

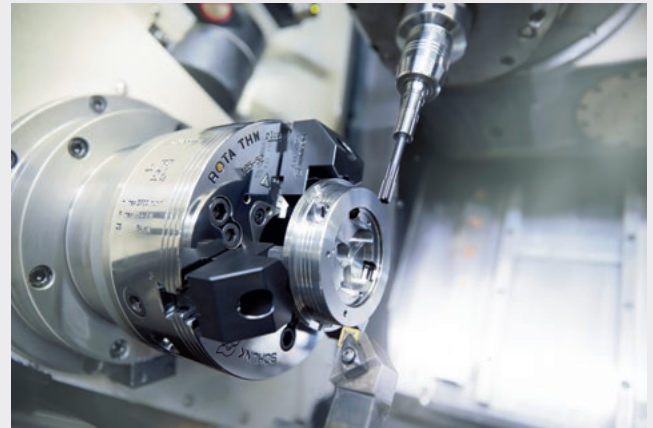


## **ROTA THW**plus

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

# Jaw quick-change chuck for maximum flexibility starting from batch size 1

The ROTA THW plus jaw quick-change chuck from SCHUNK, which has demonstrated its value for decades, embodies the concept of flexible production starting from batch size 1. The jaw quick-change system reduces set-up times to a maximum and adapts the chuck to the new clamping task within 60 seconds. High jaw quick-change repeatability allows existing jaws to be reused directly without their having to be ground again.



## 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
- + Optimized lubrication system**  
Consistently high clamping forces ensured
- + Modular center sleeve system**  
Optimal adjustment to new clamping tasks thanks to the exchangeable center sleeves
- + Straight serrated base jaws GBK**  
Compatible to ROTA-G and system "R" (Reishauer)
- + Two mounting bolt circles**  
For fast and direct attachment to all commercially available spindle heads
- + All sides of the functional parts are hardened and ground**  
Ensures a long service life

## Technical data

| Description           | Max. rotational speed<br>[min <sup>-1</sup> ] | Max. clamping force<br>[kN] | Max. actuating force<br>[kN] | Stroke/jaw<br>[mm] | Piston stroke<br>[mm] | Through-hole<br>[mm] |
|-----------------------|-----------------------------------------------|-----------------------------|------------------------------|--------------------|-----------------------|----------------------|
| ROTA THW plus 165-43  | 6000                                          | 45                          | 30                           | 5.9                | 20                    | 43                   |
| ROTA THW plus 185-52  | 5700                                          | 64                          | 36                           | 6.7                | 23                    | 52                   |
| ROTA THW plus 215-66  | 5400                                          | 82                          | 46                           | 7.4                | 25                    | 66                   |
| ROTA THW plus 260-81  | 4000                                          | 115                         | 65                           | 8.2                | 28                    | 81                   |
| ROTA THW plus 315-104 | 3600                                          | 160                         | 90                           | 8.6                | 28                    | 104                  |

## Function of ROTA THW plus

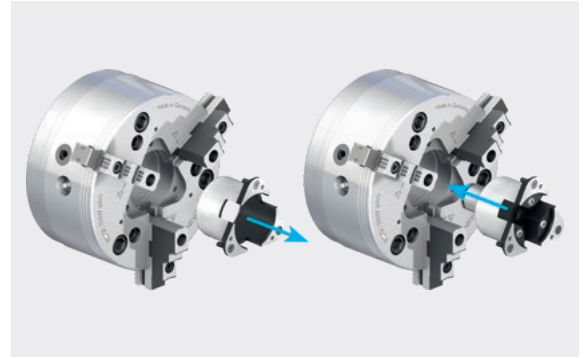
The wedge bars that can be tangentially moved in the chuck are driven via slanted effective surfaces of an axially guided piston. The wedge bars transmit the force to the base jaws, generating a jaw movement that is synchronous and radial to the rotational axis. The jaw change occurs by drawing back the wedge bar serration.



- |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <ul style="list-style-type: none"> <li>❶ <b>Wedge bar actuation system</b><br/>It offers high run-out accuracies even at high speeds</li> <li>❷ <b>Hardened and extremely rigid base body</b><br/>Therefore a longer service life at highest precision.<br/>Even with maximum clamping force</li> <li>❸ <b>Large through-hole</b><br/>For machining of all standard raw material diameters</li> <li>❹ <b>Optimized lubrication system</b><br/>For a high level of efficiency</li> <li>❺ <b>Mounting thread</b><br/>For workpiece stops or cover plates</li> <li>❻ <b>Jaw quick-change system</b><br/>Shortest set-up times due to individual unlocking of jaws</li> <li>❼ <b>Base jaws with straight serration (GBK)</b><br/>Compatible with the ROTA THW and ROTA-G</li> </ul> | <ul style="list-style-type: none"> <li>❽ <b>Locking mechanism</b><br/>Enables a safe base jaw position and thus ensures secure intermeshing of the base jaw serration with the wedge-bar serration</li> <li>❾ <b>Two mounting bolt circles</b><br/>For fast and direct attachment to all commercially available spindle heads</li> <li>❿ <b>Admissible jaw locking</b><br/>The jaw change wrench can only be removed if the wedge bar is properly engaged in the base jaw.</li> <li>⓫ <b>Various direct mountings</b><br/>Without additional flange</li> <li>⓬ <b>Modular center sleeve system</b><br/>Therefore optimal adjustment to new clamping tasks</li> <li>⓭ <b>Additional seals</b><br/>For sealing against coolants and chips</li> </ul> |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

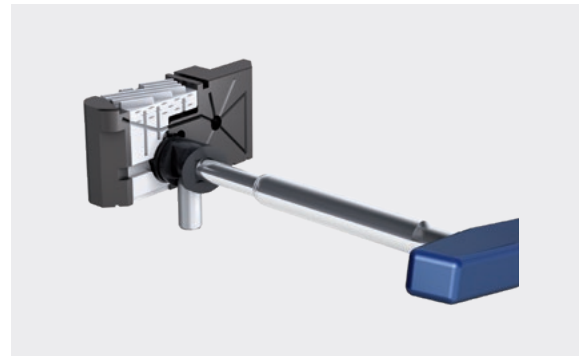
### Changing the center sleeve

The modular center sleeves can be changed quickly and easily while the chuck remains mounted. When the three screws are undone, all the protection sleeves can be pulled off from the front and replaced.



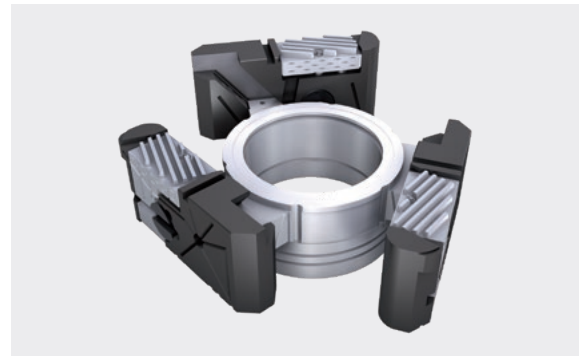
### Quick jaw change

Due to an easy pull back of the wedge bar serration. This ensures a 100% grip of the serrations. This increases the safety factor since the clamping force is ideally distributed on a large surface.



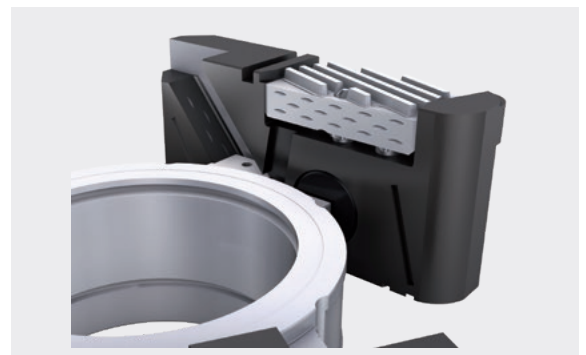
### High changing repeatability

Due to the proven wedge bar system and the double guided piston.



### Optimized lubrication system

Three 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.



### Insertion of the chuck jaws

Simply insert the new chuck jaws into the guidance. The plunger pin pre-positions the serration. Detaching the jaw change wrench safely locks the jaw in its position.



### Removal of the chuck jaws

In opened position the jaws can be adjusted or removed in seconds with the jaw change wrench.

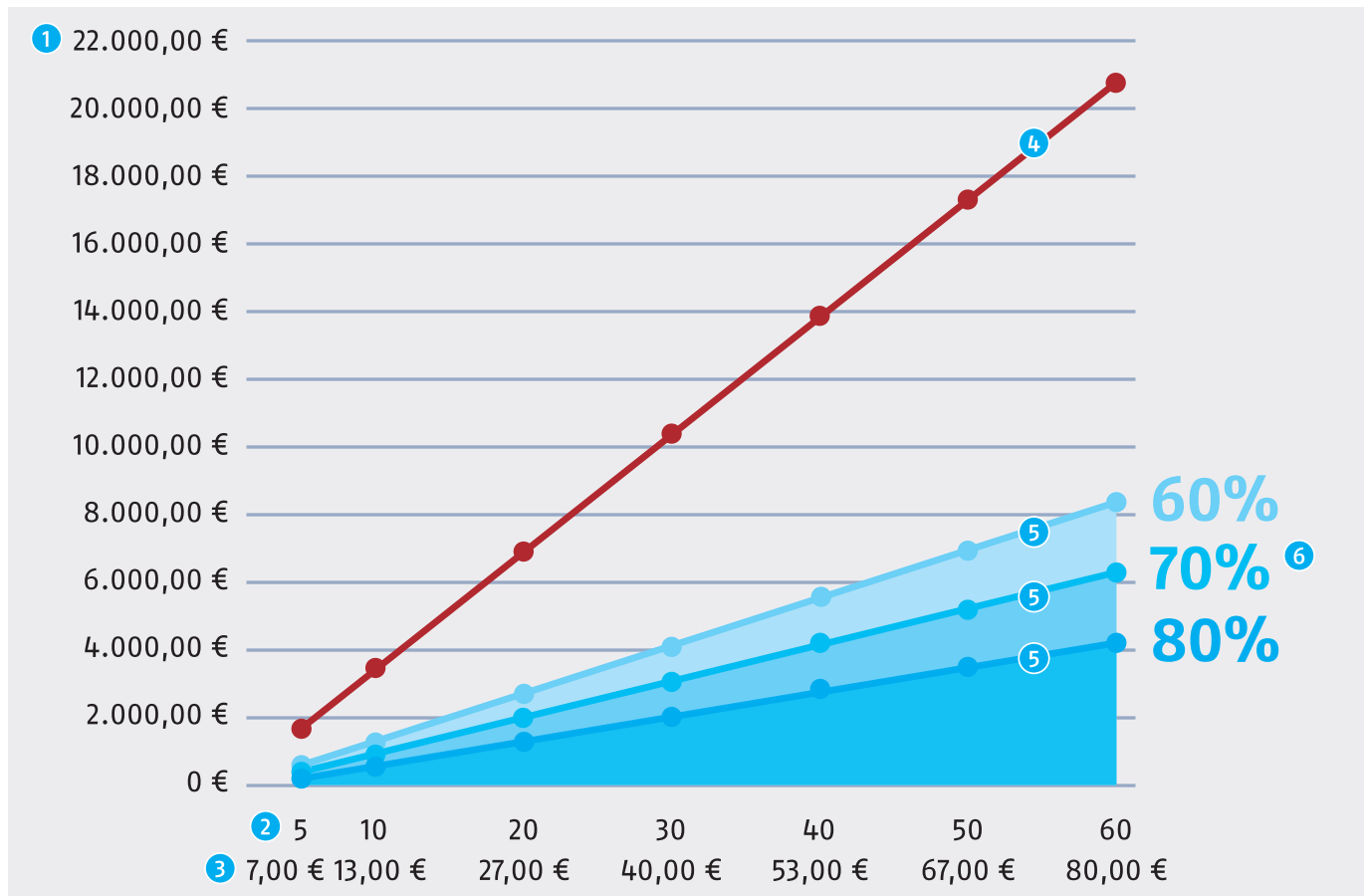


### The jaws are interchangeable

Straight serration, fits SCHUNK ROTA THW3, ROTA THW, ROTA-G and the "R" system (Reishauer). This allows jaws to be used on multiple chucks or in multiple applications.



## Savings in set-up costs due to jaw quick-change chuck

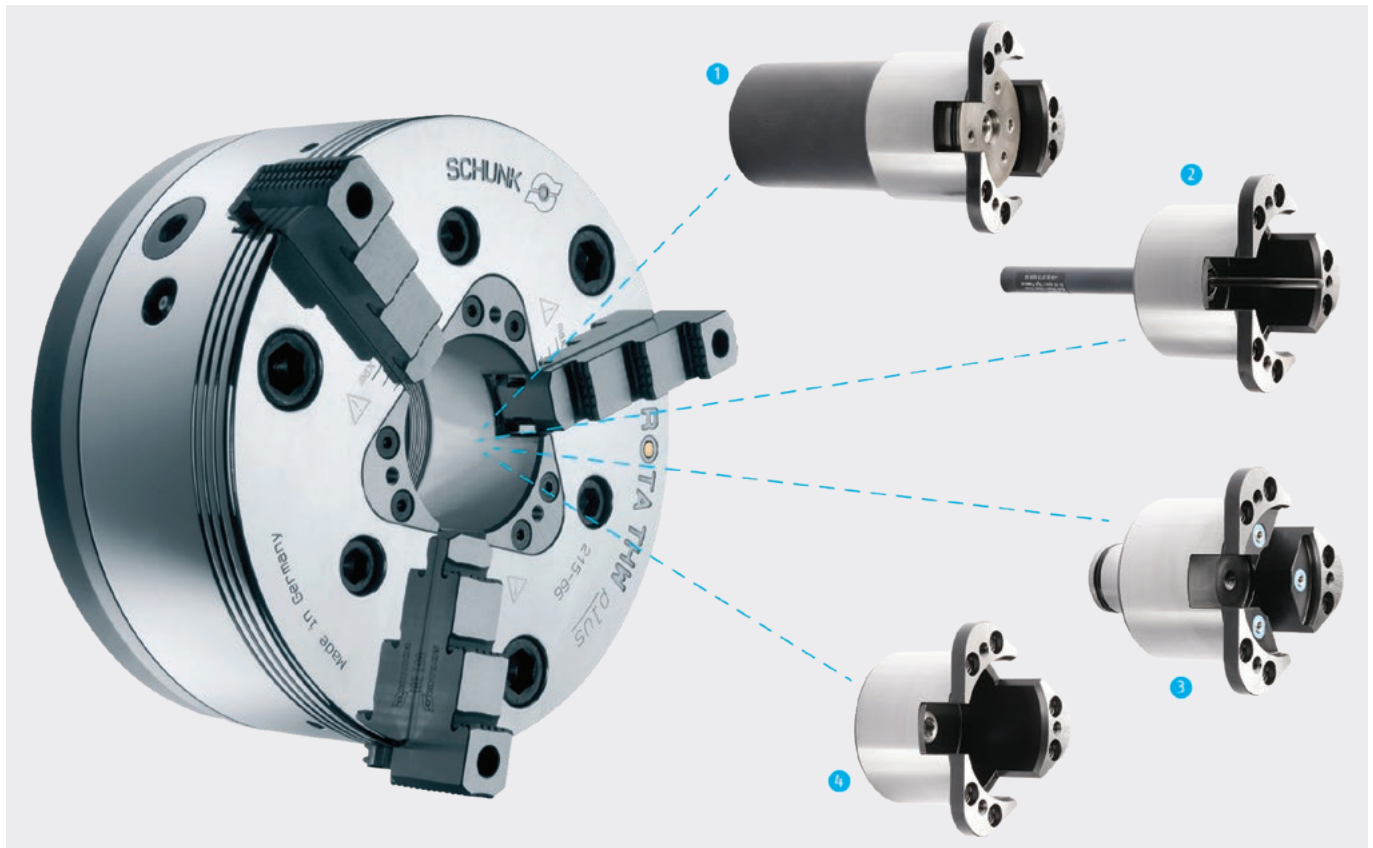


The jaw quick-change system is the ideal clamping tool for clamping tasks even up from batch size 1. Ideally the set-up times can be reduced – depending on the number of jaw changes – by up to 80% in comparison to power lathe chucks with fine serration.

- ① **Set-up costs\***  
In EURO per year
- ② **Set-up time**  
In minutes per day
- ③ **Set-up costs\***  
In EURO per day
- ④ **Set-up costs**  
Per year without jaw quick-change
- ⑤ **Set-up costs**  
Per year with jaws quick-change
- ⑥ **Savings potential**  
Depending on the set-up rate

① \* Set-up costs per minute 1.33 € (80 € per hour) at 260 business days

## Modular center sleeve system



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

**1 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.

**2 Part ejector in the center sleeve**

An optimum addition for automatic loading. The part ejector disposes of a gas spring, which will eject your workpiece safely out of the chuck.

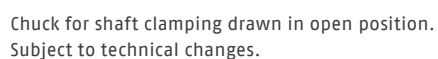
**3 Coolant nozzles in the center sleeve**

Ideal as an additional component if your machine is equipped with a central coolant supply. For I.D. machining, coolant will be fed directly to the tool.

**4 Closed center sleeve**

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

① Modular center sleeve system up to size 315 possible.



- ① Position of base jaws I outermost position
- ② Position of base jaws II outermost position
- ③ Position of base jaws I innermost position
- ④ Piston stroke direction
- ⑤ Swing diameter radius

## Technical data

| Spindle type | Spindle size | ID      | Max. rotational speed<br>[min <sup>-1</sup> ] | Max. clamping force<br>[kN] | Max. actuating force<br>[kN] | Moment of inertia<br>[kgm <sup>2</sup> ] | Weight<br>[kg] |
|--------------|--------------|---------|-----------------------------------------------|-----------------------------|------------------------------|------------------------------------------|----------------|
| ISO 702-4    | Nr. 8 (Z220) | 0800640 | 3600                                          | 160                         | 90                           | 0.97                                     | 66             |
| ISO 702-1    | Nr. 8        | 0800641 | 3600                                          | 160                         | 90                           | 0.97                                     | 67             |
| ISO 702-1    | Nr. 11       | 0800642 | 3600                                          | 160                         | 90                           | 0.97                                     | 70             |

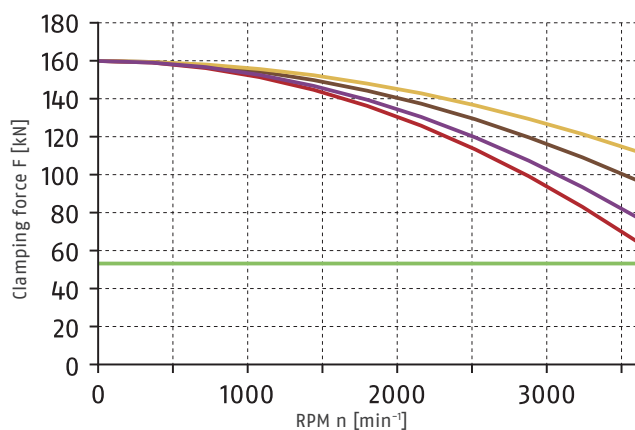
## Scope of delivery

Chuck, 1 set of base jaws with screws, jaw change wrench, chuck mounting screws, mounting wrench for turnable threaded ring, eye bolt, and operating manual

## Further technical data

| Chuck type            | Through-hole<br>[mm] | Stroke/jaw<br>[mm] | Tooth pitch<br>[mm] | Piston stroke (H)<br>[mm] | Center jaw height<br>[mm] |
|-----------------------|----------------------|--------------------|---------------------|---------------------------|---------------------------|
| ROTA THW plus 315-104 | 104                  | 8.6                | 5.498               | 28                        | 75                        |

## Clamping force-RPM-diagram



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

SHF 250  
1.9 kg



SFA 250  
3.7 kg



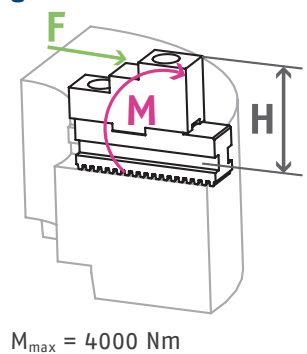
GST 315  
3.5 kg



UVB 315  
7.6 kg

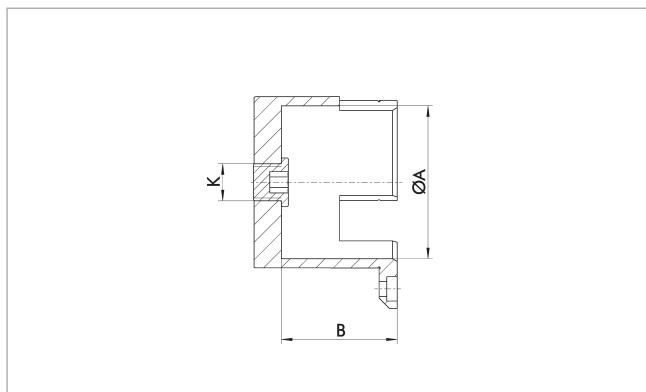


## Load of base jaw guidance



## Center sleeves

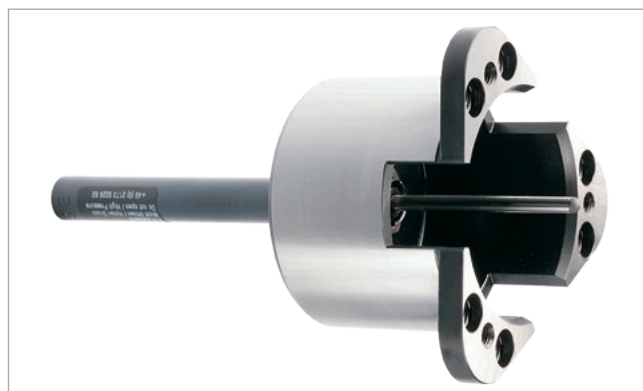
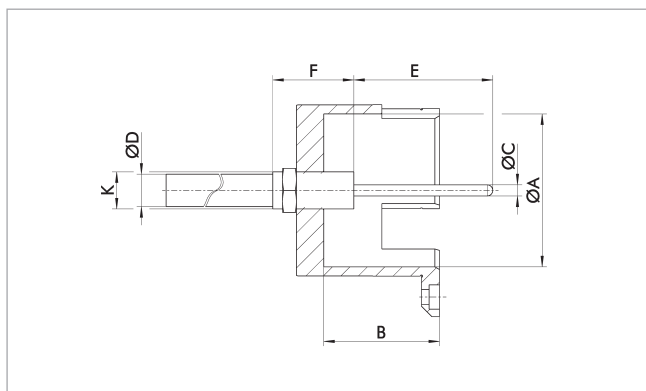
### Center sleeve closed



### Technical data

| Description | ID                      | Suitable for          | ØA<br>[mm] | B<br>[mm] | K       | Weight<br>[kg] |
|-------------|-------------------------|-----------------------|------------|-----------|---------|----------------|
| SBS-G-W 315 | <a href="#">8703538</a> | ROTA THW plus 315-104 | 104        | 63        | M16x1.5 | 2.1            |

### Protection sleeve with ejector

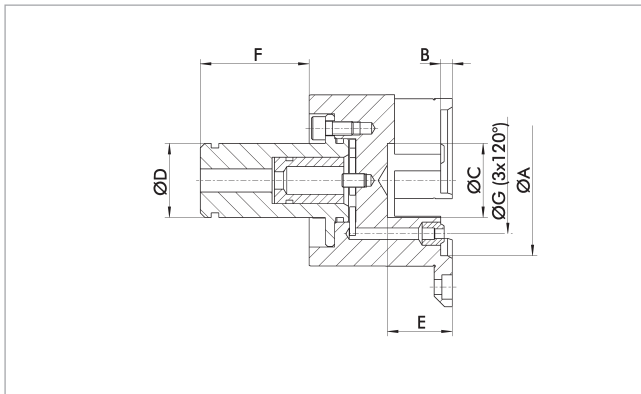


### Technical data

| Description | Suitable for          | ØA<br>[mm] | B<br>[mm] | ØC<br>[mm] | ØD<br>[mm] | E<br>[mm] | F<br>[mm] | K       |
|-------------|-----------------------|------------|-----------|------------|------------|-----------|-----------|---------|
| SBS-A-W 315 | ROTA THW plus 315-104 | 104        | 63        | 4.8        | 14         | 10 - 100  | 35        | M16x1.5 |

- Center sleeves with ejector are available on request
- The ejector stroke is selectable in increments of 10 from 10 - 100 mm
- The ejection force is selectable with 40, 100, 150, 200, 250, or 300 N

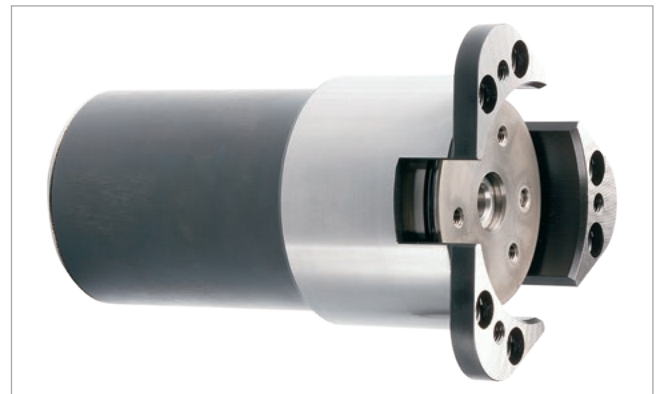
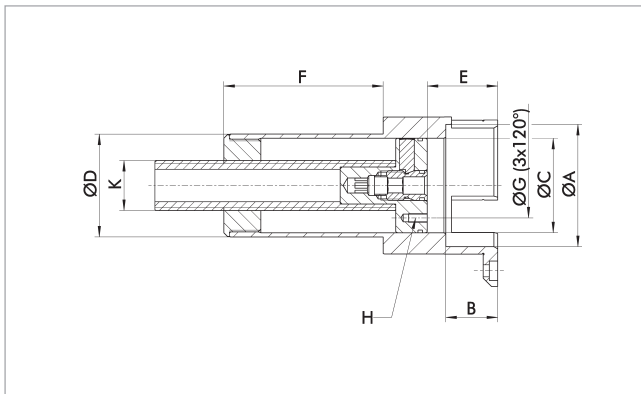
### Protection sleeve with spray nozzles



### Technical data

| Description | ID                      | Suitable for          | ØA<br>[mm] | B<br>[mm] | ØC<br>[mm] | ØD<br>[mm] | F<br>[mm] | ØG<br>[mm] | K       | Weight<br>[kg] |
|-------------|-------------------------|-----------------------|------------|-----------|------------|------------|-----------|------------|---------|----------------|
| SBS-S-W 315 | <a href="#">8703251</a> | ROTA THW plus 315-104 | 104        | 5         | 70         | 32         | 47        | 85         | M16x1.5 | 4.6            |

### Center sleeve with adjustable stop



### Technical data

| Description     | ID                      | Suitable for          | ØA<br>[mm] | 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-W 315-80  | <a href="#">8703694</a> | ROTA THW plus 315-104 | 104        | 37        | 75         | 80.5       | 38 - 105.8 | 78        | 50         | M6x12 | M27 | 4.5            |
| SBS-T-W 315-103 | <a href="#">8703260</a> | ROTA THW plus 315-104 | 104        | 37        | 97         | 103        | 38 - 105.8 | 78        | 70         | M6x12 | M27 | 4.7            |

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

## Adapter plates

### Z-mount on short taper ISO 702-1



### Technical data

| Description      | Adapter plate type | ID                      | Suitable for          | D1     | D2    | D3   | D4                        | D5   | G                           | H    | T1    | T2    |
|------------------|--------------------|-------------------------|-----------------------|--------|-------|------|---------------------------|------|-----------------------------|------|-------|-------|
|                  |                    |                         |                       | [mm]   |       |      | [mm]                      | [mm] |                             | [mm] | [mm]  | [mm]  |
| FF-T2 Z220-A5    | FF-T2              | <a href="#">0805002</a> | ROTA THW plus 315-104 | Nr. 5  | 79.6  | Z220 | 11 (6x60°)                | 17   | M16 (6x60°)<br>M16 (2x180°) | 28   | 104.8 | 171.4 |
| FF-T2 Z220-A6    | FF-T2              | <a href="#">0805003</a> | ROTA THW plus 315-104 | Nr. 6  | 103.2 | Z220 | 13 (6 x 60°)              | 20   | M16 (6x60°)<br>M16 (2x180°) | 28   | 133.4 | 171.4 |
| FF-T1 Z220-A8    | FF-T1              | <a href="#">0803002</a> | ROTA THW plus 315-104 | Nr. 8  | 136.2 | Z220 | 17 (6x60°)<br>17 (2x180°) |      |                             | 19   | 171.4 |       |
| FF-T3 Z220-A11   | FF-T3              | <a href="#">0803003</a> | ROTA THW plus 315-104 | Nr. 11 | 130   | Z220 | 21 (6x60°)                | 32   | M16 (12 x 30°)              | 50   | 235   | 171.4 |
| FF-T3 Z220-A15-1 | FF-T3              | <a href="#">0803020</a> | ROTA THW plus 315-104 | Nr. 15 | 145   | Z220 | 26 (6x60°)                | 38   | M16 (6x60°)                 | 55   | 330.2 | 171.4 |
| FF-T3 Z220-A15-2 | FF-T3              | <a href="#">0803021</a> | ROTA THW plus 315-104 | Nr. 15 | 145   | Z220 | 23 (6x60°)                | 35   | M16 (6x60°)                 | 55   | 330.2 | 171.4 |

#### Direct adapter plates

Direct adapter plates are used if the spindle mounting bolt circle has the same size as the lathe chuck mounting bolt circle. The adapter plate has to be mounted on to the spindle together with the lathe chuck. The adapter plate is preassembled on the lathe chuck.

#### Reduction adapter plates FF-T2

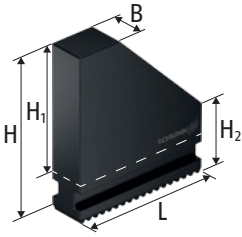
Reduction adapter plates are used if the mounting bolt circle of the spindle is smaller than the one of the lathe chuck mounting bolt circle. The adapter plate is first mounted on the spindle and then the lathe chuck is mounted on the adapter plate.

#### Expansion adapter plates FF-T3

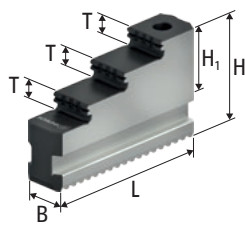
Expansion adapter plates are used if the mounting bolt circle of the spindle is larger than the one of the lathe chuck mounting bolt circle. The adapter plate is first mounted on the spindle and then the lathe chuck is mounted on the adapter plate.



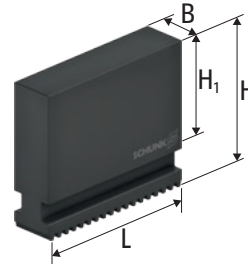
## Base jaws, Hard stepped block jaws, Soft monoblock jaws with straight serration



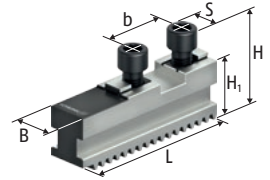
UVB-HS  
Soft monoblock jaws



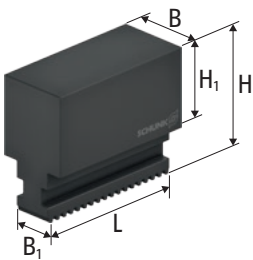
GST  
Hard stepped block jaws



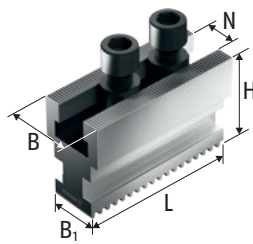
UVB  
Soft monoblock jaws



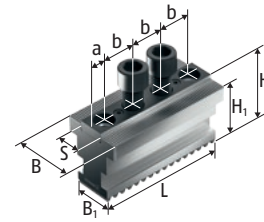
GBK  
Base jaws



UVB-B  
Soft monoblock jaws



STB-G  
Base jaws



STN  
Base jaws

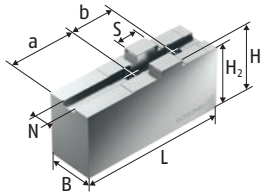
### Technical data

| Chuck type            | Description | ID                      | N<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 THW plus 315-104 | UVB 315     | <a href="#">0164102</a> |           |           | 32        |            | 90        | 56         |            | 121       |           |           |           |        | 7.6           |
| ROTA THW plus 315-104 | UVB-B 315   | <a href="#">0164115</a> |           |           | 46        | 32         | 90        | 52         |            | 121       |           |           |           |        | 9.6           |
| ROTA THW plus 315-104 | UVB-H 315   | <a href="#">0164118</a> |           |           | 32        |            | 135       | 101        |            | 121       |           |           |           |        | 11.6          |
| ROTA THW plus 315-104 | UVB-HS 315  | <a href="#">0164121</a> |           |           | 32        |            | 135       | 101        | 52         | 121       |           |           |           |        | 9.0           |
| ROTA THW plus 315-104 | GBK 315     | <a href="#">0159102</a> | 20        | 12        | 32        |            | 46        | 43         |            | 115       |           |           | 40        | M12    | 3.0           |
| ROTA THW plus 315-104 | GBKL 315    | <a href="#">0159122</a> | 20        | 12        | 32        |            | 46        | 43         |            | 137       |           |           | 40        | M12    | 3.5           |
| ROTA THW plus 315-104 | GBK-V 315   | <a href="#">0159152</a> | 20        | 12        | 32        |            | 46        | 43         |            | 115       |           |           | 40        | M12    | 3.0           |
| ROTA THW plus 315-104 | STB-G 315-2 | <a href="#">0160659</a> | 21        |           | 54        | 32         | 76        |            |            | 115       |           |           |           | M16    | 7.5           |
| ROTA THW plus 315-104 | STN 315-6   | <a href="#">0160603</a> |           | 21        | 45        | 32         | 58.5      | 56         |            | 110       |           | 13        | 28        | M16    | 4.5           |
| ROTA THW plus 315-104 | STNJ 315-5  | <a href="#">0160652</a> |           | 18        | 50        | 32         | 56        | 54         |            | 120       |           | 15        | 30        | M14    | 4.9           |
| ROTA THW plus 315-104 | STNJ 315-6  | <a href="#">0160665</a> |           | 21        | 50        | 32         | 60        | 58         |            | 125       |           | 17.5      | 30        | M16    | 5.5           |
| ROTA THW plus 315-104 | GST 315     | <a href="#">0162102</a> |           |           | 32        |            | 66        | 32         |            | 116.3     | 10        |           |           |        | 3.5           |

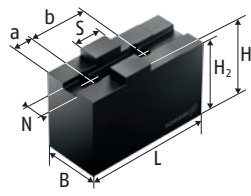
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](http://schunk.com)

## Soft top jaws

with tongue and groove



SFA-AL  
Soft top jaws



SFA  
Soft top jaws

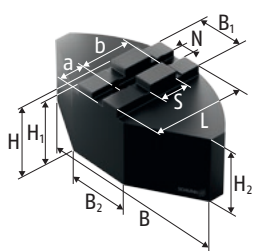
### Technical data

| 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 THW plus 315-104 | SFA 250     | <a href="#">0153102</a> | 12        | 20        | 30        | 55.5      | 50.5       | 125       | 60        | 40        | M12    | 3.7           |
| ROTA THW plus 315-104 | SFA-AL 250  | <a href="#">0172103</a> | 12        | 20        | 40        | 60        | 55         | 125       | 60        | 40        | M12    | 2.1           |
| ROTA THW plus 315-104 | SFA 250-C1  | <a href="#">0154101</a> | 12        | 20        | 40        | 60        | 55         | 90        | 34        | 40        | M12    | 3.9           |
| ROTA THW plus 315-104 | SFA 250-C2  | <a href="#">0154102</a> | 12        | 20        | 40        | 60        | 55         | 125       | 69        | 40        | M12    | 5.6           |
| ROTA THW plus 315-104 | SFA 250-C3  | <a href="#">0154103</a> | 12        | 20        | 40        | 80        | 75         | 125       | 69        | 40        | M12    | 7.7           |
| ROTA THW plus 315-104 | SFA 250-C4  | <a href="#">0154104</a> | 12        | 20        | 40        | 100       | 95         | 125       | 69        | 40        | M12    | 9.8           |
| ROTA THW plus 315-104 | SFA 250-C5  | <a href="#">0154105</a> | 12        | 20        | 40        | 120       | 115        | 125       | 69        | 40        | M12    | 11.8          |
| ROTA THW plus 315-104 | SFA 250-C6  | <a href="#">0154106</a> | 12        | 20        | 60        | 60        | 55         | 90        | 34        | 40        | M12    | 6.0           |
| ROTA THW plus 315-104 | SFA 250-C7  | <a href="#">0154107</a> | 12        | 20        | 80        | 60        | 55         | 90        | 34        | 40        | M12    | 8.5           |
| ROTA THW plus 315-104 | SFA 250-C8  | <a href="#">0154134</a> | 12        | 20        | 80        | 100       | 95         | 125       | 69        | 40        | M12    | 20.6          |

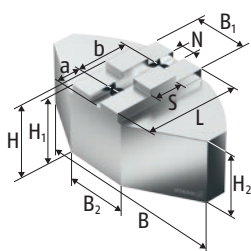
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](https://www.schunk.com)

## Hard stepped top jaws, Full grip jaws

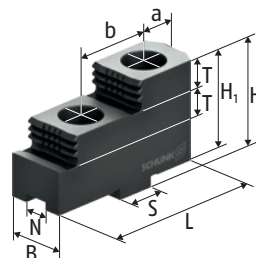
with tongue and groove



SFA-SM  
Full grip jaws



SFA-SA  
Full grip jaws



SHF  
Hard stepped top jaws

### Technical data

| Chuck type            | Description | ID                      | N<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 THW plus 315-104 | SFA-SA 250  | <a href="#">0174102</a> | 12        | 20        | 180       | 40         | 58        | 53         | 43         | 87.5      |           | 33.75     | 40        | M12    | 3.4           |
| ROTA THW plus 315-104 | SFA-SA 251  | <a href="#">0174106</a> | 12        | 20        | 180       | 40         | 80        | 75         | 65         | 87.5      |           | 33.75     | 40        | M12    | 5.0           |
| ROTA THW plus 315-104 | SFA-SM 250  | <a href="#">0173102</a> | 12        | 20        | 180       | 40         | 60        | 55         | 45         | 90        |           | 34.5      | 40        | M12    | 12.8          |
| ROTA THW plus 315-104 | SFA-SM 251  | <a href="#">0173106</a> | 12        | 20        | 180       | 40         | 80        | 75         | 65         | 90        |           | 35        | 40        | M12    | 18.9          |
| ROTA THW plus 315-104 | SHF 250     | <a href="#">0155102</a> | 12        | 20        | 30        |            | 55        | 50         |            | 90        | 14        | 21.1      | 40        | M12    | 1.9           |

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## Claw jaws, Universal claw jaws

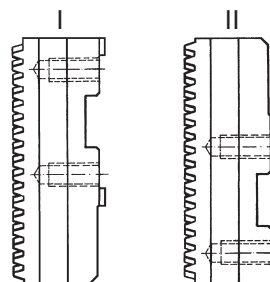
with tongue and groove



SZKU  
Universal claw jaws



SZKA  
Claw jaws



Position of base jaws

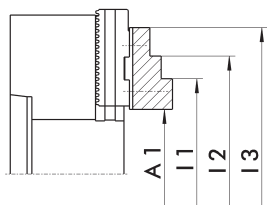
### Technical data

| 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] | [mm] |        | [kg]  |
| ROTA THW plus 315-104 | 115 - 228         | 383                  | I                     | SZKA 263    | <a href="#">0139160</a> | 12   | 20   | 30   | 55   | 50   | 85   | 25   | M6   | 40   | M12    | 1.5   |
| ROTA THW plus 315-104 | 172 - 286         | 384                  | I                     | SZKA 266    | <a href="#">0139163</a> | 12   | 20   | 40   | 55   | 50   | 74   | 25   | M6   | 40   | M12    | 1.9   |
| ROTA THW plus 315-104 | 206 - 309         | 387                  | I                     | SZKA 268    | <a href="#">0139165</a> | 12   | 20   | 40   | 55   | 50   | 83   | 25   | M6   | 40   | M12    | 2.2   |
| ROTA THW plus 315-104 | 199 - 265         |                      | I                     | SZKU 250    | <a href="#">0139302</a> | 12   | 20   | 30   | 55   | 50   | 78   | 25   | M6   | 40   | M12    | 1.6   |
| ROTA THW plus 315-104 | 41 - 141          | 377                  | II                    | SZKA 263    | <a href="#">0139160</a> | 12   | 20   | 30   | 55   | 50   | 85   | 25   | M6   | 40   | M12    | 1.5   |
| ROTA THW plus 315-104 | 86 - 199          | 377                  | II                    | SZKA 266    | <a href="#">0139163</a> | 12   | 20   | 40   | 55   | 50   | 74   | 25   | M6   | 40   | M12    | 1.9   |
| ROTA THW plus 315-104 | 130 - 232         | 377                  | II                    | SZKA 268    | <a href="#">0139165</a> | 12   | 20   | 40   | 55   | 50   | 83   | 25   | M6   | 40   | M12    | 2.2   |
| ROTA THW plus 315-104 | 104 - 181         |                      | II                    | SZKU 250    | <a href="#">0139302</a> | 12   | 20   | 30   | 55   | 50   | 78   | 25   | M6   | 40   | M12    | 1.6   |

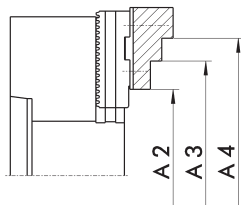
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## Hard stepped top jaws

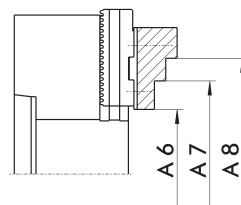
with tongue and groove



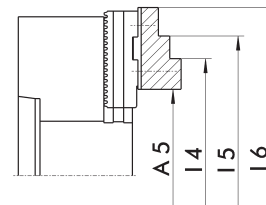
Position of base jaws II



Position of base jaws I



Position of base jaws II



Position of base jaws I

### O.D. clamping

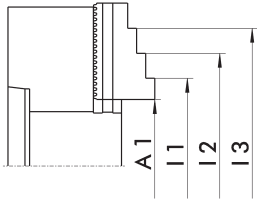
| Chuck type            | Description | ID                      | A1<br>[mm] | A3<br>[mm] | A4<br>[mm] | A5<br>[mm] | A7<br>[mm] | A8<br>[mm] |
|-----------------------|-------------|-------------------------|------------|------------|------------|------------|------------|------------|
| ROTA THW plus 315-104 | SHF 250     | <a href="#">0155102</a> | 14 - 145   | 104 - 232  | 184 - 313  | 100 - 229  | 44 - 149   | 124 - 229  |

### I.D. clamping

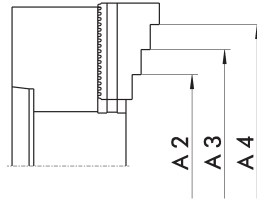
| Chuck type            | Description | ID                      | I1<br>[mm] | I2<br>[mm] | I4<br>[mm] |
|-----------------------|-------------|-------------------------|------------|------------|------------|
| ROTA THW plus 315-104 | SHF 250     | <a href="#">0155102</a> | 97 - 224   | 175 - 304  | 179 - 308  |

## 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 THW plus 315-104 | GST 315     | <a href="#">0162102</a> | 27 - 140   | 93 - 206   | 149 - 262  | 205 - 318  |

### I.D. clamping

| Chuck type            | Description | ID                      | I1<br>[mm] | I2<br>[mm] | I3<br>[mm] |
|-----------------------|-------------|-------------------------|------------|------------|------------|
| ROTA THW plus 315-104 | GST 315     | <a href="#">0162102</a> | 86 - 196   | 140 - 252  | 196 - 308  |

## 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 THW plus 315-104 | IFT Set     | <a href="#">1404235</a> |

### Jaw change wrench

Wrench for fast change of the jaws for power lathe chucks with jaw quick-change system.



| Suitable for          | Description    | ID                      |
|-----------------------|----------------|-------------------------|
| ROTA THW plus 315-104 | SSH-A SW10-148 | <a href="#">8703302</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> |

### Mounting wrench

For power lathe chucks with a turnable threaded ring in pipe design with two actuation tabs.



| Suitable for          | Description       | ID                      |
|-----------------------|-------------------|-------------------------|
| ROTA THW plus 315-104 | SSH-MR Ø104-150-1 | <a href="#">8703907</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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