

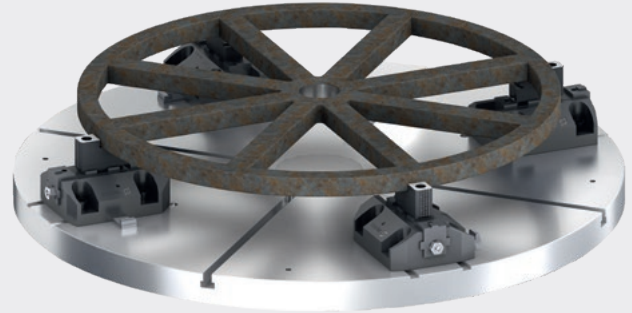


ROTA SPK

**Dirt-resistant jaw boxes with
variable gauge clearance**

Dirt-resistant jaw boxes for individual clamping solutions

SCHUNK's dirt-resistant jaw boxes are specially designed for individual clamping solutions on face plates with T-slots running in parallel. The variable adjustment of the gauge clearance makes it possible for the jaw boxes to be customized to the respective face plate. A completely enclosed jaw drive permanently ensures optimal protection against dust, chips, and coolant.



Advantages – Your benefits

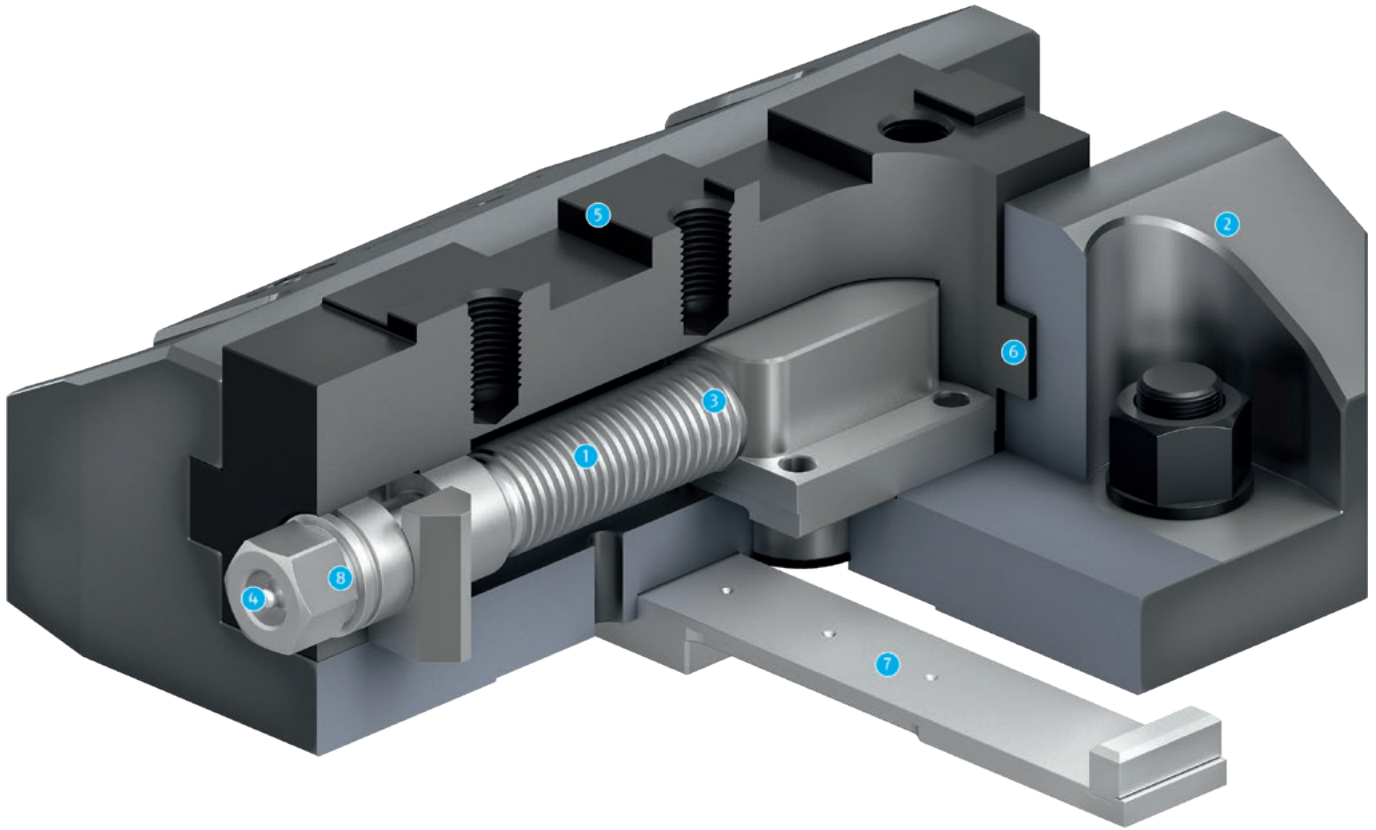
- + Hardened and extremely rigid base body**
Therefore a longer service life at highest precision.
Even with maximum clamping force
- + Base jaws with tongue and groove or fine serration, inch as standard**
High flexibility in the range of top jaws
- + Long jaw stroke and highest jaw clamping force at low tightening torques**
Reliable and variable I.D. and O.D. clamping
- + Base jaw with end-to-end T-slot for fine serration**
Increases the adjustment range of the top jaw
- + Clamping unit with fully sealed drive spindle**
Dirt-resistant and low-maintenance clamping devices
- + Easy to operate**
Fast and precise adjustment by a visible jaw stroke display
- + Low height design**
Maximum use of the machine room and maximum rigidity of the system
- + Variable gauge clearance**
Individual adjustment to suit the face plate of your machine
- + All-sided hardened functional parts**
Ensures a long service life

Technical data

Description	Max. clamping force [kN]	Max. torque [Nm]	Adjustment range chuck jaw [mm]	Possible track width [mm]
SPK 180	55	230	75	140 - 180
SPK 220	68	330	90	180 - 220
SPK 260	75	360	100	220 - 260

Function of SPK

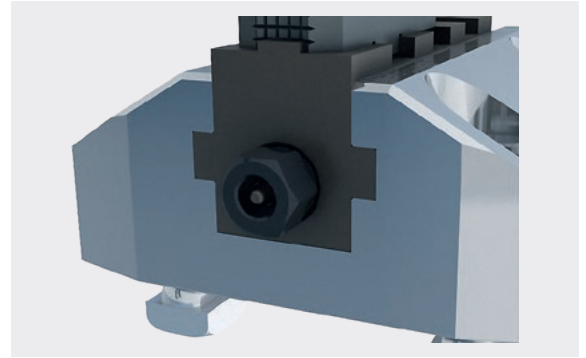
The position of the jaw box on the face plate is pre-set using the crossbar. Turning the thread spindle advances the jaw along its guideway to the workpiece. Direct power transmission ensures that the workpieces are held at the appropriate tightening torque.



- ❶ **Spindle drive**
For the highest of clamping forces
- ❷ **Hardened and extremely rigid base body**
Therefore a longer service life at highest precision.
Even with maximum clamping force
- ❸ **Completely encapsulated spindle**
Offers optimal protection against coolant and chips
- ❹ **Optimized lubrication system**
For a high level of efficiency
- ❺ **Standard jaw interface**
For the use of standard jaws from SCHUNK
- ❻ **Long jaw guidance**
Offers optimal support for O.D.- and I.D. clamping
- ❼ **Crossbar**
For radial force support and positioning
- ❽ **Actuation via hexagon connection**
This ensures easy operation

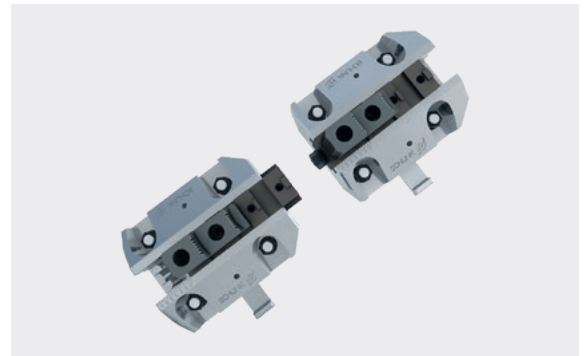
Spindle drive with integrated lubrication

The simple actuation occurs using a hexagon connection with integrated lubrication nipple. This means conventional socket wrenches, extensions, and torque wrenches can be used. In addition, the jaw box can be supplied with grease via the grease nipple.



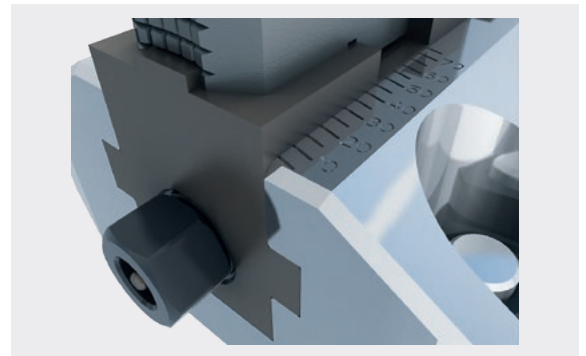
Spindle completely encapsulated

The spindle is always completely sealed, regardless of the clamping position. Dust and chips cannot penetrate the jaw box.



Jaw stroke display

For surveillance of the jaw stroke a graduation is applied on the jaw box. Therefore an optimized clamping result is ensured.

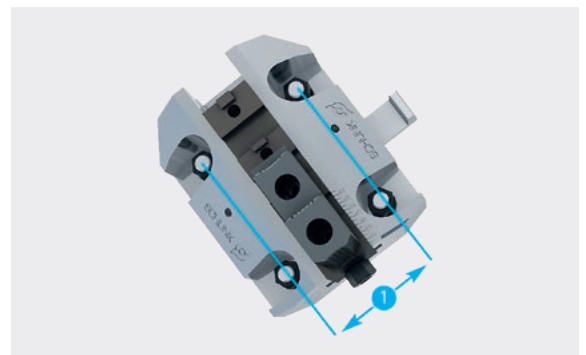


Adjustable gauge

The SPK gauge can be individually adjusted to the customer's face plate.

1 Adjustable gauge

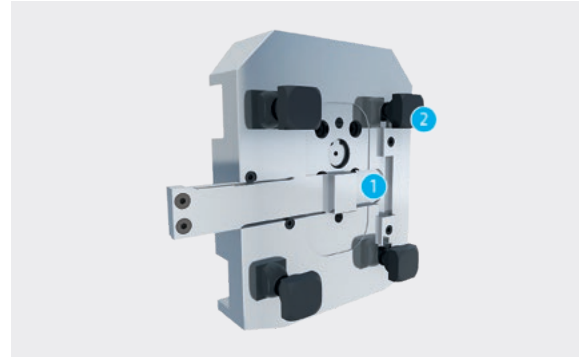
- SPK 180: Gauge 140 – 180 mm
- SPK 220: Gauge 180 – 220 mm
- SPK 260: Gauge 220 – 260 mm



Bottom

The bottom side of the jaw box always gets individually aligned to the customer's face plate.

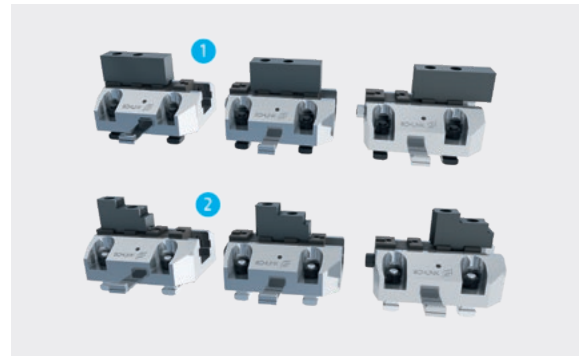
- ① Crossbar
- ② Positioning stones

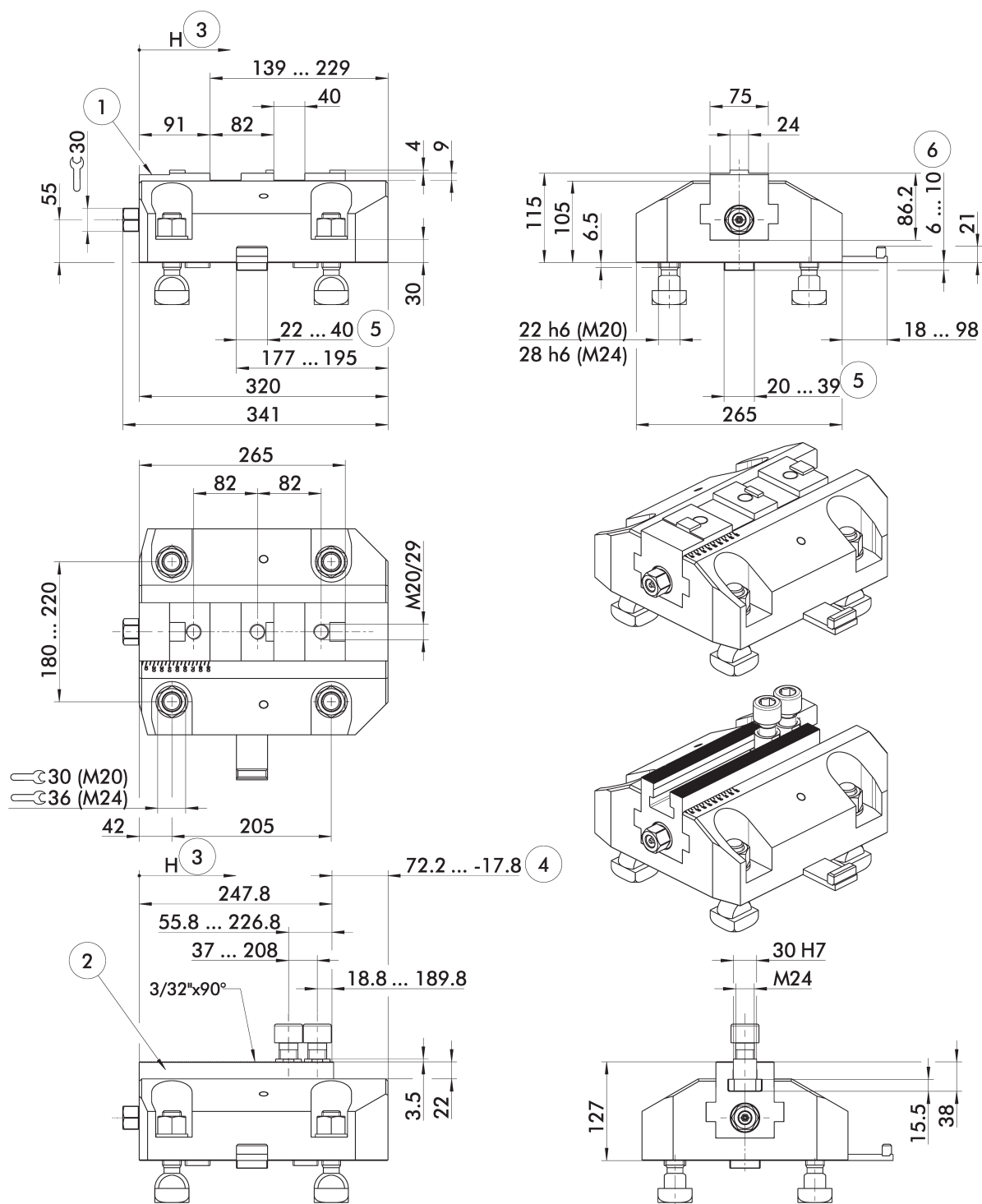


Jaw connection

The interface to the top jaws is either designed in 2x or 3x tongue and groove depending on the size of the jaw box.

- ① **SPK 180**
3-way tongue and groove with jaw connection SFA/SHF 400
- ② **SPK 220/260**
2-way tongue and groove with jaw connection SFA/SHF 630





Jaw box for face plates with T-slots shown in retracted position.
Illustration including assembly accessories.
Subject to technical changes.

- ① Base jaw with tongue and groove
- ② Base jaw with fine serration
- ③ Jaw stroke direction
- ④ Distance to center of first tooth
- ⑤ Slide width adjustable
- ⑥ Slider height adjustable

Technical data

Description	ID	Serration	Max. clamping force [kN]	Max. torque [Nm]	Adjustment range chuck jaw [mm]	Gauge [mm]	Width T-slot [mm]	Weight [kg]
SPK 220 KV	0812160	Tongue and groove	68	330	90	180 - 220	22 - 28	52.7
SPK 220 SV90°	0812161	3/32" x 90°	68	330	90	180 - 220	22 - 28	52.7

Scope of delivery

Jaw box, mounting screws, collar nuts, crossbar (adapted to face plate), eye bolts, operating manual; without top jaw, without spanner wrench

Notes

General note

With the IDs listed above, the jaw boxes are always in an undrilled state.
A new ID is generated when an order is placed.

Gauge

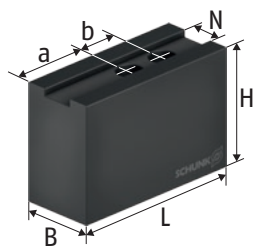
In case of an order, the gauge width and the crossbar are adapted to the relevant face plate.
For customer-specific adjustment, a table drawing is always required.

Scope of delivery

The corresponding scope of delivery is always based on the corresponding clamping disk.

Soft top jaws

with fine serration 90°



SP-WB
Soft top jaws

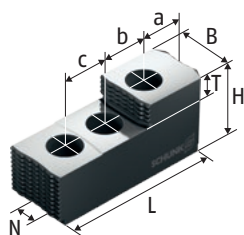
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
SPK 220	SP-WB 630/1	1548227	30	75	90	240	133	65	M24	10.7

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

Hard stepped top jaws

with fine serration 90°



SP-HB
Hard stepped top jaws

Technical data

Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	T [mm]	a [mm]	b [mm]	c [mm]	Screws	m/SET [kg]
SPK 220	SP-HB 630/1	1430139	30	75	88	174.5	30	44.5	50	50	M24	5.4

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T-nut



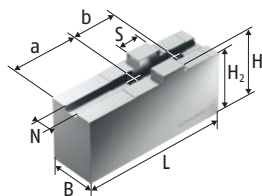
NS
T-nut

Chuck type	Description	ID	N	B	H	H1	L	Cyl.-screw	Max. adm. tightening torque
			[mm]	[mm]	[mm]	[mm]	[mm]		[Nm]
SPK 220	NS 240-2	0140124	30	42	41	15	34	M24 x 60	450

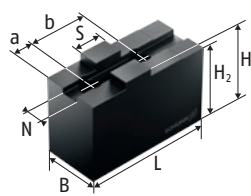
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Soft top jaws

with tongue and groove



SFA-AL
Soft top jaws



SFA
Soft top jaws

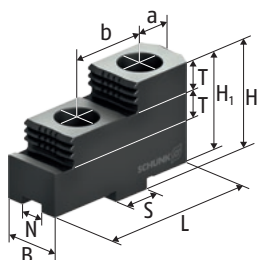
Technical data

Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	H [mm]	H2 [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
SPK 220	SFA 630/1	1539435	24	40	65	118	110	260	129	82	M20	39.6
SPK 220	SFA-AL 630/1	1548022	24	40	65	118	110	260	129	82	M20	14.2

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

Hard stepped top jaws

with tongue and groove



SHF
Hard stepped top jaws

Technical data

Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	H [mm]	H1 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
SPK 220	SHF 630/1	0155116	24	40	65	105	97	185	30	41	82	M20	6.3

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

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



H.-D. SCHUNK GmbH & Co.
Spanntechnik KG

Lothringer Str. 23
D-88512 Mengen
Tel. +49-7572-7614-1300
Fax +49-7572-7614-1039
CMM@de.schunk.com
schunk.com