

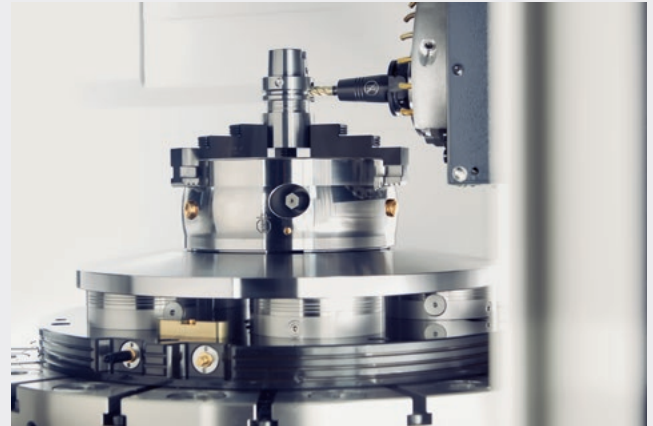


ROTA-S *plus* 2.0

**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

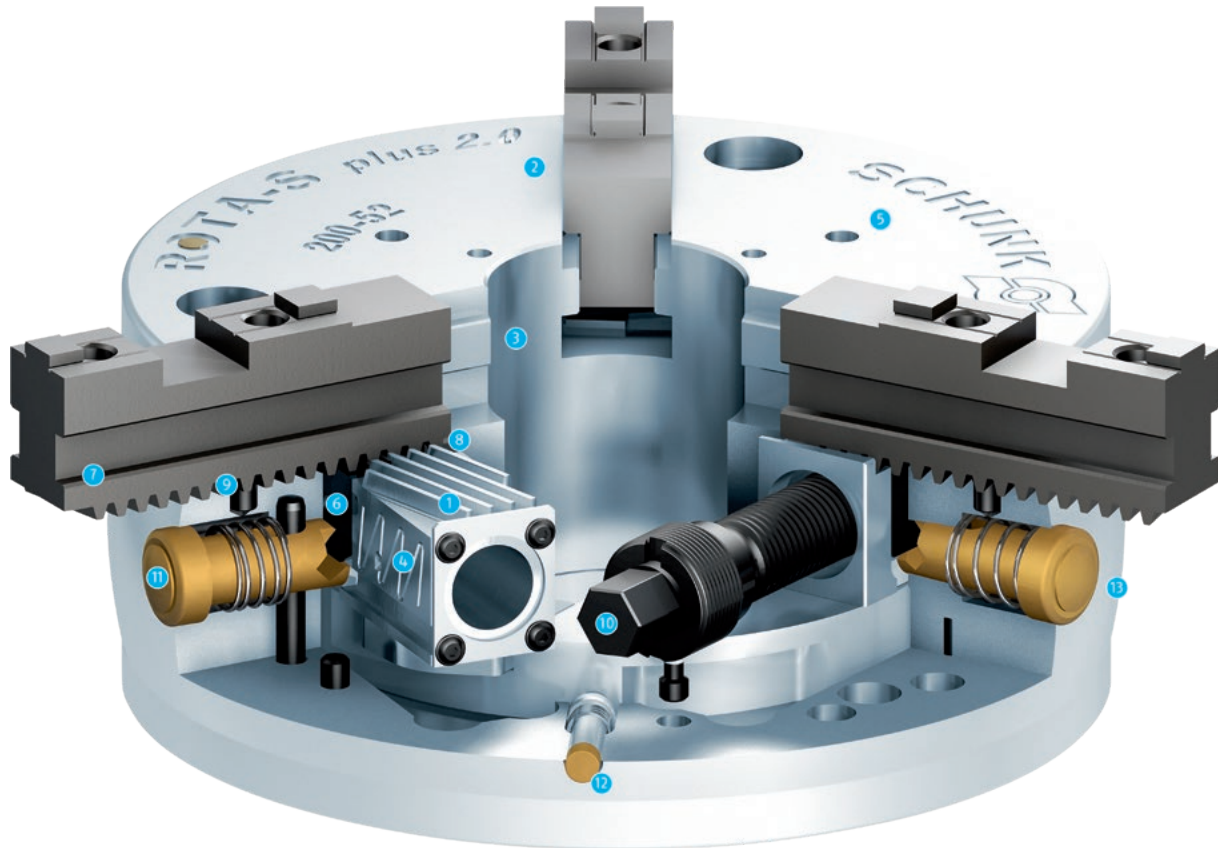
- + Convenient jaw quick-change system**
Minimizing set-up times and costs
- + High efficiency of the wedge bar system**
Process-reliable clamping due to high clamping forces
- + High jaw quick-change repeat accuracy**
No reboring of already machined jaws necessary
- + Visual safety devices**
Maximum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

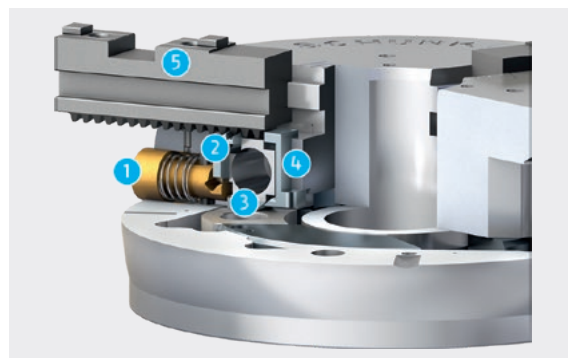
- ① Push button
- ② Slide
- ③ Traverse slide
- ④ Locking slide
- ⑤ Base jaw



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



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

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

Description	ID	Mounting	Max. clamping force [kN]	Max. torque [Nm]	Stroke per jaw [mm]	Tooth pitch [mm]	Weight [kg]
ROTA-S plus 2.0 160 Z145-SFG	0819911	Centering recess	65	80	6.5	4.8	7.9
ROTA-S plus 2.0 160 K-SFG	0819921	Consol plate	65	80	6.5	4.8	12

Technical drawing of a 3-ported hydraulic valve, showing front, top, and side views with dimensions in mm.

Front View (Top):

- Overall width: 165
- Overall height: 220
- Port diameter: $\varnothing 16$
- Port spacing: 20
- Port thread: M8x16
- Port hole diameter: 8 h8
- Port hole depth: 7
- Port hole distance from center: 32
- Port hole distance from edge: 12
- Port hole distance from center (bottom): 14
- Port hole distance from edge (bottom): 20 H7
- Port hole distance from center (bottom): 71
- Port hole distance from edge (bottom): 24
- Port hole distance from center (bottom): 1

Top View (Bottom):

- Overall width: 107.1
- Port diameter: $\varnothing 16$
- Port spacing: 20
- Port thread: M8x16
- Port hole diameter: 8 h8
- Port hole depth: 7
- Port hole distance from center: 32
- Port hole distance from edge: 12
- Port hole distance from center (bottom): 14
- Port hole distance from edge (bottom): 20 H7
- Port hole distance from center (bottom): 71
- Port hole distance from edge (bottom): 24
- Port hole distance from center (bottom): 1

Side View (Right):

- Overall width: 91.46
- Overall height: 83.5
- Port diameter: $\varnothing 16$
- Port spacing: 20
- Port thread: M8x16
- Port hole diameter: 8 h8
- Port hole depth: 7
- Port hole distance from center: 32
- Port hole distance from edge: 12
- Port hole distance from center (bottom): 14
- Port hole distance from edge (bottom): 20 H7
- Port hole distance from center (bottom): 71
- Port hole distance from edge (bottom): 24
- Port hole distance from center (bottom): 1

Side View (Left):

- Overall width: 16.5
- Overall height: 63.5
- Port diameter: $\varnothing 16$
- Port spacing: 20
- Port thread: M8x16
- Port hole diameter: 8 h8
- Port hole depth: 7
- Port hole distance from center: 32
- Port hole distance from edge: 12
- Port hole distance from center (bottom): 14
- Port hole distance from edge (bottom): 20 H7
- Port hole distance from center (bottom): 71
- Port hole distance from edge (bottom): 24
- Port hole distance from center (bottom): 1

Subject to technical changes.

- ① Water drainage grooves
- ② Position of base jaws I
- ③ Position of base jaws II

Stationary 3-jaw chuck, manually actuated

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

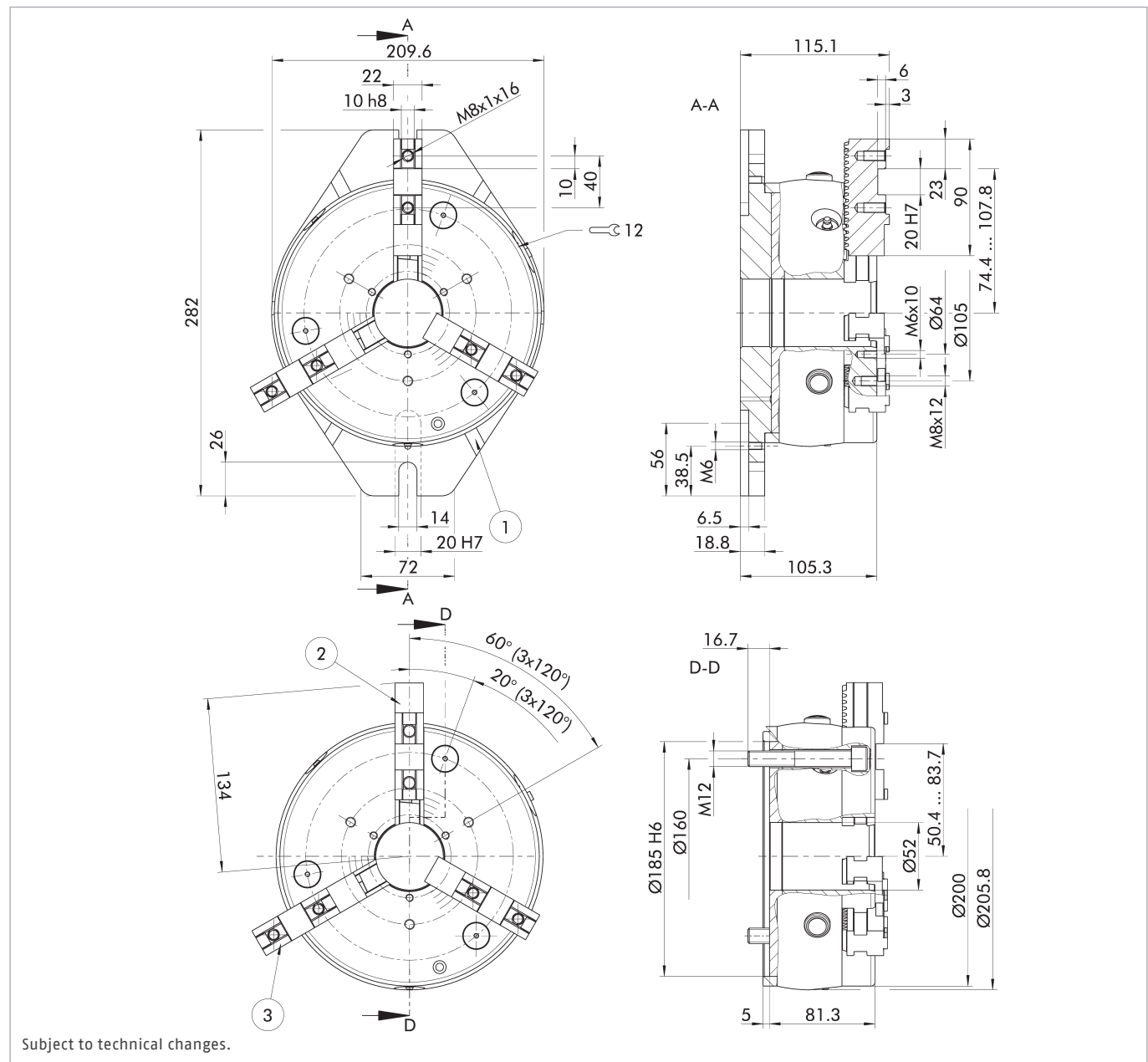
Scope of delivery

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 2.0 200 Z185-SFG	0819912	Centering recess	100	120	7	4.8	16.2
ROTA-S plus 2.0 200 K-SFG	0819922	Consol plate	100	120	7	4.8	25.5

2-jaw chuck available upon request



① Water drainage grooves

② Position of base jaws I

③ Position of base jaws II

Stationary 3-jaw chuck, manually actuated

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

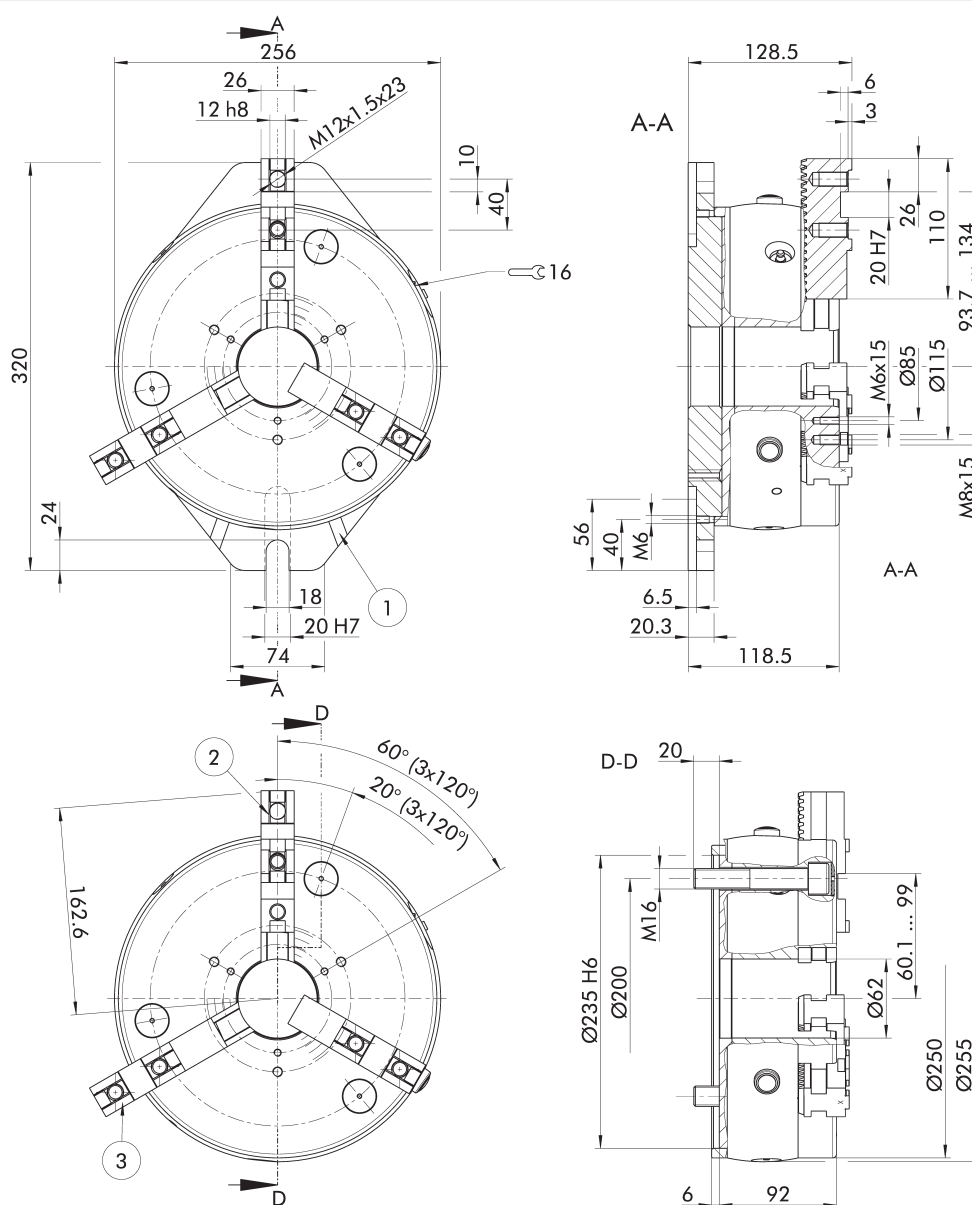
Scope of delivery

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



Subject to technical changes.

- ① Water drainage grooves
② Position of base jaws I
③ Position of base jaws II

Stationary 3-jaw chuck, manually actuated

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

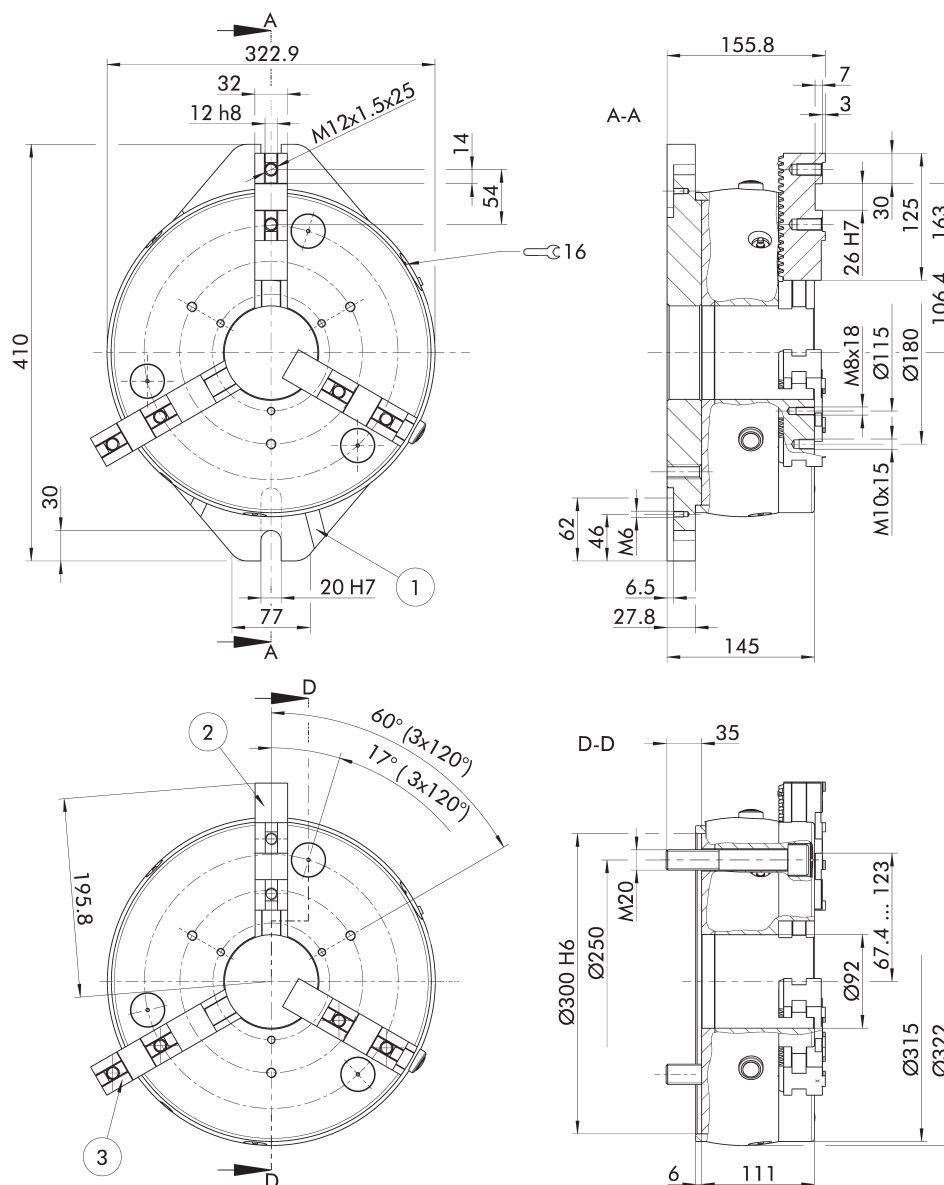
Scope of delivery

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



Subject to technical changes.

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

- ③ Position of base jaws II

Stationary 3-jaw chuck, manually actuated

With straight recess mount "Z"

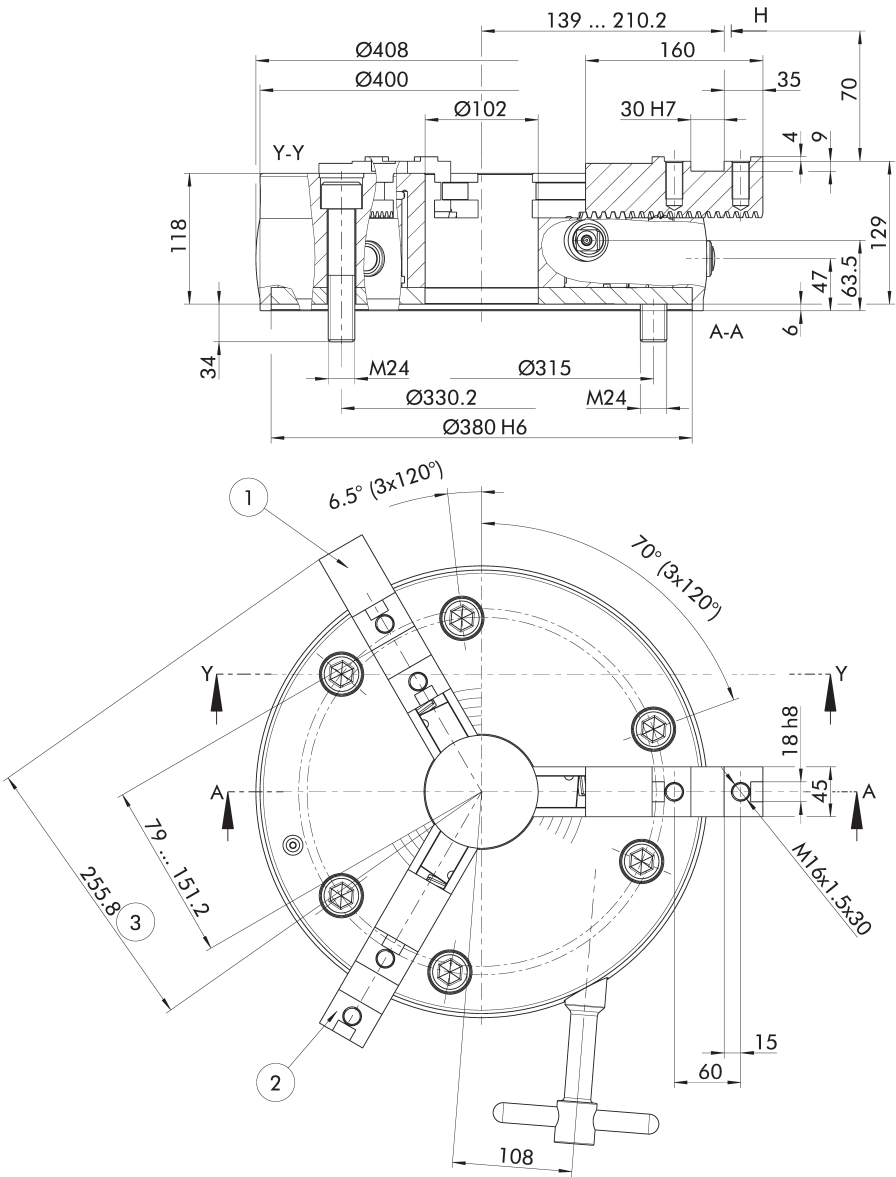
Scope of delivery

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 400 Z380-SFG	0410015	Centering recess	230	280	12	8.5	99

2-jaw chuck available upon request



Subject to technical changes.

- ① Position of base jaws I
- ② Position of base jaws II
- ③ Swing diameter radius

Stationary 3-jaw chuck, manually actuated

With straight recess mount "Z"

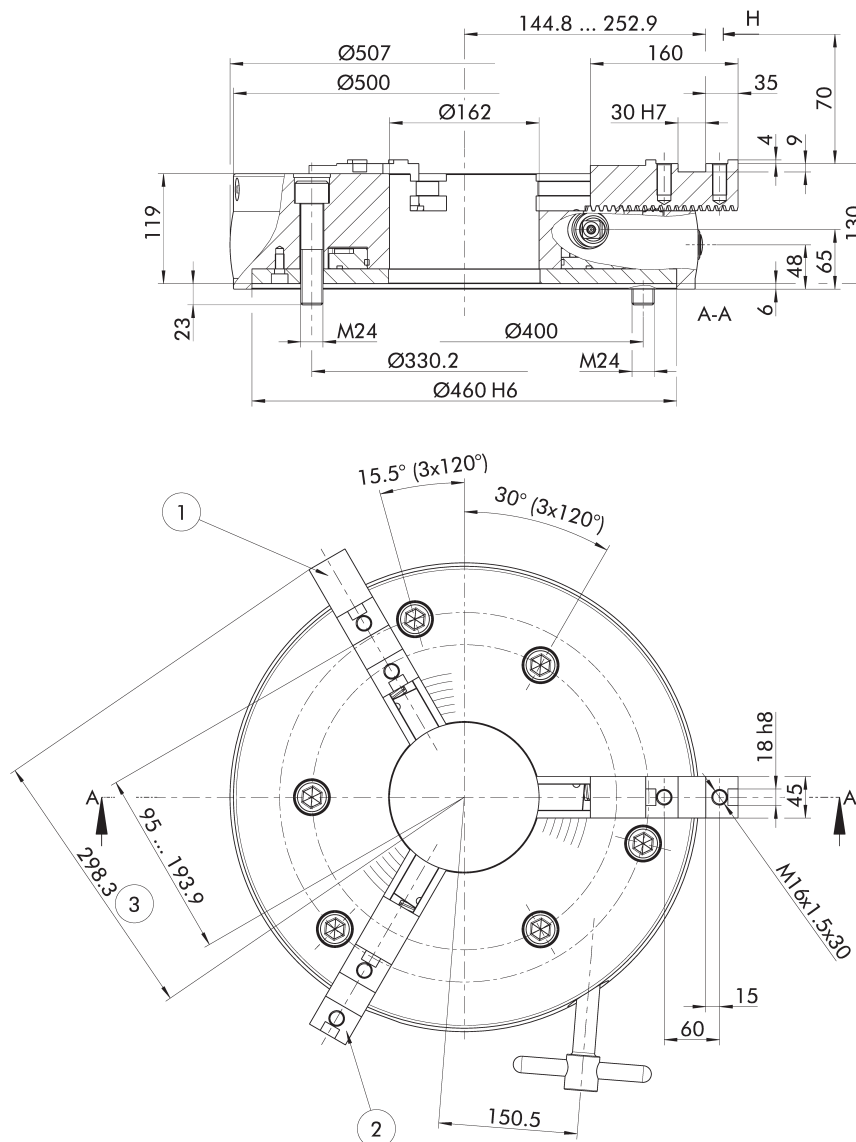
Scope of delivery

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 500 Z460-SFG	0410016	Centering recess	270	320	12	8.5	152

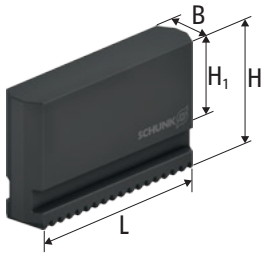
2-jaw chuck available upon request



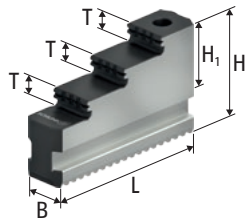
Subject to technical changes.

- ① Position of base jaws I
- ② Position of base jaws II
- ③ Swing diameter radius

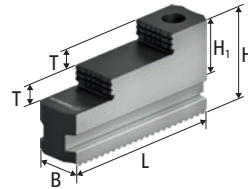
Base jaws, Hard stepped block jaws, Soft monoblock jaws with angled serration



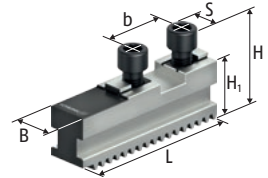
SMB
Soft monoblock jaws



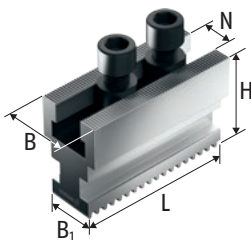
STF
Hard stepped block jaws



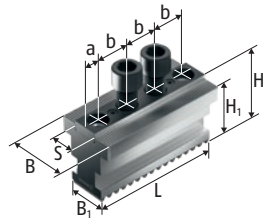
STF
Hard stepped block jaws



SFG
Base jaws



STB
Base jaws



STN
Base jaws

Technical data

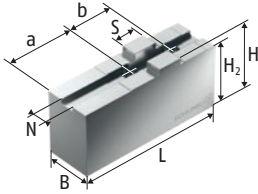
Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	B1 [mm]	H [mm]	H1 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-S plus 2.0 160	SMB 160	0163100			20		45	24	79					1.5
ROTA-S plus 2.0 160	SMB-H 160	0163200			20		60	39	79					2.0
ROTA-S plus 2.0 160	SFG 160	0157100	18	8	20		29.5	27	74			32	M8x1	0.8
ROTA-S plus 2.0 160	SFGK 160	0157500	18	8	20		29.5	27	64			32	M8x1	0.7
ROTA-S plus 2.0 160	STF 160	0161100			20		45	24	79.1	7.5				1.1
ROTA-S plus 2.0 200	SMB 200	0163101			22		60	35	94					2.6
ROTA-S plus 2.0 200	SMB-H 200	0163201			22		80	55	94					3.6
ROTA-S plus 2.0 200	SFG 200	0157101	20	10	22		35	32	90			40	M8x1	1.2
ROTA-S plus 2.0 200	SFGK 200	0157501	20	10	22		35	32	80			40	M8x1	1.1
ROTA-S plus 2.0 200	SFGL 200	0157121	20	10	22		35	32	110			40	M8x1	1.5
ROTA-S plus 2.0 200	STB 200	0156099	17		45	22	61		80				M12	3.4
ROTA-S plus 2.0 200	STF 200	0161101			22		60	35	94.2	10				1.9
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
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
ROTA-S plus 400	SMB 400	0163104			45		93	53	176					15.0

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 400	SMB 500	0163105			45		130	90	176					21.6
ROTA-S plus 400	SFG 400	0157104	30	18	45		55	51	160			60	M16x1.5	6.4
ROTA-S plus 400	SFGL 400	0157124	30	18	45		55	51	200			60	M16x1.5	8.1
ROTA-S plus 400	SFG-V 400	0157154	30	18	45		55	51	165			60	M16x1.5	6.6
ROTA-S plus 400	STB 400-1	0156104	21		54	45	80		160				M16	12.0
ROTA-S plus 400	STB 400-2	0156105	25.5		64	45	82		160				M20	12.2
ROTA-S plus 400	STF 400	0161104			45		93	52	167.1	20				10.8
ROTA-S plus 500	SMB 400	0163104			45		93	53	176					15.0
ROTA-S plus 500	SMB 500	0163105			45		130	90	176					21.6
ROTA-S plus 500	SFG 400	0157104	30	18	45		55	51	160			60	M16x1.5	6.4
ROTA-S plus 500	SFGL 400	0157124	30	18	45		55	51	200			60	M16x1.5	8.1
ROTA-S plus 500	SFG-V 400	0157154	30	18	45		55	51	165			60	M16x1.5	6.6
ROTA-S plus 500	STB 400-1	0156104	21		54	45	80		160				M16	12.0
ROTA-S plus 500	STB 400-2	0156105	25.5		64	45	82		160				M20	12.2
ROTA-S plus 500	STF 400	0161104			45		93	52	167.1	20				10.8

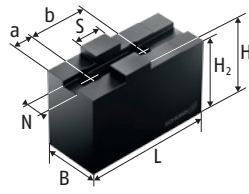
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on [schunk.com](https://www.schunk.com)

Soft top jaws

with tongue and groove



SFA-AL
Soft top jaws



SFA
Soft top jaws

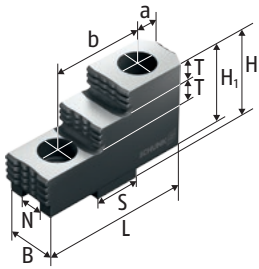
Technical data

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 2.0 160	SFA 160	0153100	8	18	20	40	36	85	35	32	M8	1.2
ROTA-S plus 2.0 160	SFA-AL 160	0172100	8	18	25	50	46	85	35	32	M8	0.7
ROTA-S plus 2.0 160	SFA 160-C1	0154121	8	18	30	55.5	51.5	85	41	32	M8	2.7
ROTA-S plus 2.0 160	SFA 160-C2	0154127	8	18	35	40	36	63	19	32	M8	1.6
ROTA-S plus 2.0 160	SFA 160-C3	0154131	8	18	40	60	56	70	26	32	M8	3.3
ROTA-S plus 2.0 160	SFA 160-C4	0154133	8	18	40	80	76	85	41	32	M8	5.6
ROTA-S plus 2.0 200	SFA 200	0153101	10	20	22	47	43	105	40	40	M8	2.0
ROTA-S plus 2.0 200	SFA-AL 200	0172102	10	20	25	50	46	105	40	40	M8	0.9
ROTA-S plus 2.0 200	SFA 200-C1	0154100	10	20	30	55.5	51.5	100	47	40	M8	3.2
ROTA-S plus 2.0 200	SFA 200-C2	0154124	10	20	22	55.5	51.5	100	47	40	M8	2.2
ROTA-S plus 2.0 200	SFA 200-C3	0154128	10	20	40	40	36	70	17	40	M8	2.1
ROTA-S plus 2.0 200	SFA 200-C4	0154130	10	20	40	60	56	85	32	40	M8	4.0
ROTA-S plus 2.0 200	SFA 200-C5	0154132	10	20	40	80	76	95	42	40	M8	6.1
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
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
ROTA-S plus 400	SFA 400	0153104	18	30	50	80	73	180	85	60	M16	13.7
ROTA-S plus 400	SFA-AL 400	0172105	18	30	50	80	73	180	85	60	M16	6.3
ROTA-S plus 400	SFA 400-C1	0154116	18	30	60	80	73	130	50	60	M16	11.8
ROTA-S plus 400	SFA 400-C3	0154118	18	30	60	100	93	155	75	60	M16	18.2
ROTA-S plus 400	SFA 400-C4	0154119	18	30	60	120	113	155	75	60	M16	22.1
ROTA-S plus 400	SFA 400-C5	0154120	18	30	80	80	73	130	50	60	M16	16.0
ROTA-S plus 400	SFA 400-C6	0154125	18	30	58	180	173	160	80	60	M16	33.6

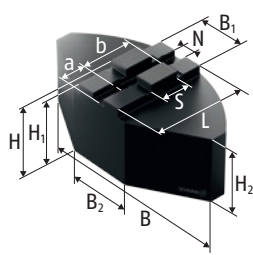
Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	H [mm]	H2 [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA-S plus 400	SFA 400-C7	0154135	18	30	96	115	108	115	35	60	M16	25.2
ROTA-S plus 500	SFA 400	0153104	18	30	50	80	73	180	85	60	M16	13.7
ROTA-S plus 500	SFA-AL 400	0172105	18	30	50	80	73	180	85	60	M16	6.3
ROTA-S plus 500	SFA 400-C1	0154116	18	30	60	80	73	130	50	60	M16	11.8
ROTA-S plus 500	SFA 400-C3	0154118	18	30	60	100	93	155	75	60	M16	18.2
ROTA-S plus 500	SFA 400-C4	0154119	18	30	60	120	113	155	75	60	M16	22.1
ROTA-S plus 500	SFA 400-C5	0154120	18	30	80	80	73	130	50	60	M16	16.0
ROTA-S plus 500	SFA 400-C6	0154125	18	30	58	180	173	160	80	60	M16	33.6
ROTA-S plus 500	SFA 400-C7	0154135	18	30	96	115	108	115	35	60	M16	25.2

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

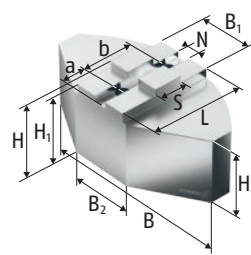
Hard stepped top jaws, Full grip jaws with tongue and groove



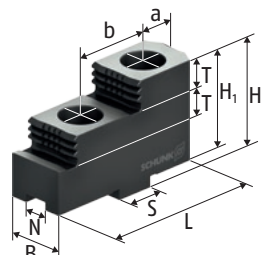
SHF
Hard stepped top jaws



SFA-SM
Full grip jaws



SFA-SA
Full grip jaws



SHF
Hard stepped top jaws

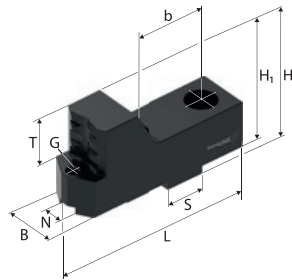
Technical data

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 2.0 160	SFA-SA 160	0174100	8	18	120	35	50	46	40	59.5		15.75	32	M8	1.4
ROTA-S plus 2.0 160	SFA-SM 160	0173100	8	18	120	30	50	46	40	60		16.5	32	M8	4.8
ROTA-S plus 2.0 160	SHF 160	0155100	8	18	20		36.5	32.5		63	7.5	16.8	32	M8	0.6
ROTA-S plus 2.0 200	SFA-SA 200	0174101	10	20	140	35	58	54	48	72.5		21.75	40	M8	2.4
ROTA-S plus 2.0 200	SFA-SA 201	0174105	10	20	140	35	80	76	70	72.5		21.75	40	M8	3.5
ROTA-S plus 2.0 200	SFA-SM 200	0173101	10	20	140	35	60	56	50	70		18	40	M8	9.0
ROTA-S plus 2.0 200	SFA-SM 201	0173105	10	20	140	35	80	76	70	70		18	40	M8	12.5
ROTA-S plus 2.0 200	SHF 200	0155101	10	20	22		42	38		71.7	10	16	40	M8	0.8
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
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
ROTA-S plus 400	SFA-SA 400	0174104	18	30	330	60	90	83	60	160		81	60	M16	16.3
ROTA-S plus 400	SFA-SM 400	0173104	18	30	330	45	85	78	55	160		81	60	M16	55.2
ROTA-S plus 400	SHF 400	0155104	18	30	45		82	75		130	20	27.05	60	M16	6.8
ROTA-S plus 500	SFA-SA 400	0174104	18	30	330	60	90	83	60	160		81	60	M16	16.3
ROTA-S plus 500	SFA-SM 400	0173104	18	30	330	45	85	78	55	160		81	60	M16	55.2
ROTA-S plus 500	SHF 400	0155104	18	30	45		82	75		130	20	27.05	60	M16	6.8

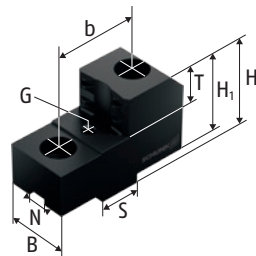
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Claw jaws

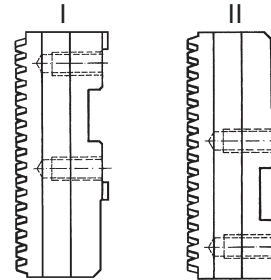
with tongue and groove



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 2.0 160	89 – 135	220	I	SZKA 163	0165146	8	18	40	44	40	60	20	M6	32	M8	1.5
ROTA-S plus 2.0 160	140 – 186	250	I	SZKA 167	0165150	8	18	30	44	40	76	20	M6	32	M8	1.3
ROTA-S plus 2.0 160	42 – 87	210	I	SZKA 169	0165174	8	18	26	44	40	71	20	M6	32	M8	1.0
ROTA-S plus 2.0 160	54 – 99	209	II	SZKA 163	0165146	8	18	40	44	40	60	20	M6	32	M8	1.5
ROTA-S plus 2.0 160	104 – 150	215	II	SZKA 167	0165150	8	18	30	44	40	76	20	M6	32	M8	1.3
ROTA-S plus 2.0 160	26 – 52	209	II	SZKA 169	0165174	8	18	26	44	40	71	20	M6	32	M8	1.0
ROTA-S plus 2.0 200	29 – 95	264	I	SZKA 212	0139153	10	20	26	49	45	93	25	M6	40	M8	1.4
ROTA-S plus 2.0 200	104 – 170	264	I	SZKA 213	0139154	10	20	30	49	45	67	25	M6	40	M8	1.3
ROTA-S plus 2.0 200	139 – 205	270	I	SZKA 216	0139159	10	20	30	49	45	70	25	M6	40	M8	1.2
ROTA-S plus 2.0 200	25 – 47	263	II	SZKA 212	0139153	10	20	26	49	45	93	25	M6	40	M8	1.4
ROTA-S plus 2.0 200	63 – 122	263	II	SZKA 213	0139154	10	20	30	49	45	67	25	M6	40	M8	1.3
ROTA-S plus 2.0 200	98 – 157	263	II	SZKA 216	0139159	10	20	30	49	45	70	25	M6	40	M8	1.2
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
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
ROTA-S plus 400	131 – 271	494	I	SZKA 409	0139170	18	30	50	78	71	126	33	M8	60	M16	6.0
ROTA-S plus 400	232 – 373	494	I	SZKA 412	0139173	18	30	50	78	71	103	33	M8	60	M16	5.1
ROTA-S plus 400	50 – 154	495	II	SZKA 409	0139170	18	30	50	78	71	126	33	M8	60	M16	6.0
ROTA-S plus 400	123 – 255	495	II	SZKA 412	0139173	18	30	50	78	71	103	33	M8	60	M16	5.1
ROTA-S plus 500	132 – 356	579	I	SZKA 409	0139170	18	30	50	78	71	126	33	M8	60	M16	6.0
ROTA-S plus 500	233 – 458	579	I	SZKA 412	0139173	18	30	50	78	71	103	33	M8	60	M16	5.1
ROTA-S plus 500	50 – 238	580	II	SZKA 409	0139170	18	30	50	78	71	126	33	M8	60	M16	6.0
ROTA-S plus 500	123 – 340	580	II	SZKA 412	0139173	18	30	50	78	71	103	33	M8	60	M16	5.1

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

Hard stepped block jaws

with tongue and groove



Jaw position I



Jaw position II

O.D. clamping

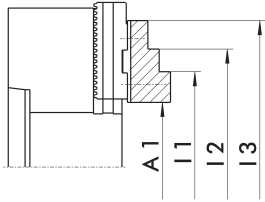
Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]
ROTA-S plus 2.0 160	STF 160	0161100	7 - 49	47 - 93	92 - 138	117 - 163
ROTA-S plus 2.0 200	STF 200	0161101	7 - 72	61 - 128	113 - 179	140 - 207
ROTA-S plus 2.0 250	STF 250	0161102	8 - 92	85 - 167		165 - 247
ROTA-S plus 2.0 315	STF 315	0161103	14 - 122	91 - 210		200 - 319
ROTA-S plus 400	STF 400	0161104	19 - 158	137 - 281		260 - 402
ROTA-S plus 500	STF 400	0161104	19 - 243	140 - 365		262 - 488

I.D. clamping

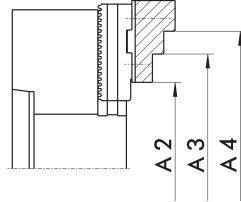
Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA-S plus 2.0 160	STF 160	0161100	62 - 104	87 - 129	132 - 174
ROTA-S plus 2.0 200	STF 200	0161101	71 - 135	98 - 162	149 - 214
ROTA-S plus 2.0 250	STF 250	0161102	89 - 171		168 - 251
ROTA-S plus 2.0 315	STF 315	0161103	92 - 200		200 - 309
ROTA-S plus 400	STF 400	0161104	124 - 260		244 - 383
ROTA-S plus 500	STF 400	0161104	124 - 345		244 - 468

Hard stepped top jaws

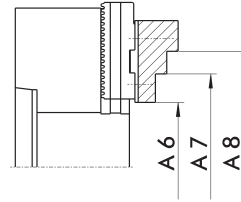
with tongue and groove



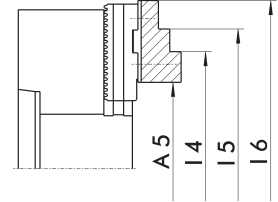
Position of base jaws II



Position of base jaws I



Position of base jaws II



Position of base jaws I

O.D. clamping

Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]	A5 [mm]	A6 [mm]	A7 [mm]	A8 [mm]
ROTA-S plus 2.0 160	SHF 160	0155100	7 - 50	47 - 92	92 - 137	117 - 162	41 - 86	15 - 56	60 - 101	85 - 126
ROTA-S plus 2.0 200	SHF 200	0155101	10 - 76	59 - 124	111 - 176	138 - 204	58 - 124	16 - 77	68 - 129	95 - 156
ROTA-S plus 2.0 250	SHF 250	0155102	11 - 96		91 - 170	171 - 250	87 - 166		41 - 100	121 - 180
ROTA-S plus 2.0 315	SHF 315	0155103	14 - 122		98 - 209	207 - 318	91 - 202		26 - 130	135 - 239
ROTA-S plus 400	SHF 400	0155104	17 - 160		132 - 272	253 - 393	137 - 277		21 - 155	141 - 276
ROTA-S plus 500	SHF 400	0155104	29 - 244		144 - 357	264 - 478	148 - 362		70 - 239	190 - 361

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]	I4 [mm]	I5 [mm]
ROTA-S plus 2.0 160	SHF 160	0155100	63 - 104	87 - 129	132 - 175	96 - 140	120 - 165
ROTA-S plus 2.0 200	SHF 200	0155101	74 - 138	100 - 165	152 - 217	121 - 186	148 - 213
ROTA-S plus 2.0 250	SHF 250	0155102	92 - 175	171 - 255		166 - 245	
ROTA-S plus 2.0 315	SHF 315	0155103	94 - 201	201 - 310		169 - 281	
ROTA-S plus 400	SHF 400	0155104	130 - 270	249 - 391		247 - 387	
ROTA-S plus 500	SHF 400	0155104	150 - 355	266 - 476		258 - 472	

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 2.0 160		
ROTA-S plus 2.0 200		
ROTA-S plus 2.0 250		
ROTA-S plus 2.0 315		
ROTA-S plus 400		
ROTA-S plus 500	IFT Set	1404235

Extension set for large chucks

For use as an extension of the IFT measuring head for measuring the jaw clamping force of large chucks of Ø 400 mm and more.



Suitable for	Description	ID
ROTA-S plus 400		
ROTA-S plus 500	IFT adapter set	1498512

Maintenance kit

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



Suitable for	Description	ID
ROTA-S plus 2.0 160	WTS-S 160	0899014
ROTA-S plus 2.0 200	WTS-S 200	0899015
ROTA-S plus 2.0 250	WTS-S 250	0899016
ROTA-S plus 2.0 315	WTS-S 315	0899017
ROTA-S plus 400	WTS-S 400	0899018
ROTA-S plus 500	WTS-S 500	0899019

Torque wrench

Torque wrench for actuation of SCHUNK manual lathe chucks.



Suitable for	Description	ID
ROTA-S plus 2.0 160		
ROTA-S plus 2.0 200	SSH-D-1/2" 40-200	9938065
ROTA-S plus 2.0 250		
ROTA-S plus 2.0 315	SSH-D-1/2" 60-300	1301281
ROTA-S plus 400		
ROTA-S plus 500	SSH-D-3/4" 80-400	1301023

Ratchets

Ratchet for fast actuation of SCHUNK manual lathe chucks.



Suitable for	Description	ID
ROTA-S plus 2.0 160		
ROTA-S plus 2.0 200		
ROTA-S plus 2.0 250		
ROTA-S plus 2.0 315	SSH-K 1/2"-350	1151118
ROTA-S plus 400	SSH-K 3/4"-510	9987240
ROTA-S plus 500	SSH-K 3/4"-620	9987241

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 2.0 160		
ROTA-S plus 2.0 200	SAS-I 1/2"-SW12	8705487
ROTA-S plus 2.0 250		
ROTA-S plus 2.0 315	SAS-I 1/2"-SW16	8705471

Square 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 400		
ROTA-S plus 500	SAV-I 3/4"-SW19	8705470

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 2.0 160	KSL 160	0814270
ROTA-S plus 2.0 200	KSL 200	0814271
ROTA-S plus 2.0 250	KSL 250	0814272
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 2.0 160	VST Ø42	8702833
ROTA-S plus 2.0 200	VST Ø52	8702867
ROTA-S plus 2.0 250	VST Ø62	8702868
ROTA-S plus 2.0 315	VST Ø92	8702869
ROTA-S plus 400	VST Ø102	8702870
ROTA-S plus 500	VST Ø162	8702871

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

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 2.0 160		
ROTA-S plus 2.0 200	SPS 160/200	9966639
ROTA-S plus 2.0 250	SPS 250	9966640
ROTA-S plus 2.0 315	SPS 315	9966641
ROTA-S plus 400		
ROTA-S plus 500	SPS 400/500	9966642

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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