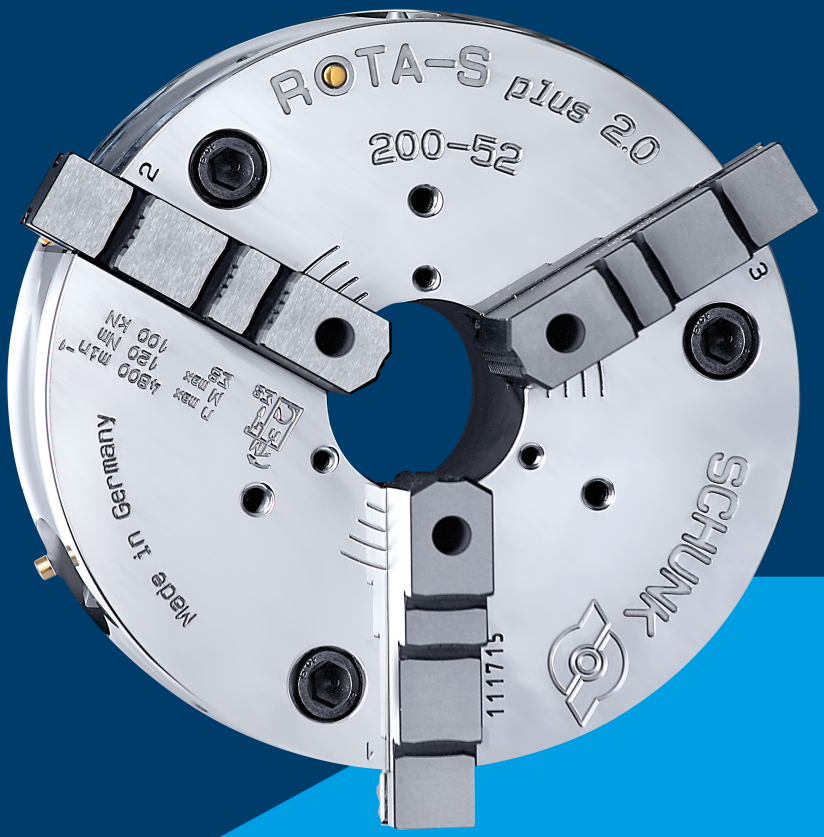


Manual Lathe Chuck
ROTA-S plus 2.0
Assembly and Operating Manual

Hand in hand for tomorrow

Imprint

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Technical changes:
We reserve the right to make alterations for the purpose of technical improvement.

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Dear Customer,

Thank you for trusting our products and our family-owned company, the leading technology supplier of robots and production machines.

Our team is always available to answer any questions on this product and other solutions. Ask us questions and challenge us. We will find a solution!

Best regards,

Your SCHUNK team

Customer Management

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Please read the operating manual in full and keep it close to the product.

Table of Contents

1 General 5

1.1 About this manual 5

1.1.1 Illustration of warnings 5

1.1.2 Applicable documents 6

1.2 Warranty 6

1.3 Scope of delivery 6

2 Basic safety notes 7

2.1 Appropriate use 7

2.2 Inappropriate use 7

2.3 Structural changes 8

2.4 Spare parts 8

2.5 Ambient conditions and operating conditions 8

2.6 Material limitations 8

2.7 Chuck Jaws 9

2.8 Personnel qualifications 9

2.9 Personal protective equipment 10

2.10 Transport 10

2.11 Protection during handling and assembly 10

2.12 Protection during commissioning and operation 10

2.13 Notes on safe operation 10

2.14 Disposal 13

2.15 Fundamental dangers 13

2.16 Protection against dangerous movements 13

2.17 Notes on particular risks 14

3 Technical data 17

3.1 Chuck data 17

3.2 Clamping force / speed diagrams 18

3.3 Calculations for clamping force and speed 22

3.3.1 Calculation of the required clamping force in case of a given rpm 22

3.3.2 Calculation example: required initial clamping force for a given speed 24

3.3.3 Calculation of the permissible speed in case of a given initial clamping force 25

3.4 Grades of Accuracy 26

3.5 Permissible imbalance DIN ISO 21940-11 26

4 Mounting 27

4.1 Torque per screw 27

4.2 Mounting in general 27

4.2.1 Pre-assembly measures 27
4.2.2 Chuck assembly options 28
4.3 Mounting of the chuck 29
4.3.1 Handling prior to attachment 29
4.3.2 Mounting of the Manual Chuck 29
5 Function 30
5.1 Handling and jaw change 30
5.2 Important notes 32
5.3 Control of the chuck 32
5.4 Control of true-running 33
6 Maintenance 34
6.1 Lubrication 34
6.2 Lubricating position 34
6.3 Maintenance and lubrication plan 35
6.4 Jaw change 35
6.5 Disassembling and assembling the chuck 35
7 Storage 38
8 Part list 39
9 Assembly drawing 40
10 Manufacturer certificate 41

1 General

1.1 About this manual

This manual contains important information for the safe, correct use of the product.

It is an integral part of the product and must be kept accessible for personnel at all times.

Personnel must have read and understood this manual before beginning any work. The observance of all safety notes in this manual is a prerequisite to ensure safe work processes.

The illustrations are intended to provide a basic understanding and may deviate from the actual version.

Besides this manual, other documents which apply are those listed under ▸ 1.1.2 [🗋 6]

1.1.1 Illustration of warnings

To make risks clear, the following signal words and symbols are used for safety notes.



⚠ DANGER

Denotes a hazard with a high degree of risk that, if not avoided, will result in death or serious injury.



⚠ WARNING

Denotes a hazard with a medium degree of risk that, if not avoided, could result in death or serious injury.



⚠ CAUTION

Denotes a hazard with a low degree of risk that, if not avoided, could result in a minor or moderate injury.

NOTICE

Information about avoiding material damage.

1.1.2 Applicable documents

- General Terms and Conditions *
- Calculation of the jaw centrifugal forces and jaw guidance load, in the "Technology" chapter of the lathe chuck catalog * and the "Calculating the clamping force and RPM" chapter
- Chuck jaws assembly and operating manual (ID number 1593578) *
- Brief operating instructions if available
- Approval drawings

The documents labeled with an asterisk (*) can be downloaded from **schunk.com**.

1.2 Warranty

The warranty for standard products is 24 months from the date of delivery from the factory, or 50,000 cycles* for manually operated clamping devices and 500,000 cycles* for power operated clamping devices. For special clamping devices, it is 12 months from the date of delivery from the factory, assuming appropriate use in accordance with the following conditions:

- Observe the applicable documents, ▸ 1.1.2 [🗋 6]
- Observance of the ambient conditions and operating conditions, ▸ 2.5 [🗋 8]
- Observance of the specified maintenance and lubrication intervals ▸ 6.3 [🗋 35]

Parts touching the workpiece and wearing parts are not part of the warranty.

* One cycle comprises one complete clamping procedure ("opening" and "closing")

1.3 Scope of delivery

1 Manual Chuck (complete)
either with cylindrical recess and mounting screws
or with the respective flange and accessories for spindle in accordance with
– DIN ISO 702-1 short-taper mount with the screws to the front
– DIN ISO 702-2 short-taper mount with Camlock mounting
– DIN ISO 702-3 short-taper mount with bayonet mounting

1 Spanner wrench

1 Assembly and operating manual

2 Basic safety notes

Improper handling, assembly and maintenance of this product may result in risk to persons and equipment if this operating manual is not observed.

2.1 Appropriate use

- The product is used for clamping metal and plastic workpieces on machine tools.
- The product may only be used within the scope of its technical data.
- The product is intended for industrial and commercial use.
- Appropriate use of the product includes compliance with all instructions in this manual.
- The maximum speed and the necessary clamping force must be determined by the operator for each clamping task in accordance with the valid standards or technical specifications of the manufacturer (See also "Calculation for clamping force and speed of rotation" in the chapter "Technical data").
- Use suitable top jaws with a suitable interface.
- The interference circuit diameter of the workpiece must be smaller or at most equal to the outer diameter of the clamping device.
- The workpiece must not experience plastic deformation under clamping force (clamping pressures are permissible).

2.2 Inappropriate use

The product is not being used appropriately if:

- the product is used as a press, a punch, a toolholder, a load-handling device or as lifting equipment.
- the specified technical data for use of the product are exceeded.
- workpieces are not properly clamped, paying particular attention to the specified clamping forces.
- the top jaws are not mounted properly.
- the product is not being operated properly.
- the product is operated in the stroke end positions.
- the guideways are overloaded due to the chuck jaws being too high or the clamping point being selected too high.
- the product has been insufficiently maintained.
- the product is brought into contact with aggressive media, especially acids.
- the product is used in abrasive blasting processes, especially sandblasting.
- the product is operated in a potentially explosive area (EX area (ATEX directive)).

2.3 Structural changes

Implementation of structural changes

Modifications, changes or reworking, e.g. additional threads, holes, or safety devices, can damage the product or impair its functionality or safety.

- Structural changes should only be made with the written approval of SCHUNK.

2.4 Spare parts

Use of unauthorized spare parts

Using unauthorized spare parts can endanger personnel and damage the product or cause it to malfunction.

- Only use original spare parts and spares authorized by SCHUNK.

2.5 Ambient conditions and operating conditions

Required ambient conditions and operating conditions

Incorrect ambient and operating conditions can make the product unsafe, leading to the risk of serious injuries, considerable material damage and/or a significant reduction in the service life of the product.

- Make sure that the product is only used within its defined application parameters.
- Ensure that the product is of a sufficient size for the application.
- Ensure that maintenance and lubricating intervals are observed.
- Only use cooling emulsions with anti-corrosive additives when machining.

Depending on the operating conditions, the function and clamping force must be checked after a certain period of operation.

With the smallest possible actuation pressure on the clamping cylinder, the base jaws should move evenly. This method is not a substitute for measuring the clamping force.

If the clamping force has dropped too much or if the base jaws and/or the release mechanism no longer move properly, the clamping device must be disassembled, cleaned, and relubricated.

2.6 Material limitations

The product is made of steel alloys, elastomers, aluminum alloys and brass. In addition, Linomax plus grease, Branotect anti-rust oil and Renolit HLT2 are incorporated into the product as auxiliary and operating materials. The safety data sheet for LINOMAX plus can be found at **www.schunk.com**.

2.7 Chuck Jaws

Requirements of the chuck jaws

Rotational or if applicable, accumulated energy, can make the product unsafe and risk the danger of serious injuries and considerable material damage.

- Change chuck jaws at a standstill and without a clamped workpiece.
- Do not use welded jaws.
- Design the chuck jaws to be as light and as low as possible. The clamping point must be as close as possible to the chuck face (clamping points at a greater distance lead to greater surface pressure in the jaw guidance and can significantly reduce the clamping force).
- If the clamping point is at a greater distance from the housing, the operating pressure must be reduced.
- After a collision, the clamping device and the chuck jaws must be subjected to a crack detection test before being used again. Replace damaged parts with original SCHUNK spare parts.
- The chuck jaw mounting screws and if present, the T-nuts, must be replaced if there are **signs of wear**, **are damaged** or if the **recommended number of clamping cycles has been exceeded**. Only use screws of quality grade 12.9 in compliance with the specified tightening torques. For clamping devices with fine serration, the jaw mounting screws must be screwed into the holes closest to the clamping point.

2.8 Personnel qualifications

Inadequate qualification of personnel

Any work on the product by inadequately qualified personnel can lead to serious injuries and considerable material damage.

- All work must be performed by appropriately qualified personnel.
- Personnel must have read and understood the complete manual before beginning any work on the product.
- Observe country-specific accident prevention regulations and the general safety notes.

The following personnel qualifications are required for the various activities on the product:

Qualified electrician Qualified electricians have the professional training, knowledge, and experience to work on electrical systems, to recognize and avoid potential dangers, and know the relevant standards and regulations.

Specialist personnel Specialist personnel have the specialized training, knowledge, and experience to perform the tasks entrusted to them, to recognize and avoid potential dangers, and know the relevant standards and regulations.

Instructed person Instructed persons have been instructed by the operator regarding the tasks entrusted to them and the potential dangers of inappropriate behavior.

Manufacturer's service personnel

The manufacturer's service personnel have the specialized training, knowledge, and experience to perform the work entrusted to them and to recognize and avoid potential dangers.

2.9 Personal protective equipment

Use of personal protective equipment

Personal protective equipment serves to protect staff in the event of a danger that may interfere with their health or safety at work.

2.10 Transport

Handling during transport

Incorrect handling during transport can make the product unsafe and risks the danger of serious injuries and considerable material damage.

- During transport and handling, secure the product to prevent it from falling.
- Use the transport thread on the clamping device.

2.11 Protection during handling and assembly

Incorrect handling and assembly

Incorrect handling and assembly can make the product unsafe and can risk the danger of serious injuries and considerable material damage.

- All work must only be performed by appropriately qualified personnel.
- Secure the system against accidental operation during all work.
- Use suitable assembly and transport equipment and take precautions to prevent jamming and crushing.

2.12 Protection during commissioning and operation

Falling or violently ejected components

Falling and ejected components can lead to serious injury or death.

- Take suitable protective measures to secure the danger zone.

2.13 Notes on safe operation

Incorrect manner of working by personnel

An incorrect manner of working can make the product unsafe and risks serious injuries and considerable material damage.

- Observe the safety notes and assembly instructions.
- Do not expose the product to any corrosive media. Products for special ambient conditions are excluded.
- Rectify malfunctions as soon as they occur.
- Observe the care and maintenance instructions.
- Observe the current safety, accident prevention, and environmental protection regulations for the application field of the product.

- The chuck may only be accelerated to speed or otherwise when a workpiece is correctly clamped. This means that the clamping force has been applied to the workpiece and the clamping has taken place within the permissible operating range.
- Unclamping may only occur once the machine spindle has come to a standstill.

Functionality check

After installation of the clamping device, its function must be checked prior to commissioning.

Two important points are:

- **Clamping force:** At max. actuation force/pressure/torque, the clamping force specified for the clamping device must be reached.
- **Stroke control:** The stroke of the clamping piston must have a margin of safety at the front and back end positions. The machine spindle must not start up until the clamping piston has passed through this safety margin.

With manual clamping devices, stroke control is carried out via the indicator pin. Clamping is only correct if the indicator pin is countersunk and clamping force is applied to the workpiece.

When determining the clamping force required to machine a workpiece, the centrifugal force acting on the chuck jaws must be taken into account (according to VDI 3106).

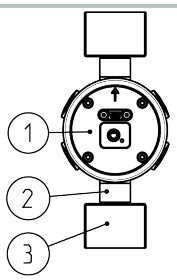
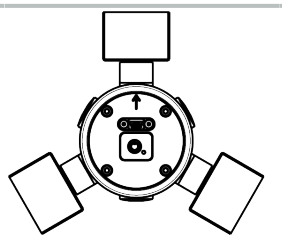
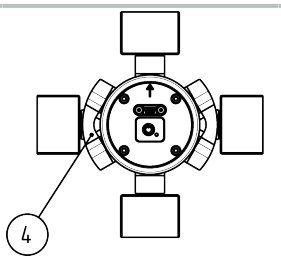
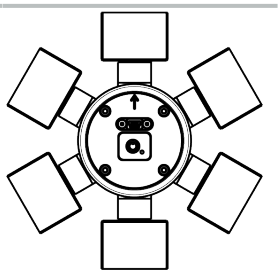
Maintenance instructions

The clamping device's reliability and safety can only be guaranteed if the operator complies with the manufacturer's maintenance instructions.

- For lubrication, we recommend our tried and tested special grease, LINOMAX plus. Unsuitable lubricants can have a negative impact on the functioning of the clamping device (clamping force, coefficient of friction, wear behavior). (For product information about LINOMAX plus, see the "Accessories" chapter of the SCHUNK lathe chuck catalog or contact SCHUNK.)
- Use a suitable high-pressure grease gun to ensure that you reach all the greasing areas.
- To ensure correct distribution of the grease, move the clamping device to its end positions several times, lubricate again, and then check the clamping force.
- Move the clamping device through to its end position several times after 500 clamping strokes, at the latest. This moves the lubricant back to the surfaces of the force transmission.
- Check the clamping device regularly for clamping force and jaw stroke.

Clamping force measurement

- Depending on the operating conditions, the function and clamping force must be checked after a certain period of operation . For this purpose, a calibrated clamping force meter (e.g. SCHUNK IFT) must be used. The loading conditions are shown below for the different chuck variants.

	2-jaw	3-jaw	4-jaw (compensating)	6-jaw (compensating)
				
Measuring device	SCHUNK IFT clamping force tester	SCHUNK IFT clamping force tester	SCHUNK IFT clamping force tester	SCHUNK IFT clamping force tester
Accessories	–	–	IFT MA4	–
Measuring points	0°/180°	0°/120°/240°	0° / 180° / 90° / 270° (IFT MA4)	0°/60°/120°/180°/ 240°/300°
Please note	Operating manual SCHUNK IFT Clamping force tester	Operating manual SCHUNK IFT Clamping force tester	Operating manual SCHUNK IFT Clamping force tester **Attention** Compensation must be activated, otherwise it may lead to inconsistent results.	Operating manual SCHUNK IFT Clamping force tester **Attention** Compensation must be activated, otherwise it may lead to inconsistent results.

① Measuring head
② Clamping insert
③ Chuck jaw
④ Bridge element (IFT MA4)

- If the clamping force has dropped too much or if the base jaws and piston no longer move properly, the chuck will have to be disassembled, cleaned and relubricated.
- The clamping force should always be measured with the clamping device in the same condition as it is used in for the current clamping application. If top jaws with clamping steps are used, measuring must be performed in the same step as for the respective clamping task. In the event of high operating speeds, clamping force losses must be accounted for due to the centrifugal force acting on the chuck jaws. In this case the value of the operating clamping force should be measured dynamically.
- We recommend checking the clamping force using a clamping force tester before starting a new production run and between maintenance intervals. "Optimum safety can only be guaranteed through regular checks".

2.14 Disposal

Handling of disposal

Incorrect handling of disposal can make the product unsafe and lead to risks of environmental harm.

- Follow local regulations on dispatching product components for recycling or proper disposal.

2.15 Fundamental dangers

General

- Disconnect power sources before installation, modification or calibration. Ensure that no residual energy remains in the system.
- Do not reach into the open mechanism or movement area of the product during operation.

2.16 Protection against dangerous movements

Unexpected movements

If the system still retains residual energy, serious injuries can be caused while working on the product.

- Switch off the energy supply, ensure that no residual energy remains and secure against inadvertent reactivation.
- Never rely merely on the response of the monitoring function to avert danger. Assume that the drive movement is faulty as long is the installed monitors are not effective, since the effect depends on the control and the current operating state of the drive.
- To avoid accidents and/or material damage, human access to the movement range of the machine must be restricted.

2.17 Notes on particular risks



⚠ DANGER

Risk of fatal injury to operating personnel due to the workpiece falling down or being flung out in the event of a power failure

This poses a risk of death or injury to the operating personnel and can result in serious damage to the machine.



⚠ DANGER

Possible risk of death for the operating personnel in case of insufficient clamping force due to ejection or falling of the workpiece!

Due to settling behavior, the clamping force may decrease over time.

- Re-clamping of the workpiece with manual or pneumatic clamping devices after 4 hours.
- The energy supply must be constantly applied to power-operated clamping devices during operation.
- Use clamping cylinders with energy conservation.



⚠ DANGER

Possible risk of death for operating personnel if the clamping device's top speed of rotation is exceeded and a workpiece is released or parts fly off.

If the machine tool or the technical equipment can reach a higher speed than the maximum speed of the clamping device, the speed must be limited for safety purposes!



⚠ DANGER

Possible risk of death for operating personnel if a jaw breaks or if the clamping device fails because the technical data has been exceeded and a workpiece is released or parts fly off!

- Never exceed the technical data specified by the manufacturer for using the clamping device.



⚠ DANGER

Possible risk of death for operating personnel from clothing or hair getting caught on the clamping device and being dragged into the machine!

Loose clothing or long hair may become caught on projecting parts of the clamping device and be drawn into the machine.

- Always wear tight-fitting clothing and a hairnet when working on the machine and the lathe chuck.



⚠ WARNING

Possible risk of death for the operating personnel due to impact of the rotating clamping device!

- Keep a safe distance to the rotating clamping device!
- Do not reach into the rotating clamping device!



⚠ CAUTION

Risk of limbs being crushed when opening and closing the chuck jaws during manual loading or unloading or when exchanging moving parts.

- Do not reach between the chuck jaws.



⚠ CAUTION

Hazard from vibration due to imbalanced rotating parts and noise generation.

Physical and mental strains due to imbalanced workpieces and noise during the machining process on the clamped and rotating workpiece.

- Ensure the clamping device's axial and concentric runout.
- Check options for remedying imbalances on special top jaws and workpieces.
- Reduce the speed.
- Wear hearing protection.



⚠ CAUTION

There is a risk of limbs being crushed by moving parts during manual loading and unloading and the clamping procedure.

- Do not reach between the chuck jaws.
- Use loading devices.



⚠ CAUTION

Allergic reactions or irritation due to skin or eye contact with lubricants on the product.

- In case of foreseeable contact with lubricants on the product (e.g. when lubricating or cleaning)
- Wear protective equipment (protective gloves, protective goggles)

NOTICE

Risk of damage due to incorrect choice of clamping position for chuck jaws on workpiece.

If an incorrect clamping position is chosen for the chuck jaws on the workpiece, the base and top jaws may become damaged.

- Observe maximum positions of base and top jaws.
- The diameter of the workpiece must not be greater than the clamping device diameter.
- For clamping devices with fine serration, do not allow the T-nuts for connecting the top jaws to protrude beyond the base jaws in radial direction.
- The outer diameter of the screwed-on top jaws must not exceed the outer diameter of the clamping device by more than 10%.

3 Technical data

3.1 Chuck data

	3-jaw chuck			
ROTA-S plus 2.0	**160-42**	**200-52**	**250-62**	**315-92**
Max. actuation torque [Nm]	80	120	210	220
Stroke per jaw [mm]	6.5	7.0	7.7	9.9
Max. speed of rotation [rpm]	5400	4800	4200	3400
Max. jaw clamping force [kN]	65	100	160	180
Mass moment of inertia [kgm²]	0.029	0.091	0.249	0.758
Chuck bore [mm]	42	52	62	92
Weight without jaws [kg]	7.94	16.1	28.8	54.2

	2-jaw chuck			
ROTA-S plus 2.0	**160-42**	**200-52**	**250-62**	**315-92**
Max. actuation torque [Nm]	55	80	140	150
Stroke per jaw [mm]	6.5	7	7.7	9.9
Max. speed of rotation [rpm]	5400	4800	4200	3400
Max. jaw clamping force [kN]	40	65	105	120
Mass moment of inertia [kgm²]	0.033	0.1	0.276	0.8196
Chuck bore [mm]	42	52	62	92
Weight without jaws [kg]	8.5	18.2	30.4	60.5

Centrifugal force of the base jaw M_{cGB} [kgm]	For the ROTA-S plus 2.0 chuck, it is necessary to specifically determine this data. Examples of calculation can be found in the "Special chuck jaws/technology" chapter in our current chuck jaw catalog.
Max. jaw eccentricity of center of gravity in axial direction a_{max} [mm]	

The maximum RPM stated is only valid with the maximum clamping force and when using the hard standard stepped jaws that go with the chuck.

For soft top jaws or special chuck jaws the permissible speed of rotation for a given initial clamping force or the required clamping force for a given speed of rotation must be calculated according to VDI 3106, whereby the maximum speed of rotation or the maximum clamping force of the lathe chuck must not be exceeded. The calculated values must be verified by means of a dynamic measurement. Functional monitoring must be performed according to the guidelines of the insurance association.

Max. oscillating circle – With type SFG base jaws

ROTA-S plus 2.0	160-42	200-52	250-62	315-92
Oscillating circle Ø	208.5	264	323	401.5

At the rated speed the chucks are balanced to Q 6.3

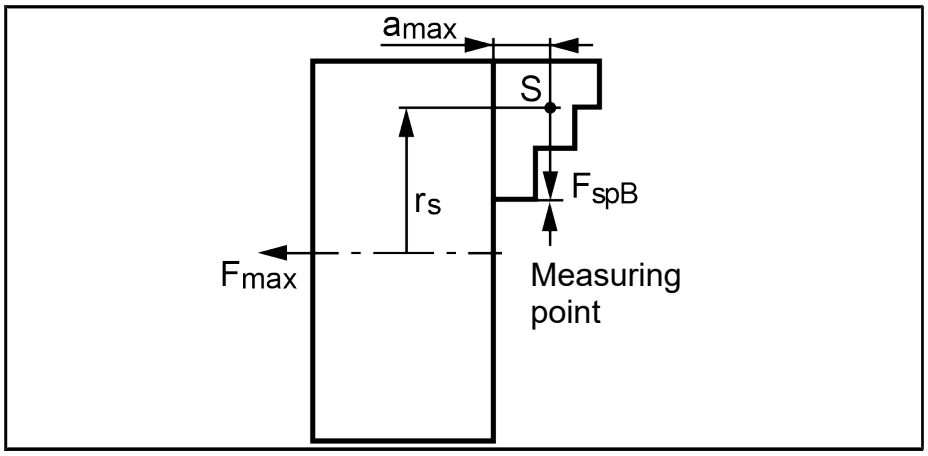
3.2 Clamping force / speed diagrams

Clamping force/RPM curves have been determined by using hard jaws. In the determination process, the maximum actuating force was applied and the jaws were set flush with the outer diameter of the chuck.

The chuck is in perfect condition and lubricated with SCHUNK LINOMAX plus special grease.

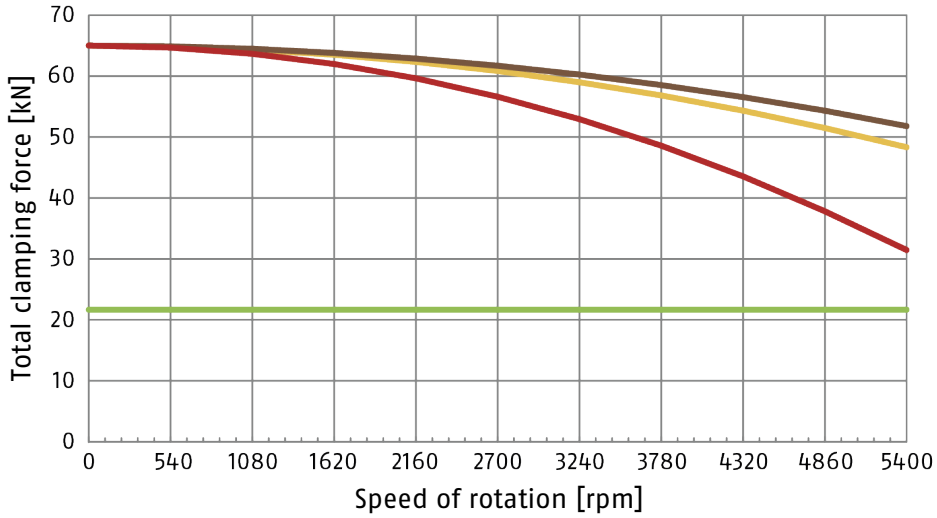
If one or more of these prerequisites is modified, the graphs will no longer be valid.

Chuck setup for clamping force/RPM graph



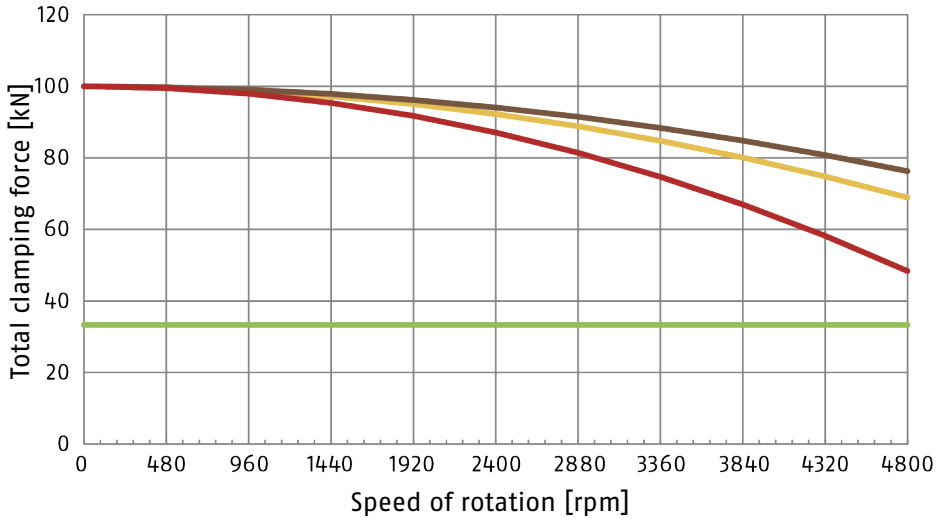
F_{spB}	Jaw clamping force	S	Center of gravity
F_s	Center of gravity radius	a_{max}	Max. jaw eccentricity of center of gravity in axial direction
F_{max}	Max. actuating force		

Clamping force RPM diagram ROTA-S plus 2.0 160 - 3-jaw chuck



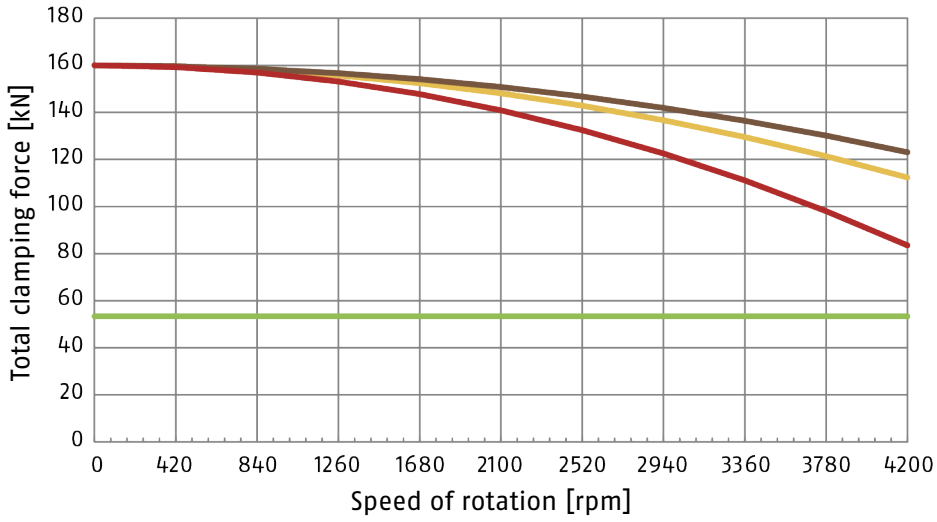
Color	Jaw ID	Weight [kg]
	STF 160	1.3
	SHF 160	0.6
	SFA 160	1.9
	minimum required clamping force 33%	

Clamping force RPM diagram, ROTA-S plus 2.0 200 – 3-jaw chuck



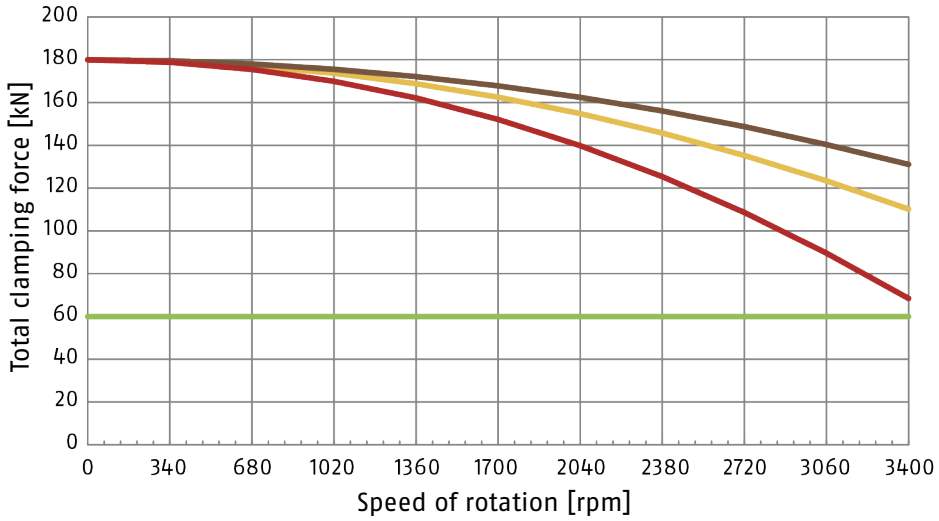
Color	Jaw ID	Weight [kg]
	STF 200	1.9
	SHF 200	2.0
	SFA 200	3.1
	minimum required clamping force 33%	

Clamping force RPM diagram ROTA-S plus 2.0 250 – 3-jaw chuck



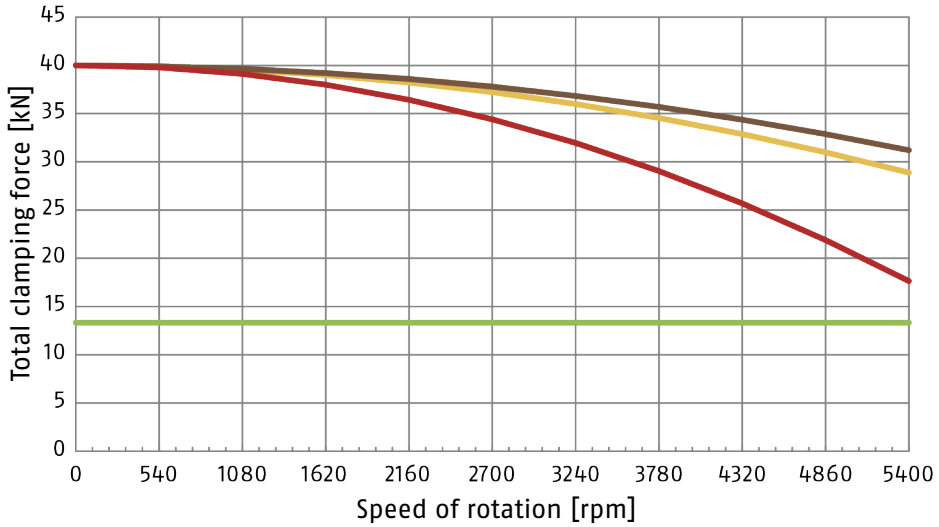
Color	Jaw ID	Weight [kg]
	STF 250	3.3
	SHF 250	4.0
	SFA 250	6.0
	minimum required clamping force 33%	

Clamping force RPM diagram, ROTA-S plus 2.0 315 – 3-jaw chuck



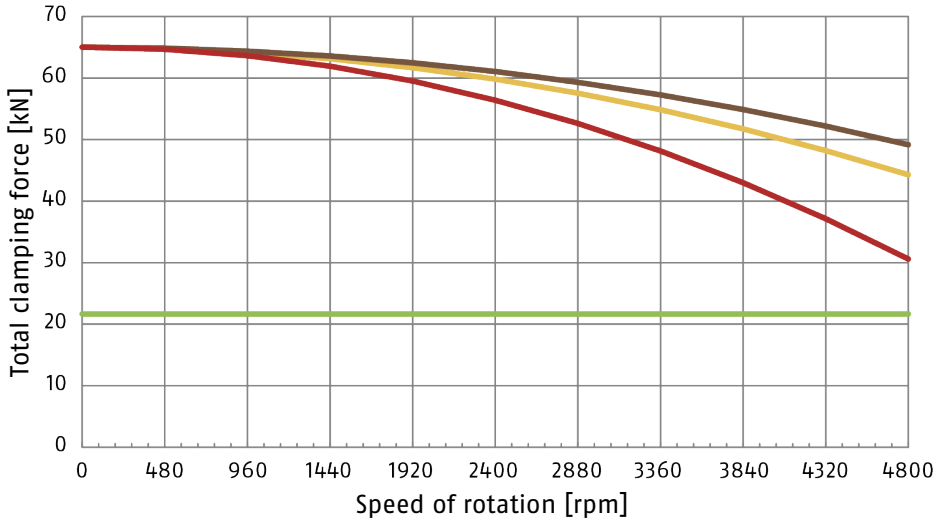
Color	Jaw ID	Weight [kg]
	STF 315	5.4
	SHF 315	6.6
	SFA 315	9.0
	minimum required clamping force 33%	

Clamping force RPM diagram ROTA-S plus 2.0 160 – 2-jaw chuck



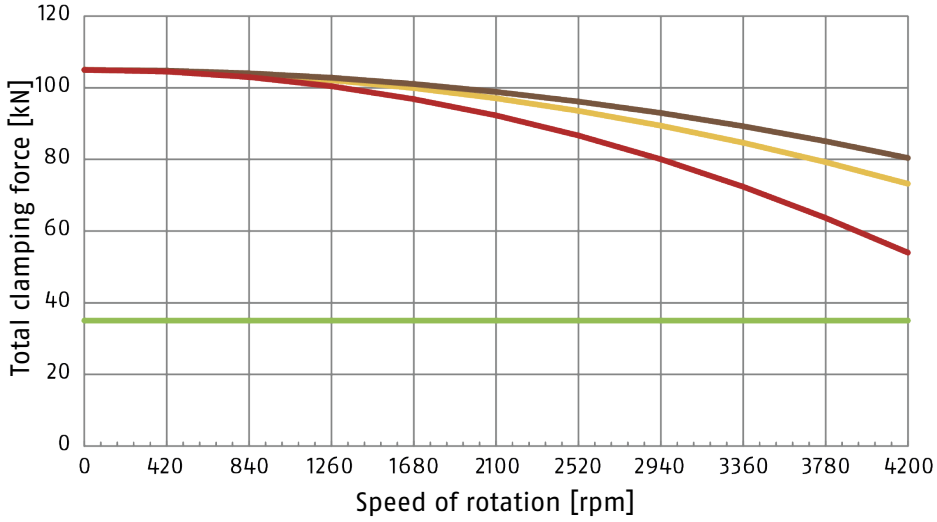
Color	Jaw ID	Weight [kg]
	STF 160	0.7
	SHF 160	0.9
	SFA 160	1.3
	minimum required clamping force 33%	

Clamping force RPM diagram, ROTA-S plus 2.0 200 – 2-jaw chuck



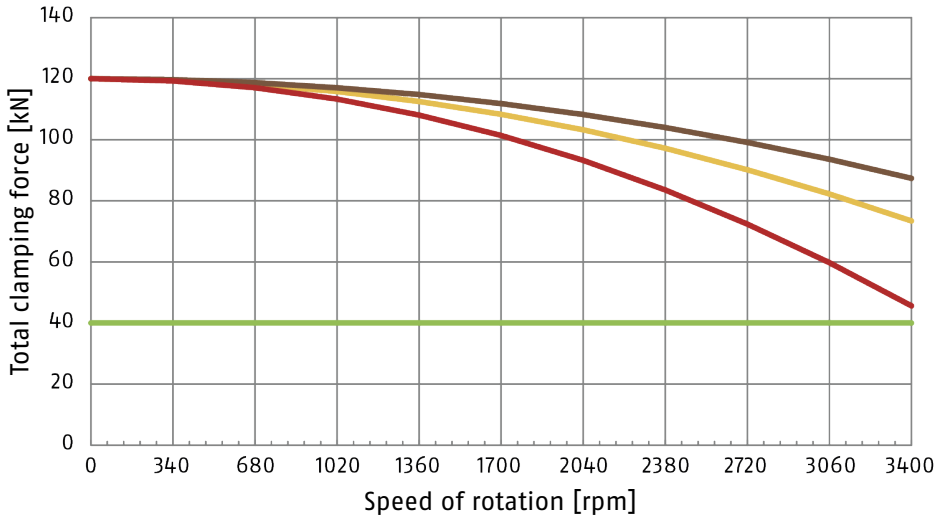
Color	Jaw ID	Weight [kg]
	STF 200	1.3
	SHF 200	1.4
	SFA 200	2.1
	minimum required clamping force 33%	

Clamping force RPM diagram ROTA-S plus 2.0 250 – 2-jaw chuck



Color	Jaw ID	Weight [kg]
	STF 250	2.2
	SHF 250	2.6
	SFA 250	4.0
	minimum required clamping force 33%	

Clamping force RPM diagram, ROTA-S plus 2.0 315 – 2-jaw chuck



Color	Jaw ID	Weight [kg]
	STF 315	3.6
	SHF 315	4.4
	SFA 315	6.0
	minimum required clamping force 33%	

3.3 Calculations for clamping force and speed

Missing information or specifications can be requested from the manufacturer.

Legend			
F_c	Total centrifugal force [N]	M_{cAB}	Centrifugal torque of top jaws [Kgm]
F_{sp}	Effective clamping force [N]	M_{cGB}	Centrifugal torque of base jaws [Kgm]
F_{spmin}	Minimum required clamping force [N]	n	Speed [rpm]
F_{sp0}	Initial clamping force [N]	r_s	Center of gravity radius [m]
F_{spz}	Cutting force [N]	r_{sAB}	Center of gravity radius of top jaw [m]
m_{AB}	Mass of one top jaw [kg]	s_{sp}	Safety factor for clamping force
m_B	Mass of chuck jaw set [kg]	s_z	Safety factor for machining
M_c	Centrifugal force torque [Kgm]	Σ_s	Max. clamping force of chuck [N]

3.3.1 Calculation of the required clamping force in case of a given rpm

The initial clamping force F_{sp0} is the total force impacting radially on the workpiece via the jaws due to actuation of the lathe chuck during shutdown. Under the influence of rotation, the jaw mass generates an additional centrifugal force. The centrifugal force reduces or increases the initial clamping force depending on whether gripping is from the outside inwards or from the inside outwards.
The sum of the initial clamping force F_{sp0} and the **total centrifugal force F_c** is **the effective clamping force F_{sp}**.

$$F_{sp} = F_{sp0} \mp F_c \text{ [N]}$$

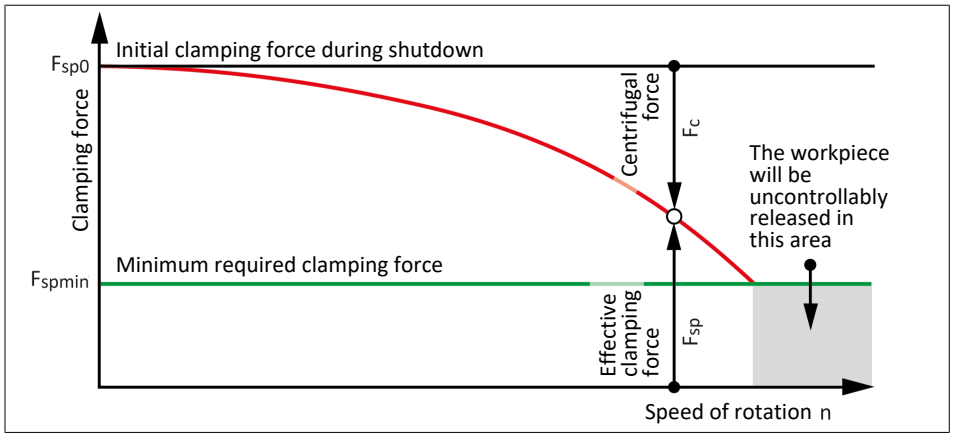
(–) for gripping from the outside inwards
(+) for gripping from the inside outwards



⚠ DANGER

Risk to life and limb of the operating personnel and significant property damage when the RPM limit is exceeded! With gripping from the outside inwards, and with increasing RPM, the effective clamping force is reduced by the magnitude of the increasing centrifugal force (the forces are opposed). When the RPM limit is exceeded, the clamping force drops below the required minimum clamping force F_{spmin}. Consequently, the workpiece is released spontaneously.

- Do not exceed the calculated RPM.
- Do not fall below the necessary minimum clamping force.



Reduction in effective clamping force by the magnitude of the total centrifugal force, for gripping from the outside inwards.

The required effective clamping force for machining F_{sp} is calculated from the product of the **machining force F_{spZ}** and the **safety factor S_z**. This factor takes into account uncertainties in the calculation of the machining force. According to VDI 3106: **$S_z \geq 1.5$.**

$$F_{sp} = F_{spz} \cdot S_z \text{ [N]}$$

From this we can derive the calculation of the initial clamping force during shutdown:

$$F_{sp0} = S_{sp} \cdot (F_{sp} \pm F_c) \text{ [N]}$$

(+) for gripping from the outside inwards
(–) for gripping from the inside outwards

NOTICE

This calculated force must not be larger than the maximum clamping force ΣS engraved on the lathe chuck.

See also "Lathe chuck data" table ▶ 3.1 [🗋 17]

From the above formula it is evident that the sum of the effective clamping force F_{sp} and the total centrifugal force F_c is multiplied by the **safety factor for the clamping force S_{sp}**. According to VDI 3106, the following also applies here: **$S_{sp} \geq 1.5$.**
The **total centrifugal force F_c** is dependent on both the sum of the masses of all jaws and on the center of gravity radius and the rpm.

NOTICE

For safety reasons, in accordance with DIN EN 1550, the centrifugal force may be a maximum of 67% of the initial clamping force.

The formula for the calculation of the total centrifugal force F_c is:

$$F_C = \sum(m_B \cdot r_S) \cdot \left(\frac{\pi \cdot n}{30}\right)^2 = \sum M_C \cdot \left(\frac{\pi \cdot n}{30}\right)^2 [N]$$

For this, **n is the given speed of rotation** in RPM. The product $\mathbf{m_B \cdot r_s}$ **is referred to as the centrifugal torque $\mathbf{M_c}$.**

$$M_C = m_B \cdot r_S [kgm]$$

In case of toolholders with split chuck jaws, i.e., with base jaws and top jaws, for which the base jaws change their radial position only by the stroke amount, the **centrifugal torque of the base jaws $\mathbf{M_{cGB}}$** and the **centrifugal torque of the top jaws $\mathbf{M_{cAB}}$** need to be added:

$$M_C = M_{cGB} + M_{cAB} [kgm]$$

The centrifugal torque of the base jaws M_{cGB} can be found in the table "Lathe chuck data"▸ 3.1 [🗋 17]. The centrifugal torque of the top jaws M_{cAB} is calculated as per:

$$M_{cAB} = m_{AB} \cdot r_{sAB} [kgm]$$

3.3.2 Calculation example: required initial clamping force for a given speed

Required initial clamping force F_{sp0} for a given RPM n

The following data is known for the machining job:

- Gripping from the outside in (application-specific)
- Machining force F_{spz} = 3000 N (application-specific)
- max. RPM n_{max} = 3200 RPM ("Lathe chuck data" table)
- RPM n = 1200 RPM (application-specific)
- Mass of one (!) top jaw m_{AB} = 5.33 kg (application-specific)
- Center of gravity radius of top jaw r_{sAB} = 0.107 m (application-specific)
- Safety factor S_z = 1.5 (according to VDI 3106)
- Safety factor S_{sp} = 1.5 (according to VDI 3106)

Note: Masses of the jaw mounting screws and T-nuts are not taken into account.

First the required effective clamping force F_{sp} is calculated using the machining force stated:

$F_{sp} = F_{spz} \cdot S_z = 3000 \cdot 1.5 \Rightarrow \mathbf{F_{sp} = 4500\ N}$

Initial clamping force during shutdown:

$F_{sp0} = S_{sp} \cdot (F_{sp} + F_c)$

Calculation of total centrifugal force:

$$F_c = \sum M_c \cdot \left(\frac{\pi \cdot n}{30}\right)^2$$

For two-part chuck jaws, the following applies:

$M_c = M_{cGB} + M_{cAB}$

Take the centrifugal torque of the base jaw and top jaw specified from the "Lathe chuck data" table:

$\mathbf{M_{cGB} = 0.319\ kgm}$

For the centrifugal torque of the top jaw, the following applies:

$M_{cAB} = m_{AB} \cdot r_{sAB} = 5.33 \cdot 0.107 \Rightarrow \mathbf{M_{cAB} = 0.57\ kgm}$

Centrifugal torque for one jaw:

$M_c = 0.319 + 0.571 \Rightarrow \mathbf{M_c = 0.89\ kgm}$

The chuck has 3 jaws, the total centrifugal torque is:

$\sum M_c = 3 \cdot M_c = 3 \cdot 0.889 \Rightarrow \mathbf{\sum M_c = 2.667\ kgm}$

The total centrifugal force can now be calculated:

$$F_c = \sum M_c \cdot \left(\frac{\pi \cdot n}{30}\right)^2 = 2.668 \cdot \left(\frac{\pi \cdot 1200}{30}\right)^2 \Rightarrow \mathbf{F_c = 42131\ N}$$

Initial clamping force during shutdown that was sought:

$F_{sp0} = S_{sp} \cdot (F_{sp} + F_c) = 1.5 \cdot (4500 + 42131) \Rightarrow \mathbf{F_{sp0} = 69947\ N}$

3.3.3 Calculation of the permissible speed in case of a given initial clamping force

Calculation of the permissible RPM n_{perm} in case of a given initial clamping force F_{sp0}

The following formula can be used to calculate the permissible RPM for a given initial clamping force during shutdown:

$$n_{zul} = \frac{30}{\pi} \cdot \sqrt{\frac{F_{sp0} - (F_{spz} \cdot S_z)}{\sum M_c}}\ [\text{min}^{-1}]$$

NOTICE

For safety reasons, the calculated permissible RPM may not exceed the maximum RPM inscribed on the lathe chuck!

Example of calculation: Permissible RPM for a given effective clamping force

The following data is known from previous calculations:

- Initial clamping force during shutdown F_{sp0} = 17723 N
- Machining force for machining job F_{spz} 3000 N (application-specific)
- Total centrifugal torque of all jaws ΣM_c = 2,668 kgm
- Safety factor S_z = 1.5 (according to VDI 3106)
- Safety factor S_{sp} = 1.5 (according to VDI 3106)

NOTE:

Masses of the jaw mounting screws and T-nuts are not taken into account.

Identifying the permissible RPM:

$$n_{zul} = \frac{30}{\pi} \cdot \sqrt{\frac{F_{sp0} - (F_{spz} \cdot S_z)}{\sum M_c}} = \frac{30}{\pi} \cdot \sqrt{\frac{69947 - (3000 \cdot 1.5)}{2.668}} \Rightarrow \mathbf{n_{zul} = 1495\ min^{-1}}$$

The calculated RPM n_{perm} = 1495 RPM is smaller than the maximum permissible RPM of the lathe chuck n_{max} = 3200 RPM (see "Lathe chuck data" table ▸ 3.1 [🗋 17]).

This calculated RPM may be used.

3.4 Grades of Accuracy

Tolerances for radial and axial run-out accuracy correspond to the Technical Supply Terms for lathe chucks as per DIN ISO 3442-3.

3.5 Permissible imbalance DIN ISO 21940-11

The ROTA-S plus 2.0 in ungreased state without chuck jaws corresponds to the balancing quality class 6.3 (according to DIN ISO 21940-11). Residual imbalance risks may arise due to insufficient rotation compensation being achieved (see DIN EN 1550 6.2 e). This applies particularly to high speeds, asymmetrical workpieces or the use of various chuck jaws, as well as uneven application of lubricants. In order to prevent damage resulting from these residual risks, the entire rotor is to be dynamically balanced in accordance with DIN ISO 21940-11.

4 Mounting

4.1 Torque per screw

Tightening torques for mounting screws for clamping the chuck (screw quality 10.9)

Screw size	M6	M8	M10	M12	M14	M16	M18	M20	M22	M24	M27	M30
Admissible torque M_A (Nm)	13	28	50	88	120	160	200	290	400	500	1050	1500

Tightening torques to mount top jaws onto the chuck (screw quality 12.9)

Screws for base jaws SFG/SFGK/SFK-V/SFGL/SFGX	M6	M8 x 1	M10	M12 x 1.5	M16 x 1.5	M20	M24
Admissible torque M_A (Nm)	16	32	60	120	150	180	230

4.2 Mounting in general

4.2.1 Pre-assembly measures

Carefully lift the product (e.g. using suitable lifting gear) from the packaging.



⚠ WARNING

Risk of injury due to unexpected movements!

If the power supply is switched on or residual energy remains in the system, components can move unexpectedly and cause serious injuries.

- Before starting any work on the product: Switch off the power supply and secure against restarting.
- Make sure, that no residual energy remains in the system.



⚠ CAUTION

Danger of injury due to sharp edges and rough or slippery surfaces

- Wear personal protective equipment, particularly protective gloves.

Check the delivery for completeness and for transport damage.

In order to achieve high run-out accuracy of the chuck, the machine side must be aligned before mounting the chuck. To do this, check the mounting surfaces for radial and axial run-out using a dial indicator.

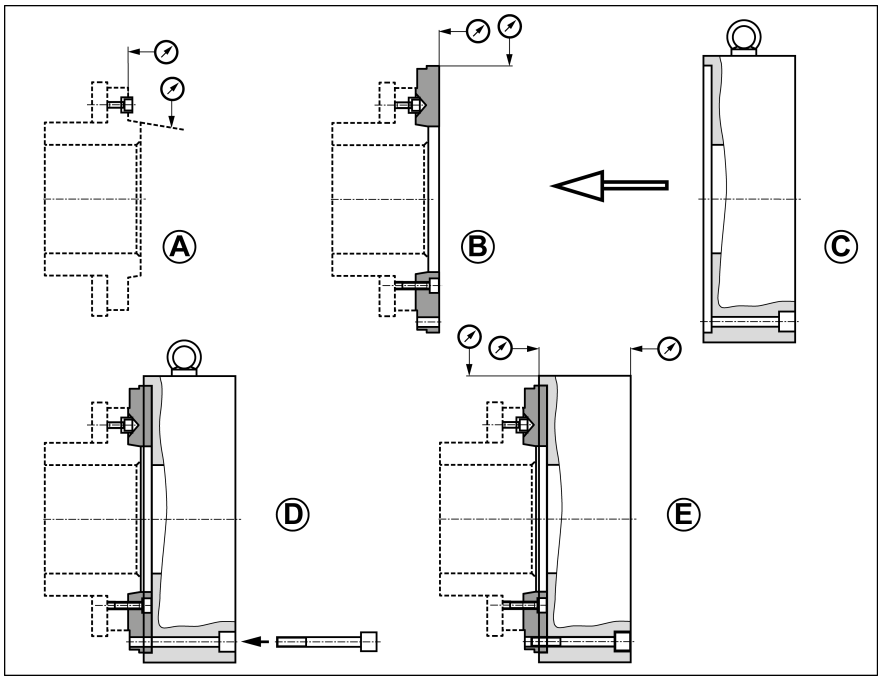
A maximum concentricity error of 0.01 mm should be ensured for the centring of the mount and a maximum axial run-out error of 0.01 mm for the contact surfaces. In addition, the flat surface must be checked for evenness using a straight edge (flat surface deburred and clean at the bore holes).

Radial and axial run-out tolerances of the chuck:

Chuck size [mm]	Max. Radial run-out tolerance [mm]	Max. Axial run-out tolerance [mm]
≤ 315	0.02	0.02
≤ 400	0.03	0.03
≤ 800	0.04	0.04
≤ 1200	0.05	0.05
≤ 1600	0.06	0.06

4.2.2 Chuck assembly options

If the interface of the machine spindle and chuck is identical, assembly is carried out without assembly preparation. If the interface of the machine spindle deviates from the interface of the chuck, a connecting flange must be installed before assembly.



Chuck assembly

- Direct assembly of the chuck to the machine spindle
- Assembly of the chuck with connecting flange
  - Direkt flange (insert ring)
  - Reduction flange
  - Expansion flange

NOTICE

When mounting with the connecting flange, never allow the outer rim of the chuck body to make contact. The flange must support on the entire surface.

NOTICE

Use a crane to install the chuck. Fasten the chuck to the eye bolt provided for this purpose (see Fig. "Chuck assembly" – C) The eye bolt must be removed prior to commissioning.

4.3 Mounting of the chuck

The item numbers specified for the corresponding individual components relate to the chapter Drawings, ▶ 9 [🗋 40].

4.3.1 Handling prior to attachment

Before mounting on the lathe, remove the base jaws from the chuck, then re-install the base jaws and turn the spindle several times as far as it will go to the right and left.

- Use the spanner wrench to turn the spindle (item 8) as far as possible to the left.
- Press the thrust bolt (item 14) under the first jaw (item 4). The base jaw is now free to move.
- Remove the base jaw and push it into the chuck again while pressing the thrust bolt (item 14) until the front side of the jaw is at the outer marking line.
- The first tooth of the base jaw holds the locking slide (item 13) in the lower position and the actuating lock for the respective jaw is released.
- Proceed in this way for all 3 base jaws.

The numbered jaws have to be pushed into the correspondingly numbered guidance (jaw 1 into guidance 1 etc.).

Finally turn the spindel several times to the right and to the left until it bottoms out.

4.3.2 Mounting of the Manual Chuck

- Before putting on the chuck on the spindle nose, carefully clean the centering and contact surfaces of both parts and rub in some oil.
- While the chuck is lightly pressed on, there should be noticeable play in the taper and at most 0.02 mm play between the flat surfaces (feeler gauge).
- Insert and **slightly tighten** the mounting screws depending on the type of fastening.
- Check the chuck for radial and axial run-out and, if necessary, align it at the outer diameter with gentle taps using a plastic hammer (See Fig. "Chuck assembly" - E and table for the attainable maximum radial and axial run-out tolerances).
- Then tighten the fastening screws with a torque wrench. Observe the specified maximum admissible torques ▶ 4.1 [🗋 27].
- Check radial and axial run-out again.

NOTICE

Danger of damage of the thrust bolt (item 14) when setting down the chuck on the thrust bolt (for example, for cleaning or maintenance).

Never put the chuck onto the thrust bolt (item 14)!

5 Function

The item numbers specified for the corresponding individual components relate to the chapter Drawings, ▸ 9 [🗋 40].

5.1 Handling and jaw change

NOTE:
For rotating lathe chucks, the centrifugal forces applied can cause the indicator pin to emerge from the chuck body. When the lathe chuck comes to a stop, the indicator pin must be reinserted.

- Use the spanner wrench to turn the spindle (item 8) as far as possible to the left. The indicator pin (item 17) protrudes from the chuck body by about 4 to 5 turns before the stop (gold-colored pin).



⚠ WARNING

If the indicator pin protrudes, the entire serration of the wedge bars (items 5 and 6) no longer engages into the base jaws. The base jaws are not sufficiently engaged by the wedge bars.

Risk of injury from jaws and workpiece being flung out.

- If the indicator pin protrudes, do not clamp the chuck and do not start up.

- Once the spindle (item 8) has reached the stop, press the pressure bolt (item 14) under the base jaw. The corresponding jaw is released and can now be adjusted or exchanged.

NOTICE

If the pressure bolt (item 14) is stuck or does not move easily, it must be removed and cleaned (see chapter "Disassembling and assembling the chuck") ▸ 6.5 [🗋 35]). Do not use force (for example, hammer blows etc.) to loosen the pressure bolt, since this could damage the slide (item 13), which in turn could impair the safety mechanism.

Oil the cleaned pressure bolt; do not grease with chuck grease!

- Adjust exchanged jaws until the desired clamping diameter has been reached. The slides (item 12) must snap in when doing this.

NOTICE

Actuating the chuck if a jaw is not engaged will damage the chuck!

Manually move the jaw back and forth without actuating the pressure bolt. This ensures that the jaw is engaged. The pressure bolt has to be in the initial position.

For all the wedge bar teeth (items 5 and 6) to be supportive, the base jaws in the guides must always be inserted at least up to the marking line on the chuck body (item 1) (see Fig. "Jaw change"). All jaws have to be at the same marking line. An additional actuating lock prevents the spindle from being turned to the right without chuck jaws.

NOTICE

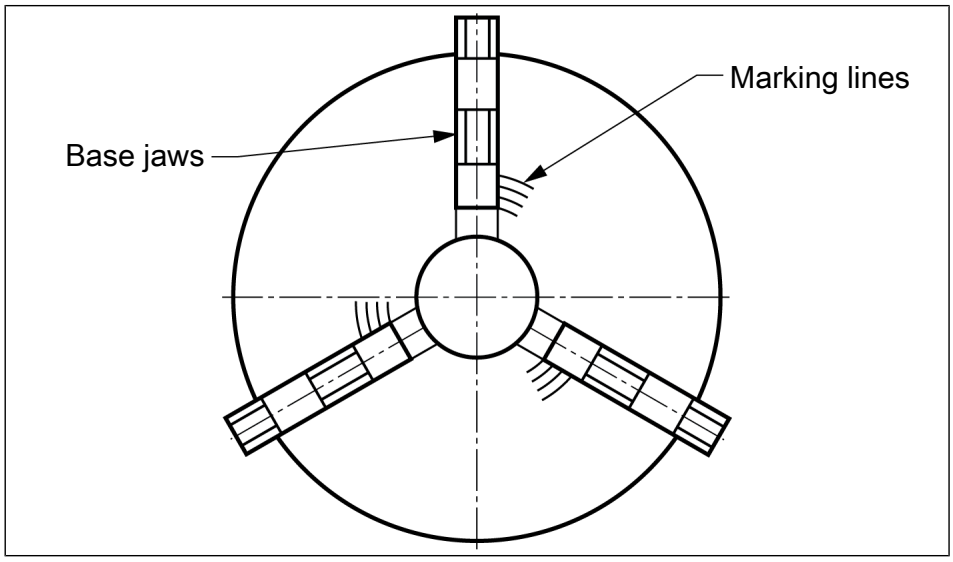
If force is used to continue turning, the chuck will be damaged and the jaw lock function will no longer be active.

Do not forcefully turn the spindle further!

Only after all the clamping jaws have been inserted into the guide will the actuating lock be unlocked. Then the wedge bars can be shifted into working position. (Turn spindle to the right!)

In the event of noticeable resistance (jaw not engaged), do not turn further forcefully. Slightly move the base jaw until it engages.

The base jaws fit into the chuck in both directions. They can be turned around.



Jaw change

If you turn the spindle to the right, the indicator pin (item 17) will protrude from the chuck body (item 1) (gold-colored pin) shortly before the stop.



⚠ WARNING

If the indicator pin protrudes, the entire serration of the wedge bars (items 5 and 6) no longer engages into the base jaws. The base jaws are not sufficiently engaged by the wedge bars.

Risk of injury from jaws and workpiece being flung out.

- If the indicator pin protrudes, do not clamp the chuck and do not start up.

5.2 Important notes

When working with a very short opening stroke or large series, lubrication grease may be pressed out between the loaded surfaces of the chuck gear. In this case efficiency will decrease!
Following a number of clampings, activate the chuck several times without a workpiece inserted at full stroke so that the grease can be distributed evenly again on the sliding areas on the inside of the chuck. The chuck will then attain its full clamping force again.

- Never remove the base jaws without actuating the thrust bolt (item 14).
- Tighten the chuck regularly during processing to compensate the loss of clamping force due to vibration.
- Following a longer period of shutdown (more than 8 hours), always re-tension the clamped toolholder in order to compensate for the spindle settling and the resulting loss of clamping force.
- When gripping the spanner wrench, do not tighten with an extension pipe or using hammer blows. Only grip using the flangemounted chuck!
- Do not flange-mount the chuck against the edge of the chuck body!
- Never clamp the base jaws outside the marked lines ▸ 5.1 [🗋 30]!
- Do not use force (e.g. hammer blows) to move jaws that are difficult to move. Clean the guides and jaws.
- Subsequently delivered hard top jaws (type SHF) or unsplit, hard jaws (type STF) must be ground in the chuck for run-out accuracy.
- For precise clamping, do not remove the ground top jaws from the base jaws. This will result in loss of true-running accuracy. Use a different set of jaws when changing the jaws.
- When re-equipping from cylindrical mounting to short-taper flange, the lid (item 2) must be removed if the centering lid is used.

5.3 Control of the chuck

The Manual Chuck ROTA-S plus can be only inspected in flanged position. The round and planar surfaces in the rear area of the chuck body area must run true.
The jaws must be just as easy-to-move after attachment as beforehand▸ 6.5 [🗋 35].

If the jaws are more difficult to move than before attachment, the chuck body has been incorrectly attached. The chuck may have become twisted.

5.4 Control of true-running

(on delivery of ROTA-S plus 2.0 with STF/SHF hard jaws ground on the chuck)

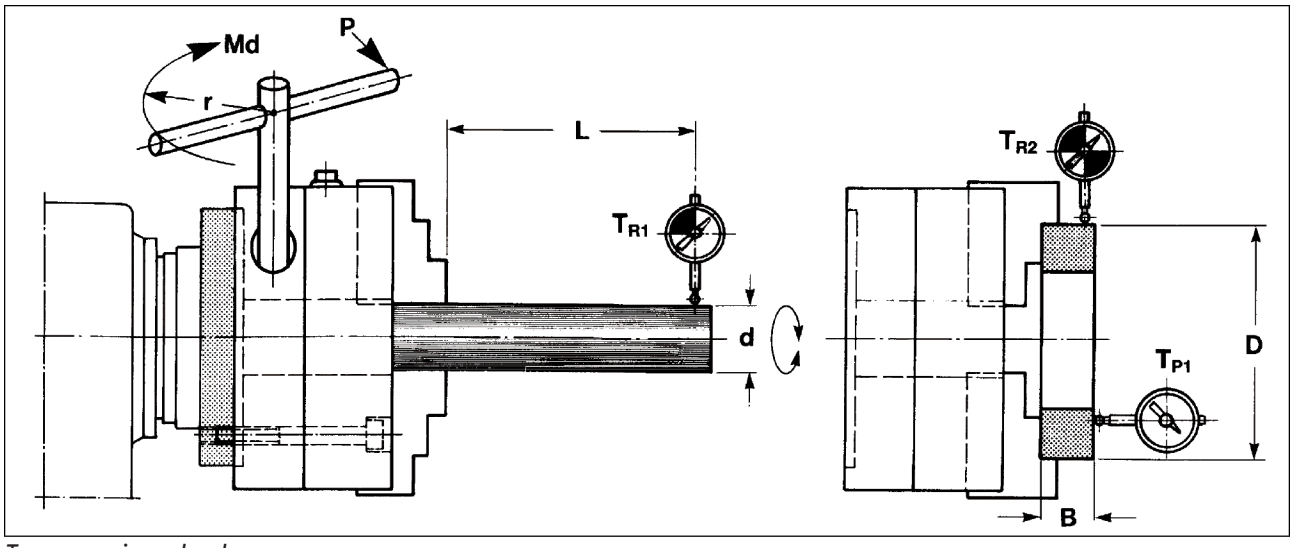
To check the radial and axial run-out accuracy, hardened and ground test pins or test disks are clamped (see Fig. "True running check"). The torques (Md) at the key when gripping the test pins and test disks as well as the position on the measuring point to the jaws are provided in the table below.

If the permissible radial and axial run-out error (see table) is exceeded, check the following points:

- applied wrench torque (Md)
- correct mounting of the chuck
- Test pins and test disks deviate from the factory specification

Table of the maximum permissible radial and axial run-out error for the ROTA-S plus 2.0 chuck with STF or SHF jaws

Chuck Size	160-42	200-52	250-62	315-92
Jaw type	STF-160	STF-200	STF-250	STF-315
	SHF-160	SHF-200	SHF-250	SHF-315
Md [Nm]	40	70	80	90
L [mm]	60	80	80	120
d (STF) [mm]	Ø 34	Ø 41	Ø 50	Ø 63
d (SHF) [mm]	Ø 34	Ø 41	Ø 41	Ø 55
T_{R1} max [mm]	0.03	0.03	0.03	0.04
D (STF) [mm]	Ø 140	Ø 160	Ø 210	Ø 243
D (SHF) [mm]	Ø 140	Ø 140	Ø 210	Ø 243
W [mm]	20	25	25	35
T_{P1} max [mm]	0.02	0.02	0.02	0.03



True running check

6 Maintenance

6.1 Lubrication



⚠ WARNING

Risk of injury through contact with lubricants!

Skin or eye contact with lubricants can cause irritation and allergic reactions.

- Avoid skin or eye contact with lubricants.
- Wear safety goggles and protective gloves.

To maintain the safe functioning and high quality of the chuck, it must be lubricated regularly at all lubrication points. For optimum grease distribution, the chuck must be lubricated in the lubricating position (▸ 6.2 [🗋 34]).

Depending on the operating conditions, the function and clamping force must be checked after a certain period of operation (▸ 6.3 [🗋 35]). Only perform the clamping force test with a calibrated clamping force tester (SCHUNK IFT). If the chuck is used over several clamping cycles in the short stroke range (< 50% clamping stroke), it is recommended to perform a empty stroke regularly to maintain the clamping force at a consistently high level.

Lubricate the chuck evenly in order to avoid large imbalances.

6.2 Lubricating position

The following procedure should be followed to ensure optimum distribution of the lubricant:

- Open the chuck and move it to the outer end position.
- Lubricate the chuck at the two lubrication nipples (item 37) on the circumference of the chuck body (item 1) using a manual press. Use SCHUNK LINOMAX plus special grease as lubricant.
- The functional surfaces of the wedge bars (items 5 and 6) and the drive ring (item 7) are reached via the lubrication nipple opposite jaw 1. The second greasing area supplies grease to the spindle bearings and the spindle thread.
- Perform several empty strokes over the entire travel range of the chuck.

6.3 Maintenance and lubrication plan



⚠ WARNING

Risk of injury from flying parts ifthe jaw mounting screws break!

If the maximum allowable number of clamping cycles is exceeded, the jaw mounting screws may break.

- The jaw mounting screws must be replaced after no more than 15,000 clamping cycles.
- The jaw mounting screws must be inspected for damage at specified maintenance intervals and replaced if necessary.

The specified intervals are guide values and must be adjusted by the operator depending on the ambient and operating conditions and the frequency of use of the clamping device used. To determine a suitable lubrication interval for the respective application, regular clamping force tests must be carried out. If only 80% of the maximum clamping force is reached, the clamping device must be lubricated. In accordance with VDI 3106, it must be ensured that sufficient clamping force is available for the application.

Maintenance task	Interval
Lubricate	Every 120 operating hours
Check clamping force	To be determined by the operator
Replacing the jaw mounting screws	After 15,000 clamping cycles
Complete cleaning / disassembly	Annually / after 2500 operating hours

6.4 Jaw change

Clean and lubricate jaws if there is no film of grease.

6.5 Disassembling and assembling the chuck

Disassembly

When replacing spare parts or cleaning, the chuck will have to be disassembled.

- First remove the manual chuck from the lathe.

Note for the corresponding mountings:

- For the direct mounting in acc. with DIN ISO 702-1:
  Evenly loosen the mounting screws (item 35) and remove the chuck from the spindle.
- For the direct mounting in acc. with DIN ISO 702-3 (bayonet):
  Loosen flanged nut, twist the bayonet disk and take the chuck out of the spindle.

- For the direct mounting in acc. with DIN ISO 702-2 (Camlock): Unlock the Camlock bolts and take the chuck out of the spindle.



⚠ WARNING

Risk of injury due to dropping the manual chuck during transport, installation or removal

During transport and when installing or detaching the manual chuck, ensure it does not fall off.

- Remove the jaws from the guideways (see chapter "Handling and jaw changes" ▸ 5.1 [🗋 30])
- Place the chuck on its front, undo the screws (item 34) and remove the cover (item 2).
- When taking out the drive ring (item 3), pay attention to the indicator pin (item 17) which has been pre-loaded by the spring (item 38).
- Take the spring and the indicator pin out of the bore hole in the chuck body (item 1).
- Pull off the sliding blocks (item 7) from the wedge bars (items 5 and 6) and carefully remove the 0 rings (item 39).
- Remove the cylindrical pin (item 30).
- Insert the assembly key (item 99) using the spindle's hexagonal head (item 8) and unscrew the spindle screw (item 8) with the actuation key. The spindle (item 8) can now be completely screwed out of the wedge bar (item 5) with the actuation key.
- The pressure bolts (item 14) are pre-loaded by the springs (item 31). After the cylindrical pins (item 45) are driven out of the chuck body with a suitable sliding hammer, the springs (item 31) and the pressure bolts (item 14) can be removed.
- Carefully remove the wedge bars (items 5 and 6) from the chuck body (item 1) and take off the locking slide (item 13) with the spring (item 32), the traverse slide (item 15) and the slide (item 12).
- Unscrew the screws (item 36) and remove the wipers (item 11).
- Take the seat of bearing (item 10) out of the chuck body.

The chuck is now completely disassembled.

Clean all parts carefully with degreasing agent and check for wear and damage.

Replace damaged parts with original SCHUNK spare parts only!

Before installation, lubricate all individual components with LINOMAX plus grease.

Assembly

The chuck is assembled in the reverse order. Observe the following when doing this:

- **Do not forget any parts! Even small components are essential for the safety of the lathe.**

- **When assembling the spindle (item 8), be sure not to tighten the spindle nut (item 9).**
  Turn the spindle nut (item 9) on the block and then turn it back until a surface on the spindle nut (item 9) can be seen through the hole of the cylindrical pin (item 30) in the chuck body (item 1). Insert the cylindrical pin (item 30) in this orientation.
- When inserting the drive ring (item 3), the position of the control area for the indicator pin (item 17) must be noted. If the drive ring (item 3) is incorrectly mounted, then the indicator pin (item 17) is not pulled in during the actuation of the chuck.

7 Storage

When storing the product for a longer period of time, observe the following points:

- Clean the product and lubricate it lightly.
- Store the product in a suitable transport container.
- Only store the product in dry rooms.
- Protect the product from major temperature fluctuations.

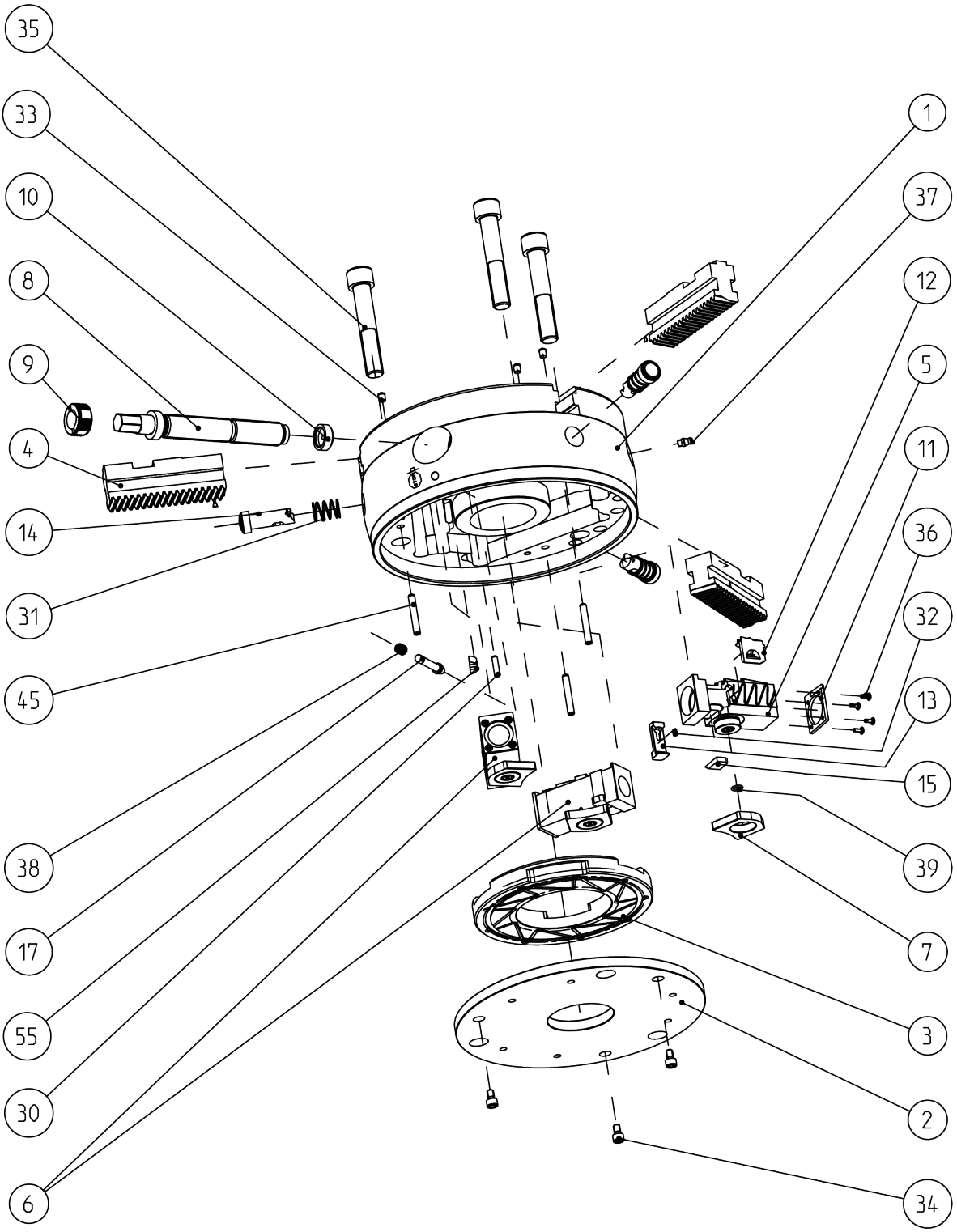
NOTE: Before recommissioning, clean the product and all attachments, check for damage, functionality and leaks.

8 Part list

When ordering spare parts, it is essential to specify the type, size and, above all, the serial number of the chuck. **Seals, sealing elements, screw connections, springs, bearings, screws and wiper strips as well as parts that come into contact with the workpiece are not covered by the warranty.**

		Quantity	
Item	Designation	3-jaw	2-jaw
1	Chuck body	1	1
2	Cover	1	1
3	Drive ring	1	1
4	Base jaw	3	2
5	Wedge bar with thread	1	1
6	Wedge bar	2	1
7	Sliding block	3	2
8	Spindle	1	1
9	Spindle nut	1	1
10	Seat of bearing	1	1
11	Wiper (starting for size 200)	3	2
12	Slide	3	2
13	Locking slide	3	2
14	Pressure bolt	3	2
15	Traverse slide	3	2
17	Indicator pin	1	1
30	Cylindrical pin	1	1
31	Compression spring for thrust bolt	3	2
32	Compression spring for locking slide	3	2
33	Spring-loaded pressure piece	3	2
34	Cylindrical screw	3	4
35	Cylindrical screw	3	4
36	Flat lens head screw (starting from size 200)	12	8
37	Lubrication nipples	2	2
38	Compression spring for indicator pin	1	1
39	O-ring	3	2
45	Cylindrical pin	3	2
50	Eye bolt (starting from size 250)	1	1
55	Insert	3	2
99	Assembly key	1	1

9 Assembly drawing



10 Manufacturer certificate

Manufacturer / Distributor:	H.-D. SCHUNK GmbH & Co. Spanntechnik KG Lothringer Str. 23 D-88512 Mengen
Product:	Lathe chuck
Designation:	ROTA
Type designation:	M-flex 2+2, S-flex, SPK, ROTA-G, ROTA-S, Vario-M

Heinz-Dieter SCHUNK GmbH & Co. Spanntechnik KG certifies that the above-mentioned products, when used as intended and in compliance with the operating manual and the warnings on the product, are safe according to the national regulations and:

- a **risk assessment** has been carried out in accordance with ISO 12100:2010.
- an **operating manual** for the assembly instructions has been created in accordance with the contents of the Machinery Directive 2006/42/EC Annex I No. 1.7.4.2. and the contents of the provisions of Annex VI of the Machinery Directive 2006/42/EC.
- the relevant basic and proven safety principles of the Annexes of **ISO 13849-2:2012**, taking into account the requirements of the documentation have been observed for the component. The parameters, limitations, ambient conditions, characteristic values, etc. for proper operation are defined in the operating manual.
- an $MTTF_D$ value of 150 years can be estimated for mechanical components using the informative procedure in Table C.1 of ISO 13849-1:2015.
- the **fault exclusion** against the fault "Breakage during operation" in compliance with the parameters, limitations, ambient conditions, characteristic values and maintenance intervals, etc., specified in the operating manual.

Harmonized Standards applied:

- **ISO 12100:2010** Safety of machinery - General principles for design - Risk assessment and risk reduction
- **EN 1550:1997+A1:2008** Machine-tools safety – Safety requirements for the design and construction of lathe chucks for the workpiece mount

Other related technical Standards and specifications:

- **ISO 702-1:2010-04** Machine tools – Connecting dimensions of spindle noses and lathe chucks – Part 1: front short-taper mount with screws
- **ISO 702-2:2010-04** Machine tools – Connecting dimensions of spindle noses and lathe chucks – Part 2: front short-taper mount with camlock mounting
- **ISO 702-3:2010-04** Machine tools – Connecting dimensions of spindle noses and lathe chucks – Part 3: front short-taper mount with bayonet mounting
- **ISO 702-4:2010-04** Machine tools – Connecting dimensions of spindle noses and lathe chucks – Part 4: cylindrical mount
- **VDI 3106:2004-04** Determination of permissible RPM of lathe chucks (jaw chucks)

Mengen, 25th of April 2023

i. V. Philipp Schräder

p.p. Philipp Schräder
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i.V. Alexander Koch

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