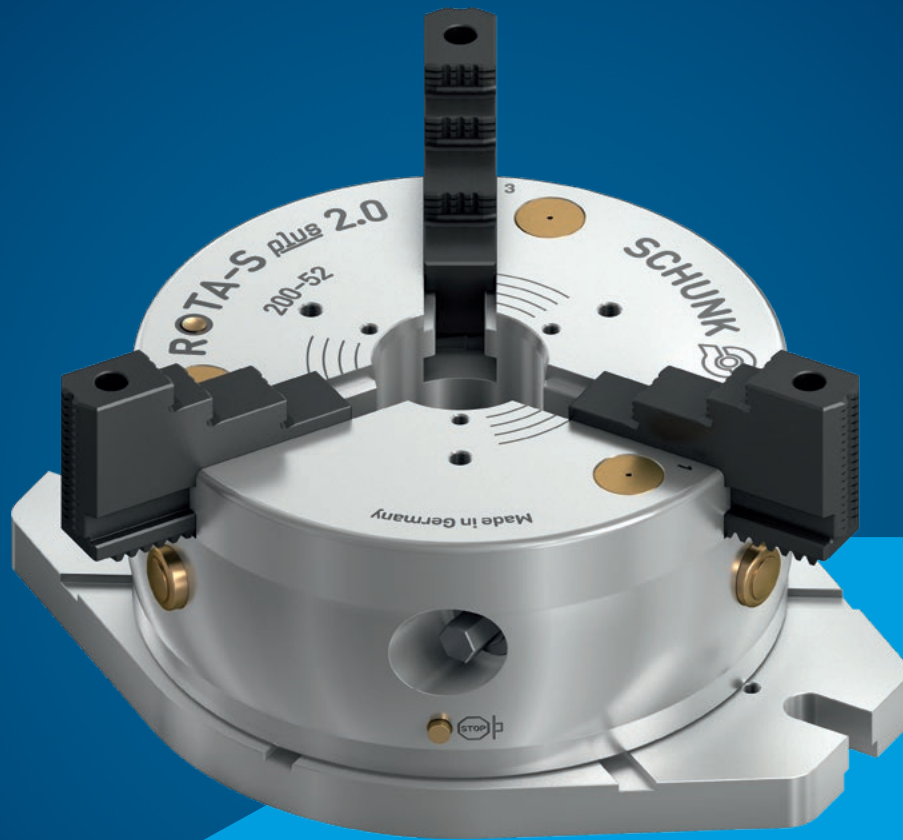


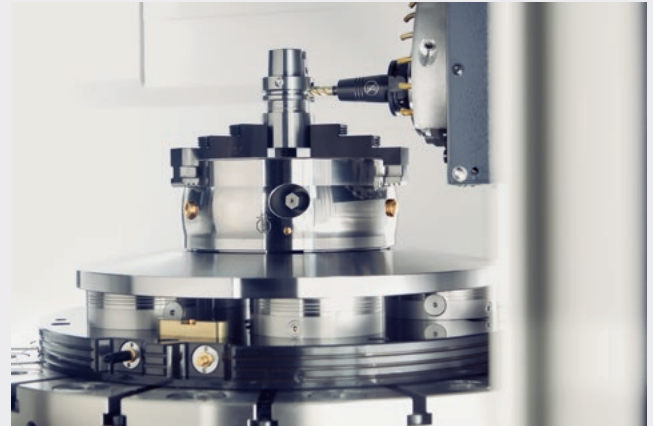


ROTA-S *plus* 2.0

**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

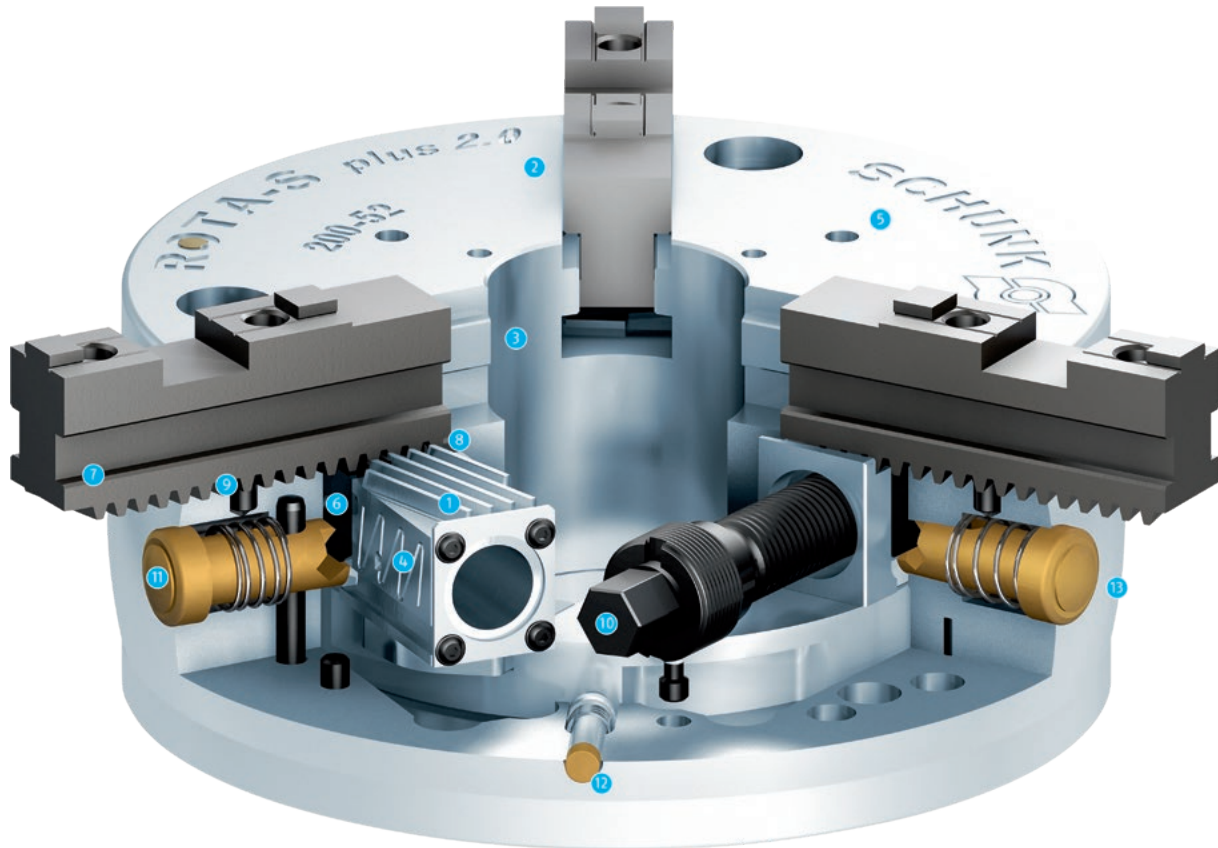
- + Convenient jaw quick-change system**
Minimizing set-up times and costs
- + High efficiency of the wedge bar system**
Process-reliable clamping due to high clamping forces
- + High jaw quick-change repeat accuracy**
No reboring of already machined jaws necessary
- + Visual safety devices**
Maximum 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> |
|---|--|

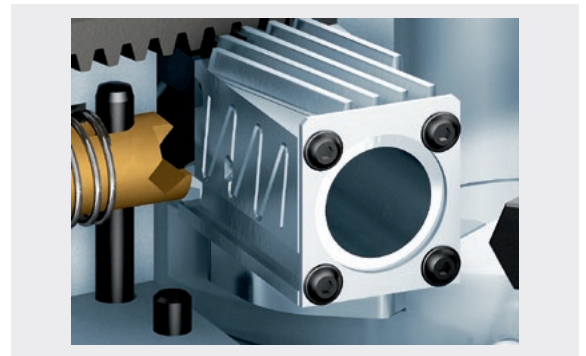
Spindel with hexagon connection

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



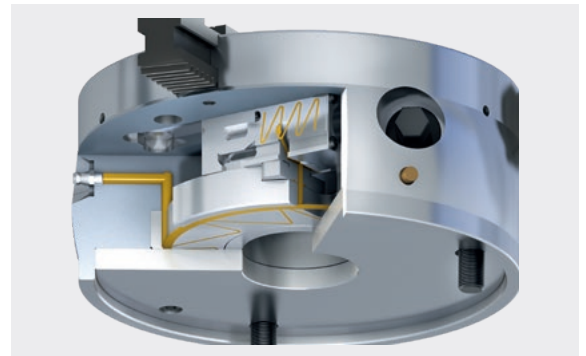
Wedge bar system with wiper

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

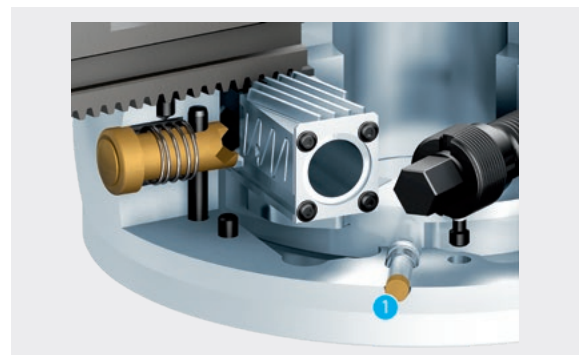
Two lubrication nipples positioned on the chuck body facilitate lubrication of all functional surfaces. The special shape of the grease grooves ensures constant lubrication of the friction surfaces. This improves the clamping behavior during operation.



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.

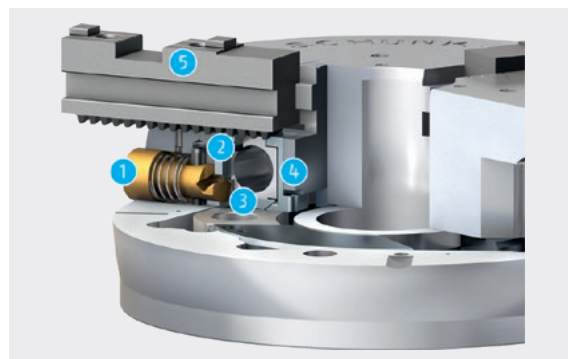
1 Indicator pin



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.

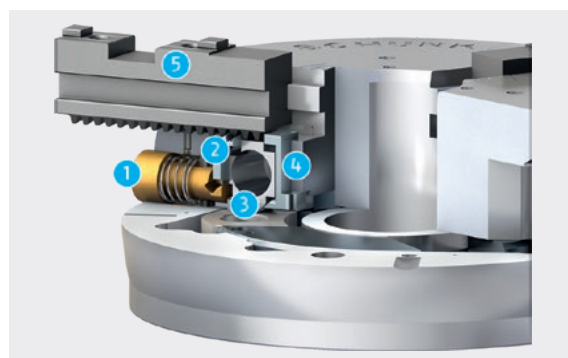
- ① Push button
- ② Slide
- ③ Traverse slide
- ④ Locking slide
- ⑤ Base jaw



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"

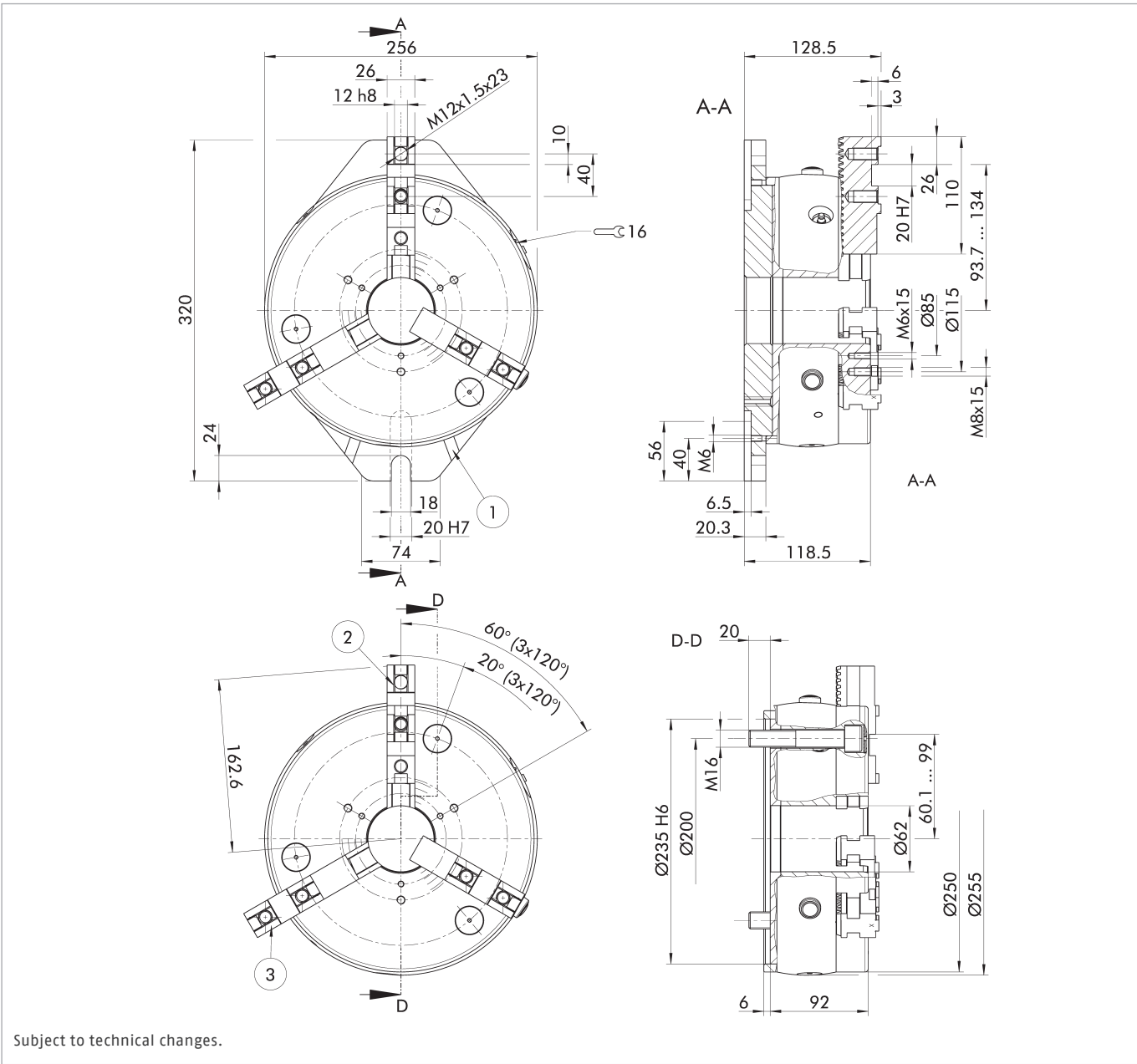
Scope of delivery

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 2.0 250 Z235-SFG	0819913	Centering recess	160	210	7.7	6	28.8
ROTA-S plus 2.0 250 K-SFG	0819923	Consol plate	160	210	7.7	6	42.2

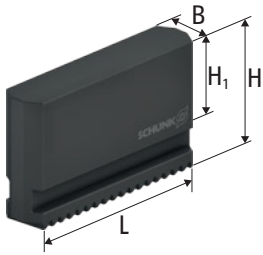
2-jaw chuck available upon request



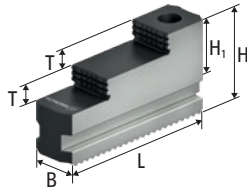
- ① Water drainage grooves
② Position of base jaws I

- ③ Position of base jaws II

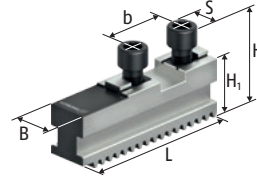
Base jaws, Hard stepped block jaws, Soft monoblock jaws with angled serration



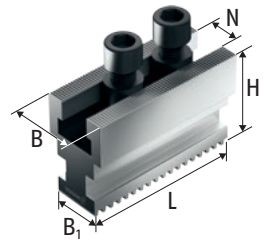
SMB
Soft monoblock jaws



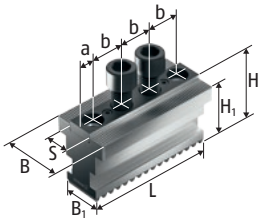
STF
Hard stepped block jaws



SFG
Base jaws



STB
Base jaws



STN
Base jaws

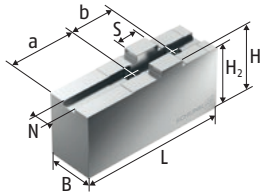
Technical data

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 2.0 250	SMB 250	0163102			26		70	40	115					4.4
ROTA-S plus 2.0 250	SMB-H 250	0163202			26		100	70	115					6.5
ROTA-S plus 2.0 250	SFG 250	0157102	20	12	26		40	37	110			40	M12x1.5	1.8
ROTA-S plus 2.0 250	SFGL 250	0157112	20	12	26		40	37	122			40	M12x1.5	2.0
ROTA-S plus 2.0 250	STB 250-1	0156100	17		45	26	65		110				M12	4.9
ROTA-S plus 2.0 250	STB 250-2	0156101	21		54	26	70		110				M16	5.2
ROTA-S plus 2.0 250	STN 250-4	0160501		21	45	26	52.5	50	110		13	28	M16	4.2
ROTA-S plus 2.0 250	STF 250	0161102			26		70	40	114	14				3.3

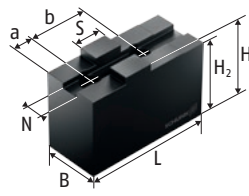
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Soft top jaws

with tongue and groove



SFA-AL
Soft top jaws



SFA
Soft top jaws

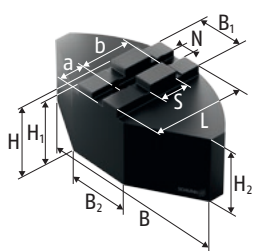
Technical data

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 2.0 250	SFA 250	0153102	12	20	30	55.5	50.5	125	60	40	M12	3.7
ROTA-S plus 2.0 250	SFA-AL 250	0172103	12	20	40	60	55	125	60	40	M12	2.1
ROTA-S plus 2.0 250	SFA 250-C1	0154101	12	20	40	60	55	90	34	40	M12	3.9
ROTA-S plus 2.0 250	SFA 250-C2	0154102	12	20	40	60	55	125	69	40	M12	5.6
ROTA-S plus 2.0 250	SFA 250-C3	0154103	12	20	40	80	75	125	69	40	M12	7.7
ROTA-S plus 2.0 250	SFA 250-C4	0154104	12	20	40	100	95	125	69	40	M12	9.8
ROTA-S plus 2.0 250	SFA 250-C5	0154105	12	20	40	120	115	125	69	40	M12	11.8
ROTA-S plus 2.0 250	SFA 250-C6	0154106	12	20	60	60	55	90	34	40	M12	6.0
ROTA-S plus 2.0 250	SFA 250-C7	0154107	12	20	80	60	55	90	34	40	M12	8.5
ROTA-S plus 2.0 250	SFA 250-C8	0154134	12	20	80	100	95	125	69	40	M12	20.6

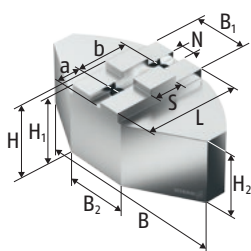
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](https://www.schunk.com)

Hard stepped top jaws, Full grip jaws

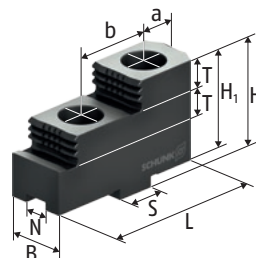
with tongue and groove



SFA-SM
Full grip jaws



SFA-SA
Full grip jaws



SHF
Hard stepped top jaws

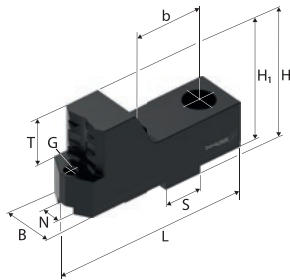
Technical data

Chuck type	Description	ID	N [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 2.0 250	SFA-SA 250	0174102	12	20	180	40	58	53	43	87.5		33.75	40	M12	3.4
ROTA-S plus 2.0 250	SFA-SA 251	0174106	12	20	180	40	80	75	65	87.5		33.75	40	M12	5.0
ROTA-S plus 2.0 250	SFA-SM 250	0173102	12	20	180	40	60	55	45	90		34.5	40	M12	12.8
ROTA-S plus 2.0 250	SFA-SM 251	0173106	12	20	180	40	80	75	65	90		35	40	M12	18.9
ROTA-S plus 2.0 250	SHF 250	0155102	12	20	30		55	50		90	14	21.1	40	M12	1.9

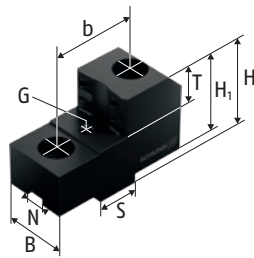
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Claw jaws

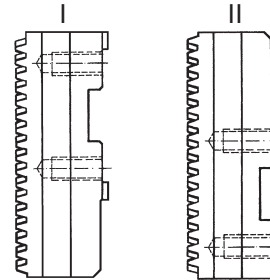
with tongue and groove



SZKA
Claw jaws



SZKA
Claw jaws



Position of base jaws

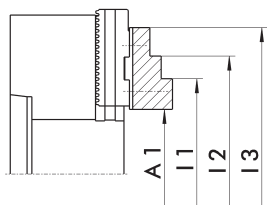
Technical data

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 2.0 250	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	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	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	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	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	118 – 188	322	II	SZKA 268	0139165	12	20	40	55	50	83	25	M6	40	M12	2.2

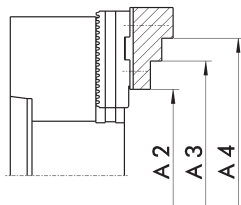
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Hard stepped top jaws

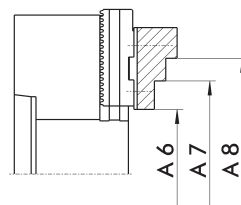
with tongue and groove



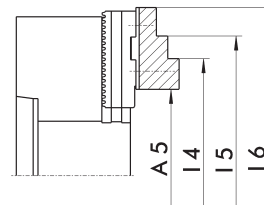
Position of base jaws II



Position of base jaws I



Position of base jaws II



Position of base jaws I

O.D. clamping

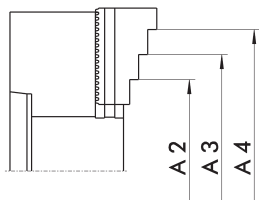
Chuck type	Description	ID	A1 [mm]	A3 [mm]	A4 [mm]	A5 [mm]	A7 [mm]	A8 [mm]
ROTA-S plus 2.0 250	SHF 250	0155102	11 - 96	91 - 170	171 - 250	87 - 166	41 - 100	121 - 180

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I4 [mm]
ROTA-S plus 2.0 250	SHF 250	0155102	92 - 175	171 - 255	166 - 245

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 2.0 250	STF 250	0161102	8 - 92	85 - 167	165 - 247

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I3 [mm]
ROTA-S plus 2.0 250	STF 250	0161102	89 - 171	168 - 251

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 2.0 250	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 2.0 250	WTS-S 250	0899016

Torque wrench

Torque wrench for actuation of SCHUNK manual lathe chucks.



Suitable for	Description	ID
ROTA-S plus 2.0 250	SSH-D-1/2" 60-300	1301281

Ratchets

Ratchet for fast actuation of SCHUNK manual lathe chucks.



Suitable for	Description	ID
ROTA-S plus 2.0 250	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 2.0 250	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 2.0 250	KSL 250	0814272

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 2.0 250	VST Ø62	8702868

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 2.0 250	SPS 250	9966640

Grease gun

Auxiliary tools for lubrication of all kinds of SCHUNK tools. 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