



ROTA-G

Jaw quick-change chuck with
straight serrated base jaw
interface

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

The ROTA-G manual lathe chuck is designed for storage solutions and conventional lathes without hydraulic or pneumatic cylinders. Due to the base jaws with straight serration, this chuck is compatible with the ROTA THW3 and ROTA THW plus power lathe chucks, as well as the "R" system (Reishauer). Thanks to the quick-change system, the lathe chucks are suitable for flexible production from batch size 1 and there is no need to rebores the jaws on the chuck.



Advantages – Your benefits

- + Convenient jaw quick-change system**
Minimizing set-up times and costs
- + Hardened and extremely rigid base body**
Therefore a longer service life at highest precision.
Even with maximum clamping force
- + 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
- + Excellent clamping force/torque ratio**
Perfect use of the machine performance
- + Straight serrated base jaws GBK are compatible to system "R" (Reishauer)**
Flexible clamping of small and large workpieces
- + Ergonomic, light safety spanner wrench**
Ensures easy operation
- + Very easy handling**
Optimal operator convenience
- + All sides of the functional parts are hardened and ground**
High run-out and jaw change repeat accuracy

Technical data

Description	Max. rotational speed [min ⁻¹]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Through-hole [mm]
ROTA-G 200-62	4600	95	90	6.8	62
ROTA-G 250-82	4000	160	200	7.1	82
ROTA-G 315-102	3200	200	210	8.5	102

Technical data

Spindle type	Spindle size	ID	Max. rotational speed [min ⁻¹]	Max. clamping force [kN]	Max. torque [Nm]	Weight [kg]
-	Z300	0815030	3200	200	210	52
ISO 702-3	Nr. 6	0815031	3200	200	210	65.7
ISO 702-3	Nr. 8	0815032	3200	200	210	65.7
ISO 702-3	Nr. 11	0815033	3200	200	210	64.5
ISO 702-2	Nr. 6	0815034	3200	200	210	65
ISO 702-2	Nr. 8	0815035	3200	200	210	69
ISO 702-2	Nr. 11	0815036	3200	200	210	68.7
ISO 702-1	Nr. 6	0815037	3200	200	210	63.3
ISO 702-1	Nr. 8	0815038	3200	200	210	61.9
ISO 702-1	Nr. 11	0815039	3200	200	210	62

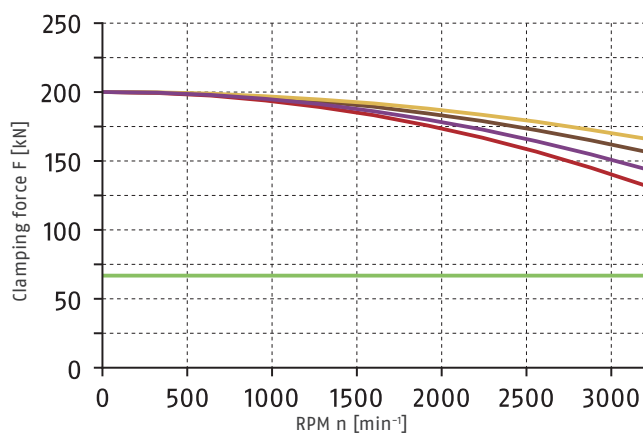
Scope of delivery

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

Further technical data

Chuck type	Through-hole [mm]	Stroke/jaw [mm]	Tooth pitch [mm]	Center jaw height [mm]
ROTA-G 315-102	102	8.5	5.5	69

Clamping force-RPM-diagram



Required minimum clamping force F_{spmin} 33%

SHF 250
1.9 kg



SFA 250
3.7 kg



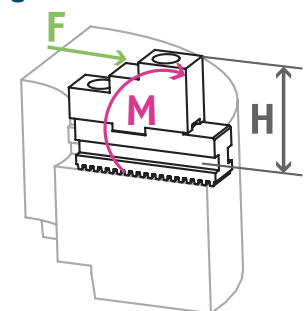
GST 315
3.5 kg



UVB 315
7.6 kg

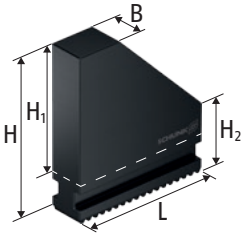


Load of base jaw guidance

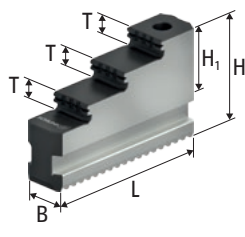


$$M_{max} = 4600 \text{ Nm}$$

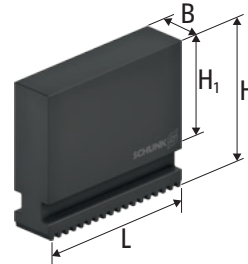
Base jaws, Hard stepped block jaws, Soft monoblock jaws with straight serration



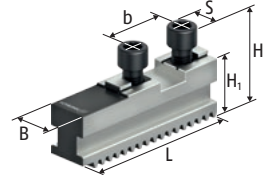
UVB-HS
Soft monoblock jaws



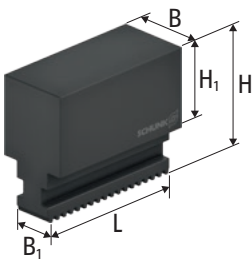
GST
Hard stepped block jaws



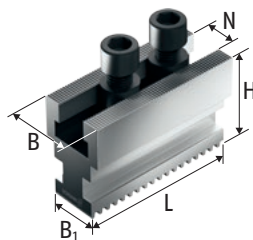
UVB
Soft monoblock jaws



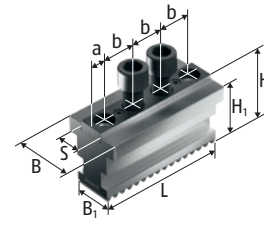
GBK
Base jaws



UVB-B
Soft monoblock jaws



STB-G
Base jaws



STN
Base jaws

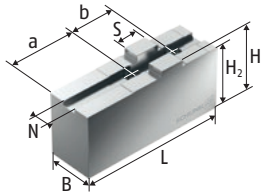
Technical data

Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	B1 [mm]	H [mm]	H1 [mm]	H2 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-G 315-102	UVB 315	0164102			32		90	56		121					7.6
ROTA-G 315-102	UVB-B 315	0164115			46	32	90	52		121					9.6
ROTA-G 315-102	UVB-H 315	0164118			32		135	101		121					11.6
ROTA-G 315-102	UVB-HS 315	0164121			32		135	101	52	121					9.0
ROTA-G 315-102	GBK 315	0159102	20	12	32		46	43		115			40	M12	3.0
ROTA-G 315-102	GBKL 315	0159122	20	12	32		46	43		137			40	M12	3.5
ROTA-G 315-102	GBK-V 315	0159152	20	12	32		46	43		115			40	M12	3.0
ROTA-G 315-102	STB-G 315-2	0160659	21		54	32	76			115				M16	7.5
ROTA-G 315-102	STN 315-6	0160603		21	45	32	58.5	56		110		13	28	M16	4.5
ROTA-G 315-102	STNJ 315-5	0160652		18	50	32	56	54		120		15	30	M14	4.9
ROTA-G 315-102	STNJ 315-6	0160665		21	50	32	60	58		125		17.5	30	M16	5.5
ROTA-G 315-102	GST 315	0162102			32		66	32		116.3	10				3.5

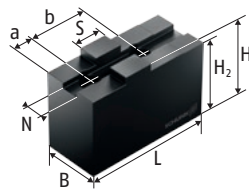
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Soft top jaws

with tongue and groove



SFA-AL
Soft top jaws



SFA
Soft top jaws

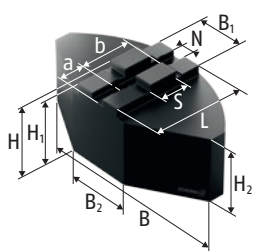
Technical data

Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	H [mm]	H2 [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-G 315-102	SFA 250	0153102	12	20	30	55.5	50.5	125	60	40	M12	3.7
ROTA-G 315-102	SFA-AL 250	0172103	12	20	40	60	55	125	60	40	M12	2.1
ROTA-G 315-102	SFA 250-C1	0154101	12	20	40	60	55	90	34	40	M12	3.9
ROTA-G 315-102	SFA 250-C2	0154102	12	20	40	60	55	125	69	40	M12	5.6
ROTA-G 315-102	SFA 250-C3	0154103	12	20	40	80	75	125	69	40	M12	7.7
ROTA-G 315-102	SFA 250-C4	0154104	12	20	40	100	95	125	69	40	M12	9.8
ROTA-G 315-102	SFA 250-C5	0154105	12	20	40	120	115	125	69	40	M12	11.8
ROTA-G 315-102	SFA 250-C6	0154106	12	20	60	60	55	90	34	40	M12	6.0
ROTA-G 315-102	SFA 250-C7	0154107	12	20	80	60	55	90	34	40	M12	8.5
ROTA-G 315-102	SFA 250-C8	0154134	12	20	80	100	95	125	69	40	M12	20.6

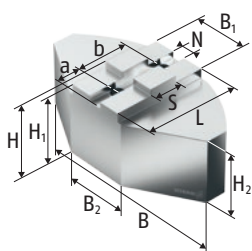
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Hard stepped top jaws, Full grip jaws

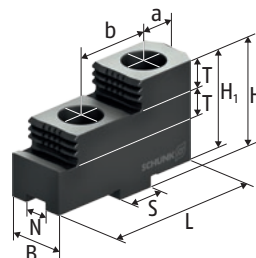
with tongue and groove



SFA-SM
Full grip jaws



SFA-SA
Full grip jaws



SHF
Hard stepped top jaws

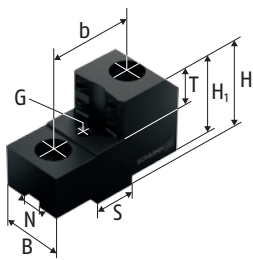
Technical data

Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	B1 [mm]	H [mm]	H1 [mm]	H2 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-G 315-102	SFA-SA 250	0174102	12	20	180	40	58	53	43	87.5		33.75	40	M12	3.4
ROTA-G 315-102	SFA-SA 251	0174106	12	20	180	40	80	75	65	87.5		33.75	40	M12	5.0
ROTA-G 315-102	SFA-SM 250	0173102	12	20	180	40	60	55	45	90		34.5	40	M12	12.8
ROTA-G 315-102	SFA-SM 251	0173106	12	20	180	40	80	75	65	90		35	40	M12	18.9
ROTA-G 315-102	SHF 250	0155102	12	20	30		55	50		90	14	21.1	40	M12	1.9

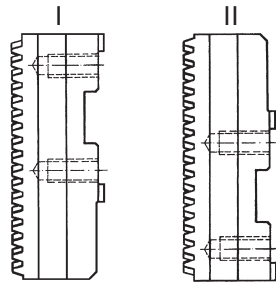
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Claw jaws

with tongue and groove



SZKA
Claw jaws



Position of base jaws

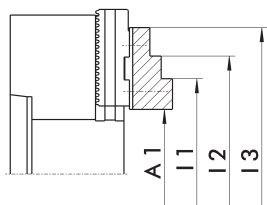
Technical data

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-G 315-102	112 - 233	385	I	SZKA 263	0139160	12	20	30	55	50	85	25	M6	40	M12	1.5
ROTA-G 315-102	203 - 320	408	I	SZKA 268	0139165	12	20	40	55	50	83	25	M6	40	M12	2.2
ROTA-G 315-102	38 - 145	380	II	SZKA 263	0139160	12	20	30	55	50	85	25	M6	40	M12	1.5

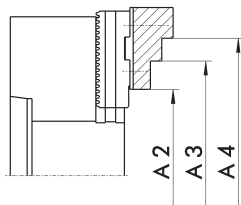
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Hard stepped top jaws

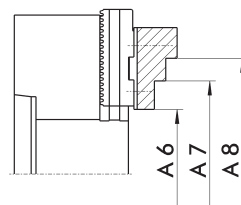
with tongue and groove



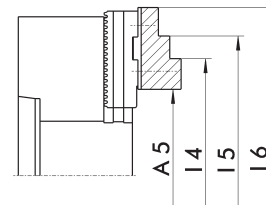
Position of base jaws II



Position of base jaws I



Position of base jaws II



Position of base jaws I

O.D. clamping

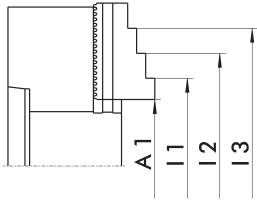
Chuck type	Description	ID	A1 [mm]	A3 [mm]	A4 [mm]	A5 [mm]	A7 [mm]	A8 [mm]
ROTA-G 315-102	SHF 250	0155102	14 - 140	104 - 232	184 - 312	100 - 228	44 - 145	124 - 225

I.D. clamping

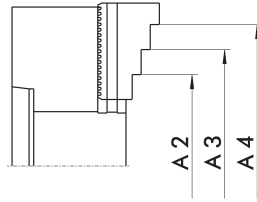
Chuck type	Description	ID	I1 [mm]	I2 [mm]	I4 [mm]
ROTA-G 315-102	SHF 250	0155102	97 - 219	175 - 300	179 - 307

Hard stepped block jaws

with tongue and groove



Jaw position I



Jaw position II

O.D. clamping

Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]
ROTA-G 315-102	GST 315	0162102	8 - 138	77 - 204	133 - 260	189 - 316

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA-G 315-102	GST 315	0162102	68 - 194	122 - 250	177 - 306

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-G 315-102	IFT Set	1404235

Maintenance kit

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



Suitable for	Description	ID
ROTA-G 315-102	WTS-G 315	0899056

Torque wrench

Torque wrench for actuation of SCHUNK manual lathe chucks.



Suitable for	Description	ID
ROTA-G 315-102	SSH-D-1/2" 60-300	1301281

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-G 315-102	SSH-VK SW16-235	8700130

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-G 315-102	SSH-VL SW16-420	88001937

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-G 315-102	SSH-VQ SW16-235	88018577

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-G 315-102	SAV-I 1/2"-SW16	8702916

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-G 315-102	VST Ø102	8702870

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-G 315-102	SPS 315	9966641

Grease

LINOMAX plus

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



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

Grease gun

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



Bundle	Description	ID
Cartridge	Grease gun	9900543



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