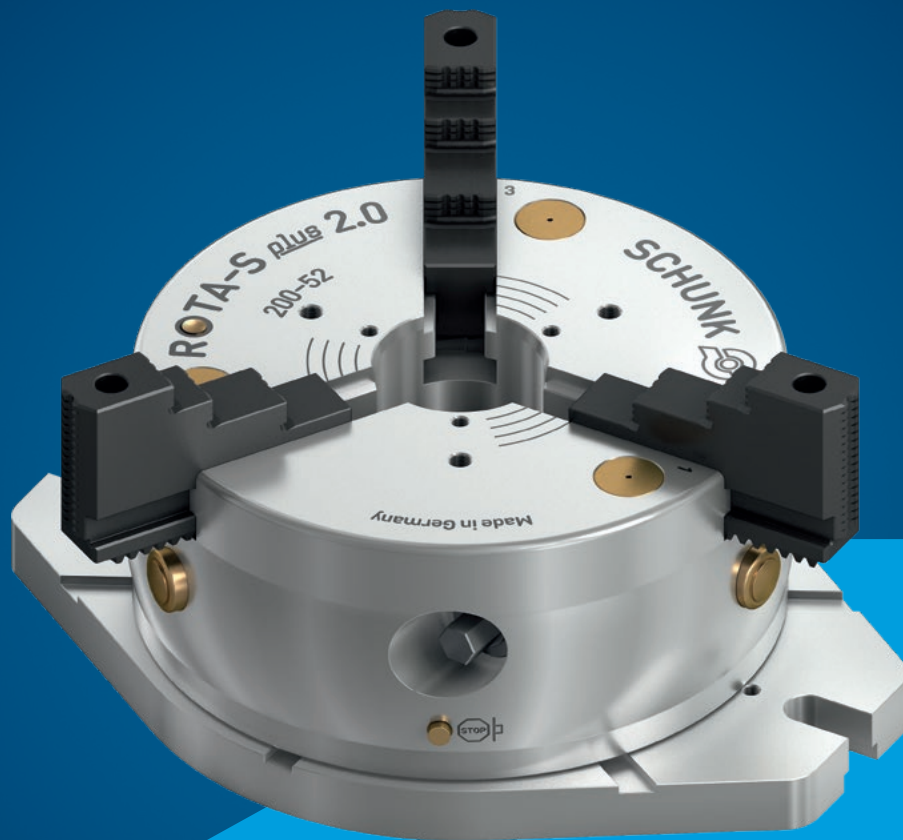


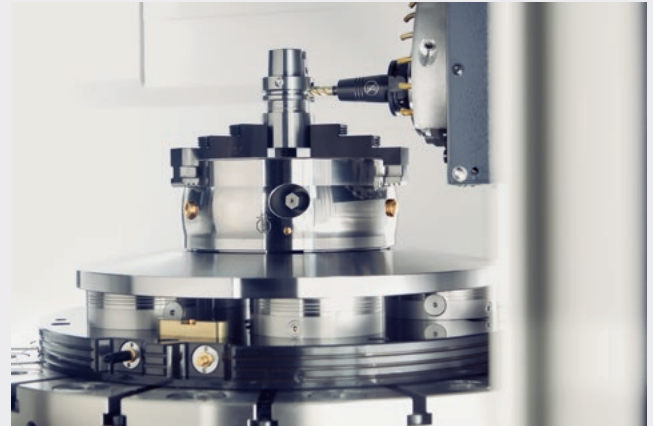


ROTA-S *plus* 2.0

Jaw quick-change chuck for
stationary use

Universally applicable manual lathe chucks for stationary applications with jaw quick-change system for jaw change within 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 lathe chucks suitable for flexible manufacturing from batch size 1. The manual lathe chucks can be quickly and easily attached to the machine table using a base plate or, in combination with VERO-S, can also be automatically inserted and removed using a robot.



Advantages – Your benefits

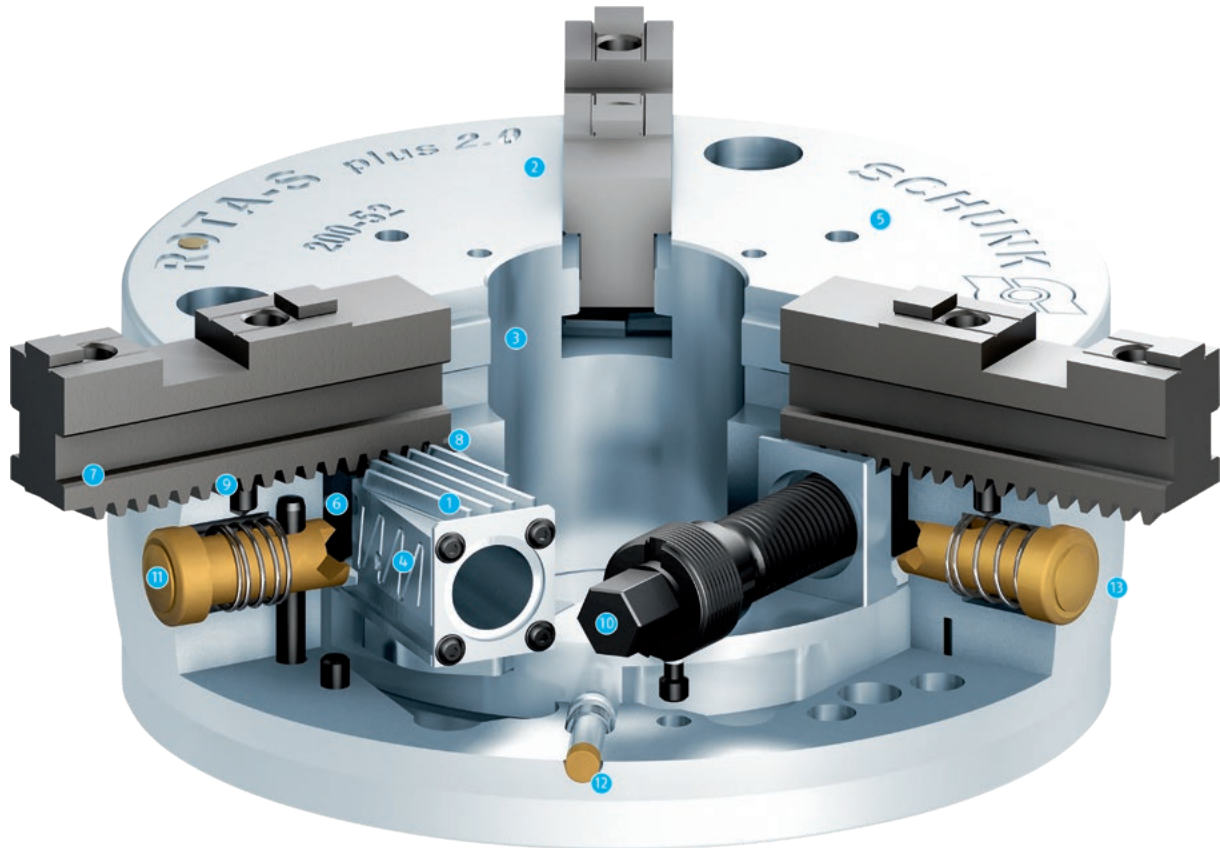
- + Convenient jaw quick-change system**
Minimizing set-up times and costs
- + High efficiency of the wedge bar system**
Process-reliable clamping due to high clamping forces
- + High jaw quick-change repeat accuracy**
No reboring of already machined jaws necessary
- + Visual safety devices**
Maximum operating safety
- + Optimized lubrication system**
Consistently high clamping forces ensured
- + Angled serrated base jaws SFG**
Compatible with the ROTA-S plus and "F" system (Forkardt)
- + All sides of the functional parts are hardened and ground**
Ensures a long service life

Technical data

Description	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]
ROTA-S plus 2.0 160	65	80	6.5
ROTA-S plus 2.0 200	100	120	7
ROTA-S plus 2.0 250	160	210	7.7
ROTA-S plus 2.0 315	180	220	9.9
ROTA-S plus 400	230	280	12
ROTA-S plus 500	270	320	12

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

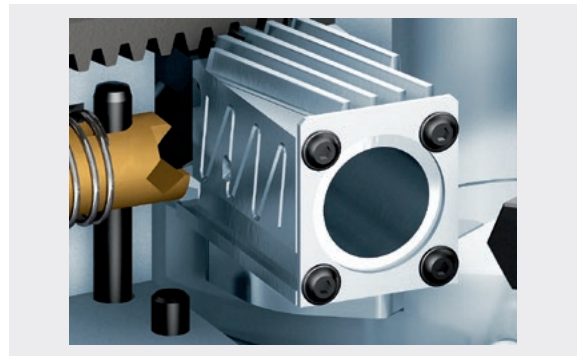
Spindel with hexagon connection

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



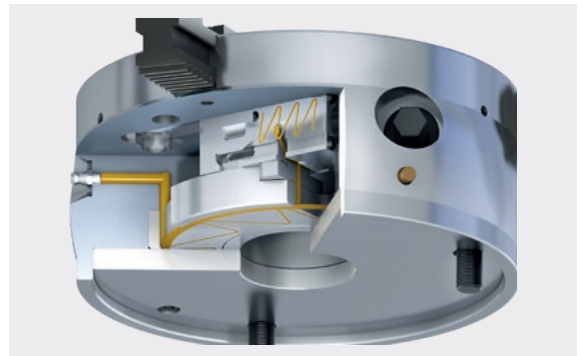
Wedge bar system with wiper

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

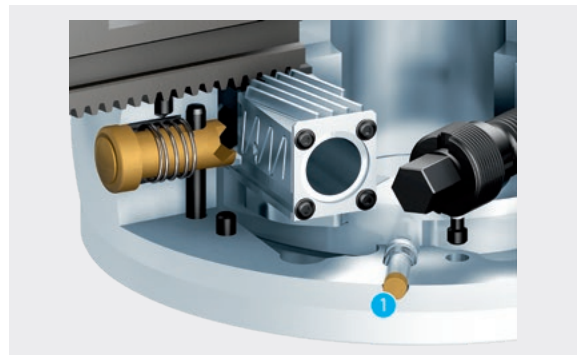
Two lubrication nipples positioned on the chuck body facilitate lubrication of all functional surfaces. The special shape of the grease grooves ensures constant lubrication of the friction surfaces. This improves the clamping behavior during operation.



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.

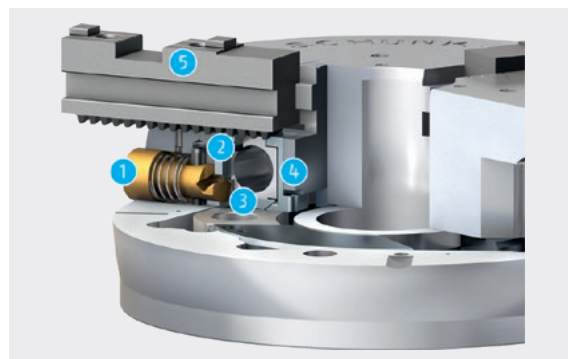
1 Indicator pin



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.

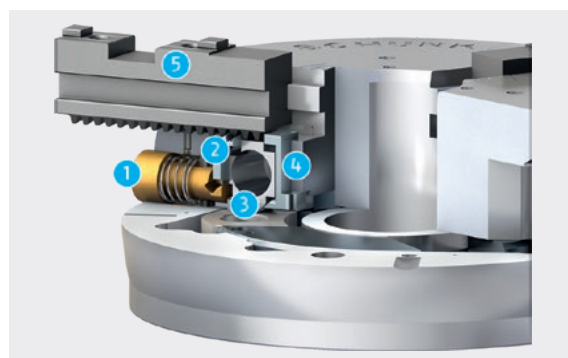
- ① Push button
- ② Slide
- ③ Traverse slide
- ④ Locking slide
- ⑤ Base jaw



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



Stationary 3-jaw chuck, manually actuated

With base plate "K" or with straight recess mount "Z"

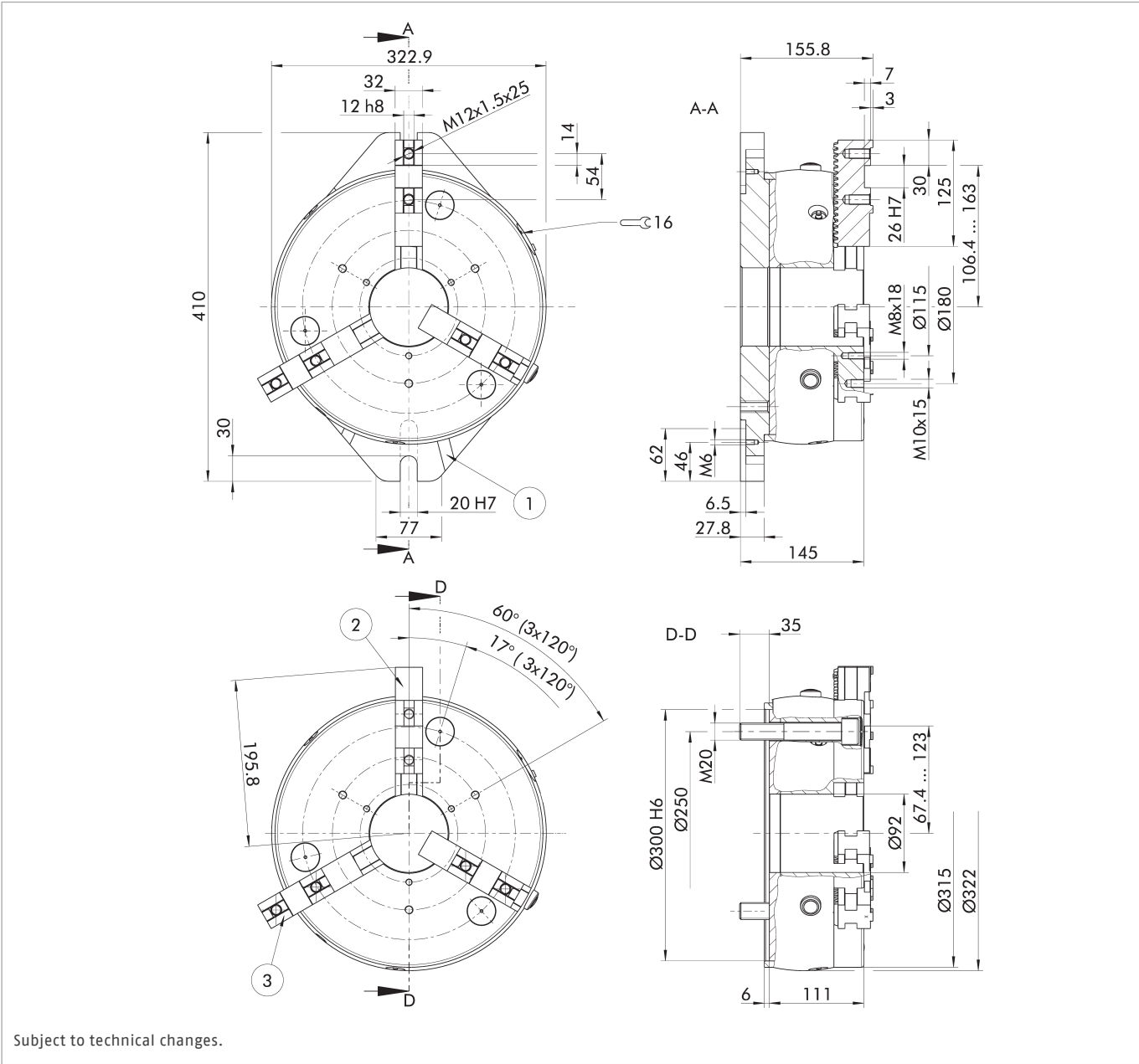
Scope of delivery

Manual lathe chuck, base jaws with tongue and groove, mounting screws, spanner wrench, SCHUNK magnets, quick guide, operating manual; without top jaws

Technical data

Description	ID	Mounting	Max. clamping force [kN]	Max. torque [Nm]	Stroke per jaw [mm]	Tooth pitch [mm]	Weight [kg]
ROTA-S plus 2.0 315 Z300-SFG	0819914	Centering recess	180	220	9.9	7	54.2
ROTA-S plus 2.0 315 K-SFG	0819924	Consol plate	180	220	9.9	7	80

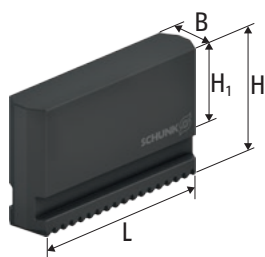
2-jaw chuck available upon request



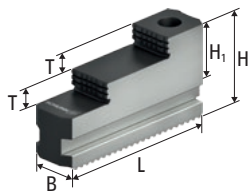
- ① Water drainage grooves
- ② Position of base jaws I

- ③ Position of base jaws II

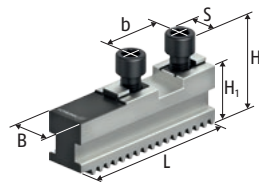
Base jaws, Hard stepped block jaws, Soft monoblock jaws with angled serration



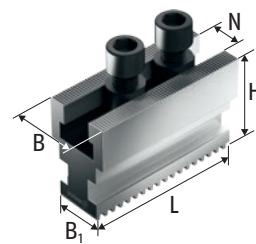
SMB
Soft monoblock jaws



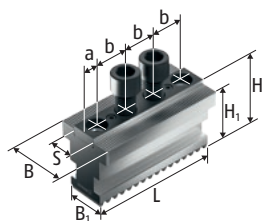
STF
Hard stepped block jaws



SFG
Base jaws



STB
Base jaws



STN
Base jaws

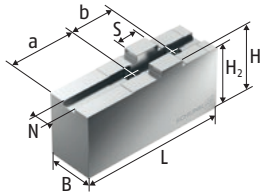
Technical data

Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	B1 [mm]	H [mm]	H1 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-S plus 2.0 315	SMB 315	0163103			32		81	46	140					7.5
ROTA-S plus 2.0 315	SMB-H 315	0163203			32		135	100	140					13.0
ROTA-S plus 2.0 315	SFG 315	0157103	26	12	32		46	43	125			54	M12x1.5	3.1
ROTA-S plus 2.0 315	SFGL 315	0157123	26	12	32		46	43	160			54	M12x1.5	4.0
ROTA-S plus 2.0 315	STB 315-2	0156103	21		54	32	75		125				M16	9.3
ROTA-S plus 2.0 315	STN 315-4	0160503		21	45	32	57.5	55	110		13	28	M16	4.5
ROTA-S plus 2.0 315	STF 315	0161103			32		81	46	129.1	15				5.5

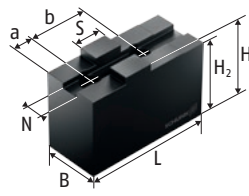
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Soft top jaws

with tongue and groove



SFA-AL
Soft top jaws



SFA
Soft top jaws

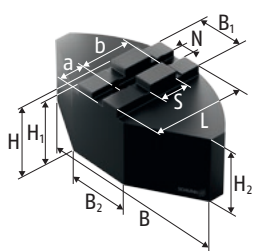
Technical data

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-S plus 2.0 315	SFA 315	0153103	12	26	35	60	54	145	60	54	M12	5.6
ROTA-S plus 2.0 315	SFA-AL 315	0172104	12	26	40	60	54	145	60	54	M12	2.4
ROTA-S plus 2.0 315	SFA 315-C1	0154108	12	26	40	60	54	110	40	54	M12	4.9
ROTA-S plus 2.0 315	SFA 315-C2	0154109	12	26	40	60	54	145	75	54	M12	6.6
ROTA-S plus 2.0 315	SFA 315-C3	0154110	12	26	40	100	94	145	75	54	M12	11.4
ROTA-S plus 2.0 315	SFA 315-C4	0154111	12	26	40	120	114	145	75	54	M12	13.8
ROTA-S plus 2.0 315	SFA 315-C5	0154112	12	26	40	150	144	145	75	54	M12	17.5
ROTA-S plus 2.0 315	SFA 315-C51	0154123	12	26	50	80	74	145	75	54	M12	11.4
ROTA-S plus 2.0 315	SFA 315-C6	0154113	12	26	60	60	54	110	40	54	M12	7.6
ROTA-S plus 2.0 315	SFA 315-C7	0154114	12	26	80	60	54	110	40	54	M12	10.3
ROTA-S plus 2.0 315	SFA 315-C8	0154115	12	26	80	80	74	110	40	54	M12	14.0

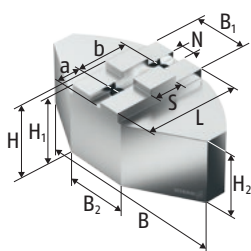
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Hard stepped top jaws, Full grip jaws

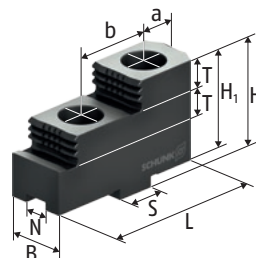
with tongue and groove



SFA-SM
Full grip jaws



SFA-SA
Full grip jaws



SHF
Hard stepped top jaws

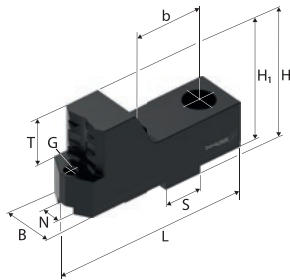
Technical data

Chuck type	Description	ID	N [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-S plus 2.0 315	SFA-SA 315	0174103	12	26	240	45	75	69	60	117		49.75	54	M12	8.0
ROTA-S plus 2.0 315	SFA-SM 315	0173103	12	26	240	45	75	69	60	110		41	54	M12	29.2
ROTA-S plus 2.0 315	SHF 315	0155103	12	26	36		62	56		105	15	22.3	54	M12	3.3

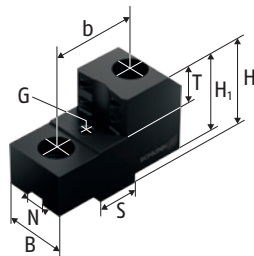
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Claw jaws

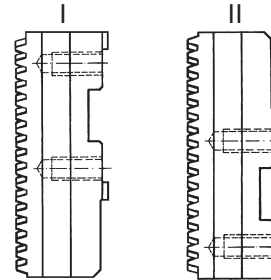
with tongue and groove



SZKA
Claw jaws



SZKA
Claw jaws



Position of base jaws

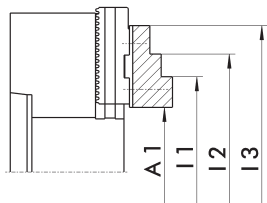
Technical data

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-S plus 2.0 315	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	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	43 - 118	386	II	SZKA 321	0139166	12	26	40	59	53	108	25	M8	54	M12	3.1
ROTA-S plus 2.0 315	118 - 226	386	II	SZKA 324	0139169	12	26	40	59	53	90	25	M8	54	M12	2.8

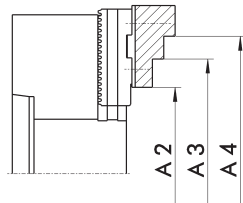
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Hard stepped top jaws

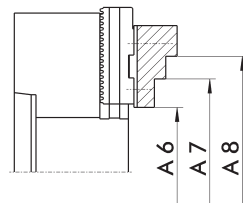
with tongue and groove



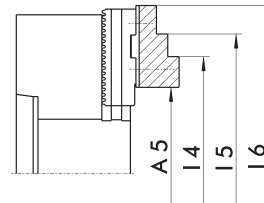
Position of base jaws II



Position of base jaws I



Position of base jaws II



Position of base jaws I

O.D. clamping

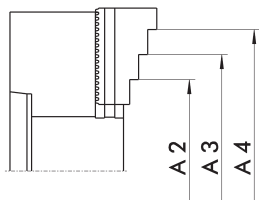
Chuck type	Description	ID	A1 [mm]	A3 [mm]	A4 [mm]	A5 [mm]	A7 [mm]	A8 [mm]
ROTA-S plus 2.0 315	SHF 315	0155103	14 - 122	98 - 209	207 - 318	91 - 202	26 - 130	135 - 239

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I4 [mm]
ROTA-S plus 2.0 315	SHF 315	0155103	94 - 201	201 - 310	169 - 281

Hard stepped block jaws

with tongue and groove



Jaw position II

O.D. clamping

Chuck type	Description	ID	A1 [mm]	A2 [mm]	A4 [mm]
ROTA-S plus 2.0 315	STF 315	0161103	14 - 122	91 - 210	200 - 319

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I3 [mm]
ROTA-S plus 2.0 315	STF 315	0161103	92 - 200	200 - 309

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 2.0 315	IFT Set	1404235

Maintenance kit

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



Suitable for	Description	ID
ROTA-S plus 2.0 315	WTS-S 315	0899017

Torque wrench

Torque wrench for actuation of SCHUNK manual lathe chucks.



Suitable for	Description	ID
ROTA-S plus 2.0 315	SSH-D-1/2" 60-300	1301281

Ratchets

Ratchet for fast actuation of SCHUNK manual lathe chucks.



Suitable for	Description	ID
ROTA-S plus 2.0 315	SSH-K 1/2"-350	1151118

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

Hexagon spanner wrench adapter with ejector

For use as an attachment for a torque wrench and ratchet for actuating SCHUNK manual lathe chucks with hexagonal connection.



Suitable for	Description	ID
ROTA-S plus 2.0 315	SAS-I 1/2"-SW16	8705471

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 2.0 315	KSL 315	0814273

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 2.0 315	VST Ø92	8702869

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 2.0 315	SPS 315	9966641

Grease gun

Auxiliary tools for lubrication of all kinds of SCHUNK tools 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