

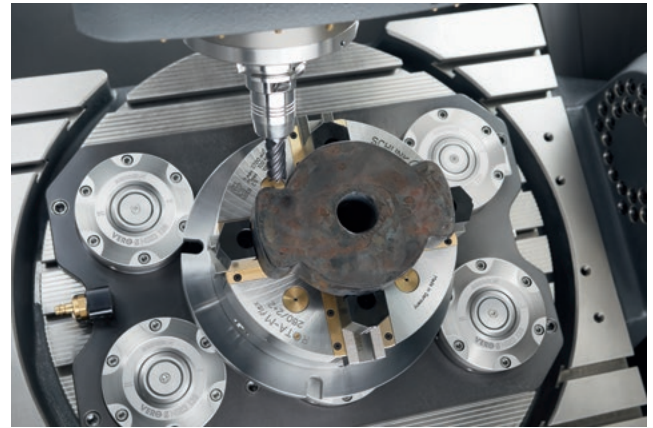
ROTA-M *flex* 2+2

**Extremely flexible 4-jaw
manual lathe chuck**

Sealed manual lathe chuck with patented drive concept for centrally compensating workpiece clamping of any workpiece geometries

Field of application

Clamping of round, cubic and geometrically unshaped parts – no problem for the ROTA-M flex 2+2. Thanks to the patented drive concept with coupled jaw pairs, any workpiece geometry can be clamped centrally and without overdetermination. The chucks are used in particular in storage solutions and on mill/turn machines, but can also be used on lathes. The special sealing also allows cast and forged parts to be machined without hesitation.



Advantages – Your benefits

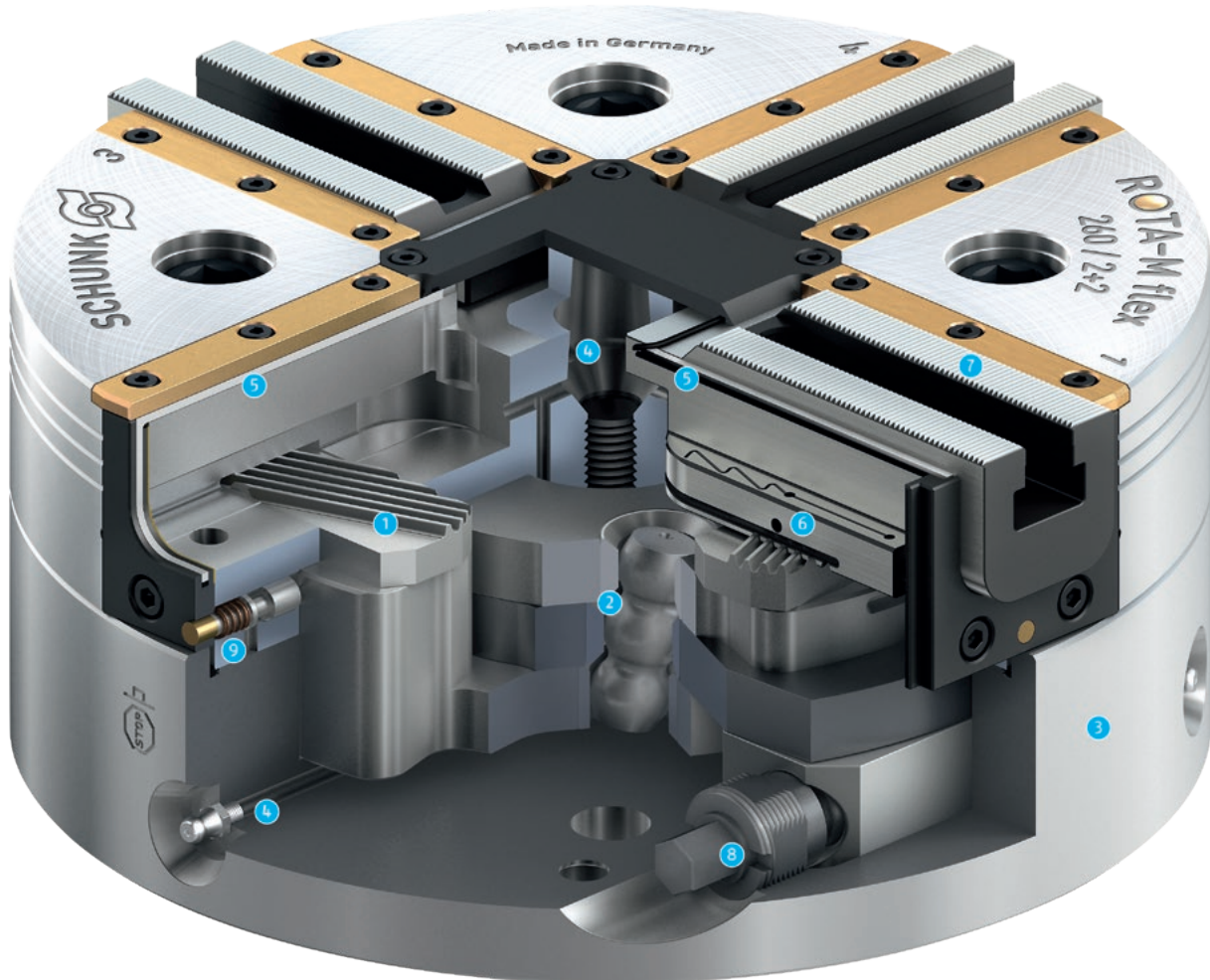
- + Sealed manual lathe chuck**
For significantly longer maintenance intervals
- + Patented drive concept**
Independent installation of the jaw pairs with subsequent centrally compensating workpiece clamping
- + Flexible clamping system**
For clamping round, cubic or geometrically unshaped workpieces
- + Compensation mechanism**
Enables centric clamping even of thin-walled workpieces
- + High efficiency of the wedge bar system**
Process-reliable clamping due to high clamping forces
- + Lubrication system with grease circulation**
Ensures permanent grease supply for constant clamping forces
- + Visual clamping release**
As an indicator for the range in which safe clamping can be ensured
- + Extremely weight-reduced design from size Ø 630 mm**
For a maximum additional payload of workpiece weight
- + All functional parts are ground and hardened**
Ensures a long life span

Technical data

Description	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Compensation stroke/jaw [mm]
ROTA-M flex 2+2 260	2700	100	120	9.5	5.1
ROTA-M flex 2+2 315	2200	100	120	9.5	5.1
ROTA-M flex 2+2 400	1500	150	200	14.5	7.9
ROTA-M flex 2+2 500	1100	180	250	17.8	10
ROTA-ML flex 2+2 630	900	150	200	14.5	7.9
ROTA-ML flex 2+2 800	800	180	250	17.8	10
ROTA-ML flex 2+2 1000	700	180	250	17.8	10
ROTA-ML flex 2+2 1200	600	180	250	17.8	10

Function ROTA-M flex 2+2

A patented drive ring system transfers the rotary motion of the threaded spindle onto the jaws. The opposing pairs of jaws contact the workpiece one after the other and center it in the corresponding plane. The workpiece is then clamped evenly at full clamping force.

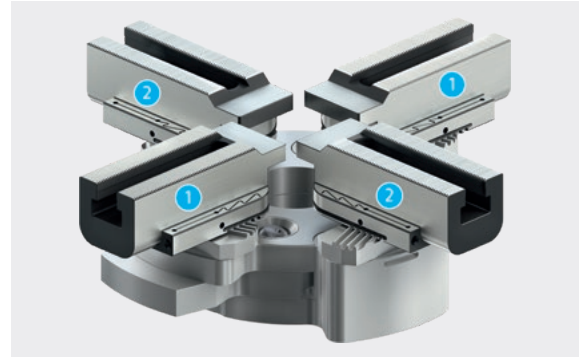


- 1 Wedge bar actuation system**
It offers high run-out accuracies even at high speeds
- 2 Patented drive concept**
As a basis for centrally compensating workpiece clamping
- 3 Hardened and extremely rigid base body**
Therefore a longer life span at highest precision. Even with maximum clamping force
- 4 Central lubrication system with grease reservoir**
Provides sufficient grease during machining. The actuation as well as the centrifugal force during machining also ensure that the grease is circulated in the chuck
- 5 Sealing of the lathe chuck**
Consists of a gasket and O-rings for the initial tension
- 6 Long jaw guidance**
Offers optimum support for O.D. and I.D. clamping
- 7 Standard jaw interface**
For using of standard clamping jaws from SCHUNK
- 8 Operation via hexagon connection**
This ensures easy operation
- 9 Indicator pin**
For monitoring the jaw position via drive ring movement

Compensating workpiece clamping

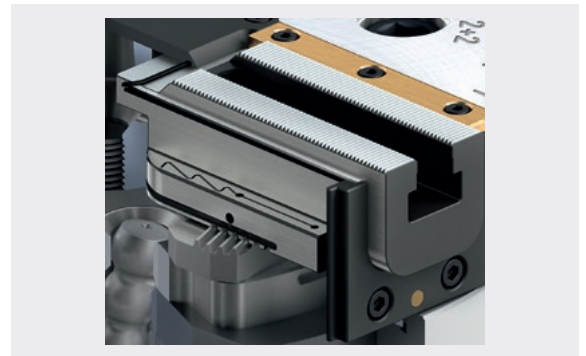
Due to the innovative drive concept, round, cubic and geometrically unshaped workpieces can be clamped in a compensating manner. The opposing jaws are always connected to each other via a drive ring system. Overdetermination is prevented by the pendulum mechanism.

- 1 First pair of jaws
- 2 Second pair of jaws



Sealed manual lathe chuck

A sealing system consisting of a pre-loaded gasket and O-rings prevents grease from being flushed out during machining and the penetration of dirt or chips. This means that cast or forged parts can also be machined without hesitation.



Visual clamping release

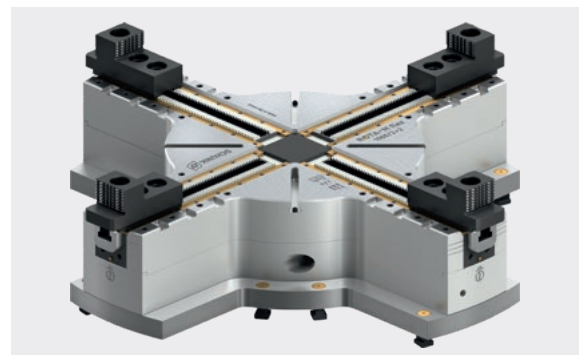
To ensure safe working, an indicator pin shows when the chuck mechanism is close to the stroke end position. As soon as the indicator pin moves outwards, the workpiece is no longer clamped correctly and machining must not be started.

- 1 Indicator pin



Weight-reduced design

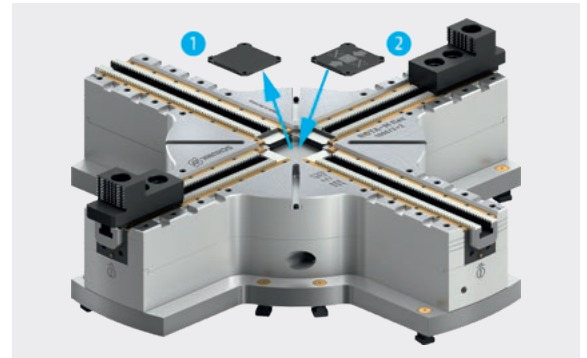
From size \varnothing 630 the ROTA-M flex 2+2 is designed in an extremely weight-reduced monolithic design. As a result, a weight reduction of up to 60% can be achieved compared to conventional chucks of the same size.



2-jaw clamping

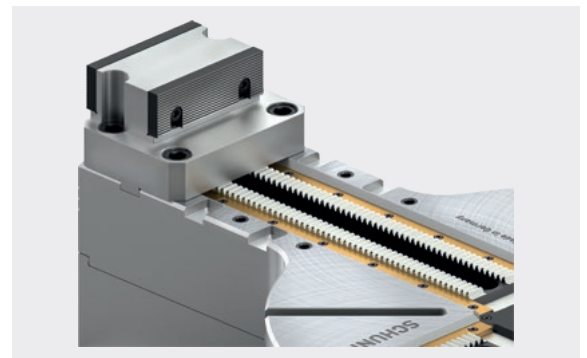
The ROTA-ML flex 2+2 can be converted from a 4-jaw chuck into a 2-jaw chuck with one simple adjustment. All you have to do is to exchange the central locking cover.

- ❶ **Locking cover without stop**
Both pairs of jaws can be moved freely
- ❷ **Locking cover with stop**
One pair of jaws is blocked, the other one clamps centrally

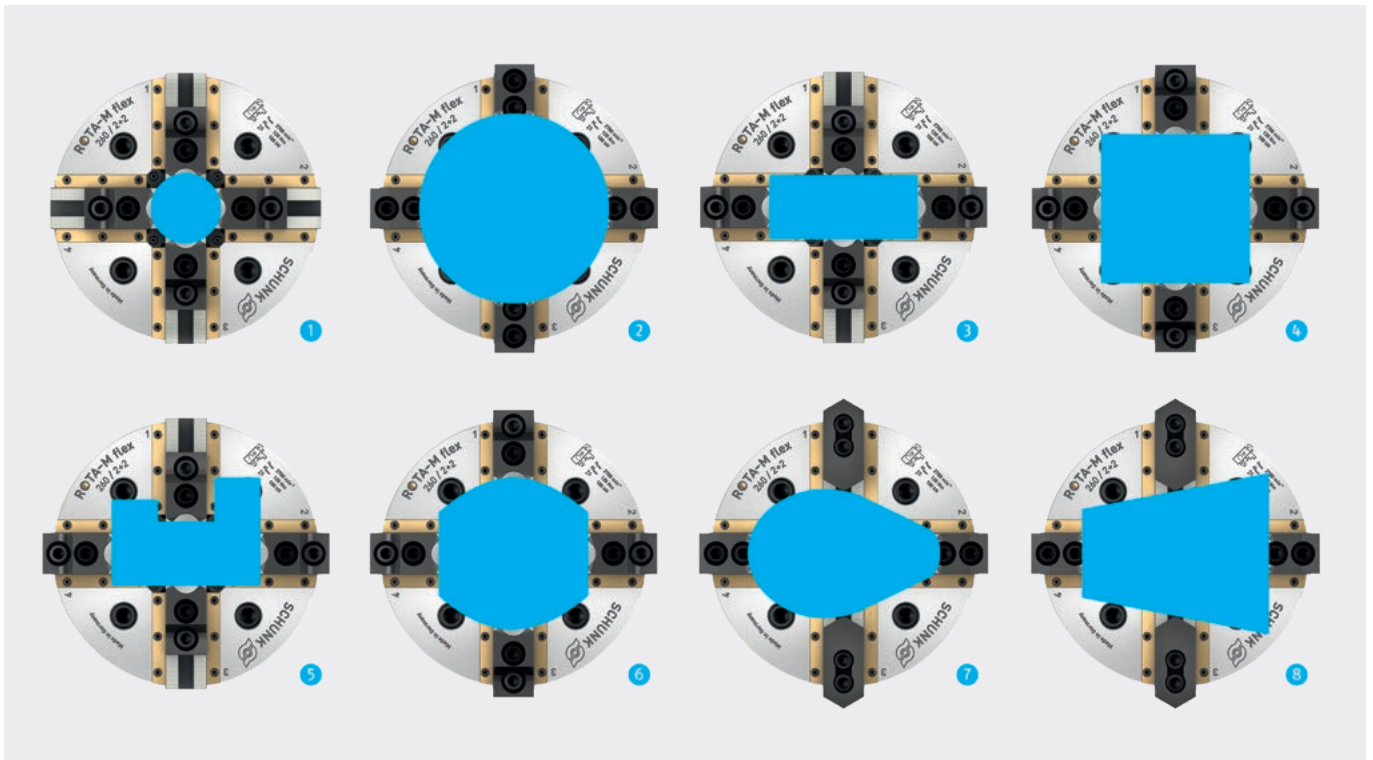


Console clamping

If one or two fixed zero points are required on mill/turn centers instead of centric compensating clamping, the ROTA-ML flex 2+2 can be converted into a "fixed jaw clamping vise" using special jaws. Via grooves in the chuck face, the fixed jaws can be connected to the chuck.



Highest flexibility



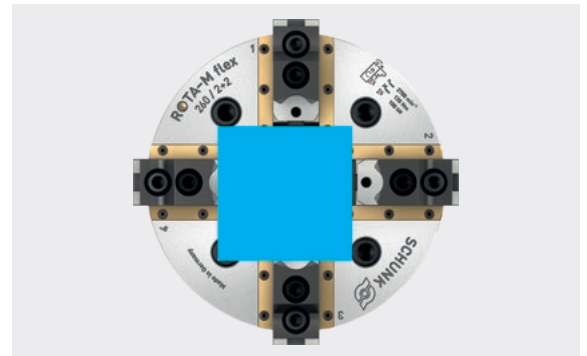
The ROTA-M flex 2+2 is impressive with its high degree of flexibility. With this centrally compensating manual lathe chuck, there is virtually no workpiece that cannot be clamped with this clamping device. With a selection of proper top jaws, round, cubic and a variety of geometrically unshaped parts can be clamped.

- ❶ Small workpieces
- ❷ Large workpieces
- ❸ Rectangular workpieces
- ❹ Square workpieces
- ❺ Free-form parts
- ❻ Semicircular and angular workpieces
- ❼ Cams
- ❽ Inclined workpieces

Functionality: Compensating workpiece clamping

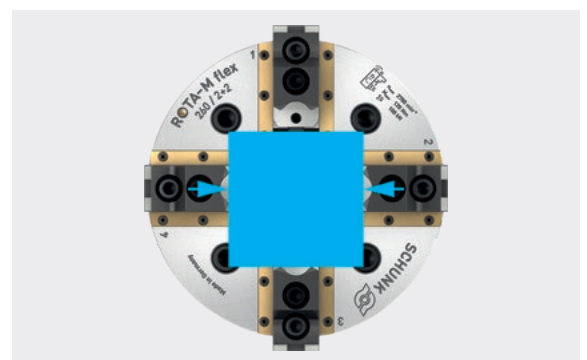
Step 1: Insert the workpiece

Round, cubic or geometrically unshaped parts can be inserted in open state.



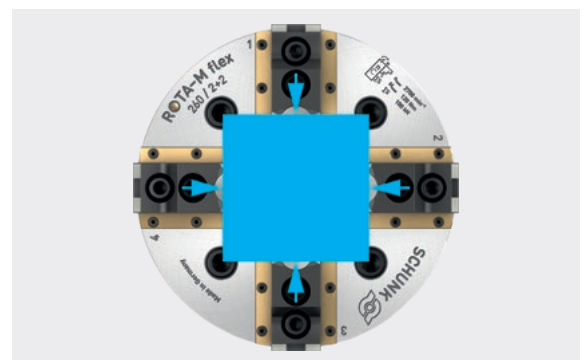
Step 2: Install the first pair of jaws

By actuating the manual lathe chuck, the first pair of jaws contacts the workpiece. The workpiece is now centered in this plane.



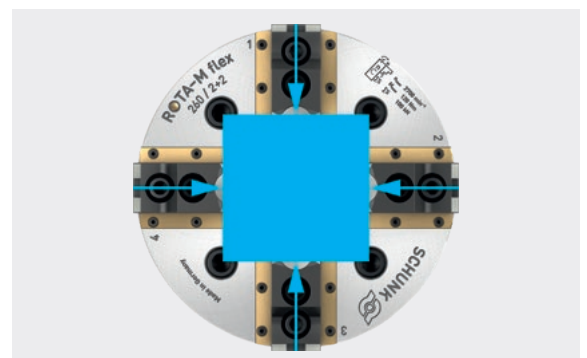
Step 3: Install the second pair of jaws

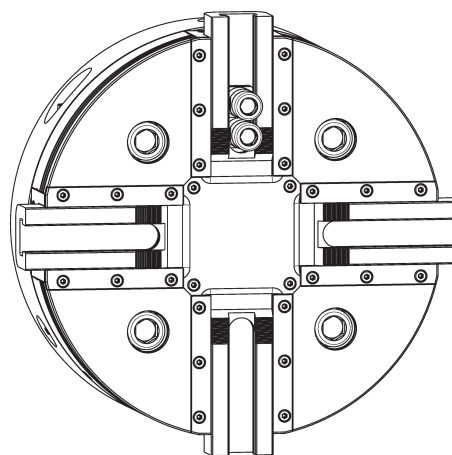
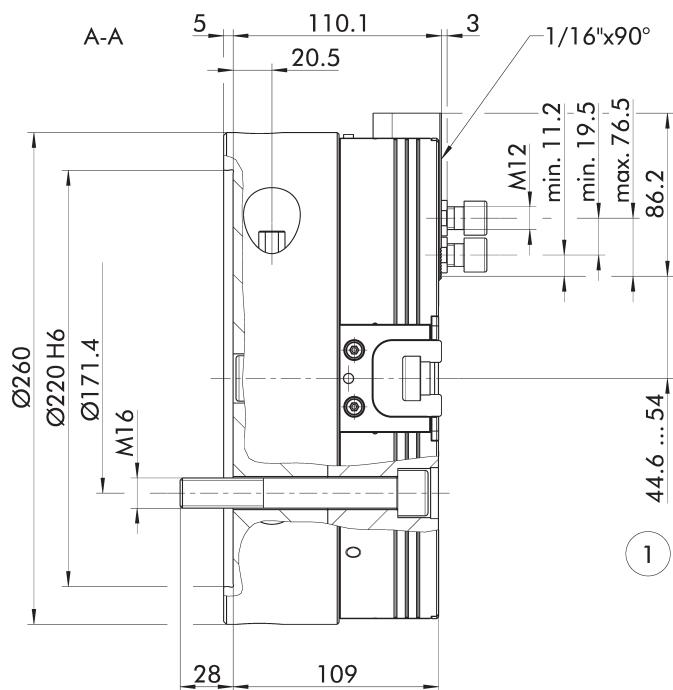
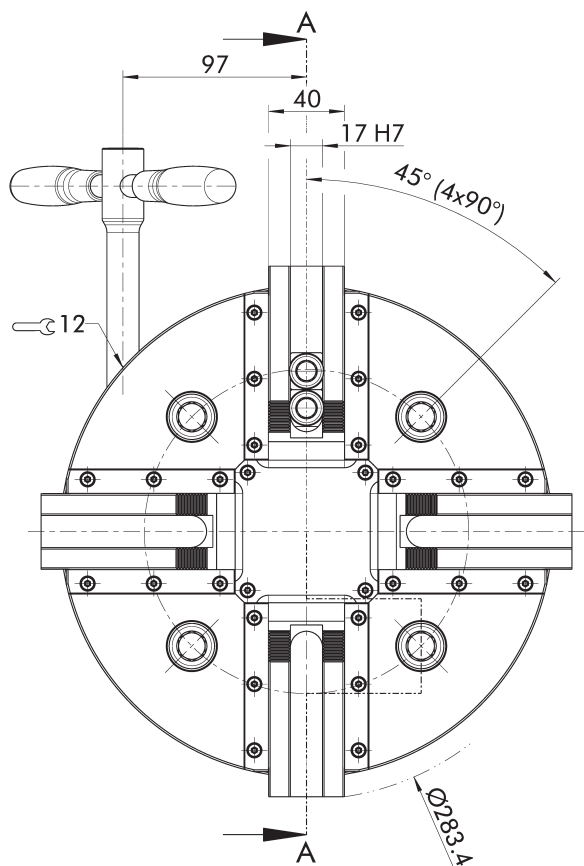
During further actuation, the second pair of jaws also contacts the workpiece and moves the workpiece in this plane to the center.



Step 4: Clamp the workpiece

If both pairs of jaws are in contact with the workpiece, the workpiece is clamped evenly and centrally with the full clamping force (depending on the torque).





Subject to technical changes.

① Distance to center of first tooth

Technical data

Spindle type	Spindle size	ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Compensation stroke/jaw [mm]	Weight [kg]
ISO 702-4	Nr. 8 (Z220)	1389670	1/16" x 90°	2700	100	120	9.5	5.1	41

Scope of delivery

Chuck, T-nuts, or attachment screws for top jaws, chuck mounting screws, spanner wrench, eye bolt, operating manual; without top jaws, without locking cover

Notes

Stationary applications

For stationary use, the ROTA-M flex 2+2 can be retrofitted with standardized console and adapter plates (see accessories).

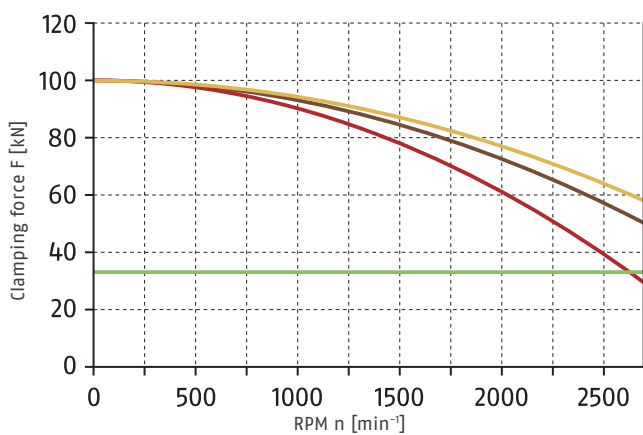
Use of 2-jaw clamping

When using 2-jaw clamping, a locking cover is additionally required to block one pair of jaws (see accessories).

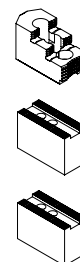
Clamping force, 2-jaw clamping

When changing to 2-jaw clamping, the maximum clamping force is halved at the same torque.

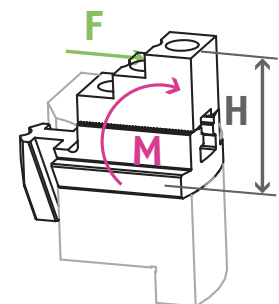
Clamping force-RPM-diagram



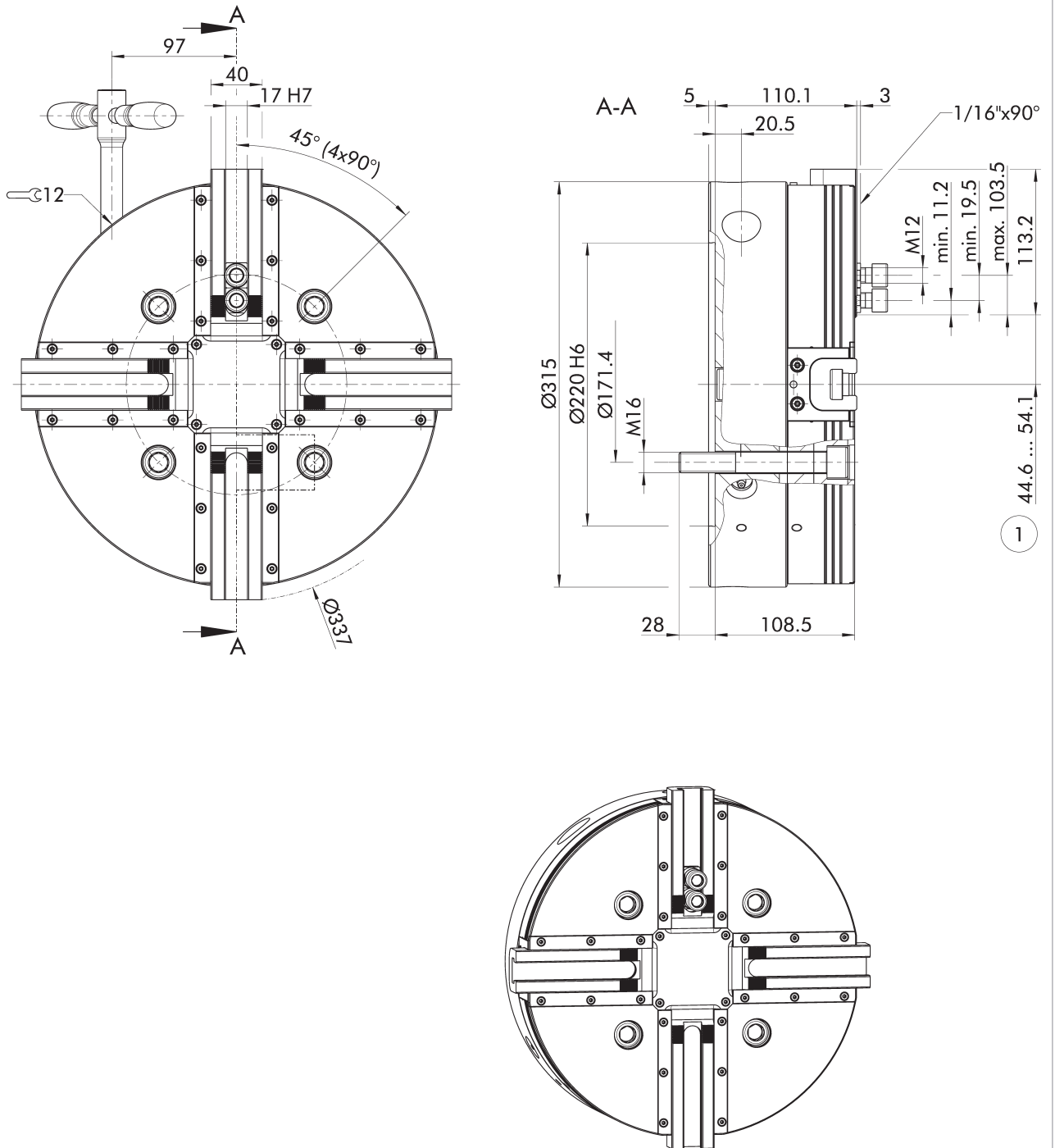
- Required minimum clamping force F_{spmin} 33%
- SHB 210/4
1.5 kg
- SWB 200/4
5.6 kg
- SWB-AL 200/4
2 kg



Load of base jaw guidance



$M_{max} = 1850 \text{ Nm}$



Subject to technical changes.

① Distance to center of first tooth

Technical data

Spindle type	Spindle size	ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Compensation stroke/jaw [mm]	Weight [kg]
ISO 702-4	Nr. 8 (Z220)	1400911	1/16" x 90°	2200	100	120	9.5	5.1	63

Scope of delivery

Chuck, T-nuts, or attachment screws for top jaws, chuck mounting screws, spanner wrench, eye bolt, operating manual; without top jaws, without locking cover

Notes

Stationary applications

For stationary use, the ROTA-M flex 2+2 can be retrofitted with standardized console and adapter plates (see accessories).

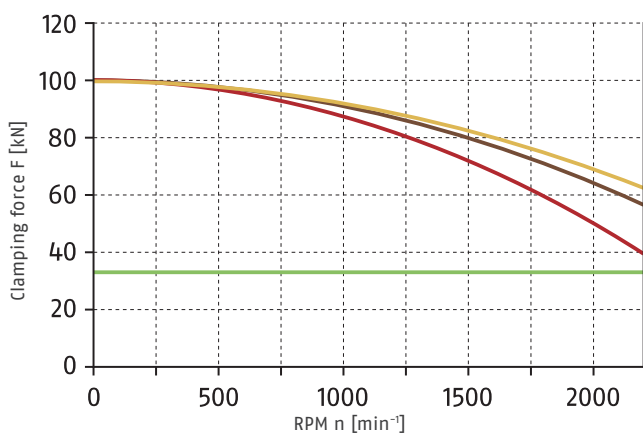
Use of 2-jaw clamping

When using 2-jaw clamping, a locking cover is additionally required to block one pair of jaws (see accessories).

Clamping force, 2-jaw clamping

When changing to 2-jaw clamping, the maximum clamping force is halved at the same torque.

Clamping force-RPM-diagram

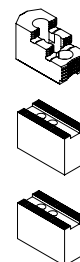


Required minimum clamping force F_{spmin} 33%

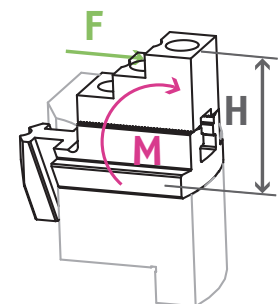
SHB 210/4
1.5 kg

SWB 200/4
5.6 kg

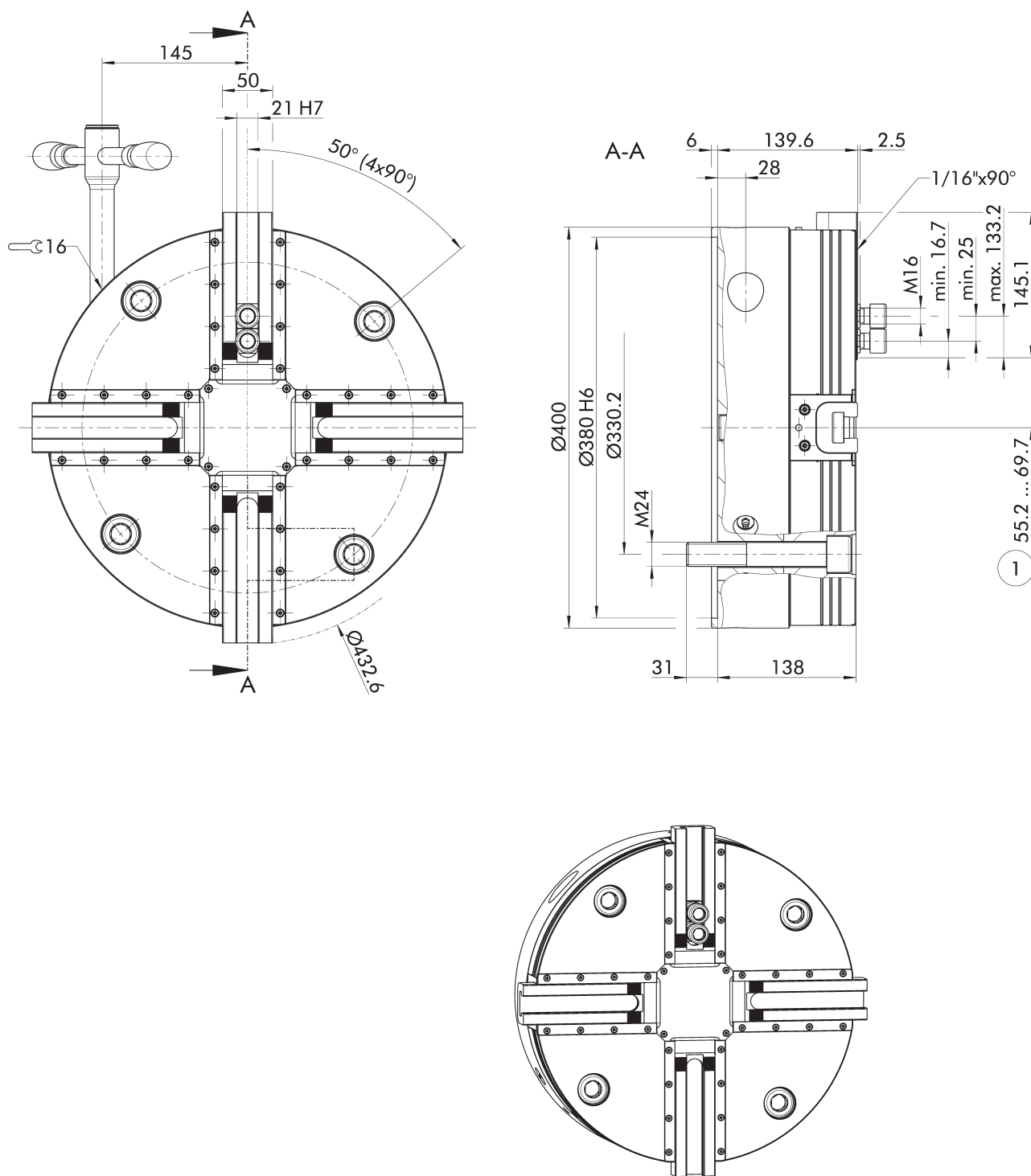
SWB-AL
200/4
2 kg



Load of base jaw guidance



$M_{max} = 1850 \text{ Nm}$



Subject to technical changes.

① Distance to center of first tooth

Technical data

Spindle type	Spindle size	ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Compensation stroke/jaw [mm]	Weight [kg]
ISO 702-4	Nr. 15 (Z380)	1407684	1/16" x 90°	1500	150	200	14.5	7.9	125

Scope of delivery

Chuck, T-nuts, or attachment screws for top jaws, chuck mounting screws, spanner wrench, eye bolt, operating manual; without top jaws, without locking cover

Notes

Stationary applications

For stationary use, the ROTA-M flex 2+2 can be retrofitted with standardized console and adapter plates (see accessories).

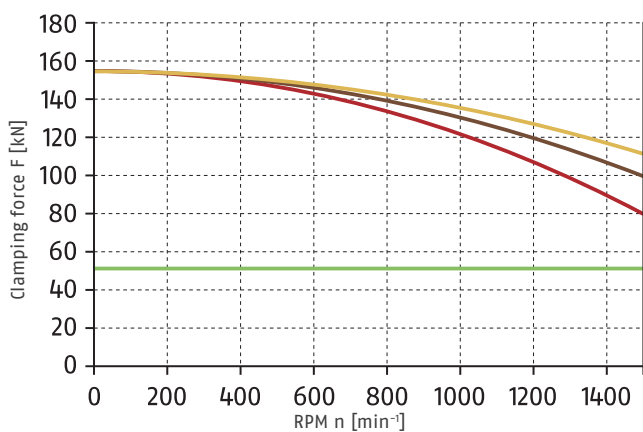
Use of 2-jaw clamping

When using 2-jaw clamping, a locking cover is additionally required to block one pair of jaws (see accessories).

Clamping force, 2-jaw clamping

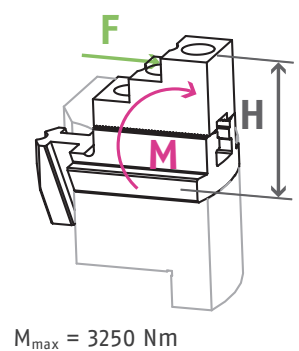
When changing to 2-jaw clamping, the maximum clamping force is halved at the same torque.

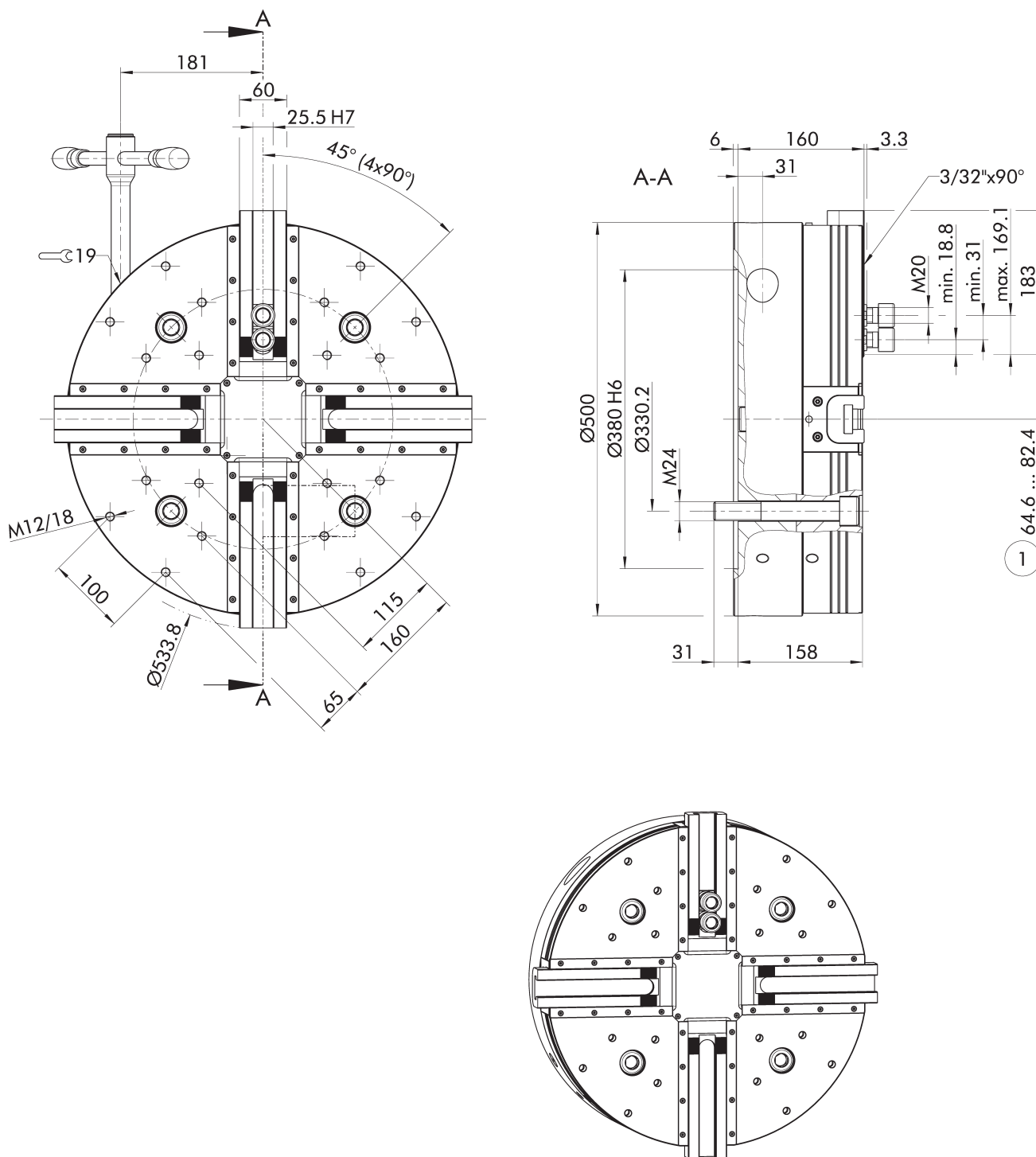
Clamping force-RPM-diagram



- Required minimum clamping force F_{spmin} 33%
- SHB 250/4
4.8 kg
- SWB 250/4
12.4 kg
- SWB-AL 250/4
4.4 kg

Load of base jaw guidance





Subject to technical changes.

① Distance to center of first tooth

Technical data

Spindle type	Spindle size	ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Compensation stroke/jaw [mm]	Weight [kg]
ISO 702-4	Nr. 15 (Z380)	1410477	3/32" x 90°	1100	180	250	17.8	10	227

Scope of delivery

Chuck, T-nuts, or attachment screws for top jaws, chuck mounting screws, spanner wrench, eye bolt, operating manual; without top jaws, without locking cover

Notes

Stationary applications

For stationary use, the ROTA-M flex 2+2 can be retrofitted with standardized console and adapter plates (see accessories).

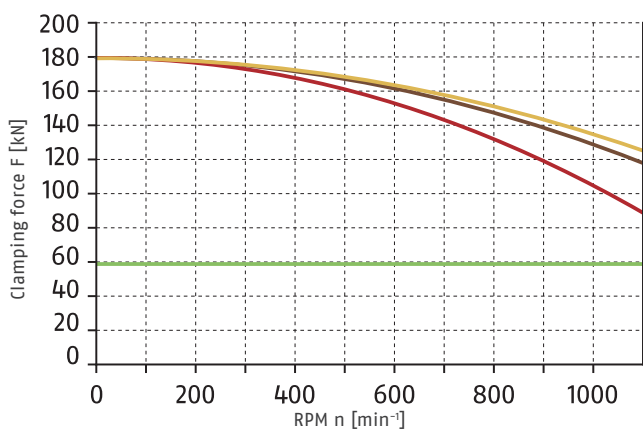
Use of 2-jaw clamping

When using 2-jaw clamping, a locking cover is additionally required to block one pair of jaws (see accessories).

Clamping force, 2-jaw clamping

When changing to 2-jaw clamping, the maximum clamping force is halved at the same torque.

Clamping force-RPM-diagram

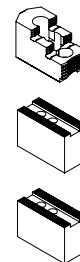


Required minimum clamping force F_{spmin} 33%

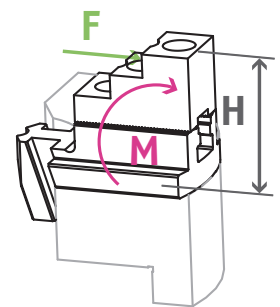
SHB 400/4
10.8 kg

SWB 400/4
21.6 kg

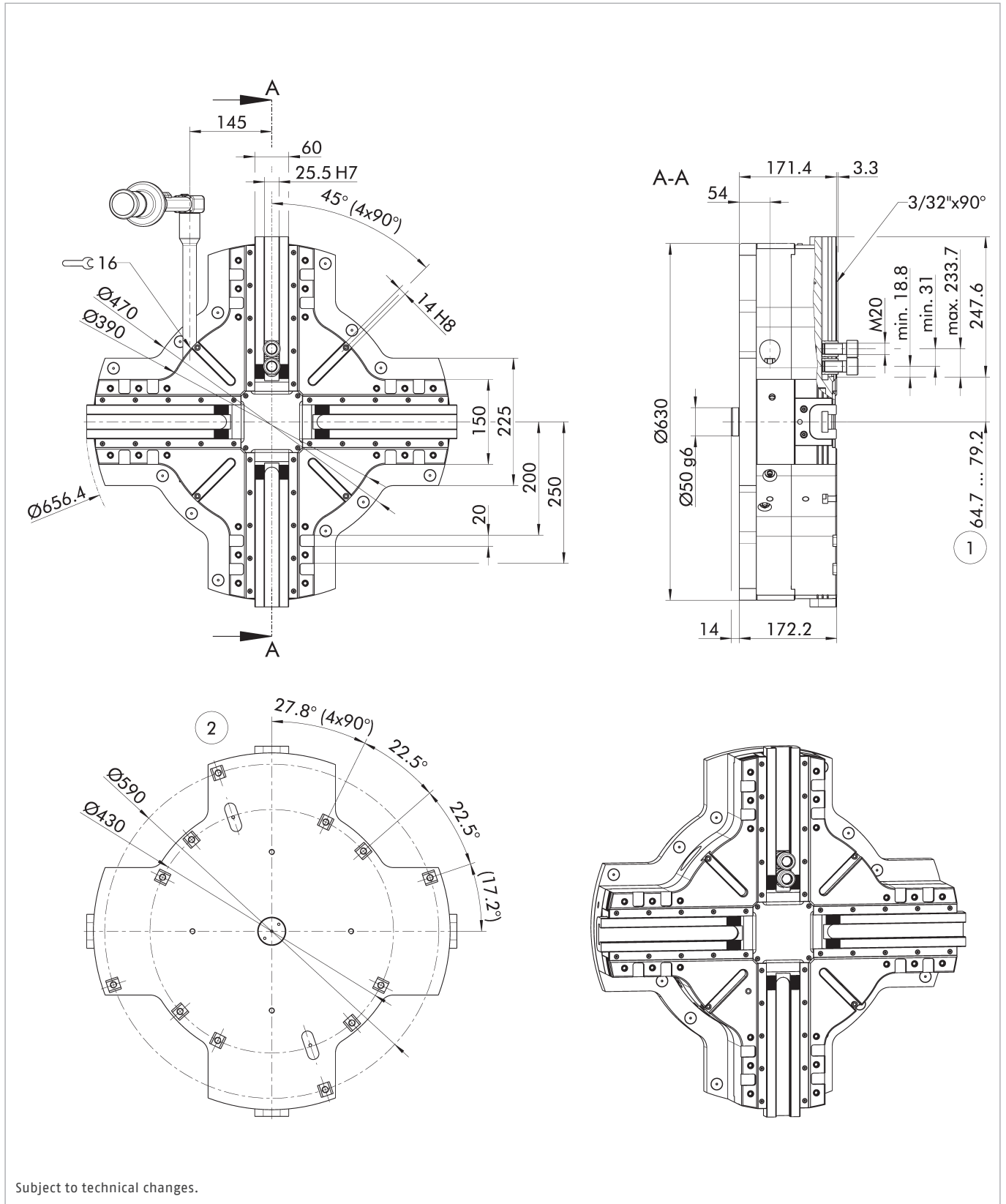
SWB-AL 400/4
8.6 kg



Load of base jaw guidance



$M_{max} = 4850 \text{ Nm}$



① Distance to center of first tooth

② Lathe chuck suitable for a 22.5° star groove table

Technical data

ID	Serration	Max. RPM	Max. clamping force	Max. torque	Stroke/jaw	Compensation stroke/jaw	Weight
		[min ⁻¹]	[kN]	[Nm]	[mm]	[mm]	[kg]
1464186	3/32" x 90°	900	150	200	14.5	7.9	217

Scope of delivery

Chuck, centering pin, T-nuts, ratchet wrenches with adapter, eye bolt, mounting screws, nut for T-slots, bore closing cover, operating manual; without top jaws, without fixed workpiece stops, without locking cover

Notes

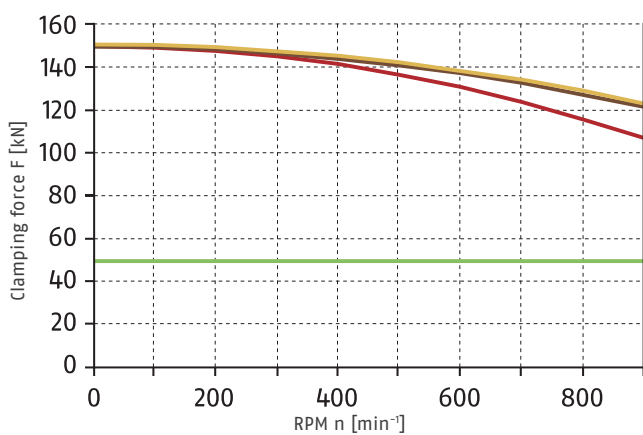
Use of 2-jaw clamping

When using 2-jaw clamping, a locking cover is additionally required to block one pair of jaws (see accessories).

Clamping force, 2-jaw clamping

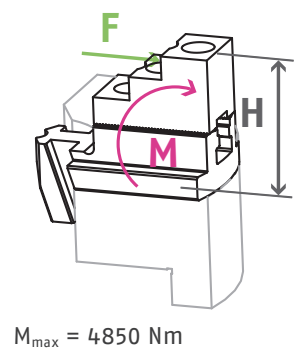
When changing to 2-jaw clamping, the maximum clamping force is halved at the same torque.

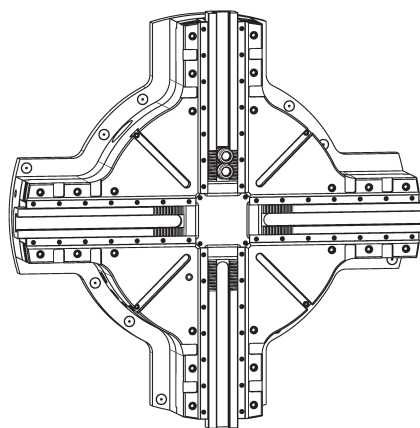
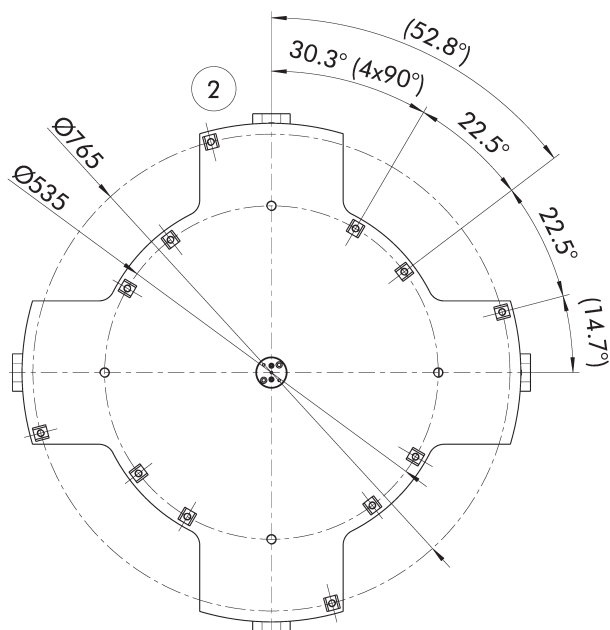
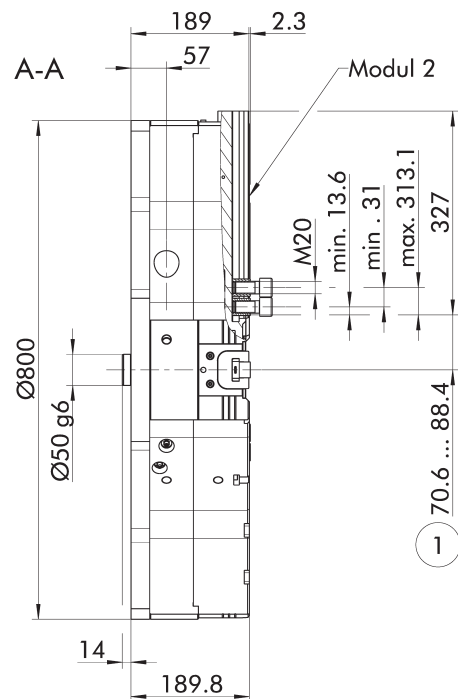
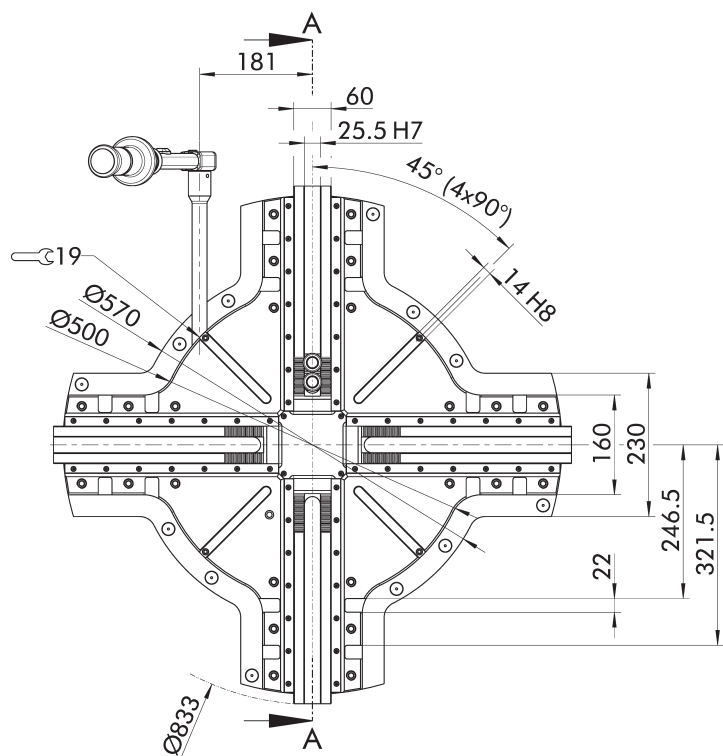
Clamping force-RPM-diagram



- Required minimum clamping force F_{spmin} 33%
- SHB 400/4
10.8 kg
- SWB 400/4
21.6 kg
- SWB-AL 400/4
8.6 kg

Load of base jaw guidance





Subject to technical changes.

① Distance to center of first tooth

② Lathe chuck suitable for a 22.5° star groove table

Technical data

ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Compensation stroke/jaw [mm]	Weight [kg]
1446775	Modul 2	800	180	250	17.8	10	395

Scope of delivery

Chuck, centering pin, T-nuts, ratchet wrenches with adapter, eye bolt, mounting screws, nut for T-slots, bore closing cover, operating manual; without top jaws, without fixed workpiece stops, without locking cover

Notes

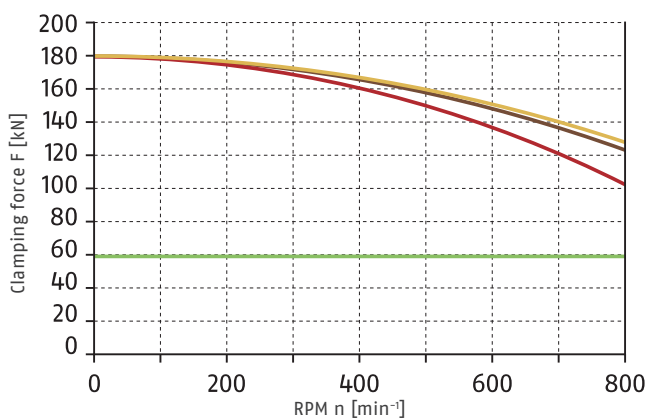
Use of 2-jaw clamping

When using 2-jaw clamping, a locking cover is additionally required to block one pair of jaws (see accessories).

Clamping force, 2-jaw clamping

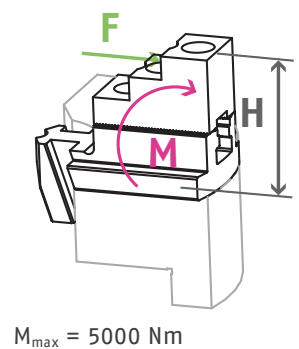
When changing to 2-jaw clamping, the maximum clamping force is halved at the same torque.

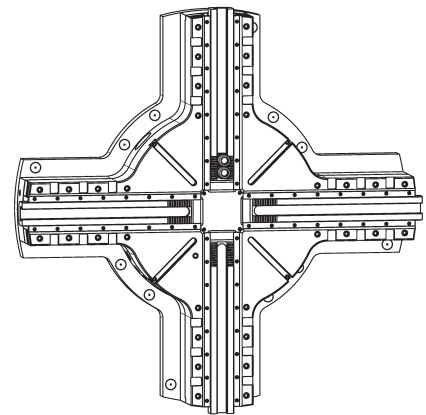
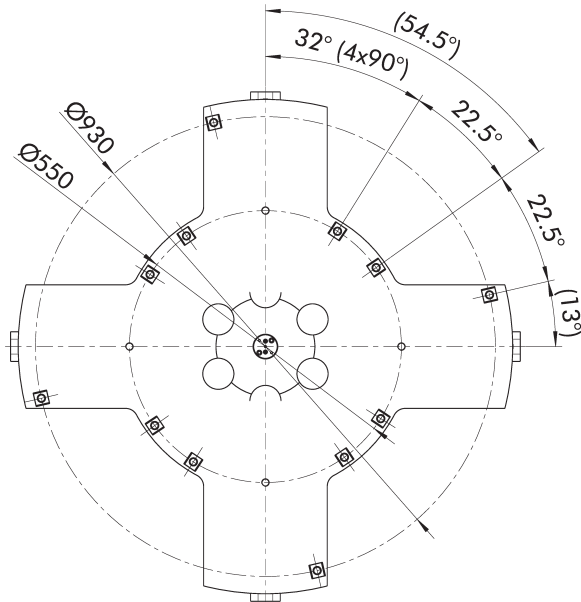
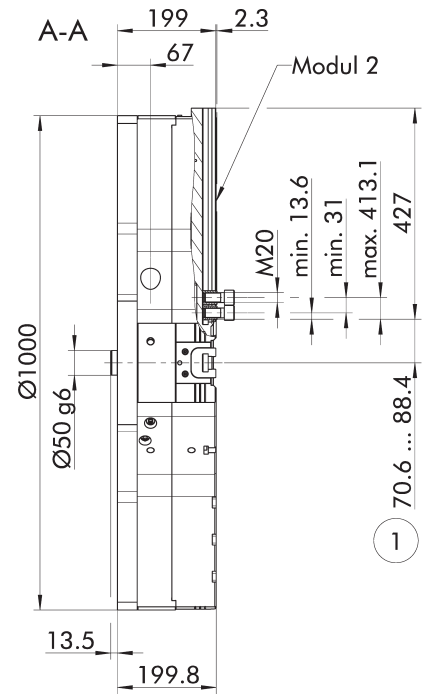
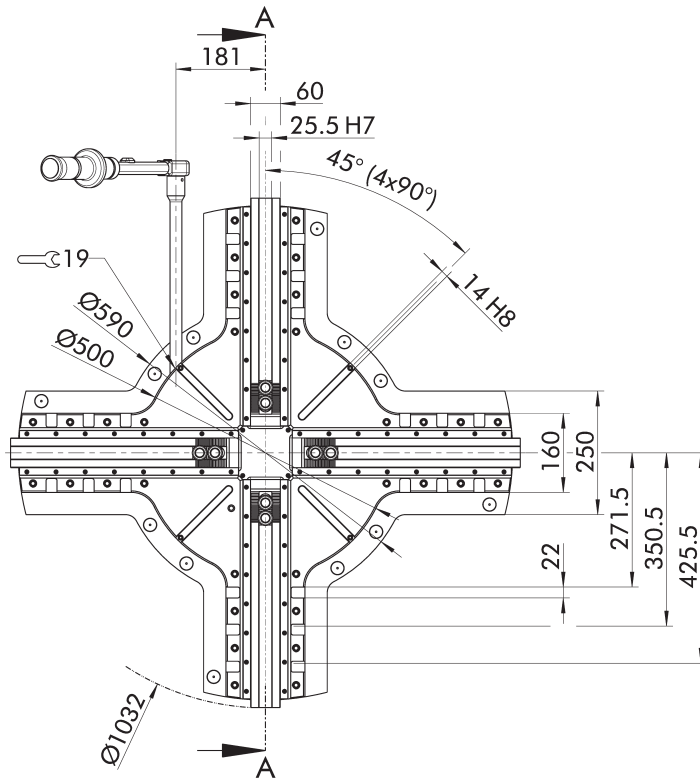
Clamping force-RPM-diagram



- Required minimum clamping force F_{spmin} 33%
- SP-HB-M 400-500/4 13.6 kg
- SWB-M 400/4 21.8 kg
- SWBL-M 400/4 9 kg

Load of base jaw guidance





Subject to technical changes.

① Distance to center of first tooth

② Lathe chuck suitable for a 22.5° star groove table

Technical data

ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Compensation stroke/jaw [mm]	Weight [kg]
1446776	Modul 2	700	180	250	17.8	10	520

Scope of delivery

Chuck, centering pin, T-nuts, ratchet wrenches with adapter, eye bolt, mounting screws, nut for T-slots, bore closing cover, operating manual; without top jaws, without fixed workpiece stops, without locking cover

Notes

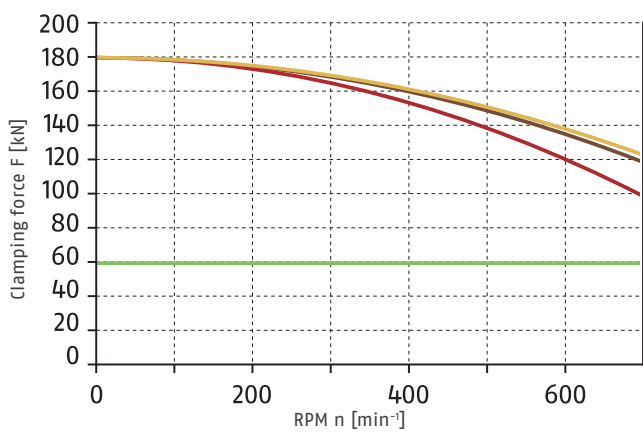
Use of 2-jaw clamping

When using 2-jaw clamping, a locking cover is additionally required to block one pair of jaws (see accessories).

Clamping force, 2-jaw clamping

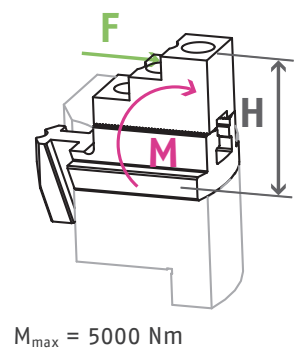
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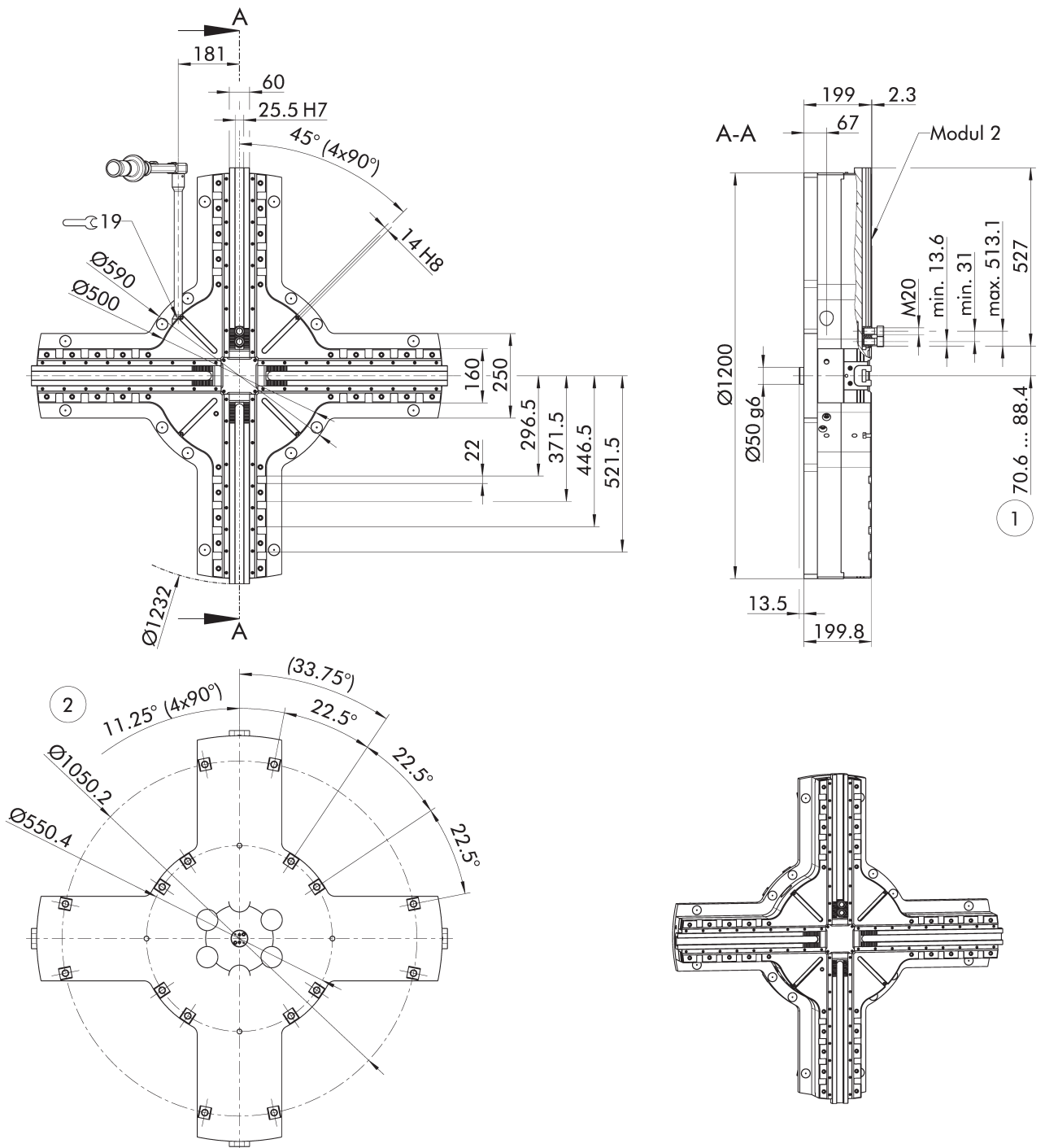
Clamping force-RPM-diagram



- Required minimum clamping force F_{spmin} 33%
- SP-HB-M
400-500/4
13.6 kg
- SWB-M 400/4
21.8 kg
- SWBL-M
400/4
9 kg

Load of base jaw guidance





Subject to technical changes.

① Distance to center of first tooth

② Lathe chuck suitable for a 22.5° star groove table

Technical data

ID	Serration	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Compensation stroke/jaw [mm]	Weight [kg]
1446777	Modul 2	600	180	250	17.8	10	620

Scope of delivery

Chuck, centering pin, T-nuts, ratchet wrenches with adapter, eye bolt, mounting screws, nut for T-slots, bore closing cover, operating manual; without top jaws, without fixed workpiece stops, without locking cover

Notes

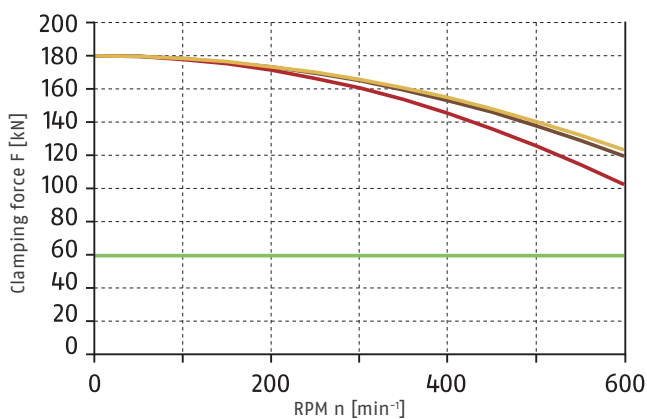
Use of 2-jaw clamping

When using 2-jaw clamping, a locking cover is additionally required to block one pair of jaws (see accessories).

Clamping force, 2-jaw clamping

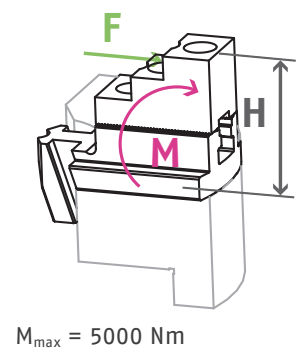
When changing to 2-jaw clamping, the maximum clamping force is halved at the same torque.

Clamping force-RPM-diagram



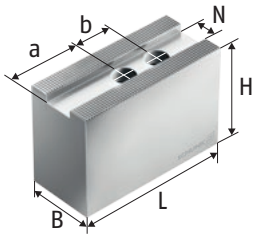
- Required minimum clamping force F_{spmin} 33%
- SP-HB-M
400-500/4
13.6 kg
- SWB-M 400/4
21.8 kg
- SWBL-M
400/4
9 kg

Load of base jaw guidance

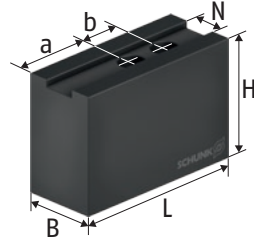


Soft top jaws

with fine serration 90°



SWB-AL
Soft top jaws



SWB
Soft top jaws

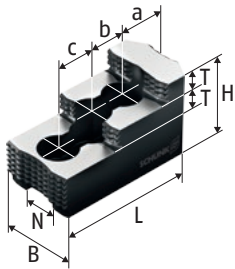
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-M flex 2+2 260	SWB-AL 200/4	1457304	17	40	60	90	43	22	M12	2.0
ROTA-M flex 2+2 260	SWB 200/4	1455397	17	40	60	90	43	22	M12	5.6
ROTA-M flex 2+2 315	SWB-AL 200/4	1457304	17	40	60	90	43	22	M12	2.0
ROTA-M flex 2+2 315	SWB 200/4	1455397	17	40	60	90	43	22	M12	5.6
ROTA-M flex 2+2 400	SWB-AL 250/4	1457305	21	50	80	120	62	28	M16	4.4
ROTA-M flex 2+2 400	SWB 250/4	1457272	21	50	80	120	62	28	M16	12.4
ROTA-M flex 2+2 500	SWB-AL 400/4	1457306	25.5	60	100	155	90	35	M20	8.6
ROTA-M flex 2+2 500	SWB 400/4	1457273	25.5	60	90	155	90	35	M20	21.6
ROTA-ML flex 2+2 630	SWB-AL 400/4	1457306	25.5	60	100	155	90	35	M20	8.6
ROTA-ML flex 2+2 630	SWB 400/4	1457273	25.5	60	90	155	90	35	M20	21.6

Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Hard stepped top jaws

with fine serration 90°



SHB
Hard stepped top jaws

Technical data

Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	T [mm]	a [mm]	b [mm]	c [mm]	Screws	m/SET [kg]
ROTA-M flex 2+2 260	SHB 210/4	1457276	17	40	49	84.2	12	28.7	19	19	M12	1.5
ROTA-M flex 2+2 315	SHB 210/4	1457276	17	40	49	84.2	12	28.7	19	19	M12	1.5
ROTA-M flex 2+2 400	SHB 250/4	1457277	21	50	58	103.5	14	34	25	25	M16	4.8
ROTA-M flex 2+2 500	SHB 400/4	1457278	25.5	60	75	140	18	53	31	31	M20	10.8
ROTA-ML flex 2+2 630	SHB 400/4	1457278	25.5	60	75	140	18	53	31	31	M20	10.8

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T-nut

with fine serration 90°



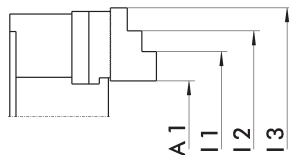
NS
T-nut

Chuck type	Description	ID	H [mm]	H1 [mm]	G	Cyl.-screw	Max. adm. tightening torque [Nm]
ROTA-M flex 2+2 260	NS 120	0140101	23	9	M12	M12 x 30	70
ROTA-M flex 2+2 315	NS 120	0140101	23	9	M12	M12 x 30	70
ROTA-M flex 2+2 400	NS 160	0140102	27	11	M16	M16 x 35	150
ROTA-M flex 2+2 500	NS 200	0140103	29	11	M20	M20 x 40	220
ROTA-ML flex 2+2 630	NS 200	0140103	29	11	M20	M20 x 40	220
ROTA-ML flex 2+2 800	NS 200	0140103	29	11	M20	M20 x 40	220
ROTA-ML flex 2+2 1000	NS 200	0140103	29	11	M20	M20 x 40	220
ROTA-ML flex 2+2 1200	NS 200	0140103	29	11	M20	M20 x 40	220

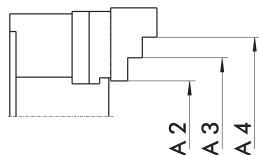
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Hard stepped top jaws

with fine serration 90°



Jaw position I



Jaw position II

O.D. clamping

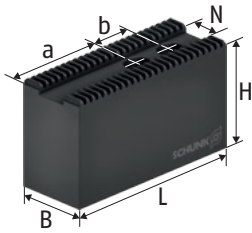
Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]
ROTA-M flex 2+2 260	SHB 210/4	1457276	23 - 161	48 - 173	98 - 223	143 - 260
ROTA-M flex 2+2 315	SHB 210/4	1457276	23 - 215	47 - 240	97 - 290	143 - 315
ROTA-M flex 2+2 400	SHB 250/4	1457277	38 - 282	66 - 312	148 - 394	221 - 400
ROTA-M flex 2+2 500	SHB 400/4	1457278	48 - 330	67 - 377	169 - 479	271 - 500
ROTA-ML flex 2+2 630	SHB 400/4	1457278	48 - 454	66 - 510	168 - 613	270 - 630

I.D. clamping

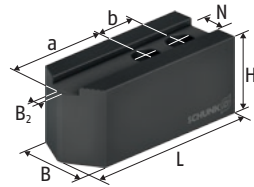
Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA-M flex 2+2 260	SHB 210/4	1457276	98 - 236	144 - 282	192 - 330
ROTA-M flex 2+2 315	SHB 210/4	1457276	98 - 289	144 - 335	192 - 384
ROTA-M flex 2+2 400	SHB 250/4	1457277	91 - 335	164 - 408	244 - 488
ROTA-M flex 2+2 500	SHB 400/4	1457278	121 - 454	223 - 506	324 - 607
ROTA-ML flex 2+2 630	SHB 400/4	1457278	121 - 528	223 - 630	324 - 731

Soft top jaws

Modul 2



SWB-M/4
Soft top jaws



SWBL-M/4
Soft top jaws

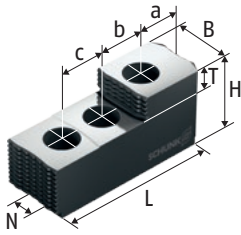
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-ML flex 2+2 800	SWBL-M 400/4	1457325	25.5	60	90	195	110	35		9.0
ROTA-ML flex 2+2 800	SWB-M 400/4	1457324	25.5	60	90	157	30	35	M20	21.8
ROTA-ML flex 2+2 1000	SWBL-M 400/4	1457325	25.5	60	90	195	110	35		9.0
ROTA-ML flex 2+2 1000	SWB-M 400/4	1457324	25.5	60	90	157	30	35	M20	21.8
ROTA-ML flex 2+2 1200	SWBL-M 400/4	1457325	25.5	60	90	195	110	35		9.0
ROTA-ML flex 2+2 1200	SWB-M 400/4	1457324	25.5	60	90	157	30	35	M20	21.8

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Hard stepped top jaws

Modul 2



SP-HB-M/4
Hard stepped top jaws

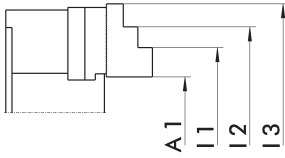
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	T [mm]	a [mm]	b [mm]	c [mm]	Screws	m/SET [kg]
ROTA-ML flex 2+2 800	SP-HB-M 400-500/4	1457323	25.5	57.5	73	159.1	22	38.3	42	42	M20	13.6
ROTA-ML flex 2+2 1000	SP-HB-M 400-500/4	1457323	25.5	57.5	73	159.1	22	38.3	42	42	M20	13.6
ROTA-ML flex 2+2 1200	SP-HB-M 400-500/4	1457323	25.5	57.5	73	159.1	22	38.3	42	42	M20	13.6

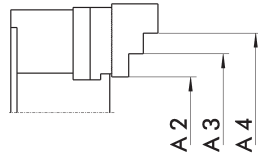
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Hard stepped top jaws

Modul 2



Jaw position I



Jaw position II

O.D. clamping

Chuck type	Description	ID	A1 [mm]	A2 [mm]	A4 [mm]
ROTA-ML flex 2+2 800	SP-HB-M	1457323	48 - 627	59 - 647	245 - 800
	400-500/4				
ROTA-ML flex 2+2 1000	SP-HB-M	1457323	48 - 827	59 - 847	245 - 1000
	400-500/4				
ROTA-ML flex 2+2 1200	SP-HB-M	1457323	48 - 1027	59 - 1047	245 - 1200
	400-500/4				

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I3 [mm]
ROTA-ML flex 2+2 800	SP-HB-M	1457323	179 - 759	366 - 945
	400-500/4			
ROTA-ML flex 2+2 1000	SP-HB-M	1457323	179 - 959	366 - 1145
	400-500/4			
ROTA-ML flex 2+2 1200	SP-HB-M	1457323	179 - 1159	366 - 1345
	400-500/4			

Console jaws

Console jaw movable

With 1/16" x 90° or Modul 2 serration.
For suitable top jaws, see "Interface" column.



Suitable for	Description	Interface	ID
ROTA-ML flex 2+2 630	SKB-SV90° 100	W-100-1	1474310
ROTA-ML flex 2+2 800			
ROTA-ML flex 2+2 1000			
ROTA-ML flex 2+2 1200	SKB-M2 125	W-125-1	1450639

Console jaw fixed

Can be positioned in the chuck face via T-slots.
For suitable top jaws, see "Interface" column.



Suitable for	Description	Interface	ID
ROTA-ML flex 2+2 630	SKB-F 100	W-100-1	1474309
ROTA-ML flex 2+2 800			
ROTA-ML flex 2+2 1000			
ROTA-ML flex 2+2 1200	SKB-F 125	W-125-1	1450640

Top Jaws

Jaw profiled

For increasing the friction between jaw and workpiece without clamping impressions.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBD 100-35-10	100	35	10	W-100-1	1373346
GBD 125-40-11.5	125	40	11.5	W-125-1	1373349

Stepped jaw

With ground step, 8 mm.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBS 100-35-10-5	100	35	10	W-100-1	1373325
GBS 125-40-11.5-8	125	40	11.5	W-125-1	1373327

Serrated jaw

For increasing the friction between jaw and workpiece with minimal clamping impressions.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBC 100-35-11	100	35	11	W-100-1	1373267
GBC 125-40-12.5	125	40	12.5	W-125-1	1373268

Stepped jaw

With coated step, 5 mm.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBS-W 100-35-10-5	100	35	10	W-100-1	1395510
GBS-W 125-40-11.5-5	125	40	11.5	W-125-1	0430414

Ground jaw

With a completely ground clamping face.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBP 100-35-10	100	35	10	W-100-1	1373272
GBP 125-40-11.5	125	40	11.5	W-125-1	1373278

Stepped jaw

With grip step 3 mm and ground step 18 mm.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBS-G3					
125-40-21.5-18	125	40	21.5	W-125-1	0430415
GBS-G3 125-40-24-18	125	40	24	W-125-1	1322989

Soft jaw

Hardenable jaws for rework at the customer site, e.g. for incorporating contours or special shapes.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBW 100-35-16	100	35	16	W-100-1	1373287
GBW 125-40-20	125	40	20	W-125-1	1373288

Stepped jaw

With special "soft" grip step, 5 mm.
For embossed clamping of soft materials such as plastic or aluminum.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBS-SG5 125-40-11.5	125	40	11.5	W-125-1	1393552

Stepped jaw

With grip step, 3 mm.
For embossed clamping of unhardened materials up to 22 HRC.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBS-G3 100-35-10	100	35	10	W-100-1	1373330
GBS-G3 125-40-11.5	125	40	11.5	W-125-1	1373331

Stepped jaw

With grip step, 5 mm.
For embossed clamping of unhardened materials up to 22 HRC.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBS-G5 100-35-10	100	35	10	W-100-1	1373333
GBS-G5 125-40-11.5	125	40	11.5	W-125-1	1373334

Stepped jaw

With grip step, 8 mm.
For embossed clamping of unhardened materials up to 22 HRC.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBS-G8 100-35-10	100	35	10	W-100-1	1373337
GBS-G8 125-40-11.5	125	40	11.5	W-125-1	1373338

Stepped jaw

With carbide grip step, 3 mm.
For embossed clamping of hardened materials up to 58 HRC.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBS-CG3 100-35-10	100	35	10	W-100-1	1428440
GBS-CG3 125-40-11.5	125	40	11.5	W-125-1	1395524

Stepped jaw

With carbide grip step, 5 mm.
For embossed clamping of hardened materials up to 58 HRC.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBS-CG5 100-35-12	100	35	12	W-100-1	1428441
GBS-CG5 125-40-11.5	125	40	11.5	W-125-1	1424000

Grip jaw

For embossed clamping of unhardened materials up to 22 HRC.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GBG 100-35-10	100	35	10	W-100-1	1373282
GBG 125-40-11.5	125	40	11.5	W-125-1	1373284

Spring plate pull-down jaw

For an active jaw pull-down function without clamping impressions on the workpiece for more precise machining results.



Description	Width [mm]	Height [mm]	Depth [mm]	Interface	ID
GFB 100-34-10	100	34	10	W-100-1	0430191
GFB 125-39-10	125	39	10	W-125-1	0430192

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

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-M flex 2+2 260		
ROTA-M flex 2+2 315		
ROTA-M flex 2+2 400		
ROTA-M flex 2+2 500		
ROTA-ML flex 2+2 630		
ROTA-ML flex 2+2 800		
ROTA-ML flex 2+2 1000		
ROTA-ML flex 2+2 1200	IFT Set	1404235

Measuring head adapter for 4-jaw clamping

For use as an extension of the IFT measuring head for measuring the jaw clamping force of 4-jaw chucks.



Suitable for	Description	ID
ROTA-M flex 2+2 260		
ROTA-M flex 2+2 315		
ROTA-M flex 2+2 400		
ROTA-M flex 2+2 500		
ROTA-ML flex 2+2 630		
ROTA-ML flex 2+2 800		
ROTA-ML flex 2+2 1000		
ROTA-ML flex 2+2 1200	IFT MA4	1452686

Torque wrench

Torque wrench for actuation of SCHUNK manual lathe chucks.



Suitable for	Description	ID
ROTA-M flex 2+2 260		
ROTA-M flex 2+2 315		
ROTA-M flex 2+2 400		
ROTA-ML flex 2+2 630	SSH-D-1/2" 40-200	9938065
ROTA-M flex 2+2 500		
ROTA-ML flex 2+2 800		
ROTA-ML flex 2+2 1000		
ROTA-ML flex 2+2 1200	SSH-D-3/4" 80-400	1301023

Ratchets

Ratchet for fast actuation of SCHUNK manual lathe chucks.



Suitable for	Description	ID
ROTA-M flex 2+2 260		
ROTA-M flex 2+2 315		
ROTA-M flex 2+2 400		
ROTA-ML flex 2+2 630	SSH-K 1/2"-350	1151118
ROTA-M flex 2+2 500	SSH-K 3/4"-510	9987240
ROTA-ML flex 2+2 800		
ROTA-ML flex 2+2 1000		
ROTA-ML flex 2+2 1200	SSH-K 3/4"-620	9987241

Hexagon actuation wrench

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



Suitable for	Description	ID
ROTA-M flex 2+2 260		
ROTA-M flex 2+2 315	SSH-SK SW12-160	1330869
ROTA-M flex 2+2 260		
ROTA-M flex 2+2 315	SSH-SL SW12-260	8704921
ROTA-M flex 2+2 400		
ROTA-ML flex 2+2 630	SSH-SK SW16-230	1330894
ROTA-M flex 2+2 400		
ROTA-ML flex 2+2 630	SSH-SL SW16-330	8704923
ROTA-M flex 2+2 500		
ROTA-ML flex 2+2 800		
ROTA-ML flex 2+2 1000		
ROTA-ML flex 2+2 1200	SSH-SK SW19-330	1448214
ROTA-M flex 2+2 500		
ROTA-ML flex 2+2 800		
ROTA-ML flex 2+2 1000		
ROTA-ML flex 2+2 1200	SSH-SL SW19-480	1448215

Hexagon spanner wrench adapter with ejector

For use as an attachment for a torque wrench and ratchet for actuating SCHUNK manual lathe chucks with hexagonal connection.



Suitable for	Description	ID
ROTA-M flex 2+2 260		
ROTA-M flex 2+2 315	SAS-I 1/2"-SW12	8705487
ROTA-M flex 2+2 400		
ROTA-ML flex 2+2 630	SAS-I 1/2"-SW16	8705471
ROTA-M flex 2+2 500		
ROTA-ML flex 2+2 800		
ROTA-ML flex 2+2 1000		
ROTA-ML flex 2+2 1200	SAS-I 3/4"-SW19	1452197

Consol plate

For mounting the ROTA-M flex 2+2 manual lathe chucks on T-slot tables. The console plate must still be adapted to the respective machine table.



Suitable for	Description	ID
ROTA-M flex 2+2 260	KSL flex 260	1452440
ROTA-M flex 2+2 315	KSL flex 315	1452441
ROTA-M flex 2+2 400	KSL flex 400	1452442
ROTA-M flex 2+2 500	KSL flex 500	1452443

Adapter plate

As a standard size for sizes \varnothing 260 to \varnothing 500 mm.

Suitable for clamping station VERO-S ...



Suitable for	Description	ID
NSL3 400	ADP-NSL3 400	1454646
NSL3 turn 450-3	ADP-NSL3 turn 450	1454659
NSL3 turn 450-3-Z	ADP-NSL3 turn 450-Z	1454670
NSL3 turn 570-5	ADP-NSL3 turn 570	1454668
NSL3 turn 570-5-Z	ADP-NSL3 turn 570-Z	1454671

Locking cover

For locking of a jaw pair to realize a two jaw clamping.



Suitable for	Description	ID
ROTA-M flex 2+2 260		
ROTA-M flex 2+2 315	SLC 260-315	1471984
ROTA-M flex 2+2 400	SLC 400	1471987
ROTA-M flex 2+2 500		
ROTA-ML flex 2+2 630		
ROTA-ML flex 2+2 800		
ROTA-ML flex 2+2 1000		
ROTA-ML flex 2+2 1200	SLC 500-1200	1471989



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