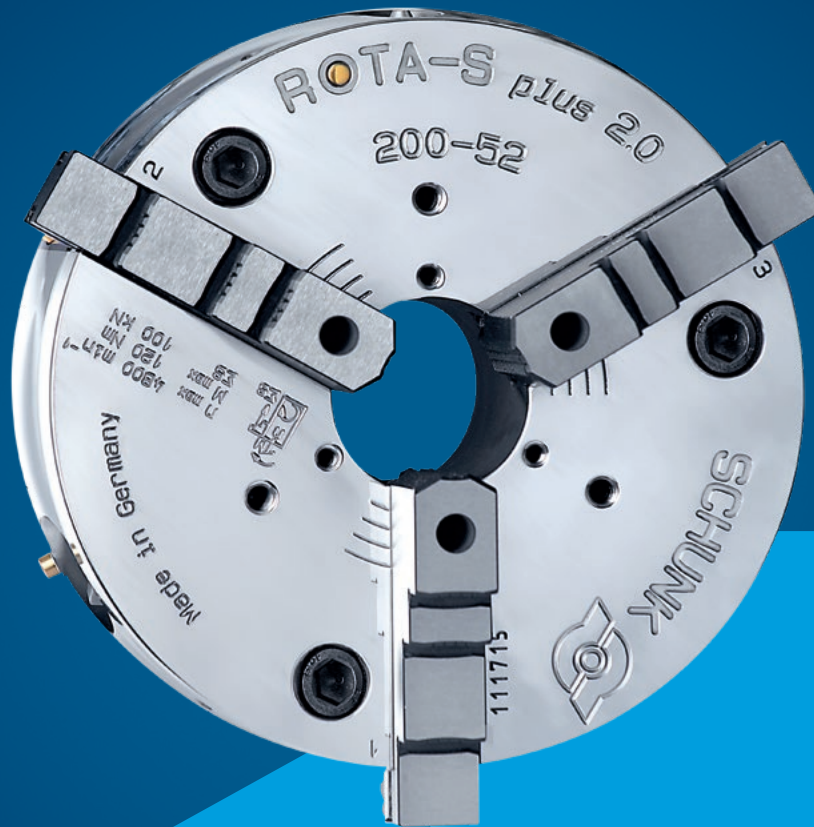




## **ROTA-S** *plus* 2.0

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

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

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



## Advantages – Your benefits

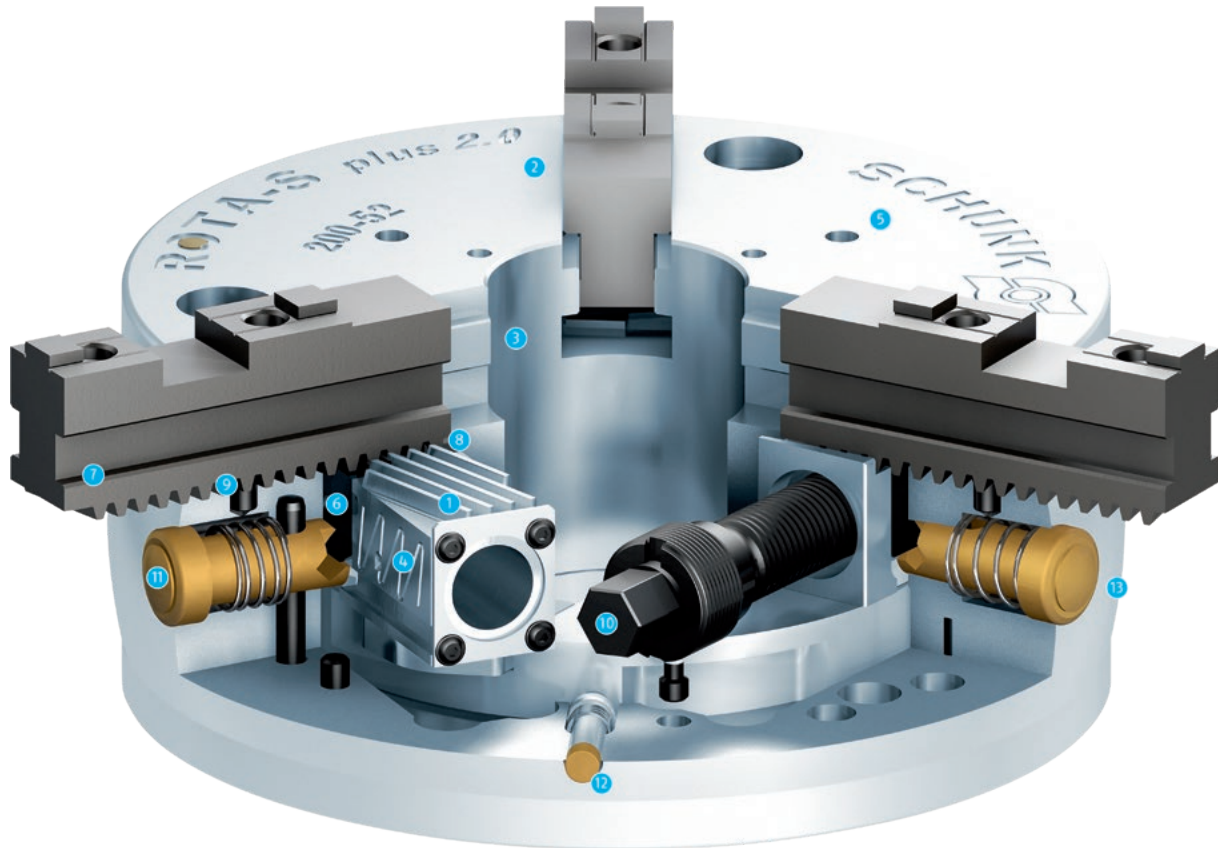
- + Convenient jaw quick-change system**  
Minimizing set-up times and costs
- + Large through-hole**  
Machining all standard pipe diameters
- + High efficiency of the wedge bar system**  
Process-reliable clamping due to high clamping forces
- + High jaw quick-change repeat accuracy**  
No reboring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

## Technical data

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

## Function ROTA-S plus 2.0

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



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

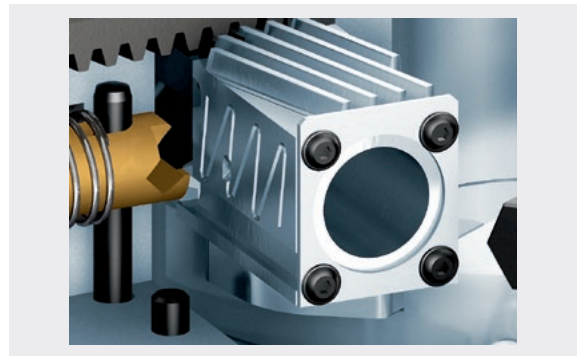
### Spindel with hexagon connection

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



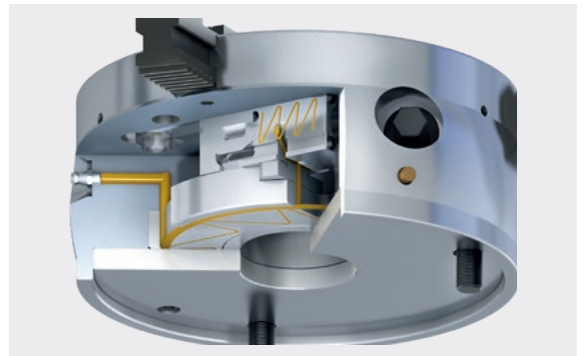
### Wedge bar system with wiper

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



### Central lubrication system

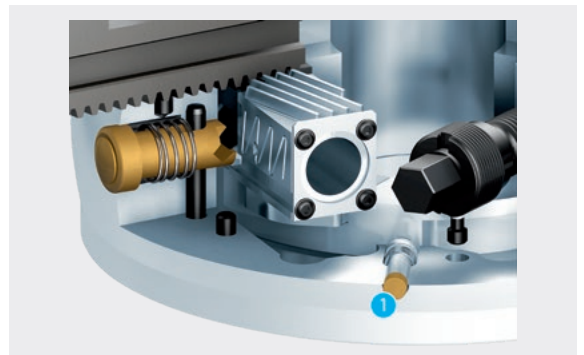
Two lubrication nipples positioned on the chuck body facilitate lubrication of all functional surfaces. The special shape of the grease grooves ensures constant lubrication of the friction surfaces. This improves the clamping behavior during operation.



### Maximum operating safety

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

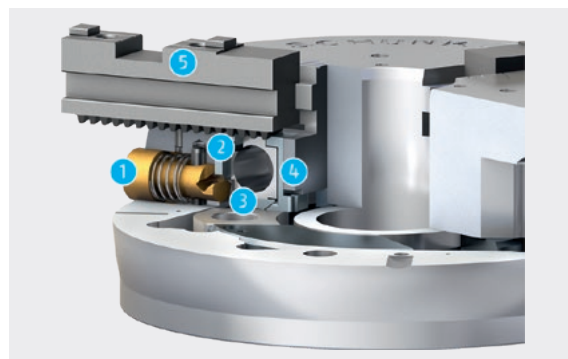
#### 1 Indicator pin



## Correct jaw change

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

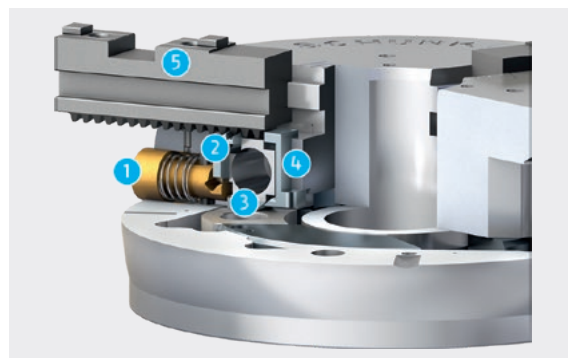
- ① Push button
- ② Slide
- ③ Traverse slide
- ④ Locking slide
- ⑤ Base jaw



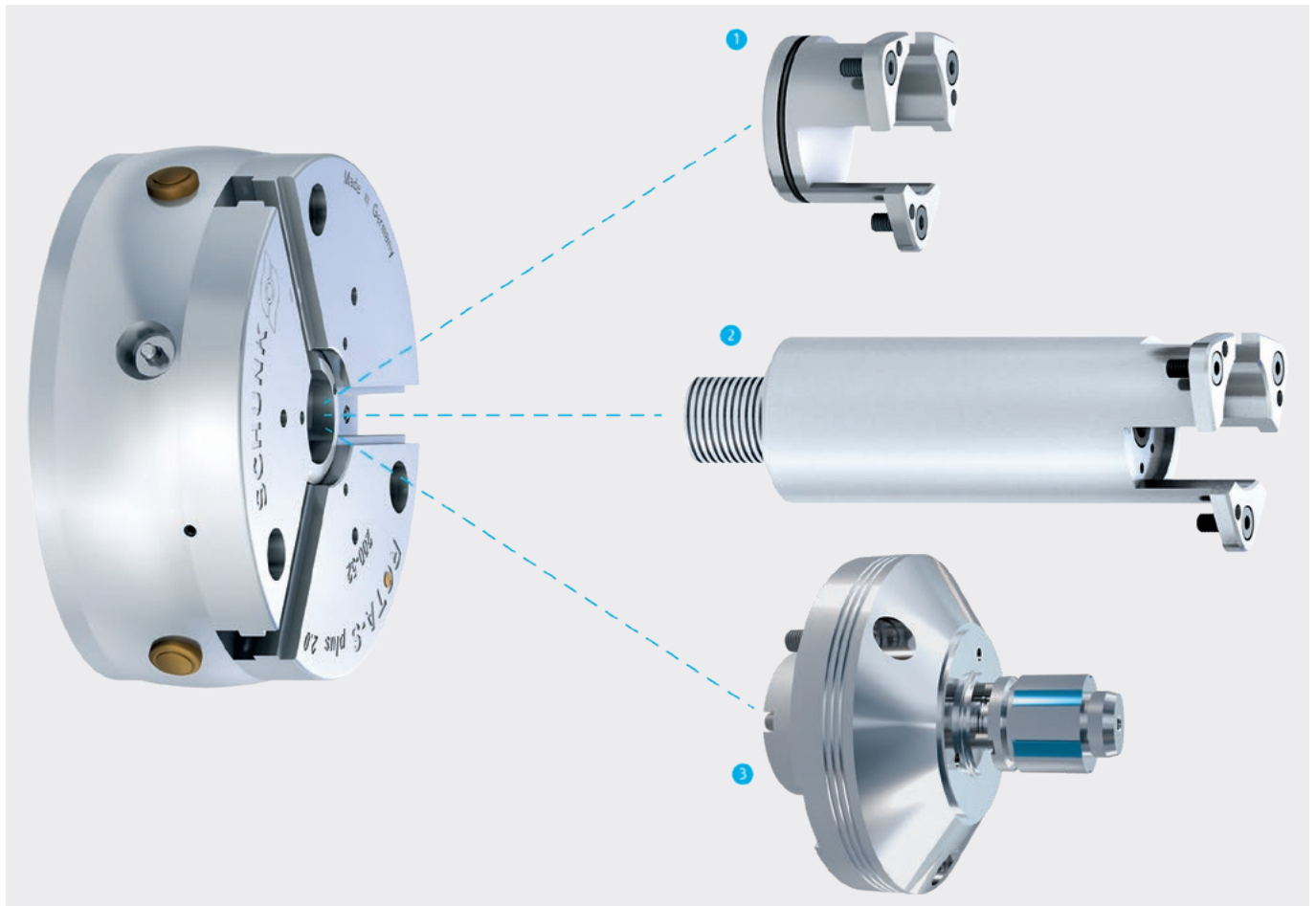
## Incorrect jaw change

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

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



## Modular center sleeve system



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

**1 Closed center sleeve**

The closed center sleeve prevents penetration of chips and coolant into the through-hole.

**2 Adjustable stop in the center sleeve**

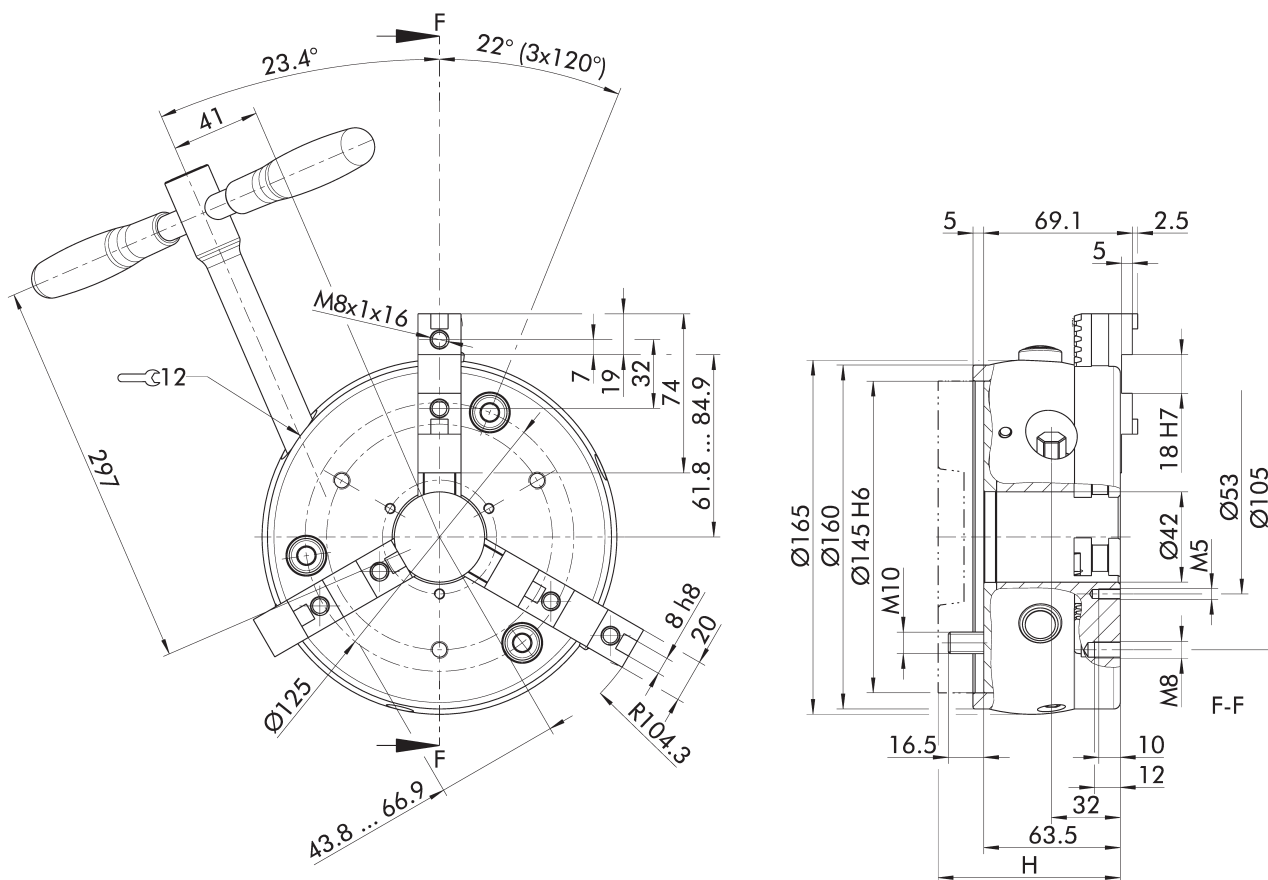
The adjustable stop ensures that all workpieces are stopped with high repeat accuracy in the same selectable position. This makes handling quick and easy.

**3 Expansion arbor**

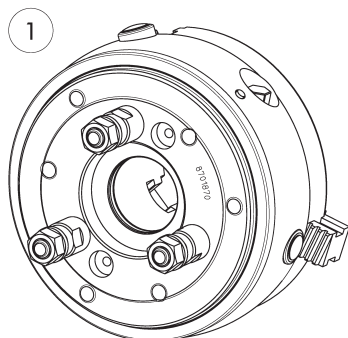
To clamp small inner clamping diameters, the ROTA-S plus 2.0 in sizes  $\varnothing$  200 mm and  $\varnothing$  250 mm can be retrofitted with an expansion arbor. However, a taper must be ground into the chuck body in order to do this.

① Modular center sleeve system up to size 315 possible.

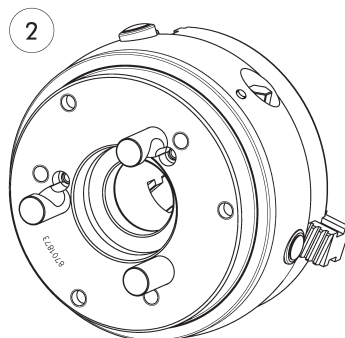




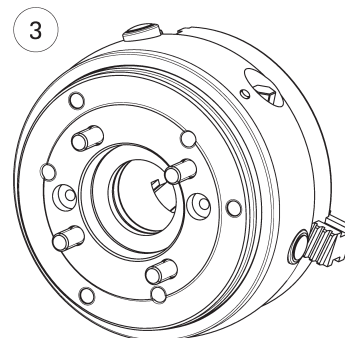
**ISO 702-3**



**ISO 702-2**



**ISO 702-1**



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

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

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

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

## Technical data

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

## Scope of delivery – Standard version

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

## Scope of delivery – Special offer package 1

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

## Scope of delivery – Special offer package 2

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

## Note

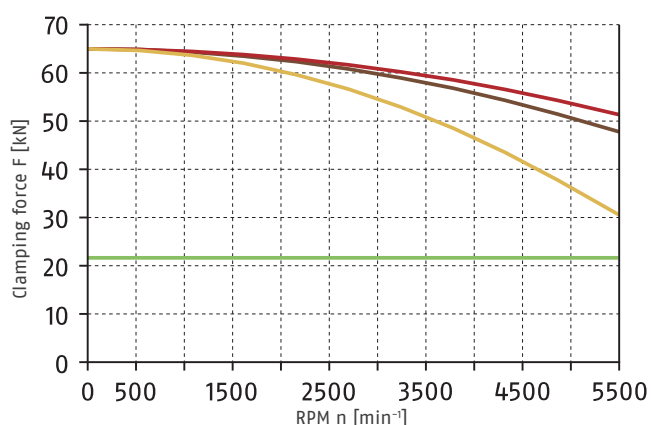
### Enlargement of the through-hole

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

## Further technical data

| Chuck type             | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Center jaw height<br>[mm] |
|------------------------|----------------------|--------------------|---------------------|---------------------------|
| ROTA-S plus 2.0 160-42 | 42                   | 6.5                | 4.8                 | 42.5                      |

## Clamping force-RPM-diagram

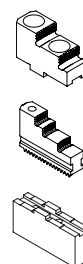


Required minimum  
clamping force  $F_{spmin}$  33%

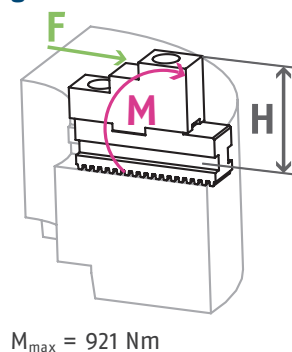
SHF 160  
0.6 kg

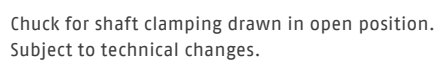
STF 160  
1.1 kg

SFA 160  
1.2 kg



## Load of base jaw guidance





## Technical data

| Spindle type | Spindle size | ID      | Max. rotational speed<br>[min <sup>-1</sup> ] | Max. clamping force<br>[kN] | Max. torque<br>[Nm] | Weight<br>[kg] |
|--------------|--------------|---------|-----------------------------------------------|-----------------------------|---------------------|----------------|
| -            | Z145         | 0819100 | 5400                                          | 40                          | 55                  | 8.5            |

## Scope of delivery

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

## Note

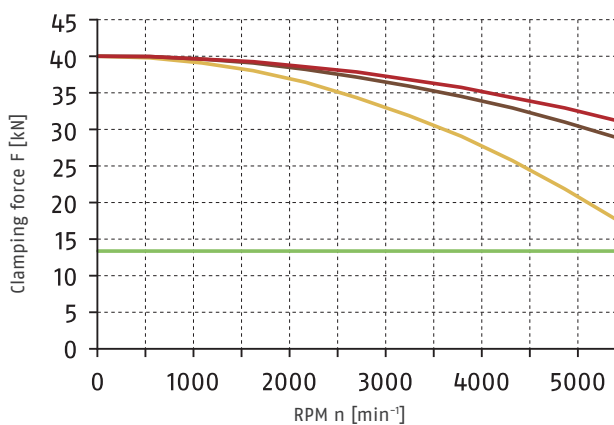
### Enlargement of the through-hole

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

## Further technical data

| Chuck type               | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Center jaw height<br>[mm] |
|--------------------------|----------------------|--------------------|---------------------|---------------------------|
| ROTA-S plus 2.0 160-42/2 | 42                   | 6.5                | 4.8                 | 42.5                      |

## Clamping force-RPM-diagram



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

SHF 160  
0.6 kg



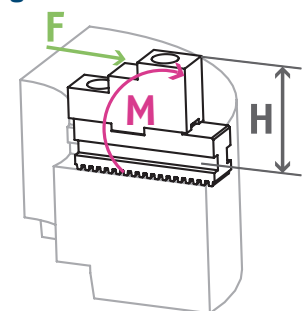
STF 160  
1.1 kg



SFA 160  
1.2 kg



## Load of base jaw guidance



$$M_{\max} = 567 \text{ Nm}$$



## Technical data

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

### Scope of delivery – Standard version

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

### Scope of delivery – Special offer package 1

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

### Scope of delivery – Special offer package 2

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

## Notes

#### Enlargement of the through-hole

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

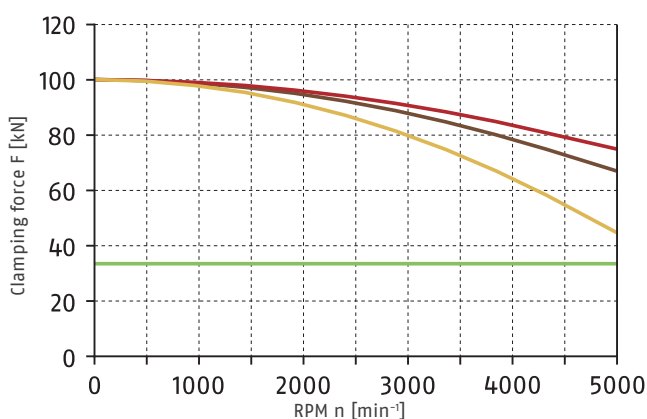
#### vario M

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

## Further technical data

| Chuck type             | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Center jaw height<br>[mm] |
|------------------------|----------------------|--------------------|---------------------|---------------------------|
| ROTA-S plus 2.0 200-52 | 52                   | 7                  | 4.8                 | 51                        |

### Clamping force-RPM-diagram

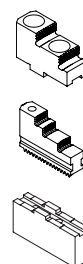


Required minimum  
clamping force  $F_{spmin}$  33%

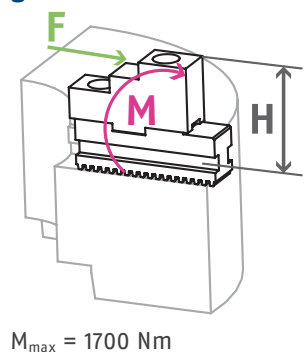
SHF 200  
0.82 kg

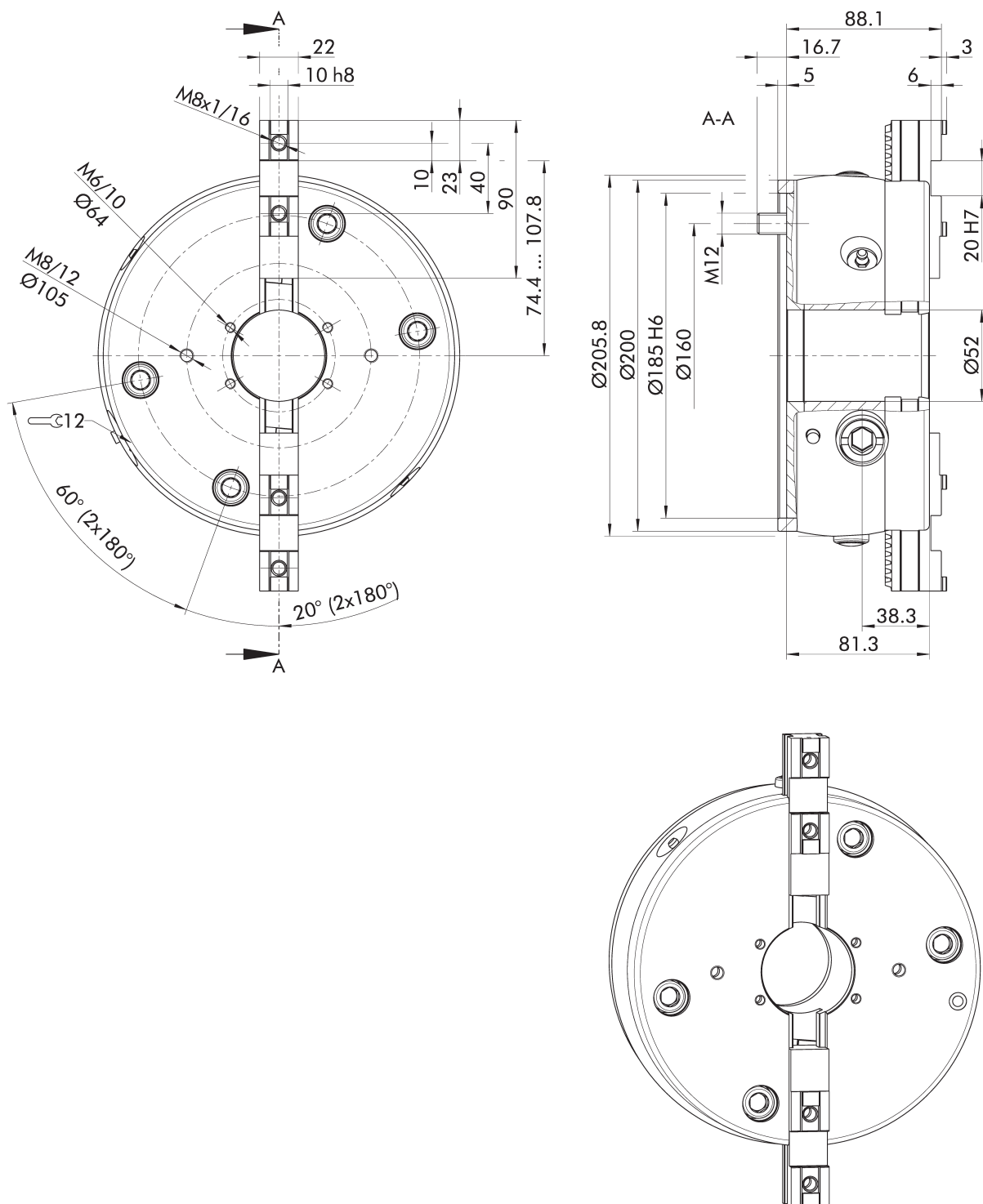
STF 200  
1.9 kg

SFA 200  
2 kg



### Load of base jaw guidance





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

### Technical data

| Spindle type | Spindle size | ID      | Max. rotational speed<br>[min <sup>-1</sup> ] | Max. clamping force<br>[kN] | Max. torque<br>[Nm] | Weight<br>[kg] |
|--------------|--------------|---------|-----------------------------------------------|-----------------------------|---------------------|----------------|
| -            | Z185         | 0819200 | 4800                                          | 65                          | 80                  | 18.2           |

### Scope of delivery

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

### Note

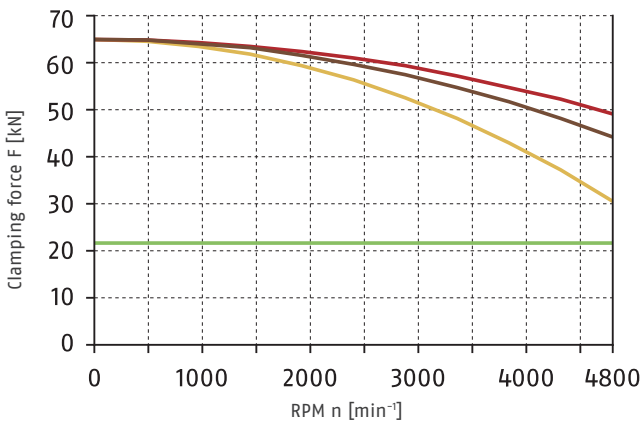
#### Enlargement of the through-hole

Enlargement of the through-hole to a maximum Ø 55 mm available upon request.

### Further technical data

| Chuck type               | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Center jaw height<br>[mm] |
|--------------------------|----------------------|--------------------|---------------------|---------------------------|
| ROTA-S plus 2.0 200-52/2 | 52                   | 7                  | 4.8                 | 51                        |

### Clamping force-RPM-diagram



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

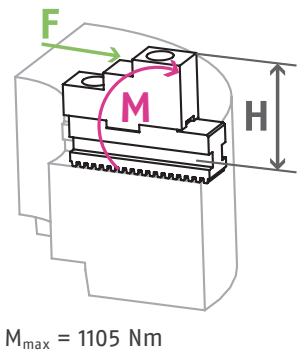
SHF 200  
0.82 kg

STF 200  
1.9 kg

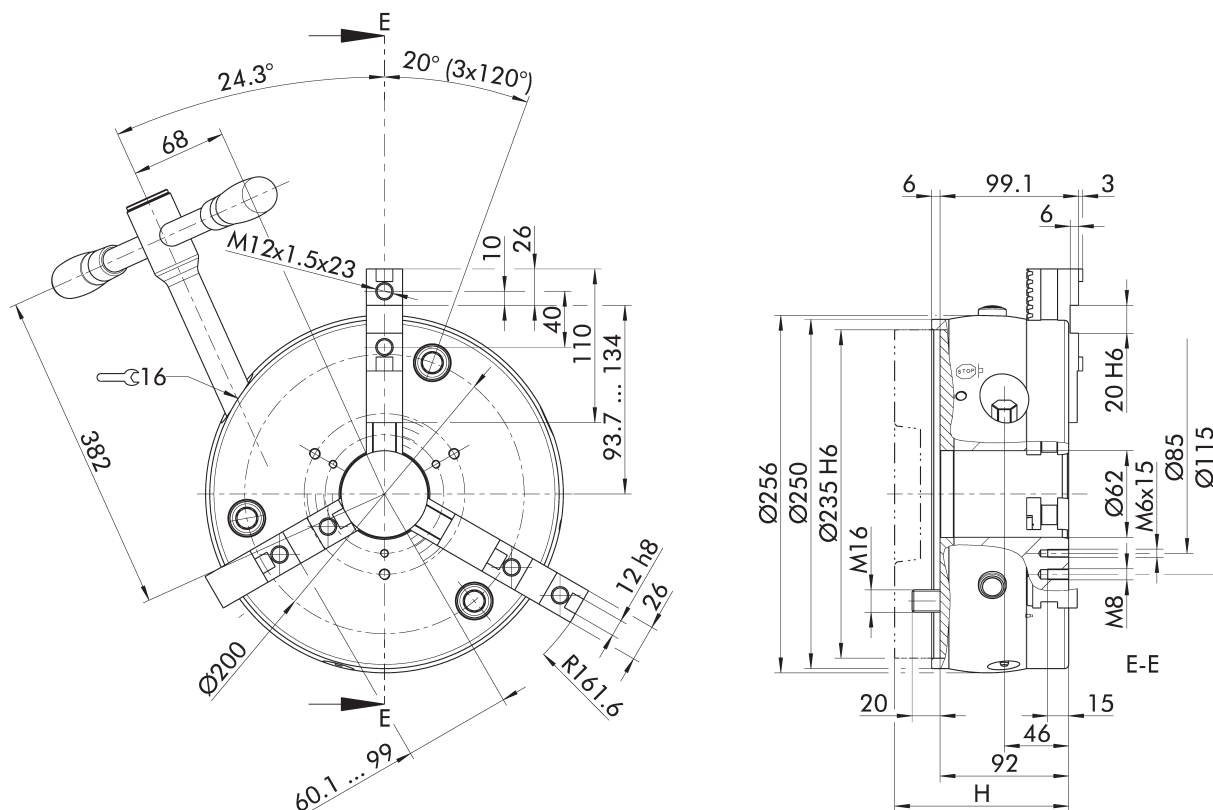
SFA 200  
2 kg



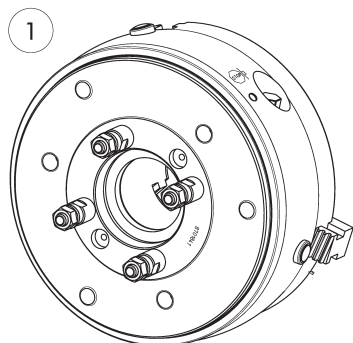
### Load of base jaw guidance



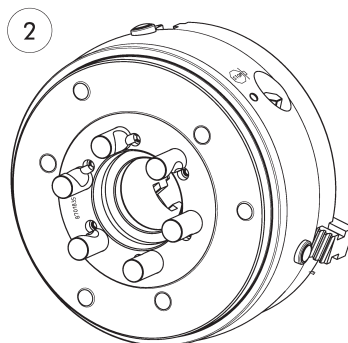
$M_{max} = 1105 \text{ Nm}$



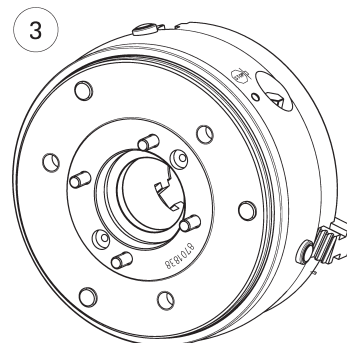
**ISO 702-3**



**ISO 702-2**



**ISO 702-1**



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

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

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

## Technical data

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

### Scope of delivery – Standard version

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

### Scope of delivery – Special offer package 1

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

### Scope of delivery – Special offer package 2

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

## Notes

#### Enlargement of the through-hole

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

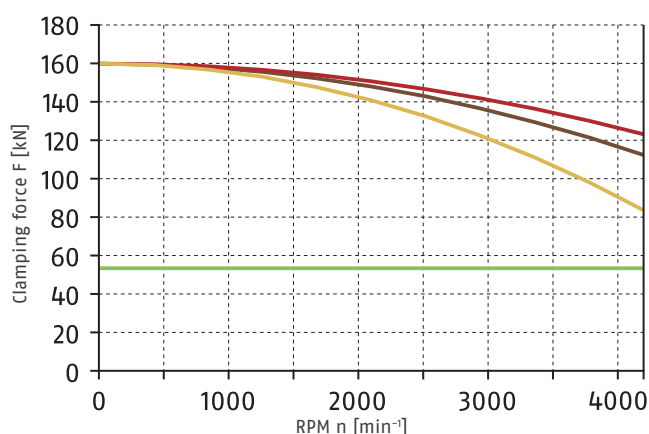
#### vario M

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

## Further technical data

| Chuck type             | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Center jaw height<br>[mm] |
|------------------------|----------------------|--------------------|---------------------|---------------------------|
| ROTA-S plus 2.0 250-62 | 62                   | 7.7                | 6                   | 66                        |

### Clamping force-RPM-diagram

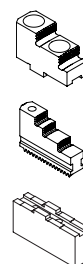


Required minimum  
clamping force  $F_{spmin}$  33%

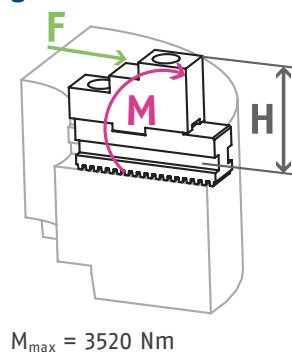
SHF 250  
1.9 kg

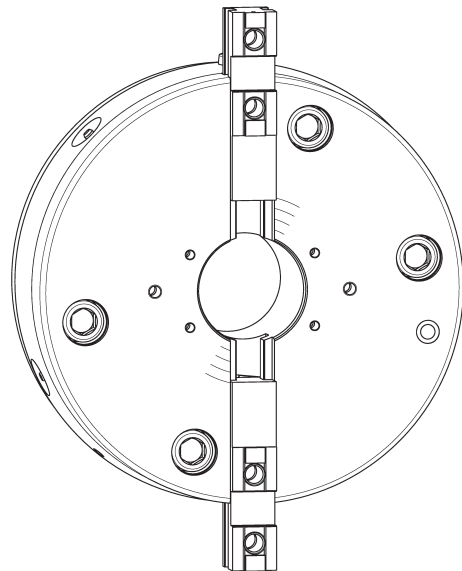
STF 250  
3.3 kg

SFA 250  
3.7 kg



### Load of base jaw guidance





Subject to technical changes.

## Technical data

| Spindle type | Spindle size | ID      | Max. rotational speed<br>[min <sup>-1</sup> ] | Max. clamping force<br>[kN] | Max. torque<br>[Nm] | Weight<br>[kg] |
|--------------|--------------|---------|-----------------------------------------------|-----------------------------|---------------------|----------------|
| -            | Z235         | 0819300 | 4200                                          | 105                         | 140                 | 30.4           |

## Scope of delivery

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

## Note

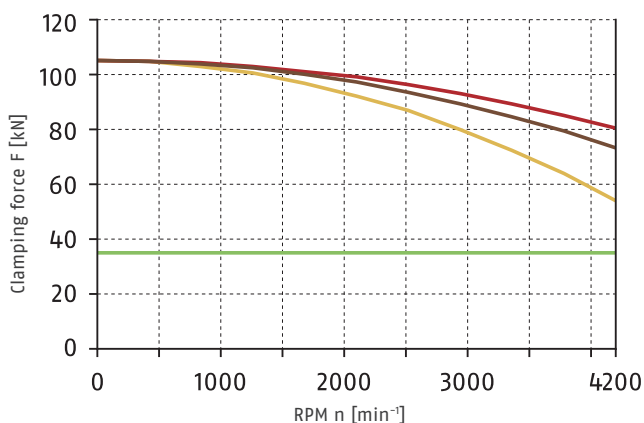
### Enlargement of the through-hole

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

## Further technical data

| Chuck type               | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Center jaw height<br>[mm] |
|--------------------------|----------------------|--------------------|---------------------|---------------------------|
| ROTA-S plus 2.0 250-62/2 | 62                   | 7.7                | 6                   | 66                        |

## Clamping force-RPM-diagram



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

SHF 250  
1.9 kg



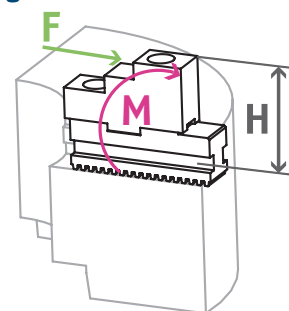
STF 250  
3.3 kg



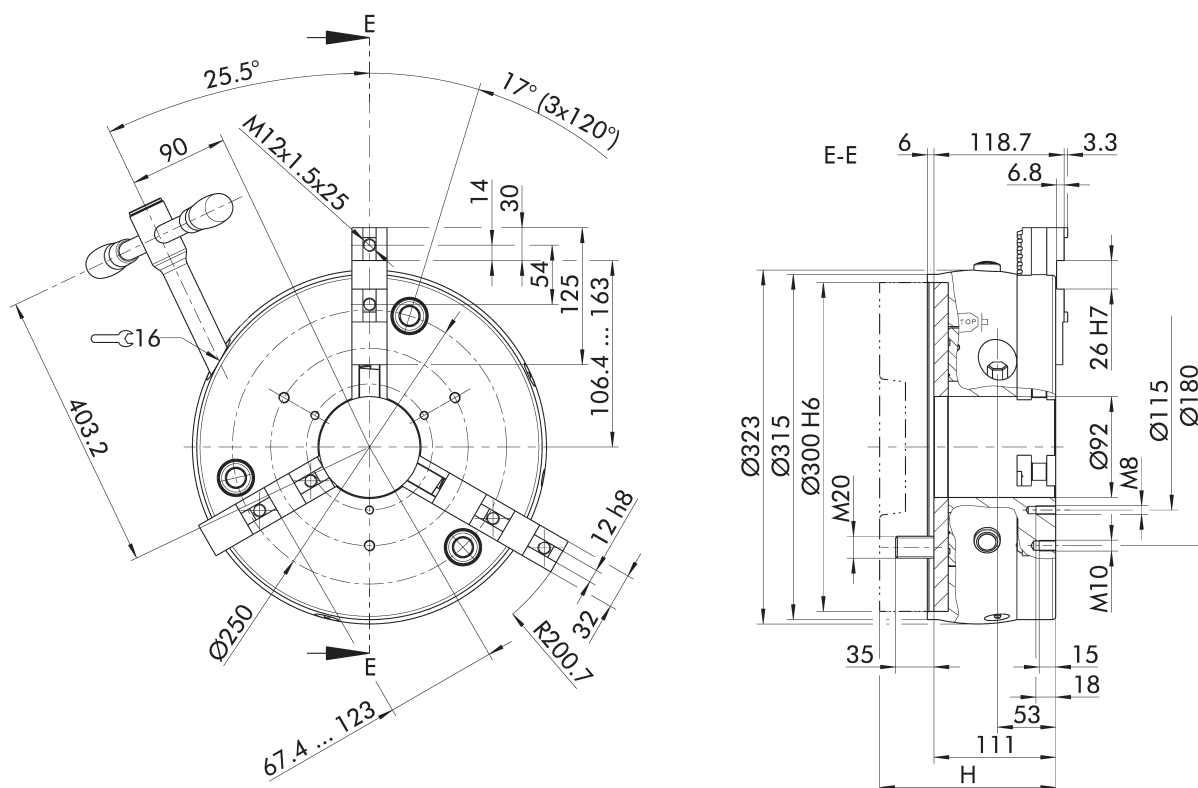
SFA 250  
3.7 kg



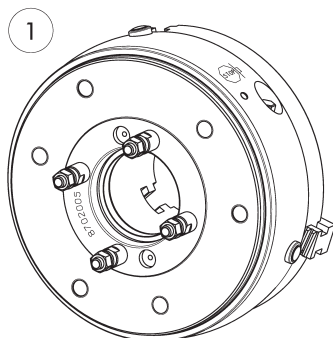
## Load of base jaw guidance



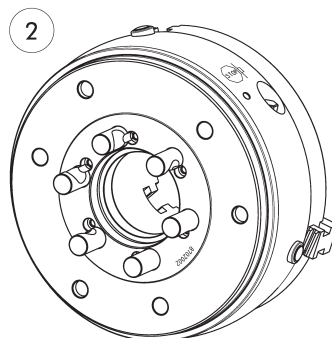
$M_{max} = 2310$  Nm



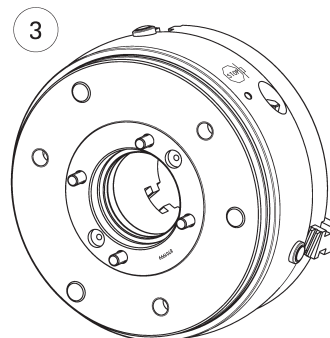
**ISO 702-3**



**ISO 702-2**



**ISO 702-1**



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

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

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

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

## Technical data

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

### Scope of delivery – Standard version

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

### Scope of delivery – Special offer package 1

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

### Scope of delivery – Special offer package 2

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

## Note

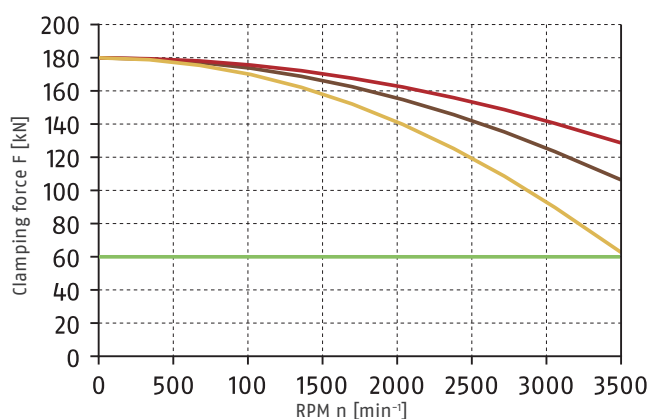
#### Enlargement of the through-hole

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

## Further technical data

| Chuck type             | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Center jaw height<br>[mm] |
|------------------------|----------------------|--------------------|---------------------|---------------------------|
| ROTA-S plus 2.0 315-92 | 92                   | 9.8                | 7                   | 74                        |

### Clamping force-RPM-diagram

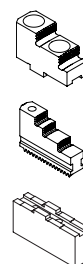


Required minimum  
clamping force  $F_{spmin}$  33%

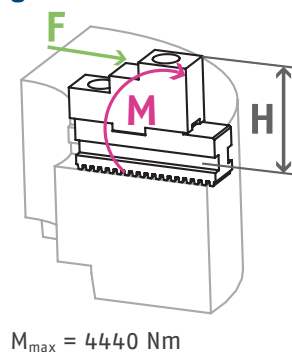
SHF 315  
3.3 kg

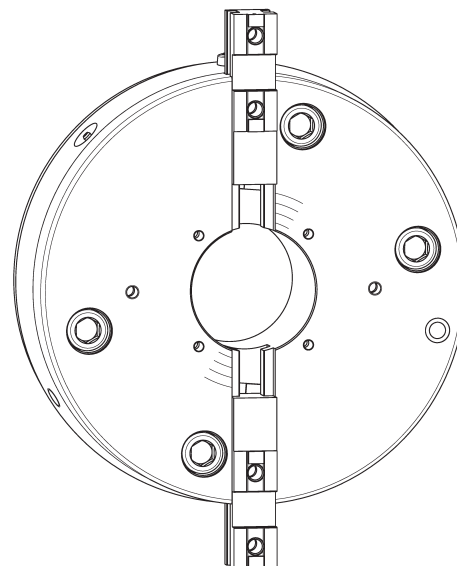
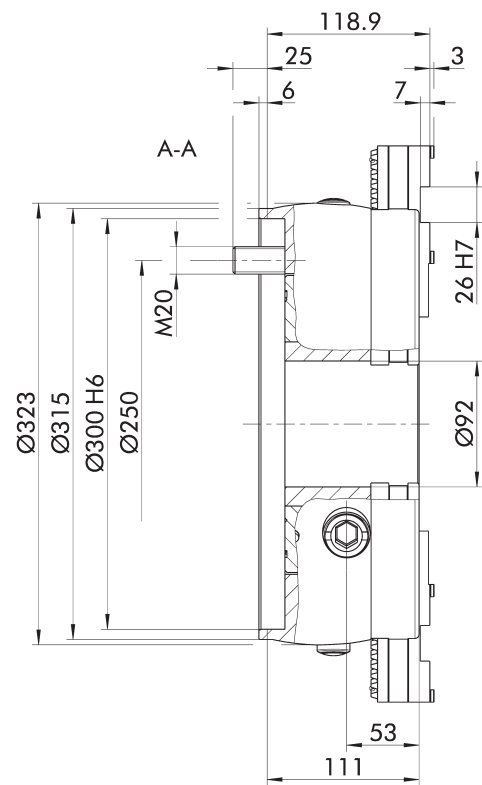
STF 315  
5.5 kg

SFA 315  
5.6 kg



### Load of base jaw guidance





22

## Technical data

| Spindle type | Spindle size | ID      | Max. rotational speed<br>[min <sup>-1</sup> ] | Max. clamping force<br>[kN] | Max. torque<br>[Nm] | Weight<br>[kg] |
|--------------|--------------|---------|-----------------------------------------------|-----------------------------|---------------------|----------------|
| -            | Z300         | 1348227 | 3400                                          | 120                         | 150                 | 60.5           |

## Scope of delivery

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

## Note

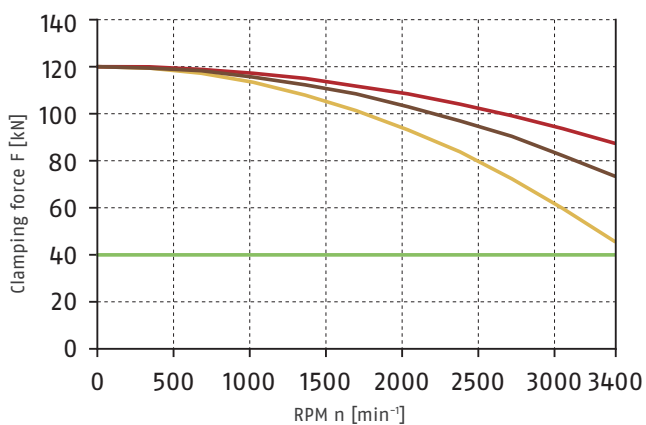
### Enlargement of the through-hole

Enlargement of the through-hole to a maximum Ø 102 mm available upon request.

## Further technical data

| Chuck type               | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] |
|--------------------------|----------------------|--------------------|---------------------|
| ROTA-S plus 2.0 315-92/2 | 92                   | 9.7                | 7                   |

## Clamping force-RPM-diagram



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

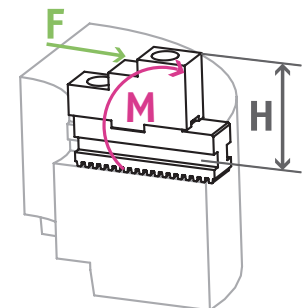
SHF 315  
3.3 kg

STF 315  
5.5 kg

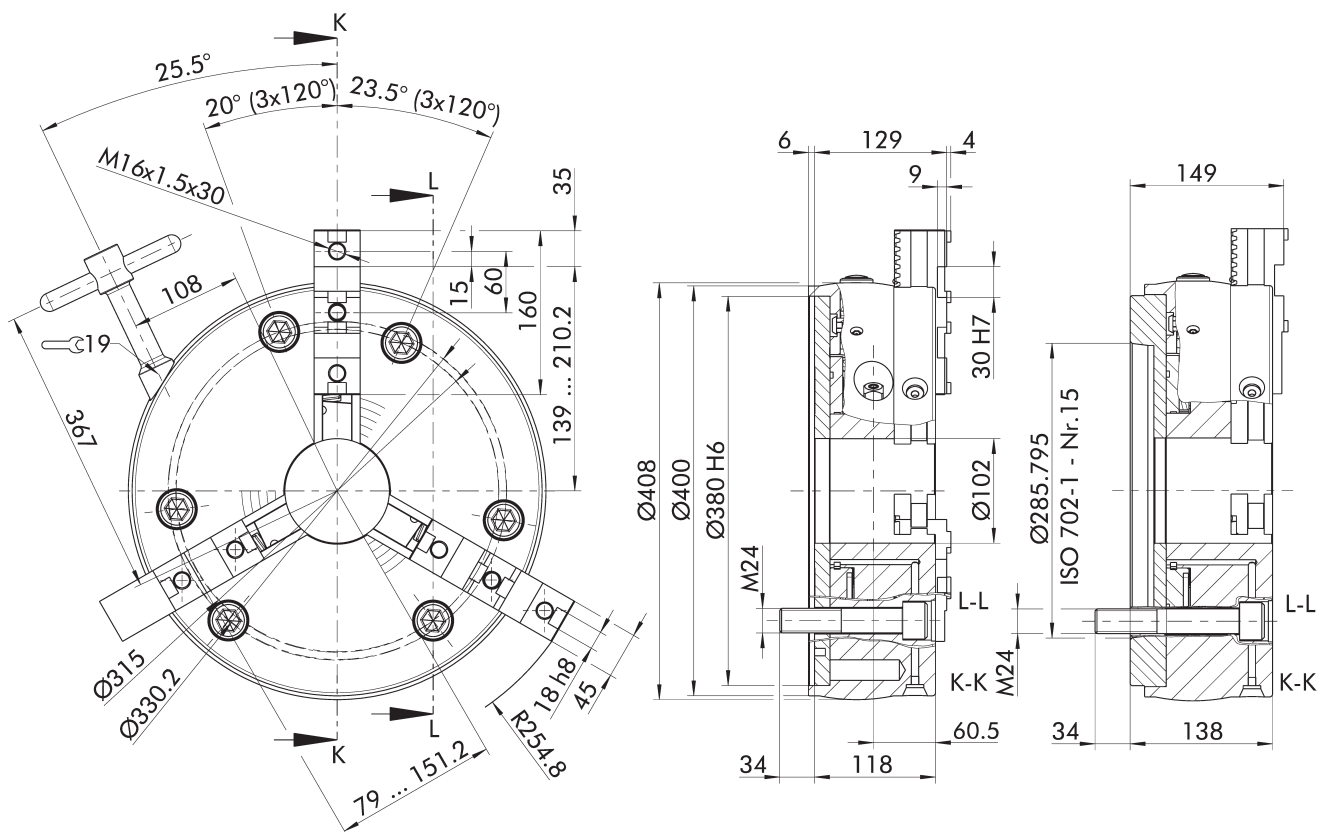
SFA 315  
5.6 kg



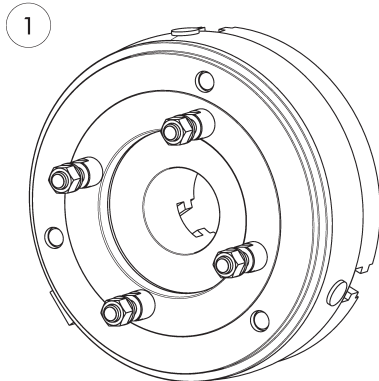
## Load of base jaw guidance



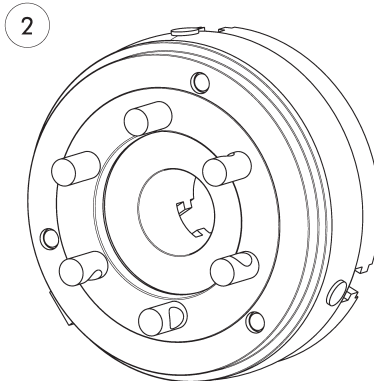
$M_{max} = 2960 \text{ Nm}$



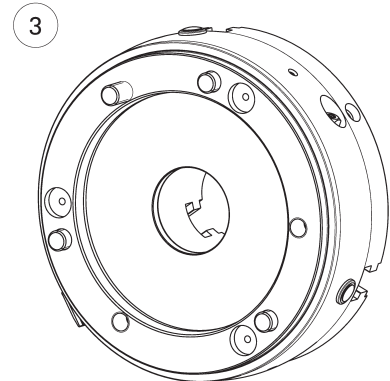
**ISO 702-3**



**ISO 702-2**



**ISO 702-1**



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

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

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

## Technical data

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

### Scope of delivery – Standard version

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

### Scope of delivery – Special offer package 1

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

### Scope of delivery – Special offer package 2

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

## Note

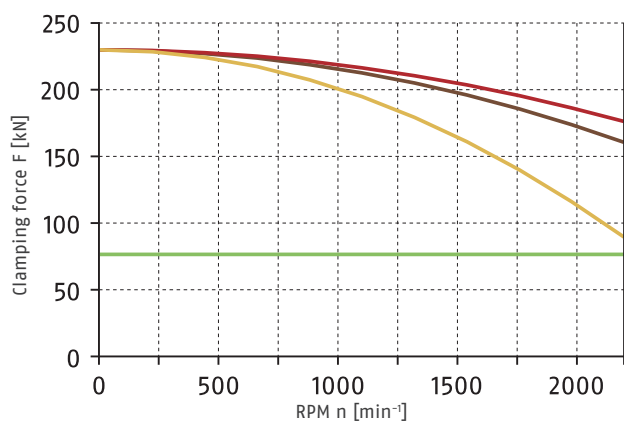
#### Enlargement of the through-hole

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

## Further technical data

| Chuck type          | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Center jaw height<br>[mm] |
|---------------------|----------------------|--------------------|---------------------|---------------------------|
| ROTA-S plus 400-102 | 102                  | 12                 | 8.5                 | 97                        |

## Clamping force-RPM-diagram

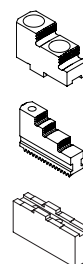


Required minimum  
clamping force  $F_{spmin}$  33%

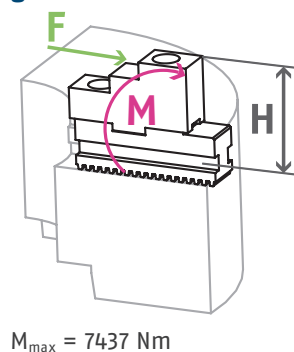
SHF 400  
6.8 kg

STF 400  
10.8 kg

SFA 400  
13.7 kg



## Load of base jaw guidance





## Technical data

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

### Scope of delivery – Standard version

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

### Scope of delivery – Special offer package 1

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

### Scope of delivery – Special offer package 2

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

## Note

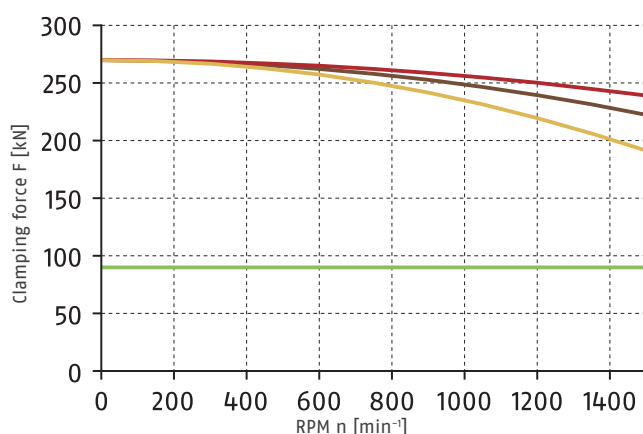
#### Enlargement of the through-hole

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

## Further technical data

| Chuck type          | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Center jaw height<br>[mm] |
|---------------------|----------------------|--------------------|---------------------|---------------------------|
| ROTA-S plus 500-162 | 162                  | 12                 | 8.5                 | 97                        |

## Clamping force-RPM-diagram



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

SHF 400  
6.8 kg



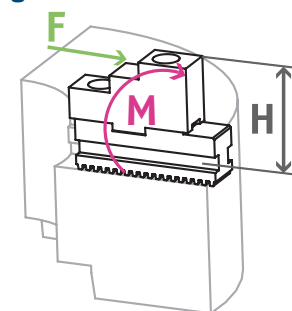
STF 400  
10.8 kg



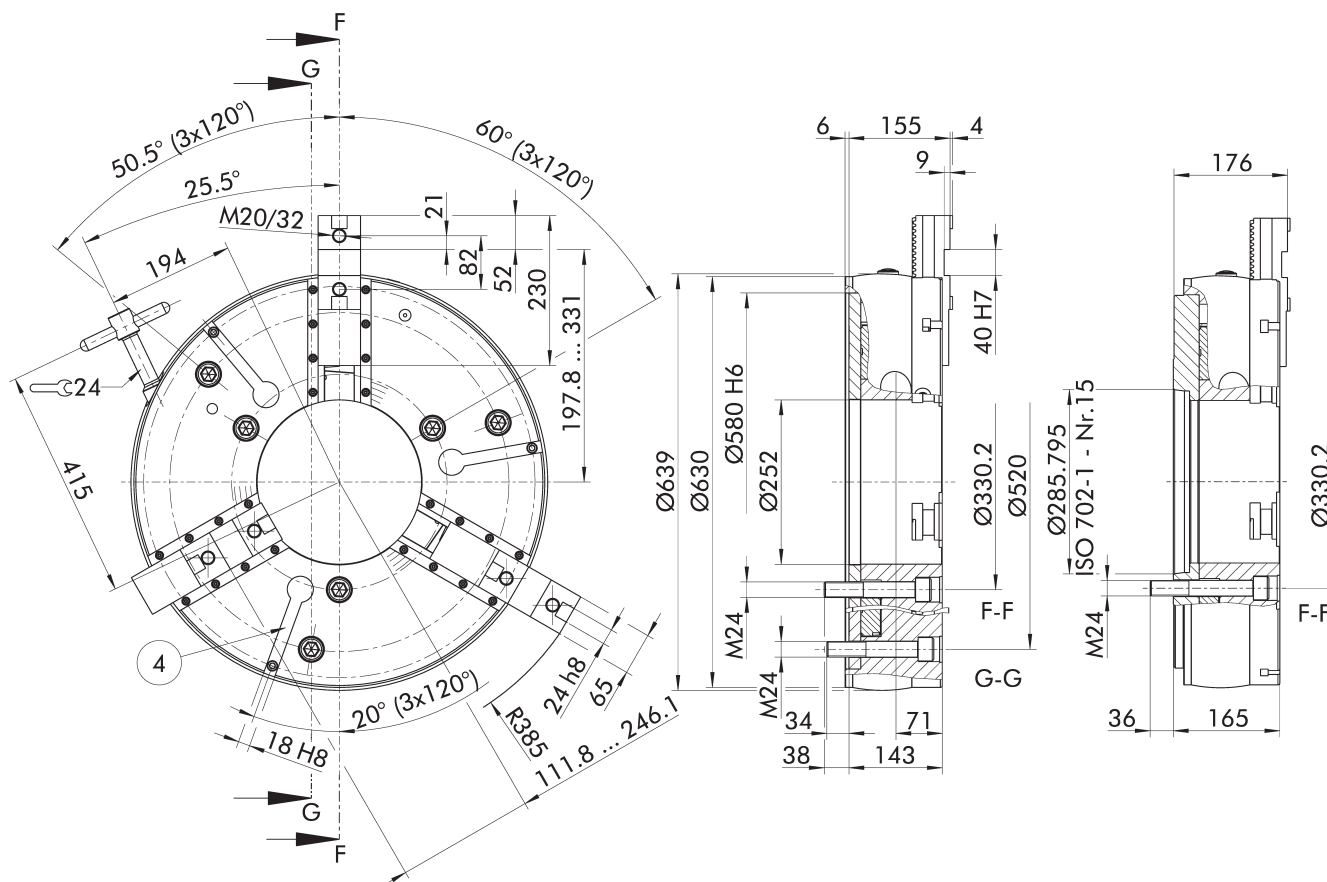
SFA 400  
13.7 kg



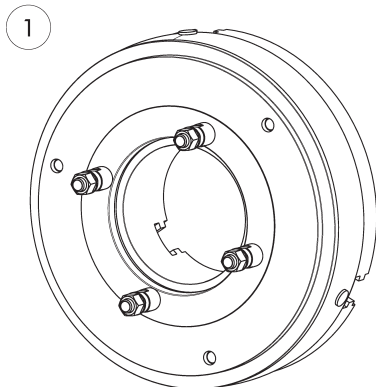
## Load of base jaw guidance



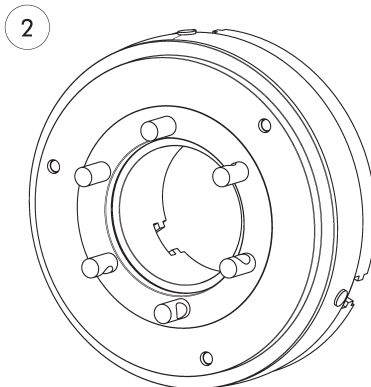
$M_{max} = 8730 \text{ Nm}$



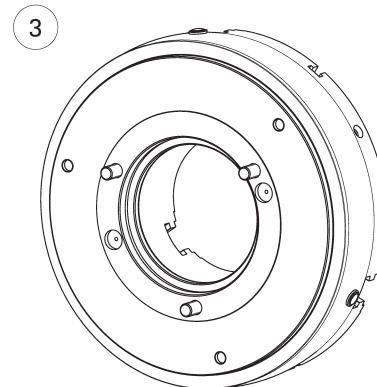
### ISO 702-3



### ISO 702-2



### ISO 702-1



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

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

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

## Technical data

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

### Scope of delivery – Standard version

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

### Scope of delivery – Special offer package 2

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

## Note

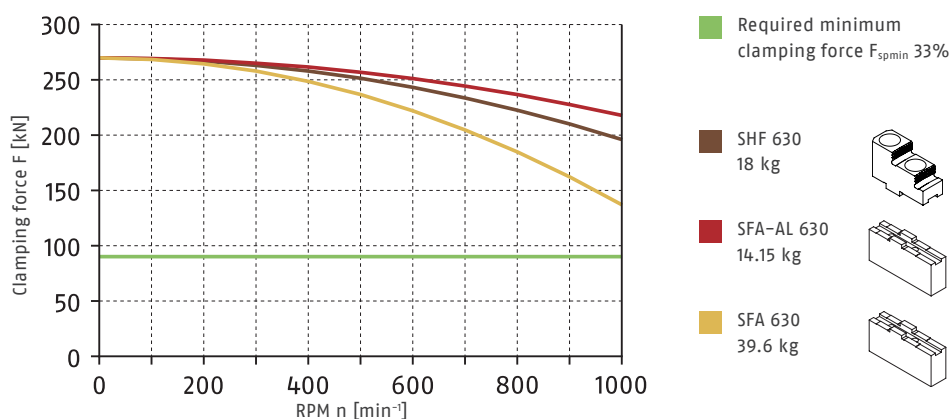
#### Enlargement of the through-hole

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

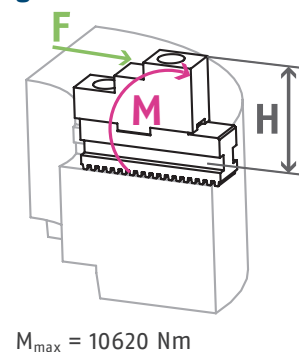
## Further technical data

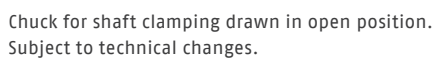
| Chuck type          | Through-hole [mm] | Stroke/jaw [mm] | Tooth pitch [mm] | Center jaw height [mm] |
|---------------------|-------------------|-----------------|------------------|------------------------|
| ROTA-S plus 630-252 | 252               | 15              | 8.5              | 118                    |

## Clamping force-RPM-diagram



## Load of base jaw guidance





- 30

## Technical data

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

## Scope of delivery

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

## Note

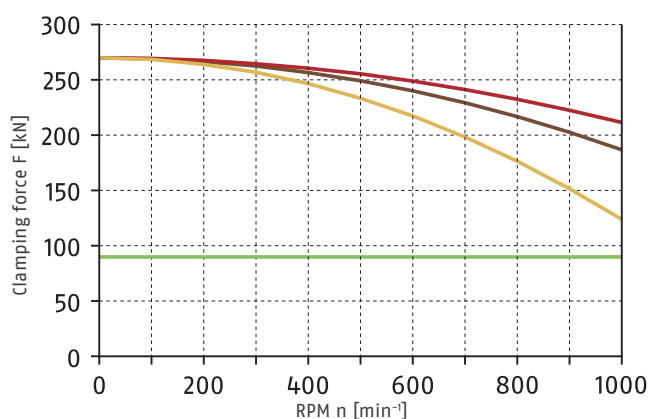
### Enlargement of the through-hole

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

## Further technical data

| Chuck type          | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Center jaw height<br>[mm] |
|---------------------|----------------------|--------------------|---------------------|---------------------------|
| ROTA-S plus 800-252 | 252                  | 15                 | 8.5                 | 118                       |

## Clamping force-RPM-diagram



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

SHF 630  
18 kg



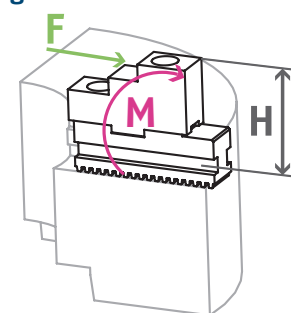
SFA-AL 630  
14.15 kg



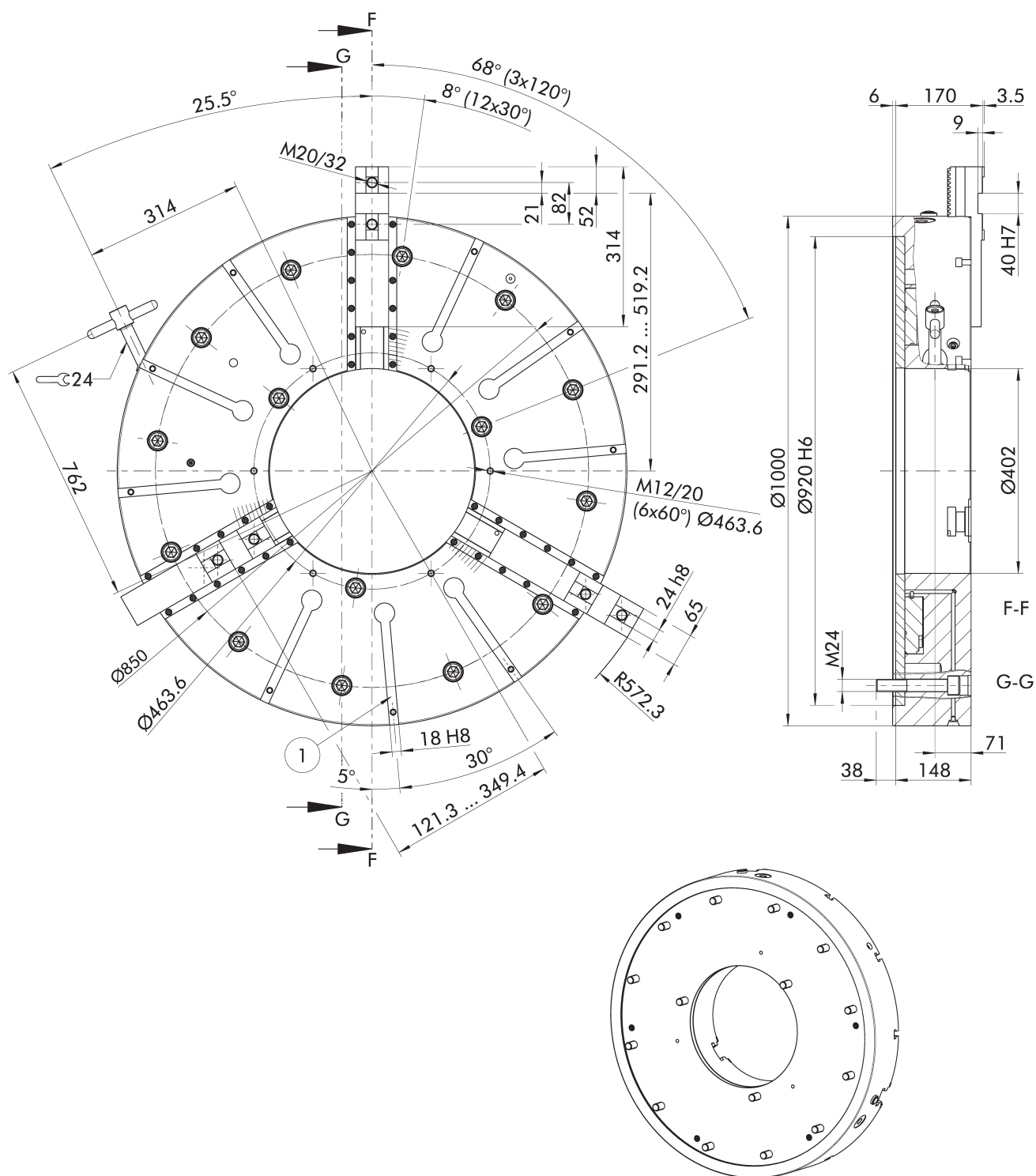
SFA 630  
39.6 kg



## Load of base jaw guidance



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



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

① For nut DIN 508 – M16 x 18

## Technical data

| Spindle type | Spindle size | ID      | Max. rotational speed<br>[min <sup>-1</sup> ] | Max. clamping force<br>[kN] | Max. torque<br>[Nm] | Weight<br>[kg] |
|--------------|--------------|---------|-----------------------------------------------|-----------------------------|---------------------|----------------|
| -            | Z920         | 0814290 | 900                                           | 270                         | 350                 | 720            |

## Scope of delivery

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

## Note

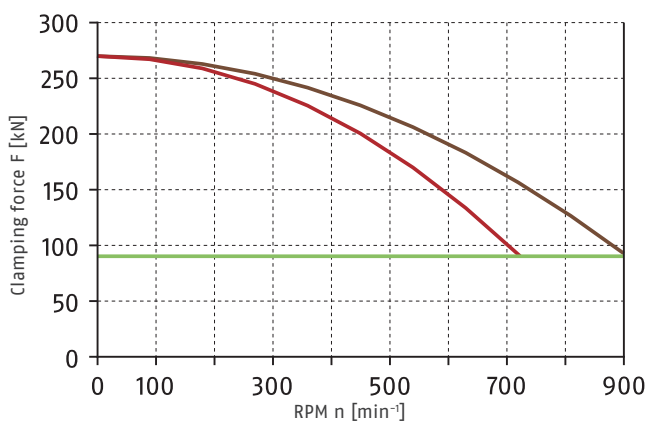
### Enlargement of the through-hole

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

## Further technical data

| Chuck type           | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Center jaw height<br>[mm] |
|----------------------|----------------------|--------------------|---------------------|---------------------------|
| ROTA-S plus 1000-402 | 402                  | 15                 | 8.5                 | 128                       |

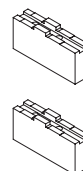
## Clamping force-RPM-diagram



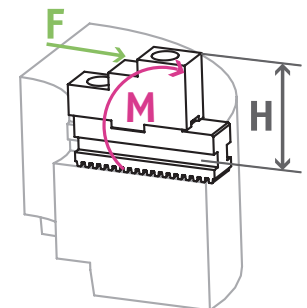
Required minimum clamping force F<sub>spmin</sub> 33%

SFA-AL 1000  
32 kg

SFA 1000  
81.79 kg



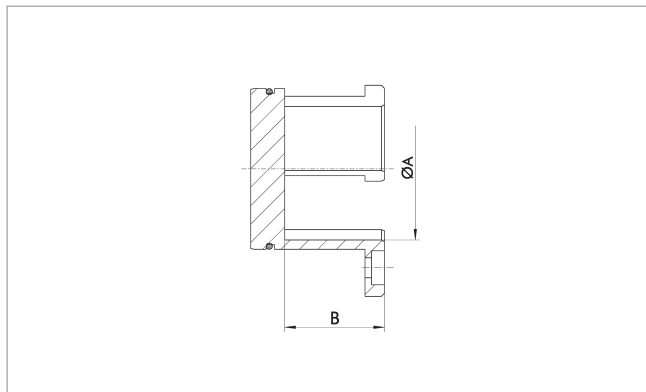
## Load of base jaw guidance



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

## Center sleeves

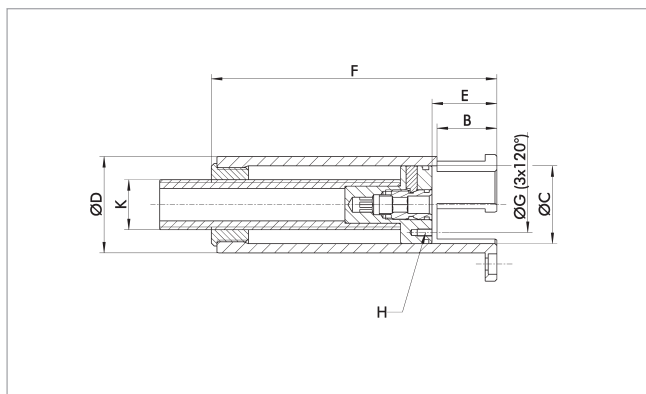
### Center sleeve closed



### Technical data

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

### Center sleeve with adjustable stop



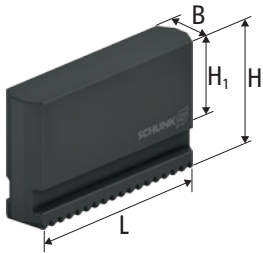
### Technical data

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

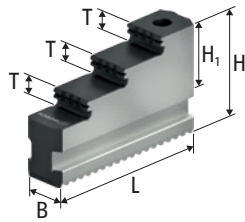
- Important: Check the spindle/draw tube through-hole
- The spindle through-hole must be at least  $\varnothing D + 0.5 \text{ mm}$



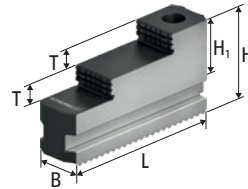
## Base jaws, Hard stepped block jaws, Soft monoblock jaws with angled serration



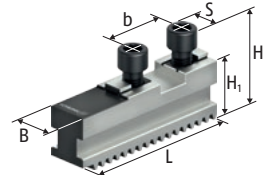
SMB  
Soft monoblock jaws



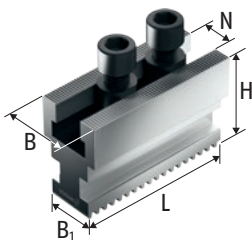
STF  
Hard stepped block jaws



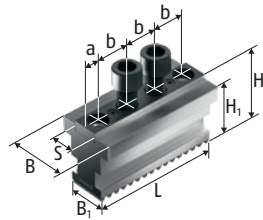
STF  
Hard stepped block jaws



SFG  
Base jaws



STB  
Base jaws



STN  
Base jaws

### Technical data

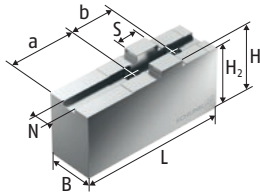
| Chuck type               | Description | ID      | N<br>[mm] | S<br>[mm] | B<br>[mm] | B1<br>[mm] | H<br>[mm] | H1<br>[mm] | L<br>[mm] | T<br>[mm] | a<br>[mm] | b<br>[mm] | Screws  | m/SET<br>[kg] |
|--------------------------|-------------|---------|-----------|-----------|-----------|------------|-----------|------------|-----------|-----------|-----------|-----------|---------|---------------|
| ROTA-S plus 2.0 160-42   | SMB 160     | 0163100 |           |           | 20        |            | 45        | 24         | 79        |           |           |           |         | 1.5           |
| ROTA-S plus 2.0 160-42   | SMB-H 160   | 0163200 |           |           | 20        |            | 60        | 39         | 79        |           |           |           |         | 2.0           |
| ROTA-S plus 2.0 160-42   | SFG 160     | 0157100 | 18        | 8         | 20        |            | 29.5      | 27         | 74        |           |           | 32        | M8x1    | 0.8           |
| ROTA-S plus 2.0 160-42   | SFGK 160    | 0157500 | 18        | 8         | 20        |            | 29.5      | 27         | 64        |           |           | 32        | M8x1    | 0.7           |
| ROTA-S plus 2.0 160-42   | SFG-V 160   | 0157150 | 18        | 8         | 20        |            | 29.5      | 27         | 74        |           |           | 32        | M8x1    | 0.7           |
| ROTA-S plus 2.0 160-42   | STF 160     | 0161100 |           |           | 20        |            | 45        | 24         | 79.1      | 7.5       |           |           |         | 1.1           |
| ROTA-S plus 2.0 160-42/2 | SMB 160     | 0163100 |           |           | 20        |            | 45        | 24         | 79        |           |           |           |         | 1.5           |
| ROTA-S plus 2.0 160-42/2 | SMB-H 160   | 0163200 |           |           | 20        |            | 60        | 39         | 79        |           |           |           |         | 2.0           |
| ROTA-S plus 2.0 160-42/2 | SFG 160     | 0157100 | 18        | 8         | 20        |            | 29.5      | 27         | 74        |           |           | 32        | M8x1    | 0.8           |
| ROTA-S plus 2.0 160-42/2 | SFGK 160    | 0157500 | 18        | 8         | 20        |            | 29.5      | 27         | 64        |           |           | 32        | M8x1    | 0.7           |
| ROTA-S plus 2.0 160-42/2 | STF 160     | 0161100 |           |           | 20        |            | 45        | 24         | 79.1      | 7.5       |           |           |         | 1.1           |
| ROTA-S plus 2.0 200-52   | SMB 200     | 0163101 |           |           | 22        |            | 60        | 35         | 94        |           |           |           |         | 2.6           |
| ROTA-S plus 2.0 200-52   | SMB-H 200   | 0163201 |           |           | 22        |            | 80        | 55         | 94        |           |           |           |         | 3.6           |
| ROTA-S plus 2.0 200-52   | SFG 200     | 0157101 | 20        | 10        | 22        |            | 35        | 32         | 90        |           |           | 40        | M8x1    | 1.2           |
| ROTA-S plus 2.0 200-52   | SFGK 200    | 0157501 | 20        | 10        | 22        |            | 35        | 32         | 80        |           |           | 40        | M8x1    | 1.1           |
| ROTA-S plus 2.0 200-52   | SFGL 200    | 0157121 | 20        | 10        | 22        |            | 35        | 32         | 110       |           |           | 40        | M8x1    | 1.5           |
| ROTA-S plus 2.0 200-52   | STB 200     | 0156099 | 17        |           | 45        | 22         | 61        |            | 80        |           |           |           | M12     | 3.4           |
| ROTA-S plus 2.0 200-52   | STF 200     | 0161101 |           |           | 22        |            | 60        | 35         | 94.2      | 10        |           |           |         | 1.9           |
| ROTA-S plus 2.0 200-52/2 | SMB 200     | 0163101 |           |           | 22        |            | 60        | 35         | 94        |           |           |           |         | 2.6           |
| ROTA-S plus 2.0 200-52/2 | SMB-H 200   | 0163201 |           |           | 22        |            | 80        | 55         | 94        |           |           |           |         | 3.6           |
| ROTA-S plus 2.0 200-52/2 | SFG 200     | 0157101 | 20        | 10        | 22        |            | 35        | 32         | 90        |           |           | 40        | M8x1    | 1.2           |
| ROTA-S plus 2.0 200-52/2 | SFGK 200    | 0157501 | 20        | 10        | 22        |            | 35        | 32         | 80        |           |           | 40        | M8x1    | 1.1           |
| ROTA-S plus 2.0 200-52/2 | SFGL 200    | 0157121 | 20        | 10        | 22        |            | 35        | 32         | 110       |           |           | 40        | M8x1    | 1.5           |
| ROTA-S plus 2.0 200-52/2 | STB 200     | 0156099 | 17        |           | 45        | 22         | 61        |            | 80        |           |           |           | M12     | 3.4           |
| ROTA-S plus 2.0 200-52/2 | STF 200     | 0161101 |           |           | 22        |            | 60        | 35         | 94.2      | 10        |           |           |         | 1.9           |
| ROTA-S plus 2.0 250-62   | SMB 250     | 0163102 |           |           | 26        |            | 70        | 40         | 115       |           |           |           |         | 4.4           |
| ROTA-S plus 2.0 250-62   | SMB-H 250   | 0163202 |           |           | 26        |            | 100       | 70         | 115       |           |           |           |         | 6.5           |
| ROTA-S plus 2.0 250-62   | SFG 250     | 0157102 | 20        | 12        | 26        |            | 40        | 37         | 110       |           |           | 40        | M12x1.5 | 1.8           |

| Chuck type               | Description | ID                      | N    | S    | B    | B1   | H    | H1   | L     | T    | a    | b    | Screws  | m/SET |
|--------------------------|-------------|-------------------------|------|------|------|------|------|------|-------|------|------|------|---------|-------|
|                          |             |                         | [mm] | [mm] | [mm] | [mm] | [mm] | [mm] | [mm]  | [mm] | [mm] | [mm] |         | [kg]  |
| ROTA-S plus 2.0 250-62   | SFGK 250    | <a href="#">0157502</a> | 20   | 12   | 26   |      | 40   | 37   | 91    |      |      | 40   | M12x1.5 | 1.6   |
| ROTA-S plus 2.0 250-62   | SFGL 250    | <a href="#">0157112</a> | 20   | 12   | 26   |      | 40   | 37   | 122   |      |      | 40   | M12x1.5 | 2.0   |
| ROTA-S plus 2.0 250-62   | SFG-V 250   | <a href="#">0157152</a> | 20   | 12   | 26   |      | 40   | 37   | 110   |      |      | 40   | M12x1.5 | 1.8   |
| ROTA-S plus 2.0 250-62   | STB 250-1   | <a href="#">0156100</a> | 17   |      | 45   | 26   | 65   |      | 110   |      |      |      | M12     | 4.9   |
| ROTA-S plus 2.0 250-62   | STB 250-2   | <a href="#">0156101</a> | 21   |      | 54   | 26   | 70   |      | 110   |      |      |      | M16     | 5.2   |
| ROTA-S plus 2.0 250-62   | STN 250-4   | <a href="#">0160501</a> |      | 21   | 45   | 26   | 52.5 | 50   | 110   |      | 13   | 28   | M16     | 4.2   |
| ROTA-S plus 2.0 250-62   | STF 250     | <a href="#">0161102</a> |      |      | 26   |      | 70   | 40   | 114   | 14   |      |      |         | 3.3   |
| ROTA-S plus 2.0 250-62/2 | SMB 250     | <a href="#">0163102</a> |      |      | 26   |      | 70   | 40   | 115   |      |      |      |         | 4.4   |
| ROTA-S plus 2.0 250-62/2 | SMB-H 250   | <a href="#">0163202</a> |      |      | 26   |      | 100  | 70   | 115   |      |      |      |         | 6.5   |
| ROTA-S plus 2.0 250-62/2 | SFG 250     | <a href="#">0157102</a> | 20   | 12   | 26   |      | 40   | 37   | 110   |      |      | 40   | M12x1.5 | 1.8   |
| ROTA-S plus 2.0 250-62/2 | SFGL 250    | <a href="#">0157112</a> | 20   | 12   | 26   |      | 40   | 37   | 122   |      |      | 40   | M12x1.5 | 2.0   |
| ROTA-S plus 2.0 250-62/2 | STB 250-1   | <a href="#">0156100</a> | 17   |      | 45   | 26   | 65   |      | 110   |      |      |      | M12     | 4.9   |
| ROTA-S plus 2.0 250-62/2 | STB 250-2   | <a href="#">0156101</a> | 21   |      | 54   | 26   | 70   |      | 110   |      |      |      | M16     | 5.2   |
| ROTA-S plus 2.0 250-62/2 | STN 250-4   | <a href="#">0160501</a> |      | 21   | 45   | 26   | 52.5 | 50   | 110   |      | 13   | 28   | M16     | 4.2   |
| ROTA-S plus 2.0 250-62/2 | STF 250     | <a href="#">0161102</a> |      |      | 26   |      | 70   | 40   | 114   | 14   |      |      |         | 3.3   |
| ROTA-S plus 2.0 315-92   | SMB 315     | <a href="#">0163103</a> |      |      | 32   |      | 81   | 46   | 140   |      |      |      |         | 7.5   |
| ROTA-S plus 2.0 315-92   | SMB-H 315   | <a href="#">0163203</a> |      |      | 32   |      | 135  | 100  | 140   |      |      |      |         | 13.0  |
| ROTA-S plus 2.0 315-92   | SFG 315     | <a href="#">0157103</a> | 26   | 12   | 32   |      | 46   | 43   | 125   |      |      | 54   | M12x1.5 | 3.1   |
| ROTA-S plus 2.0 315-92   | SFGL 315    | <a href="#">0157123</a> | 26   | 12   | 32   |      | 46   | 43   | 160   |      |      | 54   | M12x1.5 | 4.0   |
| ROTA-S plus 2.0 315-92   | SFG-V 315   | <a href="#">0157153</a> | 26   | 12   | 32   |      | 46   | 43   | 125   |      |      | 54   | M12x1.5 | 3.1   |
| ROTA-S plus 2.0 315-92   | STB 315-2   | <a href="#">0156103</a> | 21   |      | 54   | 32   | 75   |      | 125   |      |      |      | M16     | 9.3   |
| ROTA-S plus 2.0 315-92   | STN 315-4   | <a href="#">0160503</a> |      | 21   | 45   | 32   | 57.5 | 55   | 110   |      | 13   | 28   | M16     | 4.5   |
| ROTA-S plus 2.0 315-92   | STF 315     | <a href="#">0161103</a> |      |      | 32   |      | 81   | 46   | 129.1 | 15   |      |      |         | 5.5   |
| ROTA-S plus 2.0 315-92/2 | SMB 315     | <a href="#">0163103</a> |      |      | 32   |      | 81   | 46   | 140   |      |      |      |         | 7.5   |
| ROTA-S plus 2.0 315-92/2 | SMB-H 315   | <a href="#">0163203</a> |      |      | 32   |      | 135  | 100  | 140   |      |      |      |         | 13.0  |
| ROTA-S plus 2.0 315-92/2 | SFG 315     | <a href="#">0157103</a> | 26   | 12   | 32   |      | 46   | 43   | 125   |      |      | 54   | M12x1.5 | 3.1   |
| ROTA-S plus 2.0 315-92/2 | STB 315-2   | <a href="#">0156103</a> | 21   |      | 54   | 32   | 75   |      | 125   |      |      |      | M16     | 9.3   |
| ROTA-S plus 2.0 315-92/2 | STN 315-4   | <a href="#">0160503</a> |      | 21   | 45   | 32   | 57.5 | 55   | 110   |      | 13   | 28   | M16     | 4.5   |
| ROTA-S plus 2.0 315-92/2 | STF 315     | <a href="#">0161103</a> |      |      | 32   |      | 81   | 46   | 129.1 | 15   |      |      |         | 5.5   |
| ROTA-S plus 400-102      | SMB 400     | <a href="#">0163104</a> |      |      | 45   |      | 93   | 53   | 176   |      |      |      |         | 15.0  |
| ROTA-S plus 400-102      | SMB 500     | <a href="#">0163105</a> |      |      | 45   |      | 130  | 90   | 176   |      |      |      |         | 21.6  |
| ROTA-S plus 400-102      | SFG 400     | <a href="#">0157104</a> | 30   | 18   | 45   |      | 55   | 51   | 160   |      |      | 60   | M16x1.5 | 6.4   |
| ROTA-S plus 400-102      | SFGL 400    | <a href="#">0157124</a> | 30   | 18   | 45   |      | 55   | 51   | 200   |      |      | 60   | M16x1.5 | 8.1   |
| ROTA-S plus 400-102      | SFG-V 400   | <a href="#">0157154</a> | 30   | 18   | 45   |      | 55   | 51   | 165   |      |      | 60   | M16x1.5 | 6.6   |
| ROTA-S plus 400-102      | STB 400-1   | <a href="#">0156104</a> | 21   |      | 54   | 45   | 80   |      | 160   |      |      |      | M16     | 12.0  |
| ROTA-S plus 400-102      | STB 400-2   | <a href="#">0156105</a> | 25.5 |      | 64   | 45   | 82   |      | 160   |      |      |      | M20     | 12.2  |
| ROTA-S plus 400-102      | STF 400     | <a href="#">0161104</a> |      |      | 45   |      | 93   | 52   | 167.1 | 20   |      |      |         | 10.8  |
| ROTA-S plus 500-162      | SMB 400     | <a href="#">0163104</a> |      |      | 45   |      | 93   | 53   | 176   |      |      |      |         | 15.0  |
| ROTA-S plus 500-162      | SMB 500     | <a href="#">0163105</a> |      |      | 45   |      | 130  | 90   | 176   |      |      |      |         | 21.6  |
| ROTA-S plus 500-162      | SFG 400     | <a href="#">0157104</a> | 30   | 18   | 45   |      | 55   | 51   | 160   |      |      | 60   | M16x1.5 | 6.4   |
| ROTA-S plus 500-162      | SFGL 400    | <a href="#">0157124</a> | 30   | 18   | 45   |      | 55   | 51   | 200   |      |      | 60   | M16x1.5 | 8.1   |
| ROTA-S plus 500-162      | SFG-V 400   | <a href="#">0157154</a> | 30   | 18   | 45   |      | 55   | 51   | 165   |      |      | 60   | M16x1.5 | 6.6   |
| ROTA-S plus 500-162      | STB 400-1   | <a href="#">0156104</a> | 21   |      | 54   | 45   | 80   |      | 160   |      |      |      | M16     | 12.0  |
| ROTA-S plus 500-162      | STB 400-2   | <a href="#">0156105</a> | 25.5 |      | 64   | 45   | 82   |      | 160   |      |      |      | M20     | 12.2  |
| ROTA-S plus 500-162      | STF 400     | <a href="#">0161104</a> |      |      | 45   |      | 93   | 52   | 167.1 | 20   |      |      |         | 10.8  |
| ROTA-S plus 630-252      | SMB 630-800 | <a href="#">0163106</a> |      |      | 65   |      | 130  | 88   | 230   |      |      |      |         | 40.2  |
| ROTA-S plus 630-252      | SFG 630     | <a href="#">0157106</a> | 40   | 24   | 65   |      | 62   | 58   | 230   |      |      | 82   | M20     | 16.2  |
| ROTA-S plus 630-252      | SFG 630-400 | <a href="#">0157109</a> | 30   | 18   | 65   |      | 62   | 58   | 230   |      |      | 60   | M16x1.5 | 16.2  |
| ROTA-S plus 800-252      | SMB 630-800 | <a href="#">0163106</a> |      |      | 65   |      | 130  | 88   | 230   |      |      |      |         | 40.2  |
| ROTA-S plus 800-252      | SFG 630-400 | <a href="#">0157109</a> | 30   | 18   | 65   |      | 62   | 58   | 230   |      |      | 60   | M16x1.5 | 16.2  |
| ROTA-S plus 800-252      | SFG 800     | <a href="#">0157107</a> | 40   | 24   | 65   |      | 62   | 58   | 264   |      |      | 82   | M20     | 18.7  |
| ROTA-S plus 1000-402     | SMB 630-800 | <a href="#">0163106</a> |      |      | 65   |      | 130  | 88   | 230   |      |      |      |         | 40.2  |
| ROTA-S plus 1000-402     | SFG 1000    | <a href="#">0157108</a> | 40   | 24   | 65   |      | 72   | 68   | 314   |      |      | 82   | M20     | 27.1  |

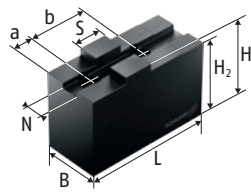
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](http://schunk.com)

## Soft top jaws

with tongue and groove



SFA-AL  
Soft top jaws



SFA  
Soft top jaws

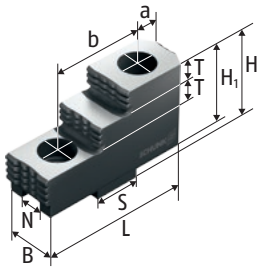
### Technical data

| Chuck type               | Description | ID                      | N<br>[mm] | S<br>[mm] | B<br>[mm] | H<br>[mm] | H2<br>[mm] | L<br>[mm] | a<br>[mm] | b<br>[mm] | Screws | m/SET<br>[kg] |
|--------------------------|-------------|-------------------------|-----------|-----------|-----------|-----------|------------|-----------|-----------|-----------|--------|---------------|
| ROTA-S plus 2.0 160-42   | SFA 160     | <a href="#">0153100</a> | 8         | 18        | 20        | 40        | 36         | 85        | 35        | 32        | M8     | 1.2           |
| ROTA-S plus 2.0 160-42   | SFA-AL 160  | <a href="#">0172100</a> | 8         | 18        | 25        | 50        | 46         | 85        | 35        | 32        | M8     | 0.7           |
| ROTA-S plus 2.0 160-42   | SFA 160-C1  | <a href="#">0154121</a> | 8         | 18        | 30        | 55.5      | 51.5       | 85        | 41        | 32        | M8     | 2.7           |
| ROTA-S plus 2.0 160-42   | SFA 160-C2  | <a href="#">0154127</a> | 8         | 18        | 35        | 40        | 36         | 63        | 19        | 32        | M8     | 1.6           |
| ROTA-S plus 2.0 160-42   | SFA 160-C3  | <a href="#">0154131</a> | 8         | 18        | 40        | 60        | 56         | 70        | 26        | 32        | M8     | 3.3           |
| ROTA-S plus 2.0 160-42   | SFA 160-C4  | <a href="#">0154133</a> | 8         | 18        | 40        | 80        | 76         | 85        | 41        | 32        | M8     | 5.6           |
| ROTA-S plus 2.0 160-42/2 | SFA 160     | <a href="#">0153100</a> | 8         | 18        | 20        | 40        | 36         | 85        | 35        | 32        | M8     | 1.2           |
| ROTA-S plus 2.0 160-42/2 | SFA-AL 160  | <a href="#">0172100</a> | 8         | 18        | 25        | 50        | 46         | 85        | 35        | 32        | M8     | 0.7           |
| ROTA-S plus 2.0 160-42/2 | SFA 160-C1  | <a href="#">0154121</a> | 8         | 18        | 30        | 55.5      | 51.5       | 85        | 41        | 32        | M8     | 2.7           |
| ROTA-S plus 2.0 160-42/2 | SFA 160-C2  | <a href="#">0154127</a> | 8         | 18        | 35        | 40        | 36         | 63        | 19        | 32        | M8     | 1.6           |
| ROTA-S plus 2.0 160-42/2 | SFA 160-C3  | <a href="#">0154131</a> | 8         | 18        | 40        | 60        | 56         | 70        | 26        | 32        | M8     | 3.3           |
| ROTA-S plus 2.0 160-42/2 | SFA 160-C4  | <a href="#">0154133</a> | 8         | 18        | 40        | 80        | 76         | 85        | 41        | 32        | M8     | 5.6           |
| ROTA-S plus 2.0 200-52   | SFA 200     | <a href="#">0153101</a> | 10        | 20        | 22        | 47        | 43         | 105       | 40        | 40        | M8     | 2.0           |
| ROTA-S plus 2.0 200-52   | SFA-AL 200  | <a href="#">0172102</a> | 10        | 20        | 25        | 50        | 46         | 105       | 40        | 40        | M8     | 0.9           |
| ROTA-S plus 2.0 200-52   | SFA 200-C1  | <a href="#">0154100</a> | 10        | 20        | 30        | 55.5      | 51.5       | 100       | 47        | 40        | M8     | 3.2           |
| ROTA-S plus 2.0 200-52   | SFA 200-C2  | <a href="#">0154124</a> | 10        | 20        | 22        | 55.5      | 51.5       | 100       | 47        | 40        | M8     | 2.2           |
| ROTA-S plus 2.0 200-52   | SFA 200-C3  | <a href="#">0154128</a> | 10        | 20        | 40        | 40        | 36         | 70        | 17        | 40        | M8     | 2.1           |
| ROTA-S plus 2.0 200-52   | SFA 200-C4  | <a href="#">0154130</a> | 10        | 20        | 40        | 60        | 56         | 85        | 32        | 40        | M8     | 4.0           |
| ROTA-S plus 2.0 200-52   | SFA 200-C5  | <a href="#">0154132</a> | 10        | 20        | 40        | 80        | 76         | 95        | 42        | 40        | M8     | 6.1           |
| ROTA-S plus 2.0 200-52/2 | SFA 200     | <a href="#">0153101</a> | 10        | 20        | 22        | 47        | 43         | 105       | 40        | 40        | M8     | 2.0           |
| ROTA-S plus 2.0 200-52/2 | SFA-AL 200  | <a href="#">0172102</a> | 10        | 20        | 25        | 50        | 46         | 105       | 40        | 40        | M8     | 0.9           |
| ROTA-S plus 2.0 200-52/2 | SFA 200-C1  | <a href="#">0154100</a> | 10        | 20        | 30        | 55.5      | 51.5       | 100       | 47        | 40        | M8     | 3.2           |
| ROTA-S plus 2.0 200-52/2 | SFA 200-C2  | <a href="#">0154124</a> | 10        | 20        | 22        | 55.5      | 51.5       | 100       | 47        | 40        | M8     | 2.2           |
| ROTA-S plus 2.0 200-52/2 | SFA 200-C3  | <a href="#">0154128</a> | 10        | 20        | 40        | 40        | 36         | 70        | 17        | 40        | M8     | 2.1           |
| ROTA-S plus 2.0 200-52/2 | SFA 200-C4  | <a href="#">0154130</a> | 10        | 20        | 40        | 60        | 56         | 85        | 32        | 40        | M8     | 4.0           |
| ROTA-S plus 2.0 200-52/2 | SFA 200-C5  | <a href="#">0154132</a> | 10        | 20        | 40        | 80        | 76         | 95        | 42        | 40        | M8     | 6.1           |
| ROTA-S plus 2.0 250-62   | SFA 250     | <a href="#">0153102</a> | 12        | 20        | 30        | 55.5      | 50.5       | 125       | 60        | 40        | M12    | 3.7           |
| ROTA-S plus 2.0 250-62   | SFA-AL 250  | <a href="#">0172103</a> | 12        | 20        | 40        | 60        | 55         | 125       | 60        | 40        | M12    | 2.1           |
| ROTA-S plus 2.0 250-62   | SFA 250-C1  | <a href="#">0154101</a> | 12        | 20        | 40        | 60        | 55         | 90        | 34        | 40        | M12    | 3.9           |
| ROTA-S plus 2.0 250-62   | SFA 250-C2  | <a href="#">0154102</a> | 12        | 20        | 40        | 60        | 55         | 125       | 69        | 40        | M12    | 5.6           |
| ROTA-S plus 2.0 250-62   | SFA 250-C3  | <a href="#">0154103</a> | 12        | 20        | 40        | 80        | 75         | 125       | 69        | 40        | M12    | 7.7           |
| ROTA-S plus 2.0 250-62   | SFA 250-C4  | <a href="#">0154104</a> | 12        | 20        | 40        | 100       | 95         | 125       | 69        | 40        | M12    | 9.8           |
| ROTA-S plus 2.0 250-62   | SFA 250-C5  | <a href="#">0154105</a> | 12        | 20        | 40        | 120       | 115        | 125       | 69        | 40        | M12    | 11.8          |
| ROTA-S plus 2.0 250-62   | SFA 250-C6  | <a href="#">0154106</a> | 12        | 20        | 60        | 60        | 55         | 90        | 34        | 40        | M12    | 6.0           |
| ROTA-S plus 2.0 250-62   | SFA 250-C7  | <a href="#">0154107</a> | 12        | 20        | 80        | 60        | 55         | 90        | 34        | 40        | M12    | 8.5           |
| ROTA-S plus 2.0 250-62   | SFA 250-C8  | <a href="#">0154134</a> | 12        | 20        | 80        | 100       | 95         | 125       | 69        | 40        | M12    | 20.6          |
| ROTA-S plus 2.0 250-62/2 | SFA 250     | <a href="#">0153102</a> | 12        | 20        | 30        | 55.5      | 50.5       | 125       | 60        | 40        | M12    | 3.7           |
| ROTA-S plus 2.0 250-62/2 | SFA-AL 250  | <a href="#">0172103</a> | 12        | 20        | 40        | 60        | 55         | 125       | 60        | 40        | M12    | 2.1           |
| ROTA-S plus 2.0 250-62/2 | SFA 250-C1  | <a href="#">0154101</a> | 12        | 20        | 40        | 60        | 55         | 90        | 34        | 40        | M12    | 3.9           |
| ROTA-S plus 2.0 250-62/2 | SFA 250-C2  | <a href="#">0154102</a> | 12        | 20        | 40        | 60        | 55         | 125       | 69        | 40        | M12    | 5.6           |
| ROTA-S plus 2.0 250-62/2 | SFA 250-C3  | <a href="#">0154103</a> | 12        | 20        | 40        | 80        | 75         | 125       | 69        | 40        | M12    | 7.7           |

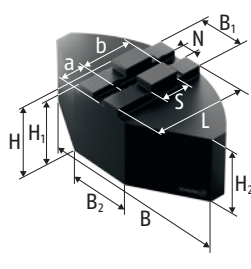
| Chuck type               | Description | ID                      | N<br>[mm] | S<br>[mm] | B<br>[mm] | H<br>[mm] | H2<br>[mm] | L<br>[mm] | a<br>[mm] | b<br>[mm] | Screws | m/SET<br>[kg] |
|--------------------------|-------------|-------------------------|-----------|-----------|-----------|-----------|------------|-----------|-----------|-----------|--------|---------------|
| ROTA-S plus 2.0 250-62/2 | SFA 250-C4  | <a href="#">0154104</a> | 12        | 20        | 40        | 100       | 95         | 125       | 69        | 40        | M12    | 9.8           |
| ROTA-S plus 2.0 250-62/2 | SFA 250-C5  | <a href="#">0154105</a> | 12        | 20        | 40        | 120       | 115        | 125       | 69        | 40        | M12    | 11.8          |
| ROTA-S plus 2.0 250-62/2 | SFA 250-C6  | <a href="#">0154106</a> | 12        | 20        | 60        | 60        | 55         | 90        | 34        | 40        | M12    | 6.0           |
| ROTA-S plus 2.0 250-62/2 | SFA 250-C7  | <a href="#">0154107</a> | 12        | 20        | 80        | 60        | 55         | 90        | 34        | 40        | M12    | 8.5           |
| ROTA-S plus 2.0 250-62/2 | SFA 250-C8  | <a href="#">0154134</a> | 12        | 20        | 80        | 100       | 95         | 125       | 69        | 40        | M12    | 20.6          |
| ROTA-S plus 2.0 315-92   | SFA 315     | <a href="#">0153103</a> | 12        | 26        | 35        | 60        | 54         | 145       | 60        | 54        | M12    | 5.6           |
| ROTA-S plus 2.0 315-92   | SFA-AL 315  | <a href="#">0172104</a> | 12        | 26        | 40        | 60        | 54         | 145       | 60        | 54        | M12    | 2.4           |
| ROTA-S plus 2.0 315-92   | SFA 315-C1  | <a href="#">0154108</a> | 12        | 26        | 40        | 60        | 54         | 110       | 40        | 54        | M12    | 4.9           |
| ROTA-S plus 2.0 315-92   | SFA 315-C2  | <a href="#">0154109</a> | 12        | 26        | 40        | 60        | 54         | 145       | 75        | 54        | M12    | 6.6           |
| ROTA-S plus 2.0 315-92   | SFA 315-C3  | <a href="#">0154110</a> | 12        | 26        | 40        | 100       | 94         | 145       | 75        | 54        | M12    | 11.4          |
| ROTA-S plus 2.0 315-92   | SFA 315-C4  | <a href="#">0154111</a> | 12        | 26        | 40        | 120       | 114        | 145       | 75        | 54        | M12    | 13.8          |
| ROTA-S plus 2.0 315-92   | SFA 315-C5  | <a href="#">0154112</a> | 12        | 26        | 40        | 150       | 144        | 145       | 75        | 54        | M12    | 17.5          |
| ROTA-S plus 2.0 315-92   | SFA 315-C51 | <a href="#">0154123</a> | 12        | 26        | 50        | 80        | 74         | 145       | 75        | 54        | M12    | 11.4          |
| ROTA-S plus 2.0 315-92   | SFA 315-C6  | <a href="#">0154113</a> | 12        | 26        | 60        | 60        | 54         | 110       | 40        | 54        | M12    | 7.6           |
| ROTA-S plus 2.0 315-92   | SFA 315-C7  | <a href="#">0154114</a> | 12        | 26        | 80        | 60        | 54         | 110       | 40        | 54        | M12    | 10.3          |
| ROTA-S plus 2.0 315-92   | SFA 315-C8  | <a href="#">0154115</a> | 12        | 26        | 80        | 80        | 74         | 110       | 40        | 54        | M12    | 14.0          |
| ROTA-S plus 2.0 315-92/2 | SFA 315     | <a href="#">0153103</a> | 12        | 26        | 35        | 60        | 54         | 145       | 60        | 54        | M12    | 5.6           |
| ROTA-S plus 2.0 315-92/2 | SFA-AL 315  | <a href="#">0172104</a> | 12        | 26        | 40        | 60        | 54         | 145       | 60        | 54        | M12    | 2.4           |
| ROTA-S plus 2.0 315-92/2 | SFA 315-C1  | <a href="#">0154108</a> | 12        | 26        | 40        | 60        | 54         | 110       | 40        | 54        | M12    | 4.9           |
| ROTA-S plus 2.0 315-92/2 | SFA 315-C2  | <a href="#">0154109</a> | 12        | 26        | 40        | 60        | 54         | 145       | 75        | 54        | M12    | 6.6           |
| ROTA-S plus 2.0 315-92/2 | SFA 315-C3  | <a href="#">0154110</a> | 12        | 26        | 40        | 100       | 94         | 145       | 75        | 54        | M12    | 11.4          |
| ROTA-S plus 2.0 315-92/2 | SFA 315-C4  | <a href="#">0154111</a> | 12        | 26        | 40        | 120       | 114        | 145       | 75        | 54        | M12    | 13.8          |
| ROTA-S plus 2.0 315-92/2 | SFA 315-C5  | <a href="#">0154112</a> | 12        | 26        | 40        | 150       | 144        | 145       | 75        | 54        | M12    | 17.5          |
| ROTA-S plus 2.0 315-92/2 | SFA 315-C51 | <a href="#">0154123</a> | 12        | 26        | 50        | 80        | 74         | 145       | 75        | 54        | M12    | 11.4          |
| ROTA-S plus 2.0 315-92/2 | SFA 315-C6  | <a href="#">0154113</a> | 12        | 26        | 60        | 60        | 54         | 110       | 40        | 54        | M12    | 7.6           |
| ROTA-S plus 2.0 315-92/2 | SFA 315-C7  | <a href="#">0154114</a> | 12        | 26        | 80        | 60        | 54         | 110       | 40        | 54        | M12    | 10.3          |
| ROTA-S plus 2.0 315-92/2 | SFA 315-C8  | <a href="#">0154115</a> | 12        | 26        | 80        | 80        | 74         | 110       | 40        | 54        | M12    | 14.0          |
| ROTA-S plus 400-102      | SFA 400     | <a href="#">0153104</a> | 18        | 30        | 50        | 80        | 73         | 180       | 85        | 60        | M16    | 13.7          |
| ROTA-S plus 400-102      | SFA-AL 400  | <a href="#">0172105</a> | 18        | 30        | 50        | 80        | 73         | 180       | 85        | 60        | M16    | 6.3           |
| ROTA-S plus 400-102      | SFA 400-C1  | <a href="#">0154116</a> | 18        | 30        | 60        | 80        | 73         | 130       | 50        | 60        | M16    | 11.8          |
| ROTA-S plus 400-102      | SFA 400-C3  | <a href="#">0154118</a> | 18        | 30        | 60        | 100       | 93         | 155       | 75        | 60        | M16    | 18.2          |
| ROTA-S plus 400-102      | SFA 400-C4  | <a href="#">0154119</a> | 18        | 30        | 60        | 120       | 113        | 155       | 75        | 60        | M16    | 22.1          |
| ROTA-S plus 400-102      | SFA 400-C5  | <a href="#">0154120</a> | 18        | 30        | 80        | 80        | 73         | 130       | 50        | 60        | M16    | 16.0          |
| ROTA-S plus 400-102      | SFA 400-C6  | <a href="#">0154125</a> | 18        | 30        | 58        | 180       | 173        | 160       | 80        | 60        | M16    | 33.6          |
| ROTA-S plus 400-102      | SFA 400-C7  | <a href="#">0154135</a> | 18        | 30        | 96        | 115       | 108        | 115       | 35        | 60        | M16    | 25.2          |
| ROTA-S plus 500-162      | SFA 400     | <a href="#">0153104</a> | 18        | 30        | 50        | 80        | 73         | 180       | 85        | 60        | M16    | 13.7          |
| ROTA-S plus 500-162      | SFA-AL 400  | <a href="#">0172105</a> | 18        | 30        | 50        | 80        | 73         | 180       | 85        | 60        | M16    | 6.3           |
| ROTA-S plus 500-162      | SFA 400-C1  | <a href="#">0154116</a> | 18        | 30        | 60        | 80        | 73         | 130       | 50        | 60        | M16    | 11.8          |
| ROTA-S plus 500-162      | SFA 400-C3  | <a href="#">0154118</a> | 18        | 30        | 60        | 100       | 93         | 155       | 75        | 60        | M16    | 18.2          |
| ROTA-S plus 500-162      | SFA 400-C4  | <a href="#">0154119</a> | 18        | 30        | 60        | 120       | 113        | 155       | 75        | 60        | M16    | 22.1          |
| ROTA-S plus 500-162      | SFA 400-C5  | <a href="#">0154120</a> | 18        | 30        | 80        | 80        | 73         | 130       | 50        | 60        | M16    | 16.0          |
| ROTA-S plus 500-162      | SFA 400-C6  | <a href="#">0154125</a> | 18        | 30        | 58        | 180       | 173        | 160       | 80        | 60        | M16    | 33.6          |
| ROTA-S plus 500-162      | SFA 400-C7  | <a href="#">0154135</a> | 18        | 30        | 96        | 115       | 108        | 115       | 35        | 60        | M16    | 25.2          |
| ROTA-S plus 630-252      | SFA 630     | <a href="#">0153106</a> | 24        | 40        | 65        | 118       | 110        | 260       | 129       | 82        | M20    | 39.6          |
| ROTA-S plus 630-252      | SFA-AL 630  | <a href="#">0172106</a> | 24        | 40        | 65        | 118       | 110        | 260       | 129       | 82        | M20    | 14.2          |
| ROTA-S plus 800-252      | SFA 630     | <a href="#">0153106</a> | 24        | 40        | 65        | 118       | 110        | 260       | 129       | 82        | M20    | 39.6          |
| ROTA-S plus 800-252      | SFA-AL 630  | <a href="#">0172106</a> | 24        | 40        | 65        | 118       | 110        | 260       | 129       | 82        | M20    | 14.2          |
| ROTA-S plus 1000-402     | SFA 630     | <a href="#">0153106</a> | 24        | 40        | 65        | 118       | 110        | 260       | 129       | 82        | M20    | 39.6          |
| ROTA-S plus 1000-402     | SFA 1000    | <a href="#">0153108</a> | 24        | 40        | 76        | 150       | 142        | 350       | 219       | 82        | M20    | 81.8          |
| ROTA-S plus 1000-402     | SFA-AL 1000 | <a href="#">0172108</a> | 24        | 40        | 80        | 155       | 147        | 350       | 219       | 82        | M20    | 32.0          |

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

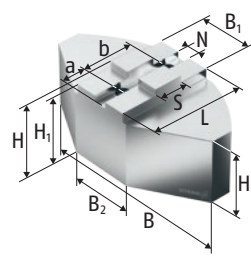
## Hard stepped top jaws, Full grip jaws with tongue and groove



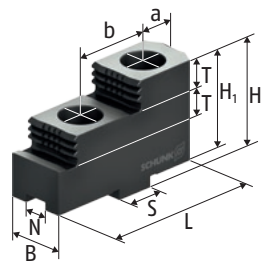
SHF  
Hard stepped top jaws



SFA-SM  
Full grip jaws



SFA-SA  
Full grip jaws



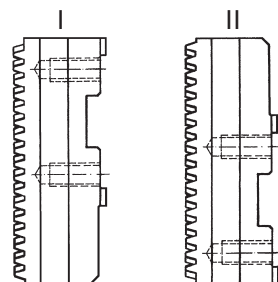
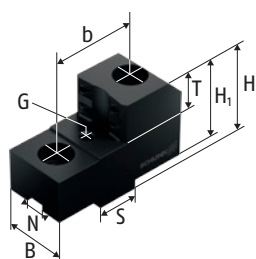
SHF  
Hard stepped top jaws

### Technical data

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

## Claw jaws

with tongue and groove



SZKA  
Claw jaws

Position of base jaws

## Technical data

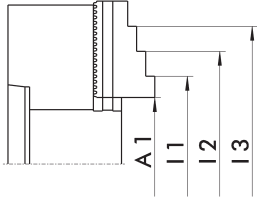
| Chuck type               | Clamping range ØD | Swing diameter SDmax | Position of base jaws | Description | ID      | N    | S    | B    | H    | H1   | L    | T    | G  | b    | Screws | m/SET |
|--------------------------|-------------------|----------------------|-----------------------|-------------|---------|------|------|------|------|------|------|------|----|------|--------|-------|
|                          | [mm]              | [mm]                 |                       |             |         | [mm] | [mm] | [mm] | [mm] | [mm] | [mm] | [mm] |    | [mm] |        | [kg]  |
| ROTA-S plus 2.0 160-42   | 89 - 135          | 220                  | I                     | SZKA 163    | 0165146 | 8    | 18   | 40   | 44   | 40   | 60   | 20   | M6 | 32   | M8     | 1.5   |
| ROTA-S plus 2.0 160-42   | 140 - 186         | 250                  | I                     | SZKA 167    | 0165150 | 8    | 18   | 30   | 44   | 40   | 76   | 20   | M6 | 32   | M8     | 1.3   |
| ROTA-S plus 2.0 160-42   | 42 - 87           | 210                  | I                     | SZKA 169    | 0165174 | 8    | 18   | 26   | 44   | 40   | 71   | 20   | M6 | 32   | M8     | 1.0   |
| ROTA-S plus 2.0 160-42   | 54 - 99           | 209                  | II                    | SZKA 163    | 0165146 | 8    | 18   | 40   | 44   | 40   | 60   | 20   | M6 | 32   | M8     | 1.5   |
| ROTA-S plus 2.0 160-42   | 104 - 150         | 215                  | II                    | SZKA 167    | 0165150 | 8    | 18   | 30   | 44   | 40   | 76   | 20   | M6 | 32   | M8     | 1.3   |
| ROTA-S plus 2.0 160-42   | 26 - 52           | 209                  | II                    | SZKA 169    | 0165174 | 8    | 18   | 26   | 44   | 40   | 71   | 20   | M6 | 32   | M8     | 1.0   |
| ROTA-S plus 2.0 160-42/2 | 89 - 135          | 220                  | I                     | SZKA 163    | 0165146 | 8    | 18   | 40   | 44   | 40   | 60   | 20   | M6 | 32   | M8     | 1.5   |
| ROTA-S plus 2.0 160-42/2 | 140 - 186         | 250                  | I                     | SZKA 167    | 0165150 | 8    | 18   | 30   | 44   | 40   | 76   | 20   | M6 | 32   | M8     | 1.3   |
| ROTA-S plus 2.0 160-42/2 | 42 - 87           | 210                  | I                     | SZKA 169    | 0165174 | 8    | 18   | 26   | 44   | 40   | 71   | 20   | M6 | 32   | M8     | 1.0   |
| ROTA-S plus 2.0 160-42/2 | 54 - 99           | 209                  | II                    | SZKA 163    | 0165146 | 8    | 18   | 40   | 44   | 40   | 60   | 20   | M6 | 32   | M8     | 1.5   |
| ROTA-S plus 2.0 160-42/2 | 104 - 150         | 215                  | II                    | SZKA 167    | 0165150 | 8    | 18   | 30   | 44   | 40   | 76   | 20   | M6 | 32   | M8     | 1.3   |
| ROTA-S plus 2.0 160-42/2 | 26 - 52           | 209                  | II                    | SZKA 169    | 0165174 | 8    | 18   | 26   | 44   | 40   | 71   | 20   | M6 | 32   | M8     | 1.0   |
| ROTA-S plus 2.0 200-52   | 29 - 95           | 264                  | I                     | SZKA 212    | 0139153 | 10   | 20   | 26   | 49   | 45   | 93   | 25   | M6 | 40   | M8     | 1.4   |
| ROTA-S plus 2.0 200-52   | 104 - 170         | 264                  | I                     | SZKA 213    | 0139154 | 10   | 20   | 30   | 49   | 45   | 67   | 25   | M6 | 40   | M8     | 1.3   |
| ROTA-S plus 2.0 200-52   | 139 - 205         | 270                  | I                     | SZKA 216    | 0139159 | 10   | 20   | 30   | 49   | 45   | 70   | 25   | M6 | 40   | M8     | 1.2   |
| ROTA-S plus 2.0 200-52   | 25 - 47           | 263                  | II                    | SZKA 212    | 0139153 | 10   | 20   | 26   | 49   | 45   | 93   | 25   | M6 | 40   | M8     | 1.4   |
| ROTA-S plus 2.0 200-52   | 63 - 122          | 263                  | II                    | SZKA 213    | 0139154 | 10   | 20   | 30   | 49   | 45   | 67   | 25   | M6 | 40   | M8     | 1.3   |
| ROTA-S plus 2.0 200-52   | 98 - 157          | 263                  | II                    | SZKA 216    | 0139159 | 10   | 20   | 30   | 49   | 45   | 70   | 25   | M6 | 40   | M8     | 1.2   |
| ROTA-S plus 2.0 200-52/2 | 29 - 95           | 264                  | I                     | SZKA 212    | 0139153 | 10   | 20   | 26   | 49   | 45   | 93   | 25   | M6 | 40   | M8     | 1.4   |
| ROTA-S plus 2.0 200-52/2 | 104 - 170         | 264                  | I                     | SZKA 213    | 0139154 | 10   | 20   | 30   | 49   | 45   | 67   | 25   | M6 | 40   | M8     | 1.3   |
| ROTA-S plus 2.0 200-52/2 | 139 - 205         | 270                  | I                     | SZKA 216    | 0139159 | 10   | 20   | 30   | 49   | 45   | 70   | 25   | M6 | 40   | M8     | 1.2   |
| ROTA-S plus 2.0 200-52/2 | 25 - 47           | 263                  | II                    | SZKA 212    | 0139153 | 10   | 20   | 26   | 49   | 45   | 93   | 25   | M6 | 40   | M8     | 1.4   |
| ROTA-S plus 2.0 200-52/2 | 63 - 122          | 263                  | II                    | SZKA 213    | 0139154 | 10   | 20   | 30   | 49   | 45   | 67   | 25   | M6 | 40   | M8     | 1.3   |
| ROTA-S plus 2.0 200-52/2 | 98 - 157          | 263                  | II                    | SZKA 216    | 0139159 | 10   | 20   | 30   | 49   | 45   | 70   | 25   | M6 | 40   | M8     | 1.2   |
| ROTA-S plus 2.0 250-62   | 90 - 172          | 326                  | I                     | SZKA 263    | 0139160 | 12   | 20   | 30   | 55   | 50   | 85   | 25   | M6 | 40   | M12    | 1.5   |
| ROTA-S plus 2.0 250-62   | 147 - 230         | 327                  | I                     | SZKA 266    | 0139163 | 12   | 20   | 40   | 55   | 50   | 74   | 25   | M6 | 40   | M12    | 1.9   |
| ROTA-S plus 2.0 250-62   | 181 - 263         | 341                  | I                     | SZKA 268    | 0139165 | 12   | 20   | 40   | 55   | 50   | 83   | 25   | M6 | 40   | M12    | 2.2   |
| ROTA-S plus 2.0 250-62   | 31 - 97           | 322                  | II                    | SZKA 263    | 0139160 | 12   | 20   | 30   | 55   | 50   | 85   | 25   | M6 | 40   | M12    | 1.5   |
| ROTA-S plus 2.0 250-62   | 73 - 154          | 322                  | II                    | SZKA 266    | 0139163 | 12   | 20   | 40   | 55   | 50   | 74   | 25   | M6 | 40   | M12    | 1.9   |
| ROTA-S plus 2.0 250-62   | 118 - 188         | 322                  | II                    | SZKA 268    | 0139165 | 12   | 20   | 40   | 55   | 50   | 83   | 25   | M6 | 40   | M12    | 2.2   |
| ROTA-S plus 2.0 250-62/2 | 90 - 172          | 326                  | I                     | SZKA 263    | 0139160 | 12   | 20   | 30   | 55   | 50   | 85   | 25   | M6 | 40   | M12    | 1.5   |
| ROTA-S plus 2.0 250-62/2 | 147 - 230         | 327                  | I                     | SZKA 266    | 0139163 | 12   | 20   | 40   | 55   | 50   | 74   | 25   | M6 | 40   | M12    | 1.9   |
| ROTA-S plus 2.0 250-62/2 | 181 - 263         | 341                  | I                     | SZKA 268    | 0139165 | 12   | 20   | 40   | 55   | 50   | 83   | 25   | M6 | 40   | M12    | 2.2   |
| ROTA-S plus 2.0 250-62/2 | 31 - 97           | 322                  | II                    | SZKA 263    | 0139160 | 12   | 20   | 30   | 55   | 50   | 85   | 25   | M6 | 40   | M12    | 1.5   |
| ROTA-S plus 2.0 250-62/2 | 73 - 154          | 322                  | II                    | SZKA 266    | 0139163 | 12   | 20   | 40   | 55   | 50   | 74   | 25   | M6 | 40   | M12    | 1.9   |
| ROTA-S plus 2.0 250-62/2 | 118 - 188         | 322                  | II                    | SZKA 268    | 0139165 | 12   | 20   | 40   | 55   | 50   | 83   | 25   | M6 | 40   | M12    | 2.2   |
| ROTA-S plus 2.0 315-92   | 83 - 197          | 389                  | I                     | SZKA 321    | 0139166 | 12   | 26   | 40   | 59   | 53   | 108  | 25   | M8 | 54   | M12    | 3.1   |
| ROTA-S plus 2.0 315-92   | 190 - 305         | 397                  | I                     | SZKA 324    | 0139169 | 12   | 26   | 40   | 59   | 53   | 90   | 25   | M8 | 54   | M12    | 2.8   |
| ROTA-S plus 2.0 315-92   | 43 - 118          | 386                  | II                    | SZKA 321    | 0139166 | 12   | 26   | 40   | 59   | 53   | 108  | 25   | M8 | 54   | M12    | 3.1   |

| Chuck type               | Clamping range ØD | Swing diameter SDmax | Position of base jaws | Description | ID                      | N    | S    | B    | H    | H1   | L    | T    | G  | b    | Screws | m/SET |
|--------------------------|-------------------|----------------------|-----------------------|-------------|-------------------------|------|------|------|------|------|------|------|----|------|--------|-------|
|                          | [mm]              | [mm]                 |                       |             |                         | [mm] | [mm] | [mm] | [mm] | [mm] | [mm] | [mm] |    | [mm] |        | [kg]  |
| ROTA-S plus 2.0 315-92   | 118 - 226         | 386                  | II                    | SZKA 324    | <a href="#">0139169</a> | 12   | 26   | 40   | 59   | 53   | 90   | 25   | M8 | 54   | M12    | 2.8   |
| ROTA-S plus 2.0 315-92/2 | 83 - 197          | 389                  | I                     | SZKA 321    | <a href="#">0139166</a> | 12   | 26   | 40   | 59   | 53   | 108  | 25   | M8 | 54   | M12    | 3.1   |
| ROTA-S plus 2.0 315-92/2 | 190 - 305         | 397                  | I                     | SZKA 324    | <a href="#">0139169</a> | 12   | 26   | 40   | 59   | 53   | 90   | 25   | M8 | 54   | M12    | 2.8   |
| ROTA-S plus 2.0 315-92/2 | 43 - 118          | 386                  | II                    | SZKA 321    | <a href="#">0139166</a> | 12   | 26   | 40   | 59   | 53   | 108  | 25   | M8 | 54   | M12    | 3.1   |
| ROTA-S plus 2.0 315-92/2 | 118 - 226         | 386                  | II                    | SZKA 324    | <a href="#">0139169</a> | 12   | 26   | 40   | 59   | 53   | 90   | 25   | M8 | 54   | M12    | 2.8   |
| ROTA-S plus 400-102      | 131 - 271         | 494                  | I                     | SZKA 409    | <a href="#">0139170</a> | 18   | 30   | 50   | 78   | 71   | 126  | 33   | M8 | 60   | M16    | 6.0   |
| ROTA-S plus 400-102      | 232 - 373         | 494                  | I                     | SZKA 412    | <a href="#">0139173</a> | 18   | 30   | 50   | 78   | 71   | 103  | 33   | M8 | 60   | M16    | 5.1   |
| ROTA-S plus 400-102      | 50 - 154          | 495                  | II                    | SZKA 409    | <a href="#">0139170</a> | 18   | 30   | 50   | 78   | 71   | 126  | 33   | M8 | 60   | M16    | 6.0   |
| ROTA-S plus 400-102      | 123 - 255         | 495                  | II                    | SZKA 412    | <a href="#">0139173</a> | 18   | 30   | 50   | 78   | 71   | 103  | 33   | M8 | 60   | M16    | 5.1   |
| ROTA-S plus 500-162      | 132 - 356         | 579                  | I                     | SZKA 409    | <a href="#">0139170</a> | 18   | 30   | 50   | 78   | 71   | 126  | 33   | M8 | 60   | M16    | 6.0   |
| ROTA-S plus 500-162      | 233 - 458         | 579                  | I                     | SZKA 412    | <a href="#">0139173</a> | 18   | 30   | 50   | 78   | 71   | 103  | 33   | M8 | 60   | M16    | 5.1   |
| ROTA-S plus 500-162      | 50 - 238          | 580                  | II                    | SZKA 409    | <a href="#">0139170</a> | 18   | 30   | 50   | 78   | 71   | 126  | 33   | M8 | 60   | M16    | 6.0   |
| ROTA-S plus 500-162      | 123 - 340         | 580                  | II                    | SZKA 412    | <a href="#">0139173</a> | 18   | 30   | 50   | 78   | 71   | 103  | 33   | M8 | 60   | M16    | 5.1   |
| ROTA-S plus 630-252      | 281 - 544         | 766                  | I                     | SZKA 409    | <a href="#">0139170</a> | 18   | 30   | 50   | 78   | 71   | 126  | 33   | M8 | 60   | M16    | 6.0   |
| ROTA-S plus 630-252      | 383 - 646         | 766                  | I                     | SZKA 412    | <a href="#">0139173</a> | 18   | 30   | 50   | 78   | 71   | 103  | 33   | M8 | 60   | M16    | 5.1   |
| ROTA-S plus 630-252      | 202 - 466         | 769                  | I                     | SZKA 631    | <a href="#">0139200</a> | 24   | 40   | 65   | 97   | 89   | 173  | 42   | M8 | 82   | M20    | 13.5  |
| ROTA-S plus 630-252      | 362 - 626         | 769                  | I                     | SZKA 632    | <a href="#">0139201</a> | 24   | 40   | 65   | 97   | 89   | 145  | 42   | M8 | 82   | M20    | 11.8  |
| ROTA-S plus 630-252      | 50 - 287          | 770                  | II                    | SZKA 409    | <a href="#">0139170</a> | 18   | 30   | 50   | 78   | 71   | 126  | 33   | M8 | 60   | M16    | 6.0   |
| ROTA-S plus 630-252      | 125 - 389         | 770                  | II                    | SZKA 412    | <a href="#">0139173</a> | 18   | 30   | 50   | 78   | 71   | 103  | 33   | M8 | 60   | M16    | 5.1   |
| ROTA-S plus 630-252      | 81 - 297          | 771                  | II                    | SZKA 631    | <a href="#">0139200</a> | 24   | 40   | 65   | 97   | 89   | 173  | 42   | M8 | 82   | M20    | 13.5  |
| ROTA-S plus 630-252      | 194 - 457         | 771                  | II                    | SZKA 632    | <a href="#">0139201</a> | 24   | 40   | 65   | 97   | 89   | 145  | 42   | M8 | 82   | M20    | 11.8  |
| ROTA-S plus 800-252      | 281 - 578         | 800                  | I                     | SZKA 409    | <a href="#">0139170</a> | 18   | 30   | 50   | 78   | 71   | 126  | 33   | M8 | 60   | M16    | 6.0   |
| ROTA-S plus 800-252      | 383 - 680         | 800                  | I                     | SZKA 412    | <a href="#">0139173</a> | 18   | 30   | 50   | 78   | 71   | 103  | 33   | M8 | 60   | M16    | 5.1   |
| ROTA-S plus 800-252      | 269 - 569         | 872                  | I                     | SZKA 631    | <a href="#">0139200</a> | 24   | 40   | 65   | 97   | 89   | 173  | 42   | M8 | 82   | M20    | 13.5  |
| ROTA-S plus 800-252      | 430 - 729         | 872                  | I                     | SZKA 632    | <a href="#">0139201</a> | 24   | 40   | 65   | 97   | 89   | 145  | 42   | M8 | 82   | M20    | 11.8  |
| ROTA-S plus 800-252      | 50 - 324          | 807                  | II                    | SZKA 409    | <a href="#">0139170</a> | 18   | 30   | 50   | 78   | 71   | 126  | 33   | M8 | 60   | M16    | 6.0   |
| ROTA-S plus 800-252      | 125 - 425         | 807                  | II                    | SZKA 412    | <a href="#">0139173</a> | 18   | 30   | 50   | 78   | 71   | 103  | 33   | M8 | 60   | M16    | 5.1   |
| ROTA-S plus 800-252      | 81 - 331          | 873                  | II                    | SZKA 631    | <a href="#">0139200</a> | 24   | 40   | 65   | 97   | 89   | 173  | 42   | M8 | 82   | M20    | 13.5  |
| ROTA-S plus 800-252      | 194 - 491         | 873                  | II                    | SZKA 632    | <a href="#">0139201</a> | 24   | 40   | 65   | 97   | 89   | 145  | 42   | M8 | 82   | M20    | 11.8  |
| ROTA-S plus 1000-402     | 388 - 876         | 1179                 | I                     | SZKA 631    | <a href="#">0139200</a> | 24   | 40   | 65   | 97   | 89   | 173  | 42   | M8 | 82   | M20    | 13.5  |
| ROTA-S plus 1000-402     | 549 - 1037        | 1179                 | I                     | SZKA 632    | <a href="#">0139201</a> | 24   | 40   | 65   | 97   | 89   | 145  | 42   | M8 | 82   | M20    | 11.8  |
| ROTA-S plus 1000-402     | 81 - 537          | 1179                 | II                    | SZKA 631    | <a href="#">0139200</a> | 24   | 40   | 65   | 97   | 89   | 173  | 42   | M8 | 82   | M20    | 13.5  |
| ROTA-S plus 1000-402     | 212 - 697         | 1179                 | II                    | SZKA 632    | <a href="#">0139201</a> | 24   | 40   | 65   | 97   | 89   | 145  | 42   | M8 | 82   | M20    | 11.8  |

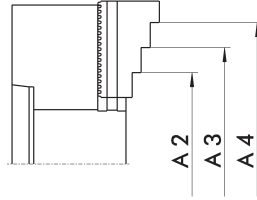
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](http://schunk.com)

## Hard stepped block jaws

with tongue and groove



Jaw position I



Jaw position II

### O.D. clamping

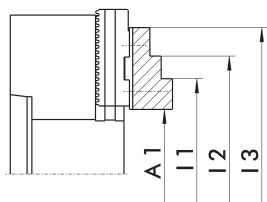
| Chuck type             | Description | ID      | A1<br>[mm] | A2<br>[mm] | A3<br>[mm] | A4<br>[mm] |
|------------------------|-------------|---------|------------|------------|------------|------------|
| ROTA-S plus 2.0 160-42 | STF 160     | 0161100 | 7 - 49     | 47 - 93    | 92 - 138   | 117 -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

### I.D. clamping

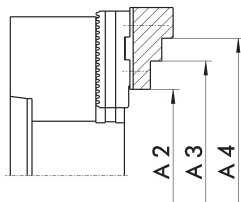
| Chuck type             | Description | ID      | I1<br>[mm] | I2<br>[mm] | I3<br>[mm] |
|------------------------|-------------|---------|------------|------------|------------|
| ROTA-S plus 2.0 160-42 | STF 160     | 0161100 | 62 - 104   | 87 - 129   | 132 - 174  |
| ROTA-S plus 2.0 200-52 | STF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

## Hard stepped top jaws

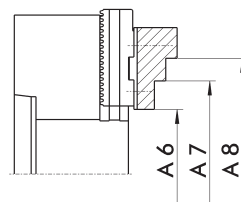
with tongue and groove



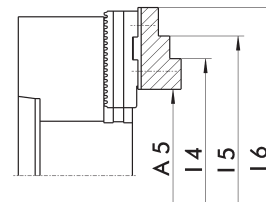
Position of base jaws II



Position of base jaws I



Position of base jaws II



Position of base jaws I

### O.D. clamping

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

### I.D. clamping

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

## Accessories

### Clamping force tester

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



| Suitable for             | Description | ID                      |
|--------------------------|-------------|-------------------------|
| ROTA-S plus 2.0 160-42   |             |                         |
| ROTA-S plus 2.0 160-42/2 |             |                         |
| ROTA-S plus 2.0 200-52   |             |                         |
| ROTA-S plus 2.0 200-52/2 |             |                         |
| ROTA-S plus 2.0 250-62   |             |                         |
| ROTA-S plus 2.0 250-62/2 |             |                         |
| ROTA-S plus 2.0 315-92   |             |                         |
| ROTA-S plus 2.0 315-92/2 |             |                         |
| ROTA-S plus 400-102      |             |                         |
| ROTA-S plus 500-162      |             |                         |
| ROTA-S plus 630-252      |             |                         |
| ROTA-S plus 800-252      |             |                         |
| ROTA-S plus 1000-402     | IFT Set     | <a href="#">1404235</a> |

### Extension set for large chucks

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



| Suitable for         | Description     | ID                      |
|----------------------|-----------------|-------------------------|
| ROTA-S plus 400-102  |                 |                         |
| ROTA-S plus 500-162  |                 |                         |
| ROTA-S plus 630-252  |                 |                         |
| ROTA-S plus 800-252  |                 |                         |
| ROTA-S plus 1000-402 | IFT adapter set | <a href="#">1498512</a> |

### Maintenance kit

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



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

### Torque wrench

Torque wrench for actuation of SCHUNK manual lathe chucks.



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

### Hexagon actuation wrench

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



| Suitable for             | Description     | ID                      |
|--------------------------|-----------------|-------------------------|
| ROTA-S plus 2.0 160-42   |                 |                         |
| ROTA-S plus 2.0 160-42/2 |                 |                         |
| ROTA-S plus 2.0 200-52   |                 |                         |
| ROTA-S plus 2.0 200-52/2 | SSH-SK SW12-160 | <a href="#">1330869</a> |
| ROTA-S plus 2.0 160-42   |                 |                         |
| ROTA-S plus 2.0 160-42/2 |                 |                         |
| ROTA-S plus 2.0 200-52   |                 |                         |
| ROTA-S plus 2.0 200-52/2 | SSH-SL SW12-260 | <a href="#">8704921</a> |
| ROTA-S plus 2.0 250-62   |                 |                         |
| ROTA-S plus 2.0 250-62/2 |                 |                         |
| ROTA-S plus 2.0 315-92   |                 |                         |
| ROTA-S plus 2.0 315-92/2 | SSH-SK SW16-230 | <a href="#">1330894</a> |
| ROTA-S plus 2.0 250-62   |                 |                         |
| ROTA-S plus 2.0 250-62/2 |                 |                         |
| ROTA-S plus 2.0 315-92   |                 |                         |
| ROTA-S plus 2.0 315-92/2 | SSH-SL SW16-330 | <a href="#">8704923</a> |

### Square actuation wrench

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



| Suitable for         | Description     | ID                      |
|----------------------|-----------------|-------------------------|
| ROTA-S plus 400-102  |                 |                         |
| ROTA-S plus 500-162  | SSH-VK SW19-255 | <a href="#">8700131</a> |
| ROTA-S plus 630-252  |                 |                         |
| ROTA-S plus 800-252  |                 |                         |
| ROTA-S plus 1000-402 | SSH-VK SW24-420 | <a href="#">8700132</a> |

### Long square actuation wrench

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



| Suitable for         | Description     | ID                       |
|----------------------|-----------------|--------------------------|
| ROTA-S plus 400-102  |                 |                          |
| ROTA-S plus 500-162  | SSH-VL SW19-420 | <a href="#">8705475</a>  |
| ROTA-S plus 630-252  |                 |                          |
| ROTA-S plus 800-252  |                 |                          |
| ROTA-S plus 1000-402 | SSH-VL SW24-600 | <a href="#">88004486</a> |

### Wrench with pin and movable cross handle

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



| Suitable for        | Description     | ID                       |
|---------------------|-----------------|--------------------------|
| ROTA-S plus 400-102 |                 |                          |
| ROTA-S plus 500-162 | SSH-VQ SW19-255 | <a href="#">88018809</a> |
| ROTA-S plus 630-252 | SSH-VQ SW24-420 | <a href="#">88018579</a> |

### Square connection for torque wrench

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



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

### Consol plate

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



| Suitable for             | Description | ID                      |
|--------------------------|-------------|-------------------------|
| ROTA-S plus 2.0 160-42   |             |                         |
| ROTA-S plus 2.0 160-42/2 | KSL 160     | <a href="#">0814270</a> |
| ROTA-S plus 2.0 200-52   |             |                         |
| ROTA-S plus 2.0 200-52/2 | KSL 200     | <a href="#">0814271</a> |
| ROTA-S plus 2.0 250-62   |             |                         |
| ROTA-S plus 2.0 250-62/2 | KSL 250     | <a href="#">0814272</a> |
| ROTA-S plus 2.0 315-92   |             |                         |
| ROTA-S plus 2.0 315-92/2 | KSL 315     | <a href="#">0814273</a> |

### Sealing plug

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



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

### Chip protection

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



| Suitable for             | Description | ID                      |
|--------------------------|-------------|-------------------------|
| ROTA-S plus 2.0 160-42   |             |                         |
| ROTA-S plus 2.0 160-42/2 |             |                         |
| ROTA-S plus 2.0 200-52   |             |                         |
| ROTA-S plus 2.0 200-52/2 | SPS 160/200 | <a href="#">9966639</a> |
| ROTA-S plus 2.0 250-62   |             |                         |
| ROTA-S plus 2.0 250-62/2 | SPS 250     | <a href="#">9966640</a> |
| ROTA-S plus 2.0 315-92   |             |                         |
| ROTA-S plus 2.0 315-92/2 | SPS 315     | <a href="#">9966641</a> |
| ROTA-S plus 400-102      |             |                         |
| ROTA-S plus 500-162      | SPS 400/500 | <a href="#">9966642</a> |
| ROTA-S plus 630-252      | SPS 630     | <a href="#">9966607</a> |

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 | <a href="#">1342585</a> |
| Can       | LINOMAX plus can       | <a href="#">1342586</a> |
| Bucket    | LINOMAX plus bucket    | <a href="#">1342587</a> |

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  | <a href="#">9900543</a> |



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