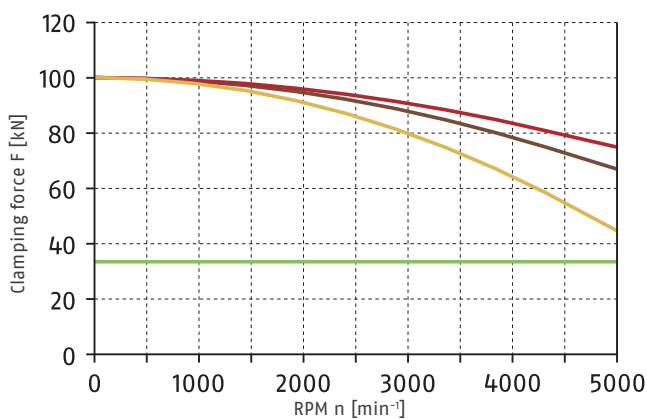
#### Enlargement of the through-hole

Enlargement of the through-hole to a maximum  $\varnothing$  55 mm available upon request.

#### vario M

vario M can be used only after modifying the lathe chuck with a ground taper (ID 1302655).

### Clamping force-RPM-diagram

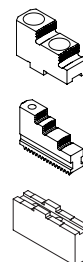


Required minimum clamping force  $F_{spmin}$  33%

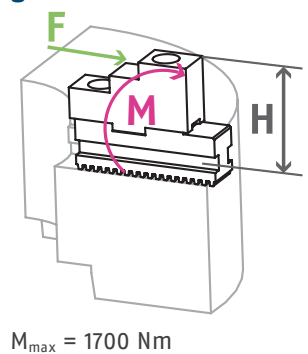
SHF 200  
0.82 kg

STF 200  
1.9 kg

SFA 200  
2 kg



### Load of base jaw guidance





### Technical data

Spindle type	Spindle size	ID	Max. rotational speed [ $\text{min}^{-1}$ ]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Tooth pitch [mm]	Weight [kg]
-	Z185	0819200	4800	65	80	7	4.8	18.2

### Scope of delivery

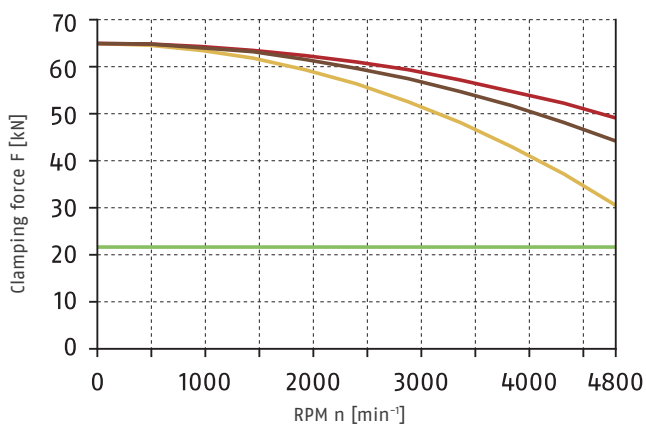
Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key, eye bolt and operating manual

### Note

#### Enlargement of the through-hole

Enlargement of the through-hole to a maximum  $\varnothing$  55 mm available upon request.

### Clamping force-RPM-diagram

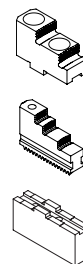


Required minimum clamping force  $F_{\text{spmin}}$  33%

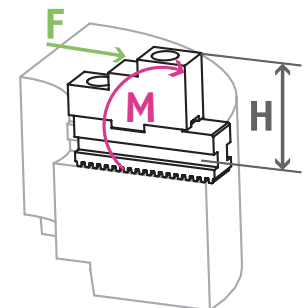
SHF 200  
0.82 kg

STF 200  
1.9 kg

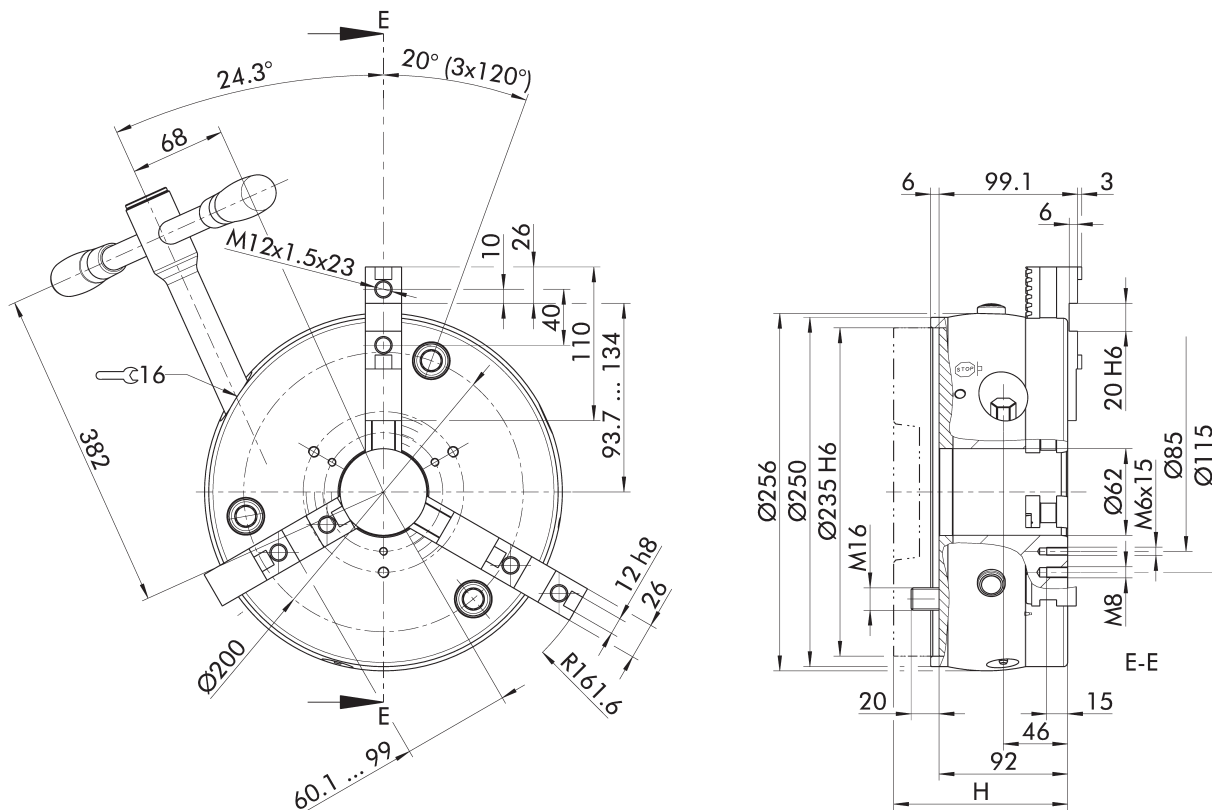
SFA 200  
2 kg



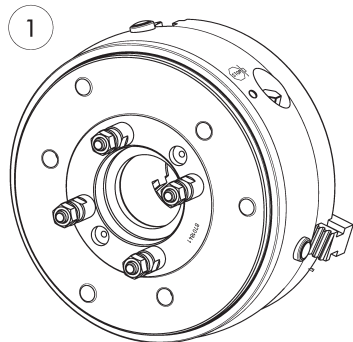
### Load of base jaw guidance



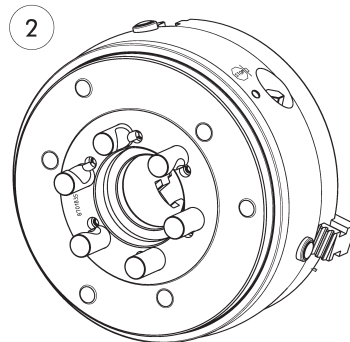
$M_{\text{max}} = 1105 \text{ Nm}$



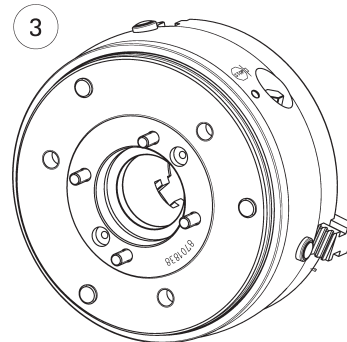
**ISO 702-3**



**ISO 702-2**



**ISO 702-1**



Chuck for shaft clamping drawn in open position.  
Subject to technical changes.

① For short taper bayonet mount ISO 702-3 (similar DIN 55027)

② For short taper camlock mount ISO 702-2 (similar DIN 55029)

③ With intermediate flange for short taper ISO 702-1 (similar DIN 55026)



Technical data

Spindle type	Spindle size	Standard	Special Offer Package 1	Special Offer Package 2	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Tooth pitch [mm]	Height H with flange [mm]	Weight [kg]
		ID	ID	ID							
-	Z235	0819003	0819203	0819103	4200	160	210	7.7	6		28.8
ISO 702-3	Nr. 5	0819013	0819213	0819113	4200	160	210	7.7	6	107	33.2
ISO 702-3	Nr. 6	0819023	0819223	0819123	4200	160	210	7.7	6	108	33.2
ISO 702-3	Nr. 8	0819033	0819233	0819133	4200	160	210	7.7	6	112	33.9
ISO 702-2	Nr. 5	0819043	0819243	0819143	4200	160	210	7.7	6	112	34.8
ISO 702-2	Nr. 6	0819053	0819253	0819153	4200	160	210	7.7	6	117	36.2
ISO 702-2	Nr. 8	0819063	0819263	0819163	4200	160	210	7.7	6	122	37
ISO 702-1	Nr. 5	0819073	0819273	0819173	4200	160	210	7.7	6	110	33.8
ISO 702-1	Nr. 6	0819083	0819283	0819183	4200	160	210	7.7	6	112	34
ISO 702-1	Nr. 8	0819093	0819293	0819193	4200	160	210	7.7	6	120	35.7

Scope of delivery – Standard version

Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key, eye bolt and operating manual

Scope of delivery – Special offer package 1

Chuck, 1 set of stepped block jaws with screws (ground on the chuck), chuck mounting screws, actuation key, eye bolt, and operating manual

Scope of delivery – Special offer package 2

Chuck, 1 set of base jaws with screws, 1 set of hard top jaws (ground on the chuck), chuck mounting screws, actuation key, eye bolt, and operating manual

Notes

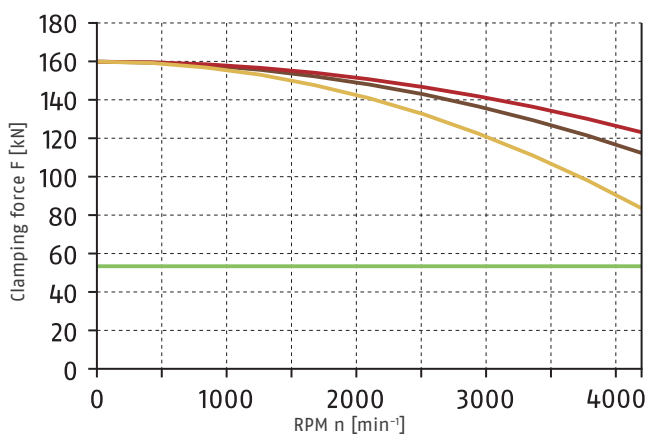
Enlargement of the through-hole

Enlargement of the through-hole to a maximum  $\varnothing$  75 mm available upon request.

vario M

vario M can only be used after modifying the lathe chuck with a ground taper (ID 1302658).

Clamping force-RPM-diagram

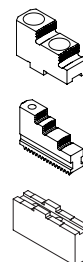


Required minimum clamping force F<sub>spmin</sub> 33%

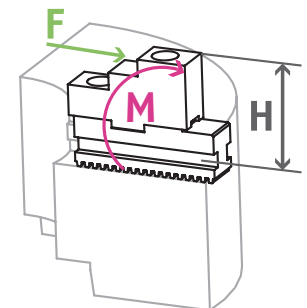
SHF 250  
1.9 kg

STF 250  
3.3 kg

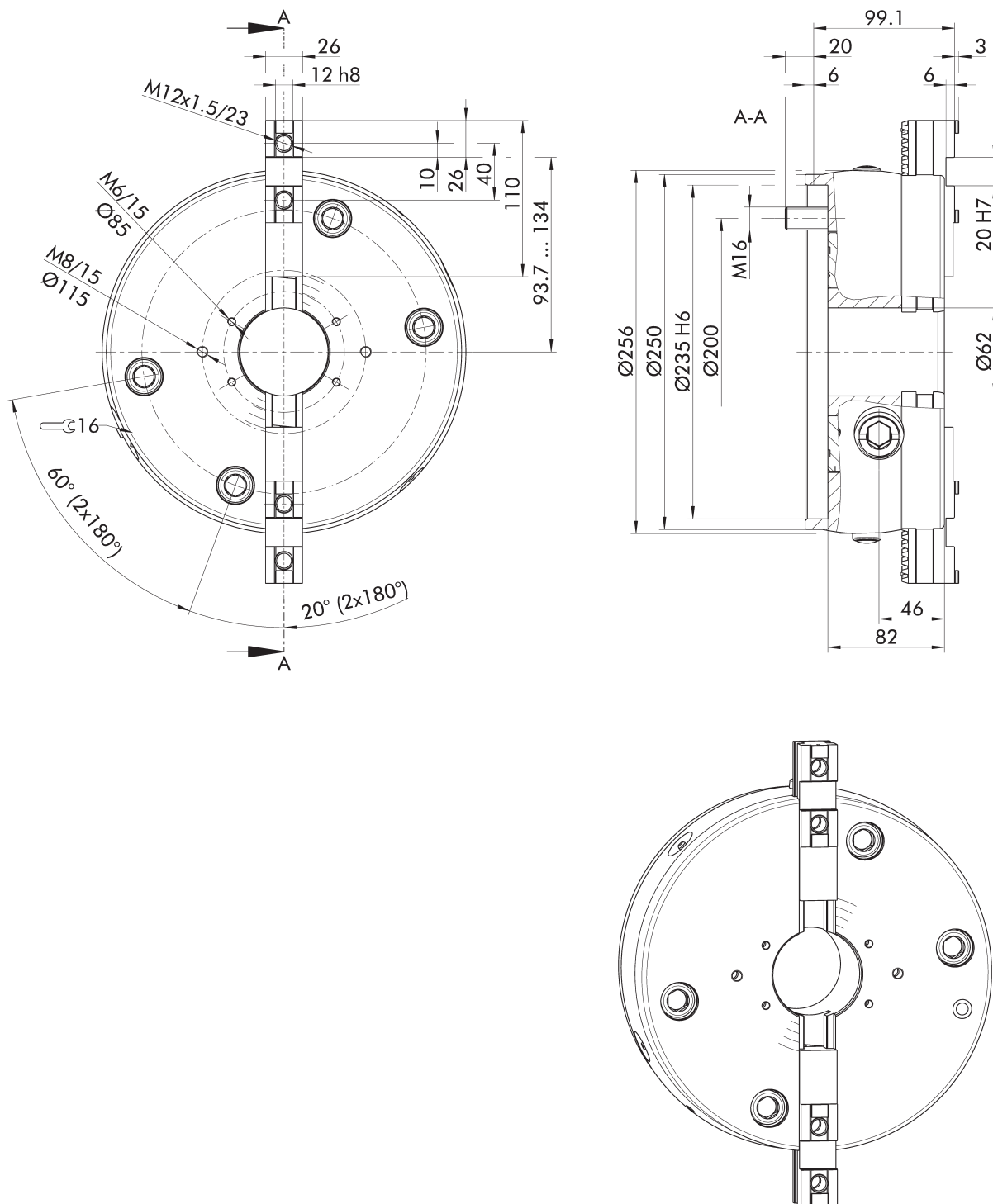
SFA 250  
3.7 kg



Load of base jaw guidance



M<sub>max</sub> = 3520 Nm



Chuck for shaft clamping drawn in open position.  
Subject to technical changes.

Technical data

Spindle type	Spindle size	ID	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Tooth pitch [mm]	Weight [kg]
-	Z235	0819300	4200	105	140	7.7	6	30.4

Scope of delivery

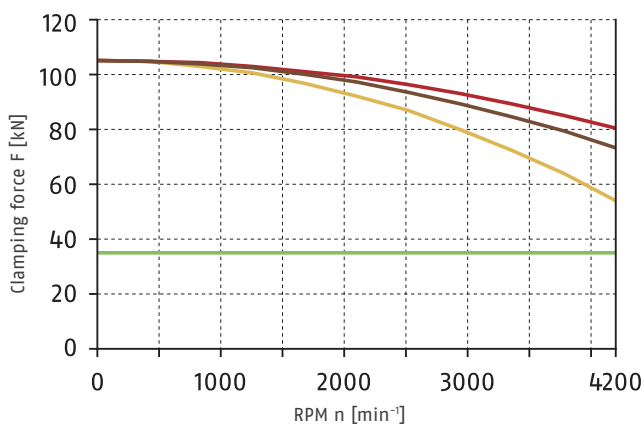
Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key, eye bolt and operating manual

Note

Enlargement of the through-hole

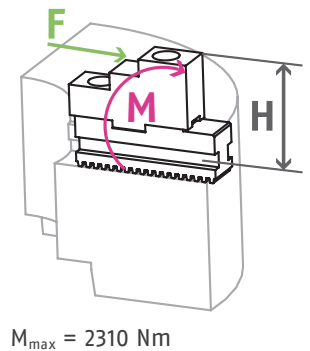
Enlargement of the through-hole to a maximum  $\varnothing$  75 mm available upon request.

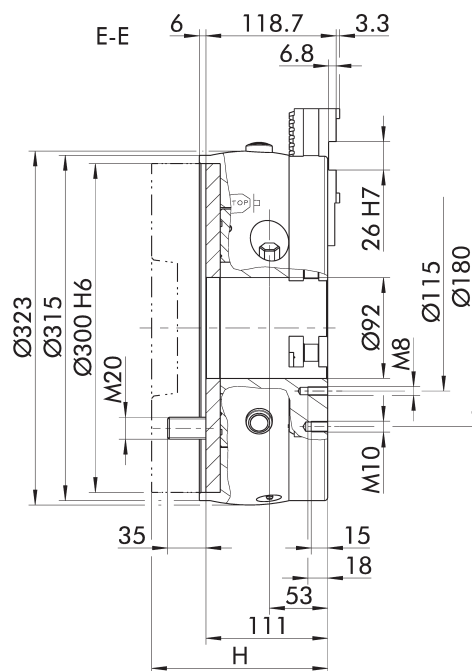
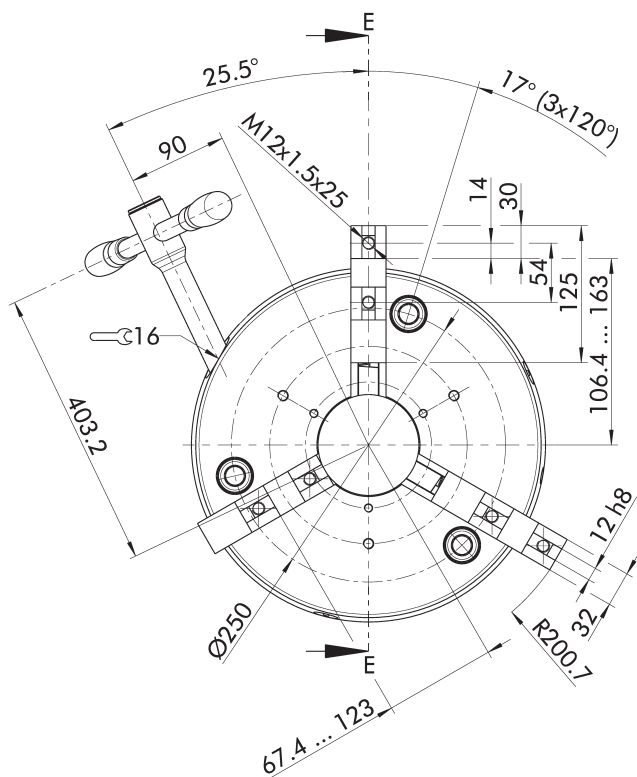
Clamping force-RPM-diagram



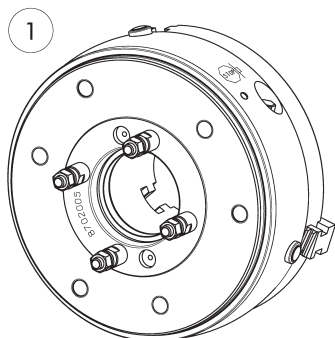
- Required minimum clamping force  $F_{spmin}$  33%
- SHF 250  
1.9 kg
- STF 250  
3.3 kg
- SFA 250  
3.7 kg

Load of base jaw guidance

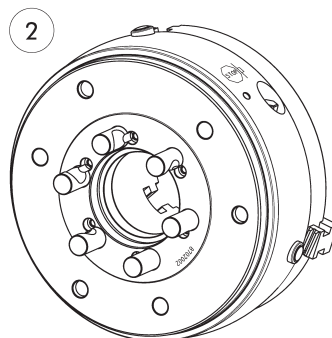




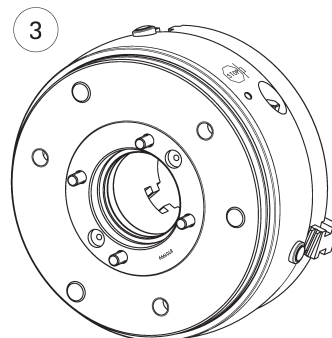
**ISO 702-3**



**ISO 702-2**



**ISO 702-1**



Chuck for shaft clamping drawn in open position.  
Subject to technical changes.

- ① For short taper bayonet mount ISO 702-3 (similar DIN 55027)
- ② For short taper camlock mount ISO 702-2 (similar DIN 55029)

- ③ With intermediate flange for short taper ISO 702-1 (similar DIN 55026)

### Technical data

Spindle type	Spindle size	Standard	Special Offer Package 1	Special Offer Package 2	Max. rotational speed	Max. clamping force	Max. torque	Stroke/jaw	Tooth pitch	Height H with flange	Weight
		ID	ID	ID	[min <sup>-1</sup> ]	[kN]	[Nm]	[mm]	[mm]	[mm]	[kg]
-	Z300	0819004	0819204	0819104	3400	180	220	9.8	7		54.2
ISO 702-3	Nr. 6	0819014	0819214	0819114	3400	180	220	9.8	7	128	62.1
ISO 702-3	Nr. 8	0819024	0819224	0819124	3400	180	220	9.8	7	130	62.6
ISO 702-3	Nr. 11	0819034	0819234	0819134	3400	180	220	9.8	7	133	63.3
ISO 702-2	Nr. 6	0819044	0819244	0819144	3400	180	220	9.8	7	133	64.7
ISO 702-2	Nr. 8	0819054	0819254	0819154	3400	180	220	9.8	7	138	66.7
ISO 702-2	Nr. 11	0819064	0819264	0819164	3400	180	220	9.8	7	143	67.5
ISO 702-1	Nr. 6	0819074	0819274	0819174	3400	180	220	9.8	7	136	65.6
ISO 702-1	Nr. 8	0819084	0819284	0819184	3400	180	220	9.8	7	136	64.8
ISO 702-1	Nr. 11	0819094	0819294	0819194	3400	180	220	9.8	7	146	67.6

### Scope of delivery – Standard version

Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key, eye bolt and operating manual

### Scope of delivery – Special offer package 1

Chuck, 1 set of stepped block jaws with screws (ground on the chuck), chuck mounting screws, actuation key, eye bolt, and operating manual

### Scope of delivery – Special offer package 2

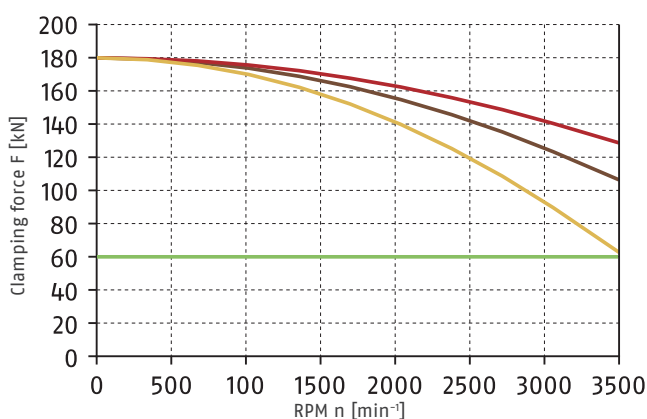
Chuck, 1 set of base jaws with screws, 1 set of hard top jaws (ground on the chuck), chuck mounting screws, actuation key, eye bolt, and operating manual

### Note

#### Enlargement of the through-hole

Enlargement of the through-hole to a maximum  $\varnothing$  102 mm available upon request.

### Clamping force-RPM-diagram

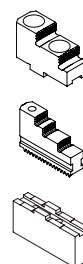


Required minimum clamping force  $F_{spmin}$  33%

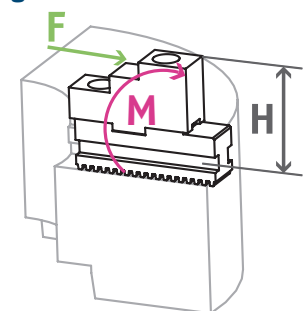
SHF 315  
3.3 kg

STF 315  
5.5 kg

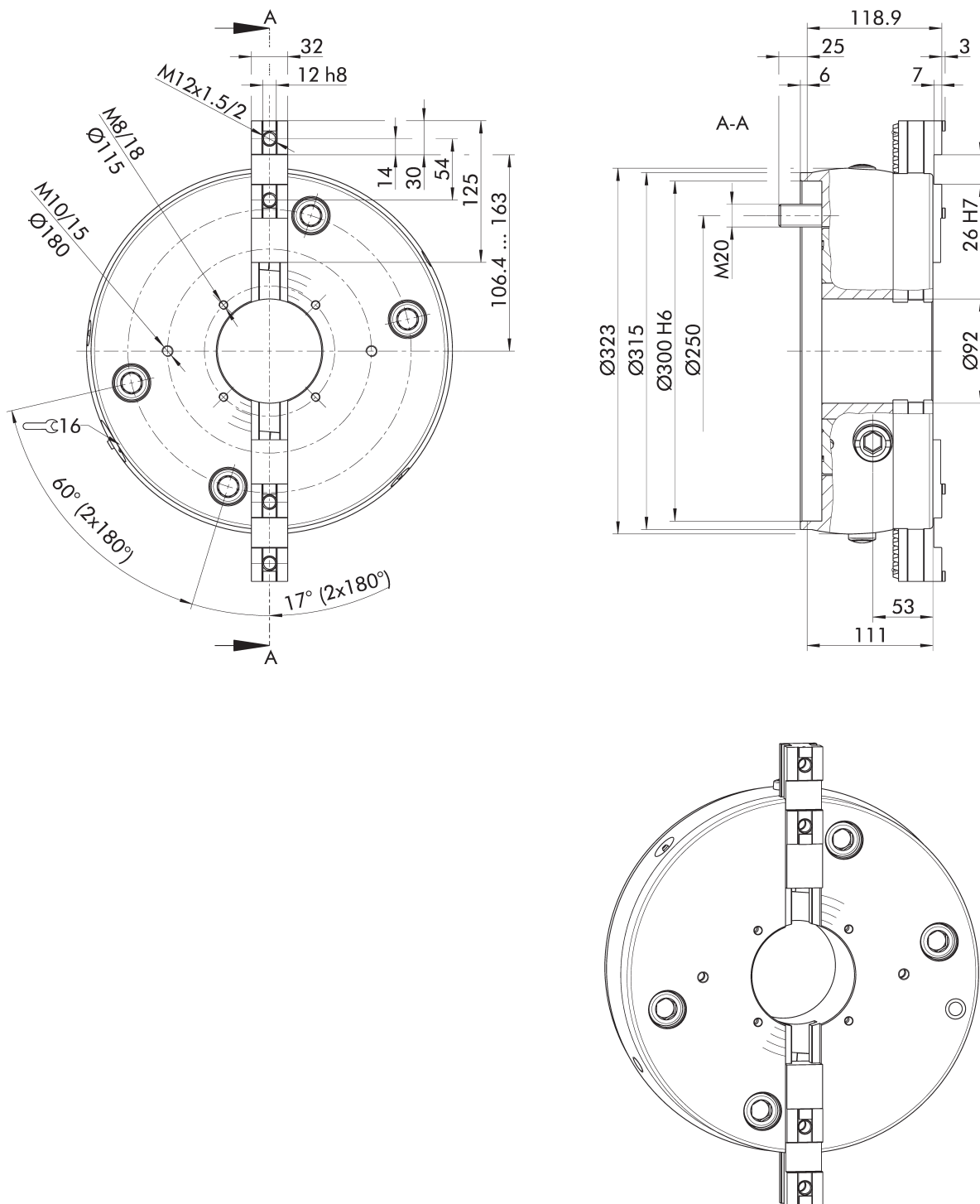
SFA 315  
5.6 kg



### Load of base jaw guidance



$$M_{max} = 4440 \text{ Nm}$$



Chuck for shaft clamping drawn in open position.  
Subject to technical changes.

Technical data

Spindle type	Spindle size	ID	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Tooth pitch [mm]	Weight [kg]
-	Z300	1348227	3400	120	150	9.7	7	60.5

Scope of delivery

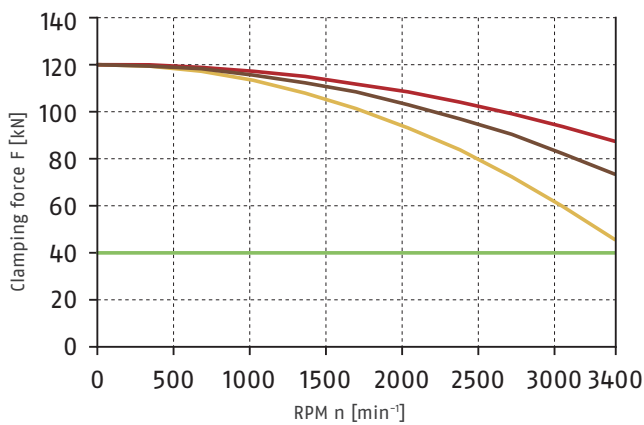
Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key, eye bolt and operating manual

Note

Enlargement of the through-hole

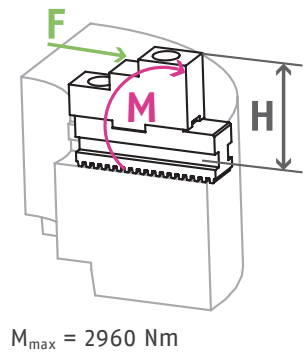
Enlargement of the through-hole to a maximum  $\varnothing$  102 mm available upon request.

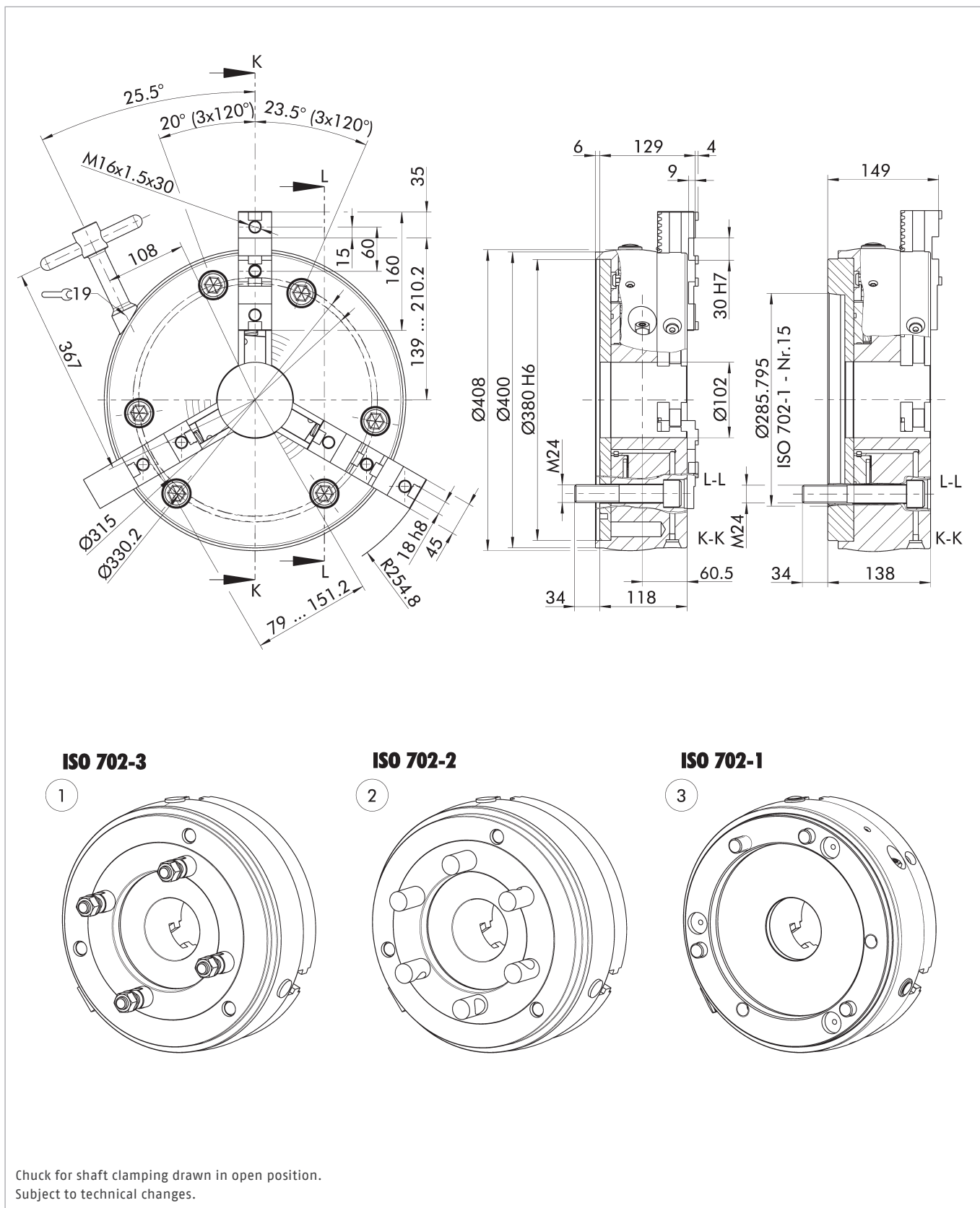
Clamping force-RPM-diagram



- Required minimum clamping force  $F_{spmin}$  33%
- SHF 315 3.3 kg
- STF 315 5.5 kg
- SFA 315 5.6 kg

Load of base jaw guidance





① For short taper bayonet mount ISO 702-3 (similar DIN 55027)

② For short taper camlock mount ISO 702-2 (similar DIN 55029)

③ With intermediate flange for short taper ISO 702-1 (similar DIN 55026)



### Technical data

Spindle type	Spindle size	Standard	Special Offer Package 1	Special Offer Package 2	Max. rotational speed	Max. clamping force	Max. torque	Stroke/jaw	Tooth pitch	Weight
		ID	ID	ID	[min <sup>-1</sup> ]	[kN]	[Nm]	[mm]	[mm]	[kg]
ISO 702-4	Nr. 15 (Z380)	0814240	0814340	0814640	2200	230	280	12	8.5	99
ISO 702-3	Nr. 8	0814241	0814341	0814641	2200	230	280	12	8.5	113
ISO 702-3	Nr. 11	0814242	0814342	0814642	2200	230	280	12	8.5	110
ISO 702-2	Nr. 8	0814243	0814343	0814643	2200	230	280	12	8.5	117
ISO 702-2	Nr. 11	0814244	0814344	0814644	2200	230	280	12	8.5	118
ISO 702-1	Nr. 8	0814245	0814345	0814645	2200	230	280	12	8.5	108
ISO 702-1	Nr. 11	0814246	0814346	0814646	2200	230	280	12	8.5	107
ISO 702-1	Nr. 15	0814249	0814349	0814649	2200	230	280	12	8.5	105

### Scope of delivery – Standard version

Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key, eye bolt and operating manual

### Scope of delivery – Special offer package 1

Chuck, 1 set of stepped block jaws with screws (ground on the chuck), chuck mounting screws, actuation key, eye bolt, and operating manual

### Scope of delivery – Special offer package 2

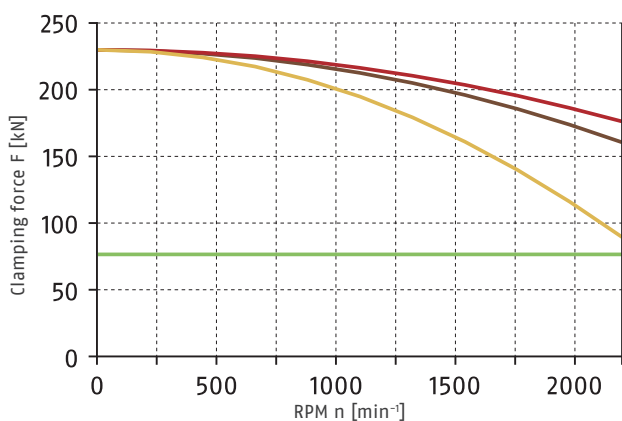
Chuck, 1 set of base jaws with screws, 1 set of hard top jaws (ground on the chuck), chuck mounting screws, actuation key, eye bolt, and operating manual

### Note

#### Enlargement of the through-hole

Enlargement of the through-hole to a maximum  $\varnothing$  130 mm available upon request.

### Clamping force-RPM-diagram

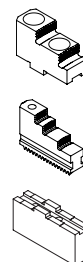


Required minimum clamping force  $F_{spmin}$  33%

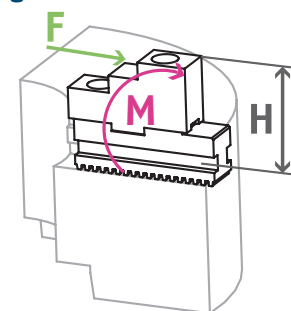
SHF 400  
6.8 kg

STF 400  
10.8 kg

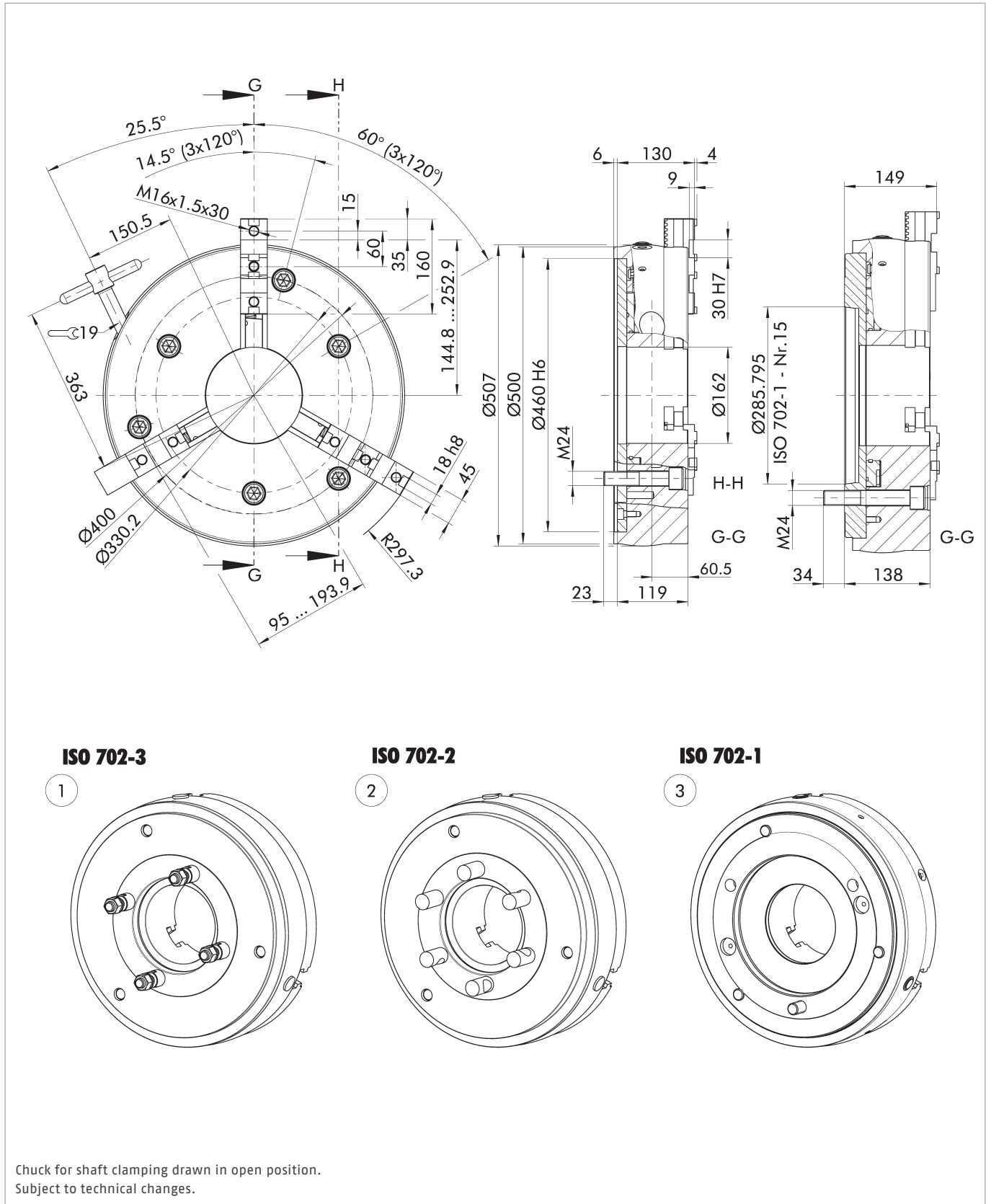
SFA 400  
13.7 kg



### Load of base jaw guidance



$$M_{max} = 7437 \text{ Nm}$$



- ① For short taper bayonet mount ISO 702-3 (similar DIN 55027)
- ② For short taper camlock mount ISO 702-2 (similar DIN 55029)

- ③ With intermediate flange for short taper ISO 702-1 (similar DIN 55026)

Technical data

Spindle type	Spindle size	Standard	Special Offer Package 1	Special Offer Package 2	Max. rotational speed	Max. clamping force	Max. torque	Stroke/jaw	Tooth pitch	Weight
		ID	ID	ID	[min <sup>-1</sup> ]	[kN]	[Nm]	[mm]	[mm]	[kg]
-	Z460	0814250	0814350	0814650	1500	270	320	12	8.5	152
ISO 702-3	Nr. 8	0814251	0814351	0814651	1500	270	320	12	8.5	175
ISO 702-3	Nr. 11	0814252	0814352	0814652	1500	270	320	12	8.5	172
ISO 702-3	Nr. 15	0814253	0814353	0814653	1500	270	320	12	8.5	174
ISO 702-2	Nr. 8	0814254	0814354	0814654	1500	270	320	12	8.5	180
ISO 702-2	Nr. 11	0814255	0814355	0814655	1500	270	320	12	8.5	182
ISO 702-2	Nr. 15	0814256	0814356	0814656	1500	270	320	12	8.5	200
ISO 702-1	Nr. 8	0814257	0814357	0814657	1500	270	320	12	8.5	192
ISO 702-1	Nr. 11	0814258	0814358	0814658	1500	270 <td 320	12	8.5	171	
ISO 702-1	Nr. 15	0814259	0814359	0814659	1500	270	320	12	8.5	183

Scope of delivery – Standard version

Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key, eye bolt and operating manual

Scope of delivery – Special offer package 1

Chuck, 1 set of stepped block jaws with screws (ground on the chuck), chuck mounting screws, actuation key, eye bolt, and operating manual

Scope of delivery – Special offer package 2

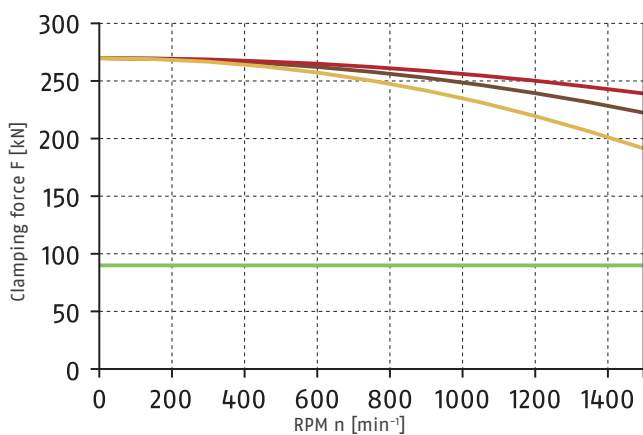
Chuck, 1 set of base jaws with screws, 1 set of hard top jaws (ground on the chuck), chuck mounting screws, actuation key, eye bolt, and operating manual

Note

Enlargement of the through-hole

Enlargement of the through-hole to a maximum  $\varnothing$  180 mm available upon request.

Clamping force-RPM-diagram

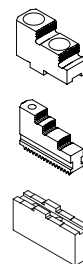


Required minimum clamping force F<sub>spmin</sub> 33%

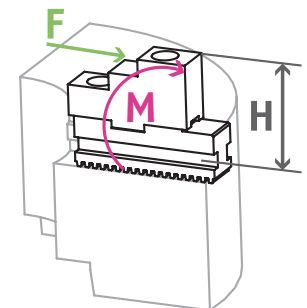
SHF 400  
6.8 kg

STF 400  
10.8 kg

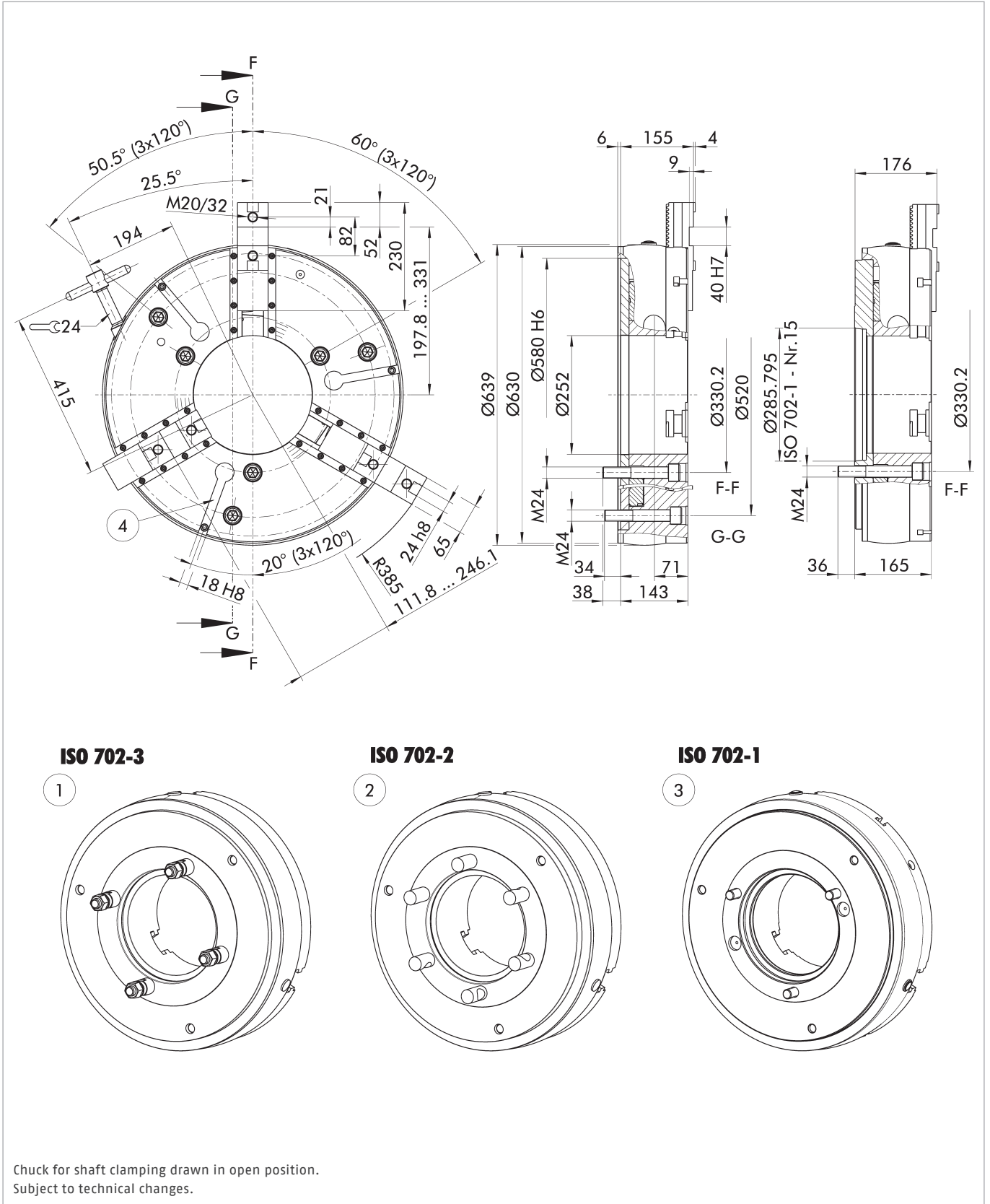
SFA 400  
13.7 kg



Load of base jaw guidance



M<sub>max</sub> = 8730 Nm



① For short taper bayonet mount ISO 702-3 (similar DIN 55027)

② For short taper camlock mount ISO 702-2 (similar DIN 55029)

③ With intermediate flange for short taper ISO 702-1 (similar DIN 55026)

### Technical data

Spindle type	Spindle size	Standard ID	Special Offer Package 2 ID	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Tooth pitch [mm]	Weight [kg]
-	Z580	0814260	0814660	1000	270	350	15	8.5	256
ISO 702-3	Nr. 11	0814261	0814661	1000	270	350	15	8.5	256
ISO 702-3	Nr. 15	0814262	0814662	1000	270	350	15	8.5	256
ISO 702-2	Nr. 11	0814263	0814663	1000	270	350	15	8.5	256
ISO 702-2	Nr. 15	0814264	0814664	1000	270	350	15	8.5	256
ISO 702-1	Nr. 11	0814265	0814665	1000	270	350	15	8.5	256
ISO 702-1	Nr. 15	0814266	0814666	1000	270 </td <td>350</td> <td>15</td> <td>8.5</td> <td>256</td>	350	15	8.5	256

### Scope of delivery – Standard version

Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key, eye bolt and operating manual

### Scope of delivery – Special offer package 2

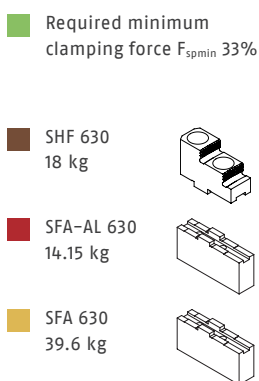
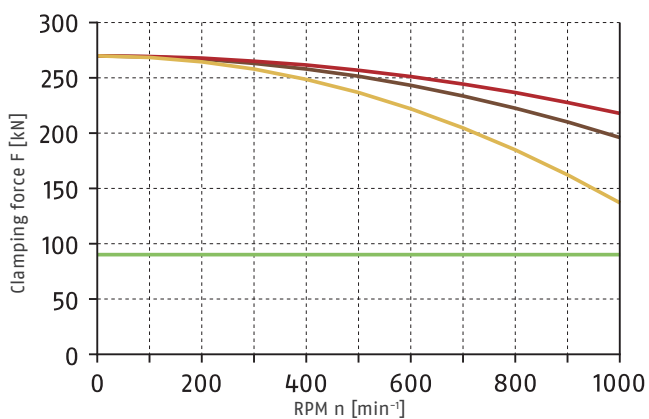
Chuck, 1 set of base jaws with screws, 1 set of hard top jaws (ground on the chuck), chuck mounting screws, actuation key, eye bolt, and operating manual

### Note

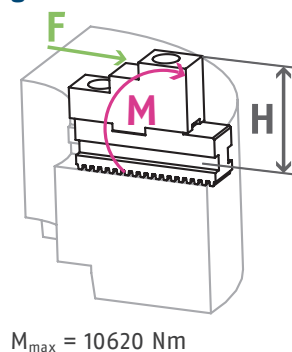
#### Enlargement of the through-hole

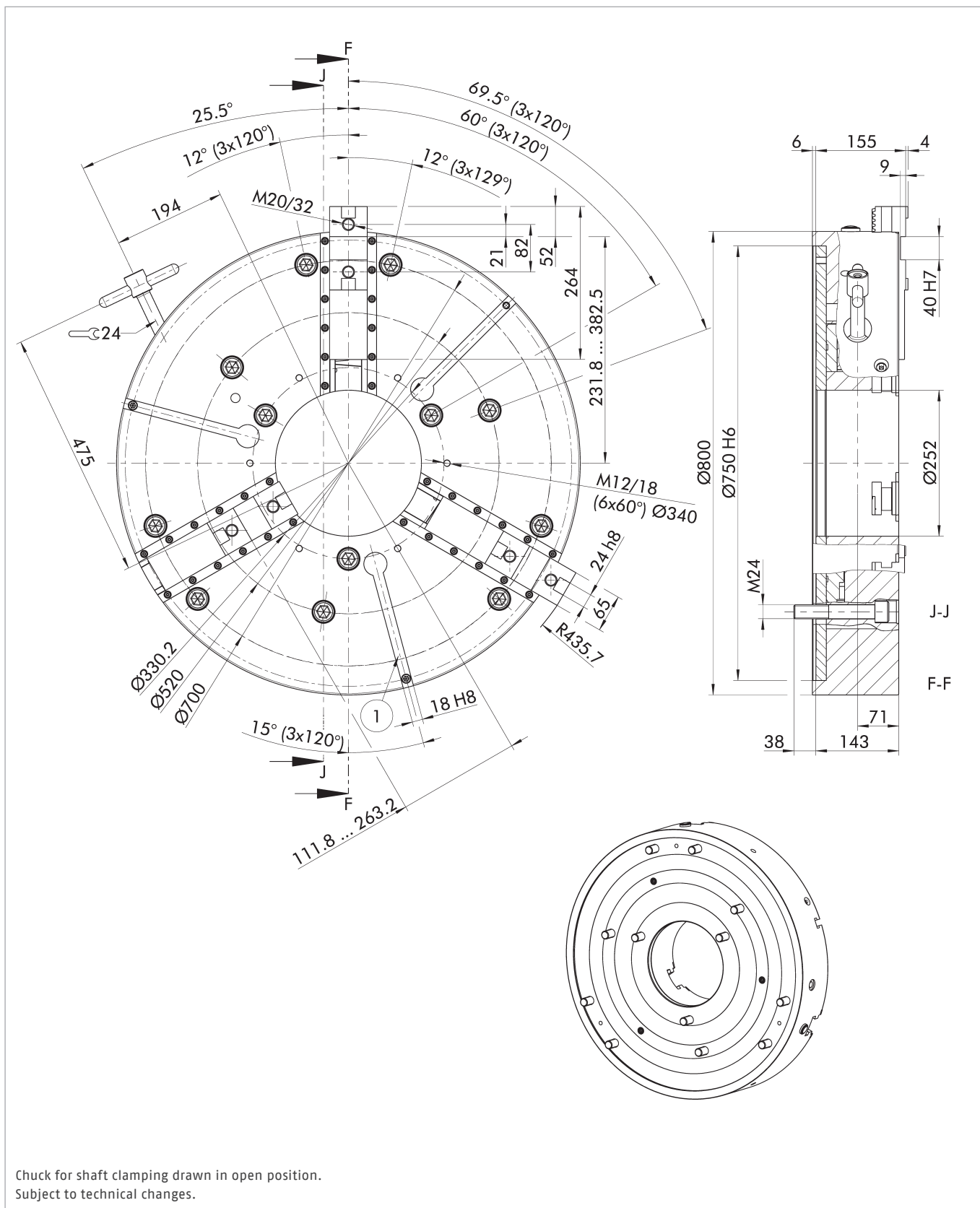
Enlargement of the through-hole to a maximum  $\varnothing$  270 mm available upon request.

### Clamping force-RPM-diagram



### Load of base jaw guidance





① For nut DIN 508 - M16 x 18

### Technical data

Spindle type	Spindle size	ID	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Tooth pitch [mm]	Weight [kg]
-	Z750	0814280	1000	270	350	15	8.5	465
ISO 702-1	Nr. 15	0814284	1000	270	350	15	8.5	465

### Scope of delivery

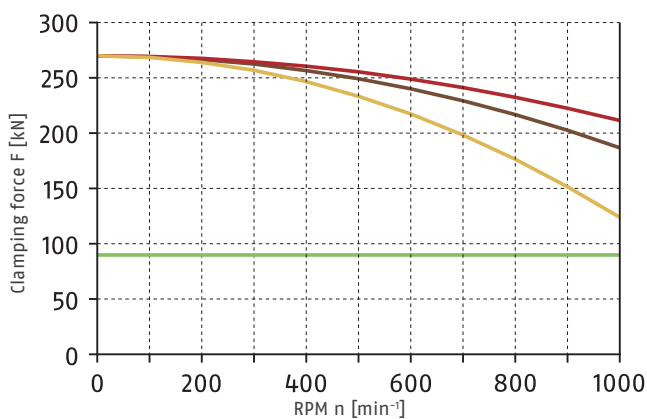
Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key, eye bolt and operating manual

### Note

#### Enlargement of the through-hole

Enlargement of the through-hole to a maximum  $\varnothing$  270 mm available upon request.

### Clamping force-RPM-diagram

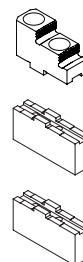


Required minimum clamping force  $F_{spmin}$  33%

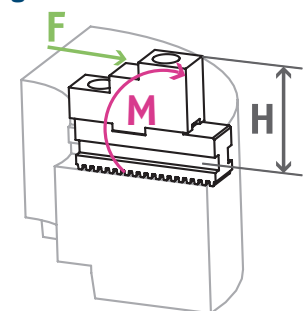
SHF 630  
18 kg

SFA-AL 630  
14.15 kg

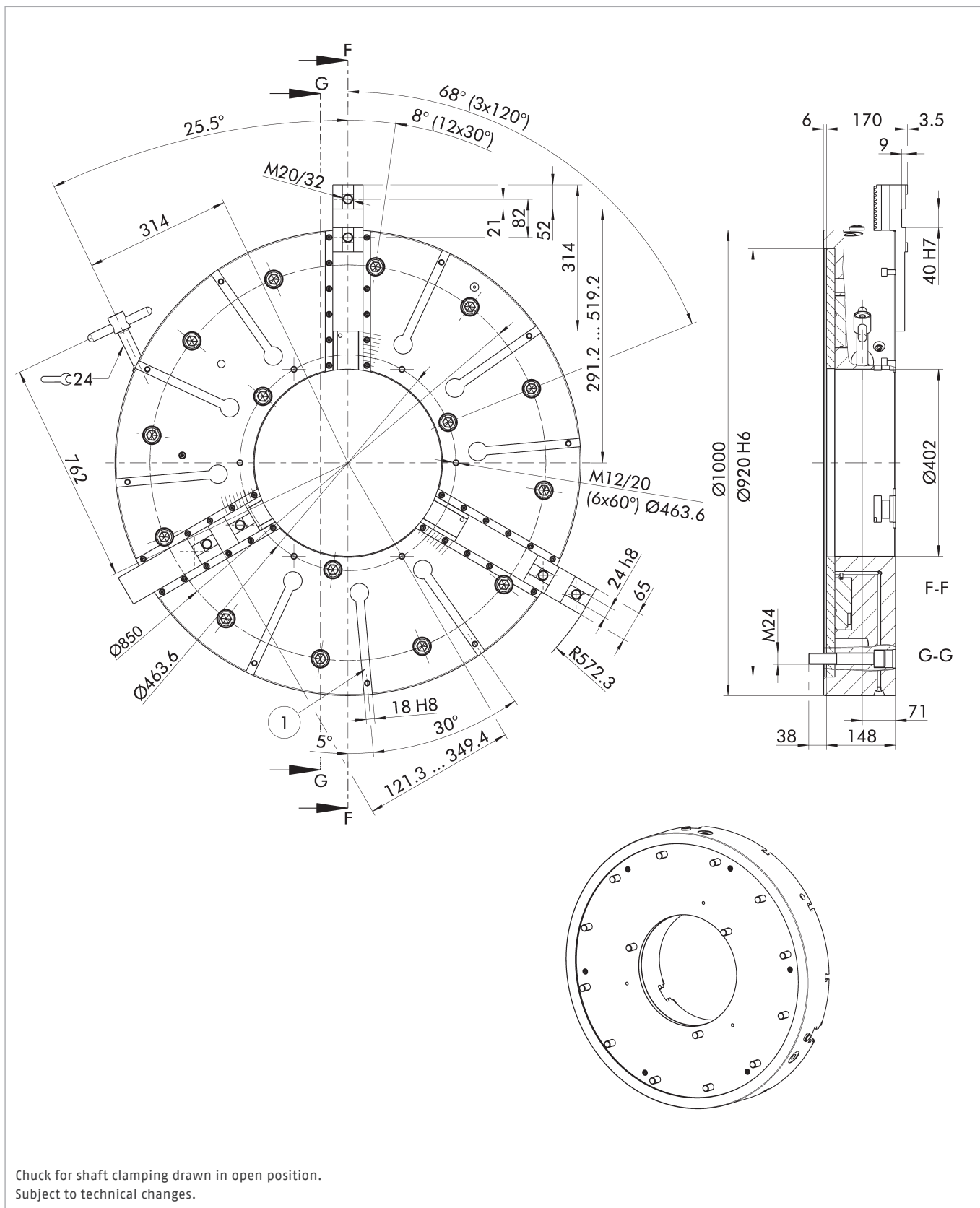
SFA 630  
39.6 kg



### Load of base jaw guidance



$M_{max} = 10620 \text{ Nm}$



① For nut DIN 508 - M16 x 18



Technical data

Spindle type	Spindle size	ID	Max. rotational speed [min <sup>-1</sup> ]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Tooth pitch [mm]	Weight [kg]
-	Z920	0814290	900	270	350	15	8.5	720

Scope of delivery

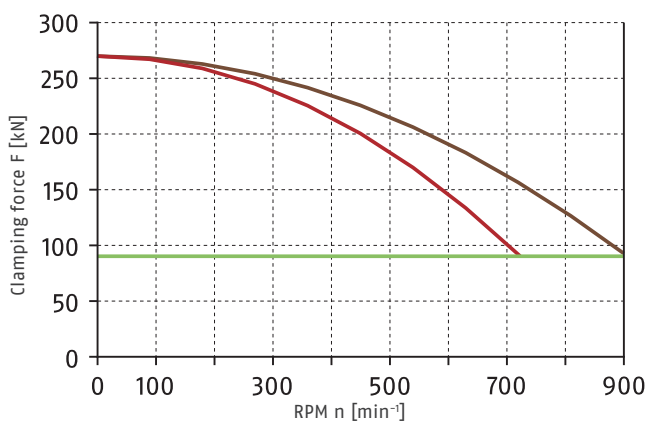
Chuck, 1 set of base jaws with screws, chuck mounting screws, actuation key, eye bolt and operating manual

Note

Enlargement of the through-hole

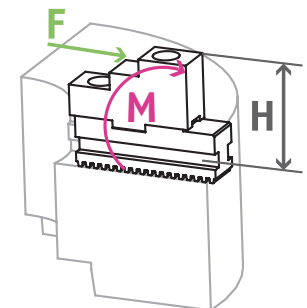
Enlargement of the through-hole to a maximum  $\varnothing$  412 mm available upon request.

Clamping force-RPM-diagram



- Required minimum clamping force F<sub>spmin</sub> 33%
- SFA-AL 1000  
32 kg
- SFA 1000  
81.79 kg

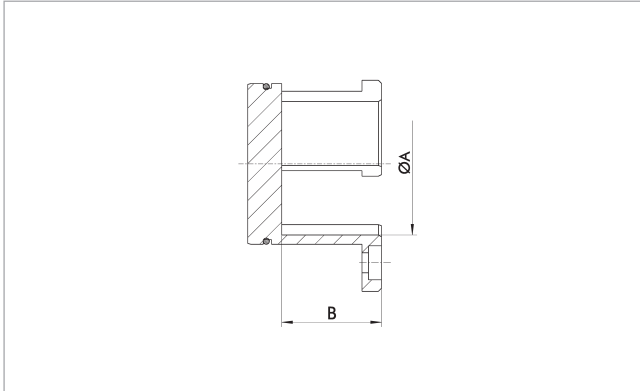
Load of base jaw guidance



M<sub>max</sub> = 11520 Nm

## Center sleeves

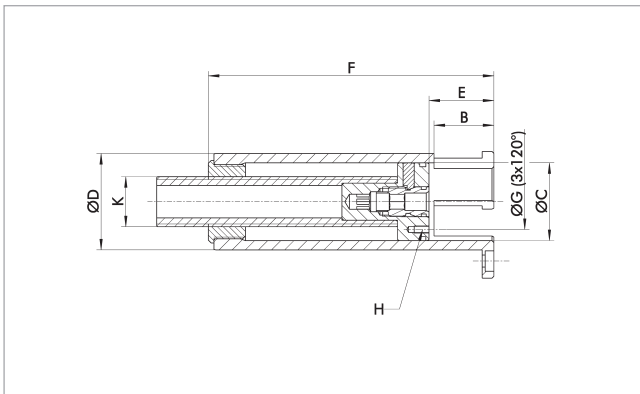
### Center sleeve closed



### Technical data

Description	ID	Suitable for	ØA [mm]	B [mm]	Weight [kg]
SBS-G-S 160	8704845	ROTA-S plus 2.0 160-42	36	28	0.6
SBS-G-S 200	8704846	ROTA-S plus 2.0 200-52	46	32.3	0.3
SBS-G-S 250	8704847	ROTA-S plus 2.0 250-62	56	36.8	0.4
SBS-G-S 315	8704848	ROTA-S plus 2.0 315-92	86	43.5	0.8

### Center sleeve with adjustable stop



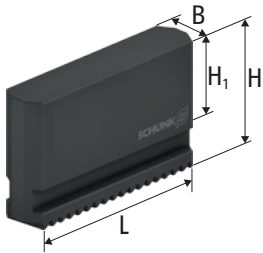
### Technical data

Description	ID	Suitable for	B [mm]	ØC [mm]	ØD [mm]	E [mm]	F [mm]	ØG [mm]	H	K	Weight [kg]
SBS-T-S 160	8704853	ROTA-S plus 2.0 160-42	28.8	34	42	28.8 - 88.3	141.5	24	M4x8	M27	0.9
SBS-T-S 200	8704854	ROTA-S plus 2.0 200-52	32.3	42	52	32.3 - 91.1	147.8	30	M4x8	M27	2
SBS-T-S 250	8704855	ROTA-S plus 2.0 250-62	38.3	51	62	38.3 - 80.3	140	35	M6x12	M27	1.9
SBS-T-S 315	8704856	ROTA-S plus 2.0 315-92	44	75	92	44 - 68	147	50	M6x12	M27	4.1

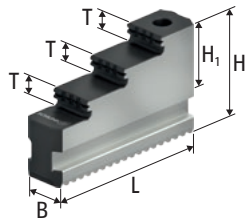
- Important: Check the spindle/draw tube through-hole
- The spindle through-hole must be at least  $\text{Ø D} + 0.5 \text{ mm}$



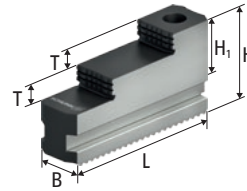
## Base jaws, Hard stepped block jaws, Soft monoblock jaws with angled serration



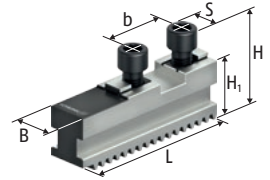
SMB  
Soft monoblock jaws



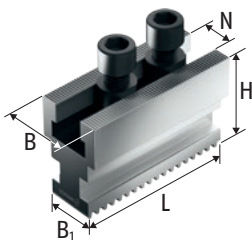
STF  
Hard stepped block jaws



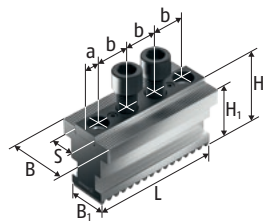
STF  
Hard stepped block jaws



SFG  
Base jaws



STB  
Base jaws



STN  
Base jaws

### Technical data

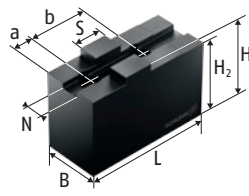
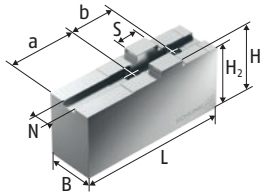
Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	B1 [mm]	H [mm]	H1 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-S plus 2.0 160-42	SMB 160	0163100			20		45	24	79					1.5
ROTA-S plus 2.0 160-42	SMB-H 160	0163200			20		60	39	79					2.0
ROTA-S plus 2.0 160-42	SFG 160	0157100	18	8	20		29.5	27	74			32	M8x1	0.8
ROTA-S plus 2.0 160-42	SFGK 160	0157500	18	8	20		29.5	27	64			32	M8x1	0.7
ROTA-S plus 2.0 160-42	STF 160	0161100			20		45	24	79	7.5				1.1
ROTA-S plus 2.0 160-42/2	SMB 160	0163100			20		45	24	79					1.5
ROTA-S plus 2.0 160-42/2	SMB-H 160	0163200			20		60	39	79					2.0
ROTA-S plus 2.0 160-42/2	SFG 160	0157100	18	8	20		29.5	27	74			32	M8x1	0.8
ROTA-S plus 2.0 160-42/2	SFGK 160	0157500	18	8	20		29.5	27	64			32	M8x1	0.7
ROTA-S plus 2.0 160-42/2	STF 160	0161100			20		45	24	79	7.5				1.1
ROTA-S plus 2.0 200-52	SMB 200	0163101			22		60	35	94					2.6
ROTA-S plus 2.0 200-52	SMB-H 200	0163201			22		80	55	94					3.6
ROTA-S plus 2.0 200-52	SFG 200	0157101	20	10	22		35	32	90			40	M8x1	1.2
ROTA-S plus 2.0 200-52	SFGK 200	0157501	20	10	22		35	32	80			40	M8x1	1.1
ROTA-S plus 2.0 200-52	SFGL 200	0157121	20	10	22		35	32	110			40	M8x1	1.5
ROTA-S plus 2.0 200-52	STB 200	0156099	17		45	22	61		80				M12	3.4
ROTA-S plus 2.0 200-52	STF 200	0161101			22		60	35	94	10				1.9
ROTA-S plus 2.0 200-52/2	SMB 200	0163101			22		60	35	94					2.6
ROTA-S plus 2.0 200-52/2	SMB-H 200	0163201			22		80	55	94					3.6
ROTA-S plus 2.0 200-52/2	SFG 200	0157101	20	10	22		35	32	90			40	M8x1	1.2
ROTA-S plus 2.0 200-52/2	SFGK 200	0157501	20	10	22		35	32	80			40	M8x1	1.1
ROTA-S plus 2.0 200-52/2	SFGL 200	0157121	20	10	22		35	32	110			40	M8x1	1.5
ROTA-S plus 2.0 200-52/2	STB 200	0156099	17		45	22	61		80				M12	3.4
ROTA-S plus 2.0 200-52/2	STF 200	0161101			22		60	35	94	10				1.9
ROTA-S plus 2.0 250-62	SMB 250	0163102			26		70	40	115					4.4
ROTA-S plus 2.0 250-62	SMB-H 250	0163202			26		100	70	115					6.5
ROTA-S plus 2.0 250-62	SFG 250	0157102	20	12	26		40	37	110			40	M12x1.5	1.8
ROTA-S plus 2.0 250-62	SFGK 250	0157502	20	12	26		40	37	91			40	M12x1.5	1.6

Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	B1 [mm]	H [mm]	H1 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-S plus 2.0 250-62	SFGL 250	0157112	20	12	26		40	37	122			40	M12x1.5	2.0
ROTA-S plus 2.0 250-62	STB 250-1	0156100	17		45	26	65		110				M12	4.9
ROTA-S plus 2.0 250-62	STB 250-2	0156101	21		54	26	70		110				M16	5.2
ROTA-S plus 2.0 250-62	STN 250-4	0160501		21	45	26	52.5	50	110		13	28	M16	4.2
ROTA-S plus 2.0 250-62	STF 250	0161102			26		70	40	114	14				3.3
ROTA-S plus 2.0 250-62/2	SMB 250	0163102			26		70	40	115					4.4
ROTA-S plus 2.0 250-62/2	SMB-H 250	0163202			26		100	70	115					6.5
ROTA-S plus 2.0 250-62/2	SFG 250	0157102	20	12	26		40	37	110			40	M12x1.5	1.8
ROTA-S plus 2.0 250-62/2	SFGL 250	0157112	20	12	26		40	37	122			40	M12x1.5	2.0
ROTA-S plus 2.0 250-62/2	STB 250-1	0156100	17		45	26	65		110				M12	4.9
ROTA-S plus 2.0 250-62/2	STB 250-2	0156101	21		54	26	70		110				M16	5.2
ROTA-S plus 2.0 250-62/2	STN 250-4	0160501		21	45	26	52.5	50	110		13	28	M16	4.2
ROTA-S plus 2.0 250-62/2	STF 250	0161102			26		70	40	114	14				3.3
ROTA-S plus 2.0 315-92	SMB 315	0163103			32		81	46	140					7.5
ROTA-S plus 2.0 315-92	SMB-H 315	0163203			32		135	100	140					13.0
ROTA-S plus 2.0 315-92	SFG 315	0157103	26	12	32		46	43	125			54	M12x1.5	3.1
ROTA-S plus 2.0 315-92	SFGL 315	0157123	26	12	32		46	43	160			54	M12x1.5	4.0
ROTA-S plus 2.0 315-92	STB 315-2	0156103	21		54	32	75		125				M16	9.3
ROTA-S plus 2.0 315-92	STN 315-4	0160503		21	45	32	57.5	55	110		13	28	M16	4.5
ROTA-S plus 2.0 315-92	STF 315	0161103			32		81	46	129	15				5.5
ROTA-S plus 2.0 315-92/2	SMB 315	0163103			32		81	46	140					7.5
ROTA-S plus 2.0 315-92/2	SMB-H 315	0163203			32		135	100	140					13.0
ROTA-S plus 2.0 315-92/2	SFG 315	0157103	26	12	32		46	43	125			54	M12x1.5	3.1
ROTA-S plus 2.0 315-92/2	STB 315-2	0156103	21		54	32	75		125				M16	9.3
ROTA-S plus 2.0 315-92/2	STN 315-4	0160503		21	45	32	57.5	55	110		13	28	M16	4.5
ROTA-S plus 2.0 315-92/2	STF 315	0161103			32		81	46	129	15				5.5
ROTA-S plus 400-102	SMB 400	0163104			45		93	53	176					15.0
ROTA-S plus 400-102	SMB 500	0163105			45		130	90	176					21.6
ROTA-S plus 400-102	SFG 400	0157104	30	18	45		55	51	160			60	M16x1.5	6.4
ROTA-S plus 400-102	SFGL 400	0157124	30	18	45		55	51	200			60	M16x1.5	8.1
ROTA-S plus 400-102	STB 400-1	0156104	21		54	45	80		160				M16	12.0
ROTA-S plus 400-102	STB 400-2	0156105	25.5		64	45	82		160				M20	12.2
ROTA-S plus 400-102	STF 400	0161104			45		93	52	167	20				10.8
ROTA-S plus 500-162	SMB 400	0163104			45		93	53	176					15.0
ROTA-S plus 500-162	SMB 500	0163105			45		130	90	176					21.6
ROTA-S plus 500-162	SFG 400	0157104	30	18	45		55	51	160			60	M16x1.5	6.4
ROTA-S plus 500-162	STB 400-1	0156104	21		54	45	80		160				M16	12.0
ROTA-S plus 500-162	STB 400-2	0156105	25.5		64	45	82		160				M20	12.2
ROTA-S plus 500-162	STF 400	0161104			45		93	52	167	20				10.8
ROTA-S plus 630-252	SMB 630-800	0163106			65		130	88	230					40.2
ROTA-S plus 630-252	SFG 630	0157106	40	24	65		62	58	230			82	M20	16.2
ROTA-S plus 630-252	SFG 630-400	0157109	30	18	65		62	58	230			60	M16x1.5	16.2
ROTA-S plus 800-252	SMB 630-800	0163106			65		130	88	230					40.2
ROTA-S plus 800-252	SFG 630-400	0157109	30	18	65		62	58	230			60	M16x1.5	16.2
ROTA-S plus 800-252	SFG 800	0157107	40	24	65		62	58	264			82	M20	18.7
ROTA-S plus 1000-402	SMB 630-800	0163106			65		130	88	230					40.2
ROTA-S plus 1000-402	SFG 1000	0157108	40	24	65		72	68	314			82	M20	27.1

Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](http://schunk.com)

## Soft top jaws

with tongue and groove



SFA-AL  
Soft top jaws

SFA  
Soft top jaws

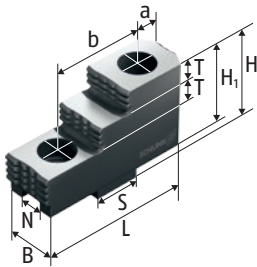
### Technical data

Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	H [mm]	H2 [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-S plus 2.0 160-42	SFA 160	0153100	8	18	20	40	36	85	18	32	M8	1.2
ROTA-S plus 2.0 160-42	SFA-AL 160	0172100	8	18	25	50	46	85	35	32	M8	0.7
ROTA-S plus 2.0 160-42	SFA 160-C1	0154121	8	18	30	55.5	51.5	85	12	32	M8	2.7
ROTA-S plus 2.0 160-42	SFA 160-C2	0154127	8	18	35	40	36	63	12	32	M8	1.6
ROTA-S plus 2.0 160-42	SFA 160-C3	0154131	8	18	40	60	56	70	12	32	M8	3.3
ROTA-S plus 2.0 160-42	SFA 160-C4	0154133	8	18	40	80	76	85	12	32	M8	5.6
ROTA-S plus 2.0 160-42/2	SFA 160	0153100	8	18	20	40	36	85	18	32	M8	1.2
ROTA-S plus 2.0 160-42/2	SFA-AL 160	0172100	8	18	25	50	46	85	35	32	M8	0.7
ROTA-S plus 2.0 160-42/2	SFA 160-C1	0154121	8	18	30	55.5	51.5	85	12	32	M8	2.7
ROTA-S plus 2.0 160-42/2	SFA 160-C2	0154127	8	18	35	40	36	63	12	32	M8	1.6
ROTA-S plus 2.0 160-42/2	SFA 160-C3	0154131	8	18	40	60	56	70	12	32	M8	3.3
ROTA-S plus 2.0 160-42/2	SFA 160-C4	0154133	8	18	40	80	76	85	12	32	M8	5.6
ROTA-S plus 2.0 200-52	SFA 200	0153101	10	20	22	47	43	105	25	40	M8	2.0
ROTA-S plus 2.0 200-52	SFA-AL 200	0172102	10	20	25	50	46	105	40	40	M8	0.9
ROTA-S plus 2.0 200-52	SFA 200-C1	0154100	10	20	30	55.5	51.5	100	13	40	M8	3.2
ROTA-S plus 2.0 200-52	SFA 200-C2	0154124	10	20	22	55.5	51.5	100	13	40	M8	2.2
ROTA-S plus 2.0 200-52	SFA 200-C3	0154128	10	20	40	40	36	70	13	40	M8	2.1
ROTA-S plus 2.0 200-52	SFA 200-C4	0154130	10	20	40	60	56	85	13	40	M8	4.0
ROTA-S plus 2.0 200-52	SFA 200-C5	0154132	10	20	40	80	76	95	13	40	M8	6.1
ROTA-S plus 2.0 200-52/2	SFA 200	0153101	10	20	22	47	43	105	25	40	M8	2.0
ROTA-S plus 2.0 200-52/2	SFA-AL 200	0172102	10	20	25	50	46	105	40	40	M8	0.9
ROTA-S plus 2.0 200-52/2	SFA 200-C1	0154100	10	20	30	55.5	51.5	100	13	40	M8	3.2
ROTA-S plus 2.0 200-52/2	SFA 200-C2	0154124	10	20	22	55.5	51.5	100	13	40	M8	2.2
ROTA-S plus 2.0 200-52/2	SFA 200-C3	0154128	10	20	40	40	36	70	13	40	M8	2.1
ROTA-S plus 2.0 200-52/2	SFA 200-C4	0154130	10	20	40	60	56	85	13	40	M8	4.0
ROTA-S plus 2.0 200-52/2	SFA 200-C5	0154132	10	20	40	80	76	95	13	40	M8	6.1
ROTA-S plus 2.0 250-62	SFA 250	0153102	12	20	30	55.5	50.5	125	25	40	M12	3.7
ROTA-S plus 2.0 250-62	SFA-AL 250	0172103	12	20	40	60	55	125	60	40	M12	2.1
ROTA-S plus 2.0 250-62	SFA 250-C1	0154101	12	20	40	60	55	90	16	40	M12	3.9
ROTA-S plus 2.0 250-62	SFA 250-C2	0154102	12	20	40	60	55	125	16	40	M12	5.6
ROTA-S plus 2.0 250-62	SFA 250-C3	0154103	12	20	40	80	75	125	16	40	M12	7.7
ROTA-S plus 2.0 250-62	SFA 250-C4	0154104	12	20	40	100	95	125	69	40	M12	9.8
ROTA-S plus 2.0 250-62	SFA 250-C5	0154105	12	20	40	120	115	125	16	40	M12	11.8
ROTA-S plus 2.0 250-62	SFA 250-C6	0154106	12	20	60	60	55	90	16	40	M12	6.0
ROTA-S plus 2.0 250-62	SFA 250-C7	0154107	12	20	80	60	55	90	16	40	M12	8.5
ROTA-S plus 2.0 250-62	SFA 250-C8	0154134	12	20	80	100	95	125	16	40	M12	20.6
ROTA-S plus 2.0 250-62/2	SFA 250	0153102	12	20	30	55.5	50.5	125	25	40	M12	3.7
ROTA-S plus 2.0 250-62/2	SFA-AL 250	0172103	12	20	40	60	55	125	60	40	M12	2.1
ROTA-S plus 2.0 250-62/2	SFA 250-C1	0154101	12	20	40	60	55	90	16	40	M12	3.9
ROTA-S plus 2.0 250-62/2	SFA 250-C2	0154102	12	20	40	60	55	125	16	40	M12	5.6
ROTA-S plus 2.0 250-62/2	SFA 250-C3	0154103	12	20	40	80	75	125	16	40	M12	7.7

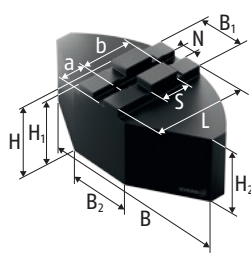
Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	H [mm]	H2 [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-S plus 2.0 250-62/2	SFA 250-C4	0154104	12	20	40	100	95	125	69	40	M12	9.8
ROTA-S plus 2.0 250-62/2	SFA 250-C5	0154105	12	20	40	120	115	125	16	40	M12	11.8
ROTA-S plus 2.0 250-62/2	SFA 250-C6	0154106	12	20	60	60	55	90	16	40	M12	6.0
ROTA-S plus 2.0 250-62/2	SFA 250-C7	0154107	12	20	80	60	55	90	16	40	M12	8.5
ROTA-S plus 2.0 250-62/2	SFA 250-C8	0154134	12	20	80	100	95	125	16	40	M12	20.6
ROTA-S plus 2.0 315-92	SFA 315	0153103	12	26	35	60	54	145	31	54	M12	5.6
ROTA-S plus 2.0 315-92	SFA-AL 315	0172104	12	26	40	60	54	145	60	54	M12	2.4
ROTA-S plus 2.0 315-92	SFA 315-C1	0154108	12	26	40	60	54	110	16	54	M12	4.9
ROTA-S plus 2.0 315-92	SFA 315-C2	0154109	12	26	40	60	54	145	16	54	M12	6.6
ROTA-S plus 2.0 315-92	SFA 315-C3	0154110	12	26	40	100	94	145	16	54	M12	11.4
ROTA-S plus 2.0 315-92	SFA 315-C4	0154111	12	26	40	120	114	145	16	54	M12	13.8
ROTA-S plus 2.0 315-92	SFA 315-C5	0154112	12	26	40	150	144	145	16	54	M12	17.5
ROTA-S plus 2.0 315-92	SFA 315-C51	0154123	12	26	50	80	74	145	16	54	M12	11.4
ROTA-S plus 2.0 315-92	SFA 315-C6	0154113	12	26	60	60	54	110	16	54	M12	7.6
ROTA-S plus 2.0 315-92	SFA 315-C7	0154114	12	26	80	60	54	110	16	54	M12	10.3
ROTA-S plus 2.0 315-92	SFA 315-C8	0154115	12	26	80	80	74	110	16	54	M12	14.0
ROTA-S plus 2.0 315-92/2	SFA 315	0153103	12	26	35	60	54	145	31	54	M12	5.6
ROTA-S plus 2.0 315-92/2	SFA-AL 315	0172104	12	26	40	60	54	145	60	54	M12	2.4
ROTA-S plus 2.0 315-92/2	SFA 315-C1	0154108	12	26	40	60	54	110	16	54	M12	4.9
ROTA-S plus 2.0 315-92/2	SFA 315-C2	0154109	12	26	40	60	54	145	16	54	M12	6.6
ROTA-S plus 2.0 315-92/2	SFA 315-C3	0154110	12	26	40	100	94	145	16	54	M12	11.4
ROTA-S plus 2.0 315-92/2	SFA 315-C4	0154111	12	26	40	120	114	145	16	54	M12	13.8
ROTA-S plus 2.0 315-92/2	SFA 315-C5	0154112	12	26	40	150	144	145	16	54	M12	17.5
ROTA-S plus 2.0 315-92/2	SFA 315-C51	0154123	12	26	50	80	74	145	16	54	M12	11.4
ROTA-S plus 2.0 315-92/2	SFA 315-C6	0154113	12	26	60	60	54	110	16	54	M12	7.6
ROTA-S plus 2.0 315-92/2	SFA 315-C7	0154114	12	26	80	60	54	110	16	54	M12	10.3
ROTA-S plus 2.0 315-92/2	SFA 315-C8	0154115	12	26	80	80	74	110	16	54	M12	14.0
ROTA-S plus 400-102	SFA 400	0153104	18	30	50	80	73	180	35	60	M16	13.7
ROTA-S plus 400-102	SFA-AL 400	0172105	18	30	50	80	73	180	85	60	M16	6.3
ROTA-S plus 400-102	SFA 400-C1	0154116	18	30	60	80	73	130	50	60	M16	11.8
ROTA-S plus 400-102	SFA 400-C3	0154118	18	30	60	100	93	155	20	60	M16	18.2
ROTA-S plus 400-102	SFA 400-C4	0154119	18	30	60	120	113	155	20	60	M16	22.1
ROTA-S plus 400-102	SFA 400-C5	0154120	18	30	80	80	73	130	20	60	M16	16.0
ROTA-S plus 400-102	SFA 400-C6	0154125	18	30	58	180	173	160	20	60	M16	33.6
ROTA-S plus 400-102	SFA 400-C7	0154135	18	30	96	115	108	115	20	60	M16	25.2
ROTA-S plus 500-162	SFA 400	0153104	18	30	50	80	73	180	35	60	M16	13.7
ROTA-S plus 500-162	SFA-AL 400	0172105	18	30	50	80	73	180	85	60	M16	6.3
ROTA-S plus 500-162	SFA 400-C1	0154116	18	30	60	80	73	130	50	60	M16	11.8
ROTA-S plus 500-162	SFA 400-C3	0154118	18	30	60	100	93	155	20	60	M16	18.2
ROTA-S plus 500-162	SFA 400-C4	0154119	18	30	60	120	113	155	20	60	M16	22.1
ROTA-S plus 500-162	SFA 400-C5	0154120	18	30	80	80	73	130	20	60	M16	16.0
ROTA-S plus 500-162	SFA 400-C6	0154125	18	30	58	180	173	160	20	60	M16	33.6
ROTA-S plus 500-162	SFA 400-C7	0154135	18	30	96	115	108	115	20	60	M16	25.2
ROTA-S plus 630-252	SFA 630	0153106	24	40	65	118	110	260	129	82	M20	39.6
ROTA-S plus 630-252	SFA-AL 630	0172106	24	40	65	118	110	260	129	82	M20	14.2
ROTA-S plus 800-252	SFA 630	0153106	24	40	65	118	110	260	129	82	M20	39.6
ROTA-S plus 800-252	SFA-AL 630	0172106	24	40	65	118	110	260	129	82	M20	14.2
ROTA-S plus 1000-402	SFA 630	0153106	24	40	65	118	110	260	129	82	M20	39.6
ROTA-S plus 1000-402	SFA 1000	0153108	24	40	76	150	142	350	49	82	M20	81.8
ROTA-S plus 1000-402	SFA-AL 1000	0172108	24	40	80	155	147	350	219	82	M20	32.0

Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](http://schunk.com)

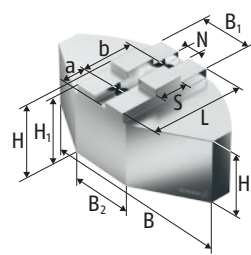
## Hard stepped top jaws, Full grip jaws with tongue and groove



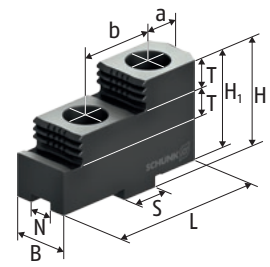
SHF  
Hard stepped top jaws



SFA-SM  
Full grip jaws



SFA-SA  
Full grip jaws



SHF  
Hard stepped top jaws

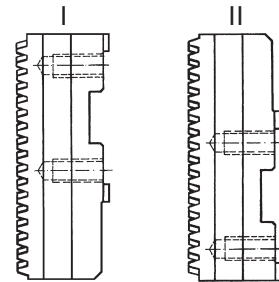
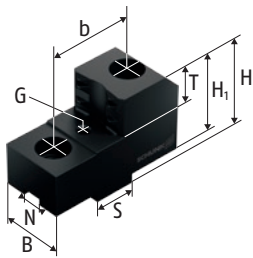
### Technical data

Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	B1 [mm]	H [mm]	H1 [mm]	H2 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-S plus 2.0 160-42	SFA-SA 160	0174100	8	18	120	35	50	46	40	59.5		15.75	32	M8	1.4
ROTA-S plus 2.0 160-42	SFA-SM 160	0173100	8	18	120	30	50	46	40	60		16.5	32	M8	4.8
ROTA-S plus 2.0 160-42	SHF 160	0155100	8	18	20		36.5	32.5		63	7.5	16.8	32	M8	0.6
ROTA-S plus 2.0 160-42/2	SFA-SA 160	0174100	8	18	120	35	50	46	40	59.5		15.75	32	M8	1.4
ROTA-S plus 2.0 160-42/2	SFA-SM 160	0173100	8	18	120	30	50	46	40	60		16.5	32	M8	4.8
ROTA-S plus 2.0 160-42/2	SHF 160	0155100	8	18	20		36.5	32.5		63	7.5	16.8	32	M8	0.6
ROTA-S plus 2.0 200-52	SFA-SA 200	0174101	10	20	140	35	58	54	48	72.5		21.75	40	M8	2.4
ROTA-S plus 2.0 200-52	SFA-SA 201	0174105	10	20	140	35	80	76	70	72.5		21.75	40	M8	3.5
ROTA-S plus 2.0 200-52	SFA-SM 200	0173101	10	20	140	35	60	56	50	70		18	40	M8	9.0
ROTA-S plus 2.0 200-52	SFA-SM 201	0173105	10	20	140	35	80	76	70	70		18	40	M8	12.5
ROTA-S plus 2.0 200-52	SHF 200	0155101	10	20	22		42	38		71.7	10	16	40	M8	0.8
ROTA-S plus 2.0 200-52/2	SFA-SA 200	0174101	10	20	140	35	58	54	48	72.5		21.75	40	M8	2.4
ROTA-S plus 2.0 200-52/2	SFA-SA 201	0174105	10	20	140	35	80	76	70	72.5		21.75	40	M8	3.5
ROTA-S plus 2.0 200-52/2	SFA-SM 200	0173101	10	20	140	35	60	56	50	70		18	40	M8	9.0
ROTA-S plus 2.0 200-52/2	SFA-SM 201	0173105	10	20	140	35	80	76	70	70		18	40	M8	12.5
ROTA-S plus 2.0 200-52/2	SHF 200	0155101	10	20	22		42	38		71.7	10	16	40	M8	0.8
ROTA-S plus 2.0 250-62	SFA-SA 250	0174102	12	20	180	40	58	53	43	87.5		33.75	40	M12	3.4
ROTA-S plus 2.0 250-62	SFA-SA 251	0174106	12	20	180	40	80	75	65	87.5		33.75	40	M12	5.0
ROTA-S plus 2.0 250-62	SFA-SM 250	0173102	12	20	180	40	60	55	45	90		34.5	40	M12	12.8
ROTA-S plus 2.0 250-62	SFA-SM 251	0173106	12	20	180	40	80	75	65	90		35	40	M12	18.9
ROTA-S plus 2.0 250-62	SHF 250	0155102	12	20	30		55	50		90	14	21.1	40	M12	1.9
ROTA-S plus 2.0 250-62/2	SFA-SA 250	0174102	12	20	180	40	58	53	43	87.5		33.75	40	M12	3.4
ROTA-S plus 2.0 250-62/2	SFA-SA 251	0174106	12	20	180	40	80	75	65	87.5		33.75	40	M12	5.0
ROTA-S plus 2.0 250-62/2	SFA-SM 250	0173102	12	20	180	40	60	55	45	90		34.5	40	M12	12.8
ROTA-S plus 2.0 250-62/2	SFA-SM 251	0173106	12	20	180	40	80	75	65	90		35	40	M12	18.9
ROTA-S plus 2.0 250-62/2	SHF 250	0155102	12	20	30		55	50		90	14	21.1	40	M12	1.9
ROTA-S plus 2.0 315-92	SFA-SA 315	0174103	12	26	240	45	75	69	60	117		49.75	54	M12	8.0
ROTA-S plus 2.0 315-92	SFA-SM 315	0173103	12	26	240	45	75	69	60	110		41	54	M12	29.2
ROTA-S plus 2.0 315-92	SHF 315	0155103	12	26	36		62	56		105	15	22.3	54	M12	3.3
ROTA-S plus 2.0 315-92/2	SFA-SA 315	0174103	12	26	240	45	75	69	60	117		49.75	54	M12	8.0
ROTA-S plus 2.0 315-92/2	SFA-SM 315	0173103	12	26	240	45	75	69	60	110		41	54	M12	29.2
ROTA-S plus 2.0 315-92/2	SHF 315	0155103	12	26	36		62	56		105	15	22.3	54	M12	3.3
ROTA-S plus 400-102	SFA-SA 400	0174104	18	30	330	60	90	83	60	160		81	60	M16	16.3
ROTA-S plus 400-102	SFA-SM 400	0173104	18	30	330	45	85	78	55	160		81	60	M16	55.2
ROTA-S plus 400-102	SHF 400	0155104	18	30	45		82	75		130	20	27.05	60	M16	6.8
ROTA-S plus 500-162	SFA-SA 400	0174104	18	30	330	60	90	83	60	160		81	60	M16	16.3
ROTA-S plus 500-162	SFA-SM 400	0173104	18	30	330	45	85	78	55	160		81	60	M16	55.2
ROTA-S plus 500-162	SHF 400	0155104	18	30	45		82	75		130	20	27.05	60	M16	6.8
ROTA-S plus 630-252	SHF 630	0155106	24	40	65		105	97		185	30	41	82	M20	18.0
ROTA-S plus 800-252	SHF 630	0155106	24	40	65		105	97		185	30	41	82	M20	18.0
ROTA-S plus 1000-402	SHF 630	0155106	24	40	65		105	97		185	30	41	82	M20	18.0



## Claw jaws

with tongue and groove



Position of base jaws

SZKA  
Claw jaws

### Technical data

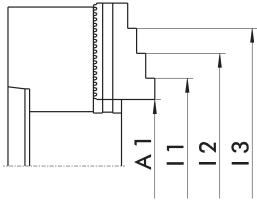
Chuck type	Clamping range ØD [mm]	Swing diameter SDmax [mm]	Position of base jaws	Description	ID	N	S	B	H	H1	T	G	b	Screws	m/SET [kg]
						[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		
ROTA-S plus 2.0 160-42	98 - 134	214	I	SZKA 163	0165146	8	18	40	44	40	20	M6	32	M8	1.5
ROTA-S plus 2.0 160-42	51 - 86	207	I	SZKA 169	0165174	8	18	26	44	40	20	M6	32	M8	1.0
ROTA-S plus 2.0 160-42	63 - 99	208	II	SZKA 163	0165146	8	18	40	44	40	20	M6	32	M8	1.5
ROTA-S plus 2.0 160-42	114 - 150	211	II	SZKA 167	0165150	8	18	30	44	40	20	M6	32	M8	1.3
ROTA-S plus 2.0 160-42/2	98 - 134	214	I	SZKA 163	0165146	8	18	40	44	40	20	M6	32	M8	1.5
ROTA-S plus 2.0 160-42/2	51 - 86	207	I	SZKA 169	0165174	8	18	26	44	40	20	M6	32	M8	1.0
ROTA-S plus 2.0 160-42/2	63 - 99	208	II	SZKA 163	0165146	8	18	40	44	40	20	M6	32	M8	1.5
ROTA-S plus 2.0 160-42/2	114 - 150	211	II	SZKA 167	0165150	8	18	30	44	40	20	M6	32	M8	1.3
ROTA-S plus 2.0 200-52	34 - 99	267	I	SZKA 212	0139153	10	20	26	49	45	25	M6	40	M8	1.4
ROTA-S plus 2.0 200-52	109 - 175	267	I	SZKA 213	0139154	10	20	30	49	45	25	M6	40	M8	1.3
ROTA-S plus 2.0 200-52	144 - 210	272	I	SZKA 216	0139159	10	20	30	49	45	25	M6	40	M8	1.2
ROTA-S plus 2.0 200-52	64 - 127	267	II	SZKA 213	0139154	10	20	30	49	45	25	M6	40	M8	1.3
ROTA-S plus 2.0 200-52/2	34 - 99	267	I	SZKA 212	0139153	10	20	26	49	45	25	M6	40	M8	1.4
ROTA-S plus 2.0 200-52/2	109 - 175	267	I	SZKA 213	0139154	10	20	30	49	45	25	M6	40	M8	1.3
ROTA-S plus 2.0 200-52/2	144 - 210	272	I	SZKA 216	0139159	10	20	30	49	45	25	M6	40	M8	1.2
ROTA-S plus 2.0 200-52/2	64 - 127	267	II	SZKA 213	0139154	10	20	30	49	45	25	M6	40	M8	1.3
ROTA-S plus 2.0 250-62	153 - 234	328	I	SZKA 266	0139163	12	20	40	55	50	25	M6	40	M12	1.9
ROTA-S plus 2.0 250-62	186 - 267	342	I	SZKA 268	0139165	12	20	40	55	50	25	M6	40	M12	2.2
ROTA-S plus 2.0 250-62	31 - 101	325	II	SZKA 263	0139160	12	20	30	55	50	25	M6	40	M12	1.5
ROTA-S plus 2.0 250-62	78 - 158	325	II	SZKA 266	0139163	12	20	40	55	50	25	M6	40	M12	1.9
ROTA-S plus 2.0 250-62/2	153 - 234	328	I	SZKA 266	0139163	12	20	40	55	50	25	M6	40	M12	1.9
ROTA-S plus 2.0 250-62/2	186 - 267	342	I	SZKA 268	0139165	12	20	40	55	50	25	M6	40	M12	2.2
ROTA-S plus 2.0 250-62/2	31 - 101	325	II	SZKA 263	0139160	12	20	30	55	50	25	M6	40	M12	1.5
ROTA-S plus 2.0 250-62/2	78 - 158	325	II	SZKA 266	0139163	12	20	40	55	50	25	M6	40	M12	1.9
ROTA-S plus 2.0 315-92	87 - 211	401	I	SZKA 321	0139166	12	26	40	59	53	25	M8	54	M12	3.1
ROTA-S plus 2.0 315-92	194 - 320	408	I	SZKA 324	0139169	12	26	40	59	53	25	M8	54	M12	2.8
ROTA-S plus 2.0 315-92	44 - 134	401	II	SZKA 321	0139166	12	26	40	59	53	25	M8	54	M12	3.1
ROTA-S plus 2.0 315-92	119 - 242	401	II	SZKA 324	0139169	12	26	40	59	53	25	M8	54	M12	2.8
ROTA-S plus 2.0 315-92/2	87 - 211	401	I	SZKA 321	0139166	12	26	40	59	53	25	M8	54	M12	3.1
ROTA-S plus 2.0 315-92/2	194 - 320	408	I	SZKA 324	0139169	12	26	40	59	53	25	M8	54	M12	2.8
ROTA-S plus 2.0 315-92/2	44 - 134	401	II	SZKA 321	0139166	12	26	40	59	53	25	M8	54	M12	3.1
ROTA-S plus 2.0 315-92/2	119 - 242	401	II	SZKA 324	0139169	12	26	40	59	53	25	M8	54	M12	2.8
ROTA-S plus 400-102	234 - 388	508	I	SZKA 412	0139173	18	30	50	78	71	33	M8	60	M16	5.1
ROTA-S plus 400-102	49 - 168	508	II	SZKA 409	0139170	18	30	50	78	71	33	M8	60	M16	6.0
ROTA-S plus 400-102	122 - 269	508	II	SZKA 412	0139173	18	30	50	78	71	33	M8	60	M16	5.1
ROTA-S plus 500-162	268 - 473	593	I	SZKA 412	0139173	18	30	50	78	71	33	M8	60	M16	5.1
ROTA-S plus 500-162	54 - 253	594	II	SZKA 409	0139170	18	30	50	78	71	33	M8	60	M16	6.0
ROTA-S plus 500-162	151 - 355	594	II	SZKA 412	0139173	18	30	50	78	71	33	M8	60	M16	5.1
ROTA-S plus 630-252	381 - 643	765	I	SZKA 412	0139173	18	30	50	78	71	33	M8	60	M16	5.1

Chuck type	Clamping range ØD	Swing diameter SDmax	Position of base jaws	Description	ID	N	S	B	H	H1	T	G	b	Screws	m/SET
	[mm]	[mm]				[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[kg]
ROTA-S plus 630-252	204 - 515	818	I	SZKA 631	0139200	24	40	65	97	89	42	M8	82	M20	13.5
ROTA-S plus 630-252	364 - 676	818	I	SZKA 632	0139201	24	40	65	97	89	42	M8	82	M20	11.8
ROTA-S plus 630-252	62 - 370	851	II	SZKA 409	0139170	18	30	50	78	71	33	M8	60	M16	6.0
ROTA-S plus 630-252	160 - 472	851	II	SZKA 412	0139173	18	30	50	78	71	33	M8	60	M16	5.1
ROTA-S plus 630-252	87 - 344	818	II	SZKA 631	0139200	24	40	65	97	89	42	M8	82	M20	13.5
ROTA-S plus 630-252	194 - 504	818	II	SZKA 632	0139201	24	40	65	97	89	42	M8	82	M20	11.8
ROTA-S plus 800-252	393 - 712	833	I	SZKA 412	0139173	18	30	50	78	71	33	M8	60	M16	5.1
ROTA-S plus 800-252	273 - 584	887	I	SZKA 631	0139200	24	40	65	97	89	42	M8	82	M20	13.5
ROTA-S plus 800-252	433 - 744	887	I	SZKA 632	0139201	24	40	65	97	89	42	M8	82	M20	11.8
ROTA-S plus 800-252	62 - 370	851	II	SZKA 409	0139170	18	30	50	78	71	33	M8	60	M16	6.0
ROTA-S plus 800-252	160 - 472	851	II	SZKA 412	0139173	18	30	50	78	71	33	M8	60	M16	5.1
ROTA-S plus 800-252	87 - 344	819	II	SZKA 631	0139200	24	40	65	97	89	42	M8	82	M20	13.5
ROTA-S plus 800-252	195 - 505	819	II	SZKA 632	0139201	24	40	65	97	89	42	M8	82	M20	11.8
ROTA-S plus 1000-402	544 - 891	1194	I	SZKA 631	0139200	24	40	65	97	89	42	M8	82	M20	13.5
ROTA-S plus 1000-402	705 - 1052	1194	I	SZKA 632	0139201	24	40	65	97	89	42	M8	82	M20	11.8
ROTA-S plus 1000-402	206 - 551	1026	II	SZKA 631	0139200	24	40	65	97	89	42	M8	82	M20	13.5
ROTA-S plus 1000-402	366 - 712	1026	II	SZKA 632	0139201	24	40	65	97	89	42	M8	82	M20	11.8

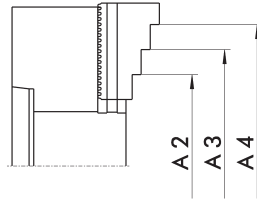
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](http://schunk.com)

## Hard stepped block jaws

with tongue and groove



Jaw position I



Jaw position II

### O.D. clamping

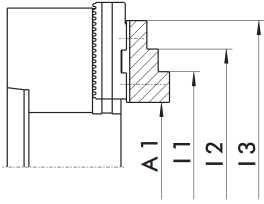
Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]
ROTA-S plus 2.0 160-42	STF 160	0161100	7 - 49	47 - 93	92 - 138	117 - 163
ROTA-S plus 2.0 200-52	STF 200	0161101	7 - 72	61 - 128	113 - 179	140 - 207
ROTA-S plus 2.0 250-62	STF 250	0161102	8 - 92	85 - 167		165 - 247
ROTA-S plus 2.0 315-92	STF 315	0161103	14 - 122	91 - 210		200 - 319
ROTA-S plus 400-102	STF 400	0161104	19 - 158	137 - 281		260 - 402
ROTA-S plus 500-162	STF 400	0161104	19 - 243	140 - 365		262 - 488

### I.D. clamping

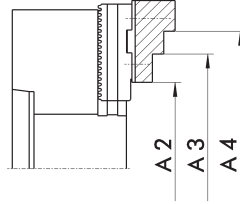
Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA-S plus 2.0 160-42	STF 160	0161100	62 - 104	87 - 129	132 - 174
ROTA-S plus 2.0 200-52	STF 200	0161101	71 - 135	98 - 162	149 - 214
ROTA-S plus 2.0 250-62	STF 250	0161102	89 - 171		168 - 251
ROTA-S plus 2.0 315-92	STF 315	0161103	92 - 200		200 - 309
ROTA-S plus 400-102	STF 400	0161104	124 - 260		244 - 383
ROTA-S plus 500-162	STF 400	0161104	124 - 345		244 - 468

## Hard stepped top jaws

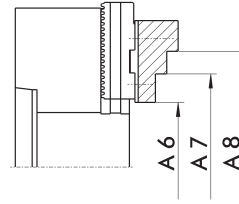
with tongue and groove



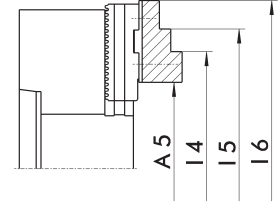
Position of base jaws II



Position of base jaws I



Position of base jaws II



Position of base jaws I

### O.D. clamping

Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]	A5 [mm]	A6 [mm]	A7 [mm]	A8 [mm]
ROTA-S plus 2.0 160-42	SHF 160	0155100	7 - 50	47 - 92	92 - 137	117 - 162	41 - 86	15 - 56	60 - 101	85 - 126
ROTA-S plus 2.0 200-52	SHF 200	0155101	10 - 76	59 - 124	111 - 176	138 - 204	58 - 124	16 - 77	68 - 129	95 - 156
ROTA-S plus 2.0 250-62	SHF 250	0155102	11 - 96		91 - 170	171 - 250	87 - 166		41 - 100	121 - 180
ROTA-S plus 2.0 315-92	SHF 315	0155103	14 - 122		98 - 209	207 - 318	91 - 202		26 - 130	135 - 239
ROTA-S plus 400-102	SHF 400	0155104	17 - 160		132 - 272	253 - 393	137 - 277		21 - 155	141 - 276
ROTA-S plus 500-162	SHF 400	0155104	29 - 244		144 - 357	264 - 478	148 - 362		70 - 239	190 - 361
ROTA-S plus 630-252	SHF 630	0155106	24 - 289		200 - 463	359 - 624	195 - 459		28 - 295	187 - 455
ROTA-S plus 800-252	SHF 630	0155106	24 - 323		268 - 566	427 - 726	262 - 561		28 - 329	187 - 489
ROTA-S plus 1000-402	SHF 630	0155106	45 - 495		387 - 839	547 - 1000	382 - 835		49 - 500	208 - 661

### I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]	I4 [mm]	I5 [mm]
ROTA-S plus 2.0 160-42	SHF 160	0155100	63 - 104	87 - 129	132 - 175	96 - 140	120 - 165
ROTA-S plus 2.0 200-52	SHF 200	0155101	74 - 138	100 - 165	152 - 217	121 - 186	148 - 213
ROTA-S plus 2.0 250-62	SHF 250	0155102	92 - 175	171 - 255		166 - 245	
ROTA-S plus 2.0 315-92	SHF 315	0155103	94 - 201	201 - 310		169 - 281	
ROTA-S plus 400-102	SHF 400	0155104	130 - 270	249 - 391		247 - 387	
ROTA-S plus 500-162	SHF 400	0155104	150 - 355	266 - 476		258 - 472	
ROTA-S plus 630-252	SHF 630	0155106	189 - 451	346 - 612		356 - 621	
ROTA-S plus 800-252	SHF 630	0155106	189 - 485	346 - 646		424 - 723	
ROTA-S plus 1000-402	SHF 630	0155106	209 - 657	367 - 818		544 - 996	

## Accessories

### Clamping force tester

For measuring the jaw clamping force of 2, 3 and 6-jaw chucks up to 6,000 RPM.



Suitable for	Description	ID
ROTA-S plus 2.0 160-42		
ROTA-S plus 2.0 160-42/2		
ROTA-S plus 2.0 200-52		
ROTA-S plus 2.0 200-52/2		
ROTA-S plus 2.0 250-62		
ROTA-S plus 2.0 250-62/2		
ROTA-S plus 2.0 315-92		
ROTA-S plus 2.0 315-92/2		
ROTA-S plus 400-102		
ROTA-S plus 500-162		
ROTA-S plus 630-252		
ROTA-S plus 800-252		
ROTA-S plus 1000-402	IFT Set	1404235

### Extension set for large chucks

For use as an extension of the IFT measuring head for measuring the jaw clamping force of large chucks of  $\varnothing$  400 mm and more.



Suitable for	Description	ID
ROTA-S plus 400-102		
ROTA-S plus 500-162		
ROTA-S plus 630-252		
ROTA-S plus 800-252		
ROTA-S plus 1000-402	IFT adapter set	1498512

### Maintenance kit

Consisting of a grease gun, LINOMAX plus grease cartridge, chip protection, and sealing plug.



Suitable for	Description	ID
ROTA-S plus 2.0 160-42		
ROTA-S plus 2.0 160-42/2	WTS-S 160	0899014
ROTA-S plus 2.0 200-52		
ROTA-S plus 2.0 200-52/2	WTS-S 200	0899015
ROTA-S plus 2.0 250-62		
ROTA-S plus 2.0 250-62/2	WTS-S 250	0899016
ROTA-S plus 2.0 315-92		
ROTA-S plus 2.0 315-92/2	WTS-S 315	0899017
ROTA-S plus 400-102	WTS-S 400	0899018
ROTA-S plus 500-162	WTS-S 500	0899019
ROTA-S plus 630-252	WTS-S 630	0899020

### Torque wrench

Torque wrench for actuation of SCHUNK manual lathe chucks.



Suitable for	Description	ID
ROTA-S plus 2.0 160-42		
ROTA-S plus 2.0 160-42/2		
ROTA-S plus 2.0 200-52		
ROTA-S plus 2.0 200-52/2	SSH-D-1/2" 40-200	9938065
ROTA-S plus 2.0 250-62		
ROTA-S plus 2.0 250-62/2		
ROTA-S plus 2.0 315-92		
ROTA-S plus 2.0 315-92/2		
ROTA-S plus 400-102	SSH-D-1/2" 60-300	1301281
ROTA-S plus 500-162		
ROTA-S plus 630-252		
ROTA-S plus 800-252		
ROTA-S plus 1000-402	SSH-D-3/4" 80-400	1301023

### Hexagon actuation wrench

Spanner wrench for manual actuation of the SCHUNK manual lathe chucks with hexagonal connections.



Suitable for	Description	ID
ROTA-S plus 2.0 160-42		
ROTA-S plus 2.0 160-42/2		
ROTA-S plus 2.0 200-52		
ROTA-S plus 2.0 200-52/2	SSH-SK SW12-160	1330869
ROTA-S plus 2.0 160-42		
ROTA-S plus 2.0 160-42/2		
ROTA-S plus 2.0 200-52		
ROTA-S plus 2.0 200-52/2	SSH-SL SW12-260	8704921
ROTA-S plus 2.0 250-62		
ROTA-S plus 2.0 250-62/2		
ROTA-S plus 2.0 315-92		
ROTA-S plus 2.0 315-92/2	SSH-SK SW16-230	1330894
ROTA-S plus 2.0 250-62		
ROTA-S plus 2.0 250-62/2		
ROTA-S plus 2.0 315-92		
ROTA-S plus 2.0 315-92/2	SSH-SL SW16-330	8704923

### Square actuation wrench

Spanner wrench for manual actuation of the SCHUNK ROTA-S plus and ROTA-G manual lathe chucks.



Suitable for	Description	ID
ROTA-S plus 400-102		
ROTA-S plus 500-162	SSH-VK SW19-255	8700131
ROTA-S plus 630-252		
ROTA-S plus 800-252		
ROTA-S plus 1000-402	SSH-VK SW24-420	8700132

**Long square actuation wrench**

Spanner wrench for manual actuation of the SCHUNK ROTA-S plus and ROTA-G manual lathe chucks.



Suitable for	Description	ID
ROTA-S plus 400-102		
ROTA-S plus 500-162	SSH-VL SW19-420	8705475
ROTA-S plus 630-252		
ROTA-S plus 800-252		
ROTA-S plus 1000-402	SSH-VL SW24-600	88004486

**Wrench with pin and movable cross handle**

Spanner wrench with ejector for manual actuation of SCHUNK ROTA-S plus and ROTA-G manual lathe chucks.



Suitable for	Description	ID
ROTA-S plus 400-102		
ROTA-S plus 500-162	SSH-VQ SW19-255	88018809
ROTA-S plus 630-252	SSH-VQ SW24-420	88018579

**Square connection for torque wrench**

Extension for torque wrench for actuation of SCHUNK ROTA-S plus and ROTA-G manual chucks.



Suitable for	Description	ID
ROTA-S plus 400-102		
ROTA-S plus 500-162	SAV-I 1/2"-SW19	8702917
ROTA-S plus 630-252		
ROTA-S plus 800-252		
ROTA-S plus 1000-402	SAV-I 3/4"-SW24	8705087

**Consol plate**

Standard version for conversion of all ROTA-S plus 2.0 manual lathe chucks for stationary applications. The sizes 400 to 630 are available on request.



Suitable for	Description	ID
ROTA-S plus 2.0 160-42		
ROTA-S plus 2.0 160-42/2	KSL 160	0814270
ROTA-S plus 2.0 200-52		
ROTA-S plus 2.0 200-52/2	KSL 200	0814271
ROTA-S plus 2.0 250-62		
ROTA-S plus 2.0 250-62/2	KSL 250	0814272
ROTA-S plus 2.0 315-92		
ROTA-S plus 2.0 315-92/2	KSL 315	0814273

**Sealing plug**

For closing the through-hole on manual lathe chucks ROTA-S plus 2.0, ROTA-S plus and ROTA-G.



Suitable for	Description	ID
ROTA-S plus 2.0 160-42		
ROTA-S plus 2.0 160-42/2	VST Ø42	8702833
ROTA-S plus 2.0 200-52		
ROTA-S plus 2.0 200-52/2	VST Ø52	8702867
ROTA-S plus 2.0 250-62		
ROTA-S plus 2.0 250-62/2	VST Ø62	8702868
ROTA-S plus 2.0 315-92		
ROTA-S plus 2.0 315-92/2	VST Ø92	8702869
ROTA-S plus 400-102	VST Ø102	8702870
ROTA-S plus 500-162	VST Ø162	8702871
ROTA-S plus 630-252		
ROTA-S plus 800-252	VST Ø252	8702872

**Chip protection**

For better protection against the penetration of chips for the manual lathe chucks ROTA-S plus 2.0, ROTA-S plus and ROTA-G.



Suitable for	Description	ID
ROTA-S plus 2.0 160-42		
ROTA-S plus 2.0 160-42/2		
ROTA-S plus 2.0 200-52		
ROTA-S plus 2.0 200-52/2	SPS 160/200	9966639
ROTA-S plus 2.0 250-62		
ROTA-S plus 2.0 250-62/2	SPS 250	9966640
ROTA-S plus 2.0 315-92		
ROTA-S plus 2.0 315-92/2	SPS 315	9966641
ROTA-S plus 400-102		
ROTA-S plus 500-162	SPS 400/500	9966642
ROTA-S plus 630-252	SPS 630	9966607

## Grease

### LINOMAX plus

High-performance grease as standard for regularly lubricating SCHUNK manual and power lathe chucks and steady rests.



Bundle	Description	ID
Cartridge	LINOMAX plus cartridge	1342585
Can	LINOMAX plus can	1342586
Bucket	LINOMAX plus bucket	1342587

### Grease gun

Auxiliary tools for lubrication of all kinds of SCHUNK products. The grease gun can be used for cartridges of all types of SCHUNK grease.



Bundle	Description	ID
Cartridge	Grease gun	9900543



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