



ROTA TP

Versatile, pneumatically
actuated power lathe chucks

Compact power lathe chucks with integrated pneumatic cylinder and large through-hole

ROTA TP power lathe chucks from SCHUNK are equipped with an integrated pneumatic cylinder. During downtime these chucks can be opened and closed via a distributor ring using a special air supply system. ROTA TP power lathe chucks are especially suitable for small lathes that do not have a hydraulic clamping cylinder, but are to be operated via a fluid medium. But the chucks are also very useful in automation technology.



Advantages – Your benefits

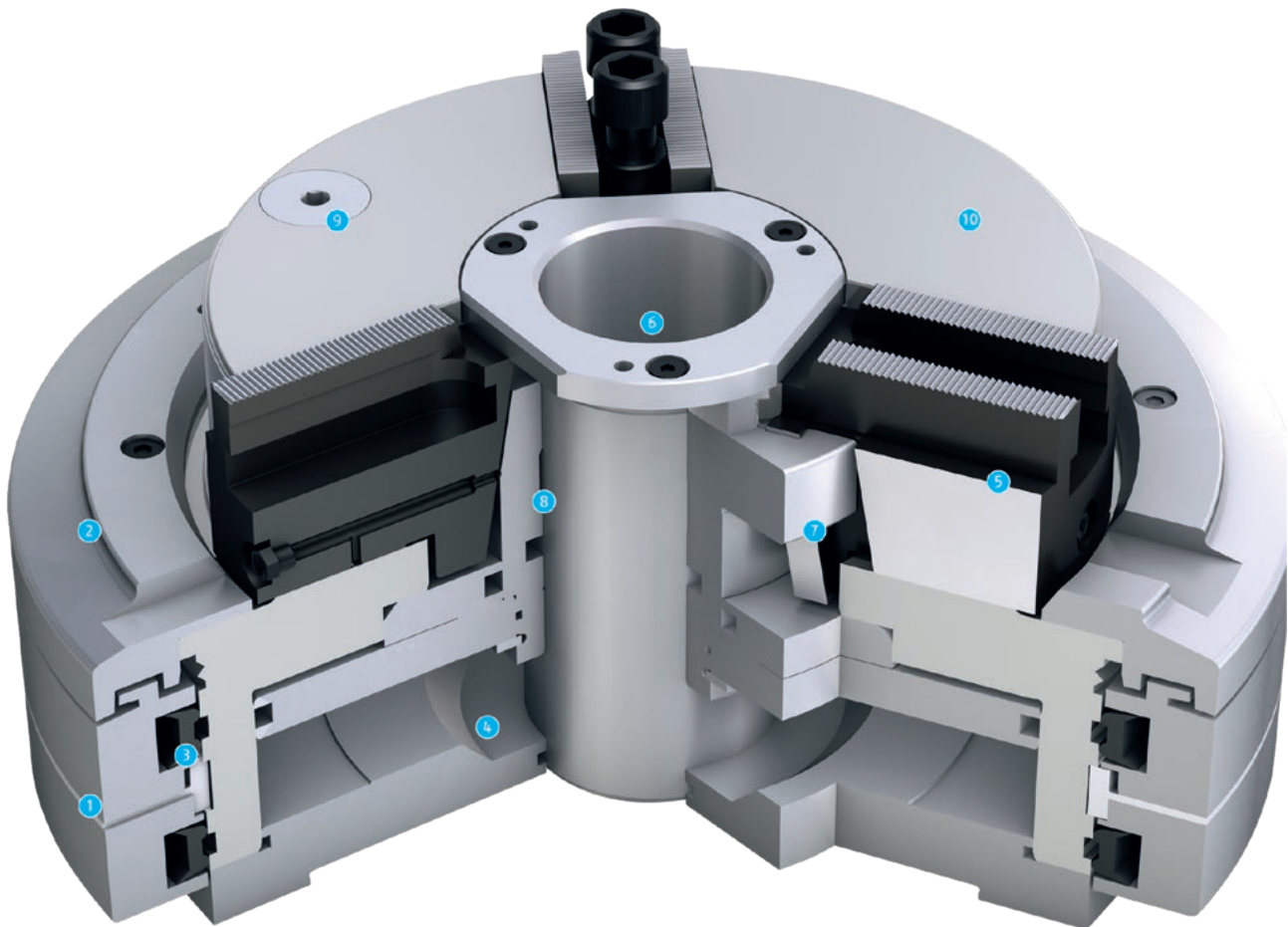
- + Precision wedge hook pneumatic chuck for top quality demands**
Allows excellent machining results
- + Large through-hole**
Machining all standard pipe diameters
- + High efficiency of the wedge hook system**
Process-reliable clamping due to high clamping forces
- + Optimized lubrication system**
Consistently high clamping forces ensured
- + Pneumatic cylinder integrated in the chuck**
Especially suited to lathes without a hydraulic cylinder
- + Air supply via a distributor ring**
Very simple control of the chuck
- + High clamping forces at system pressure**
Ensure process reliability during machining
- + All sides of the functional parts are hardened and ground**
Ensures a long service life

Technical data

Description	Max. rotational speed [min ⁻¹]	Max. clamping force (at 6 bar) [kN]	Stroke/jaw [mm]	Through-hole [mm]
ROTA TP 125-26	4000	22	3	26
ROTA TP 160-38	3500	39	4.2	38
ROTA TP 200-52	2800	68	4.2	52
ROTA TP 250-68	2200	105	5	68
ROTA TP 315-90	1800	140	5	90
ROTA TP 315-105	2200	100	5	105
ROTA TP 350-115	2200	90	5	115
ROTA TP-LH 350-115	2200	90	15	115

Function of ROTA TP

The piston integrated in the chuck is supplied during down-time with compressed air from the distributor ring and thus axially shifted. The wedge hook system converts this axial movement of the chuck piston into a radial movement of the base jaws, synchronous to the rotating axis. The double check valve prevents that after removal of the system pressure the compressed air can again escape.

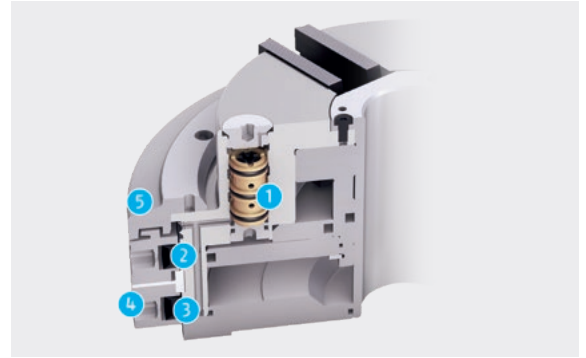


- | | |
|--|---|
| <ul style="list-style-type: none"> 1 Distributor ring
For air transmission during down-time 2 Distributor ring cover
Prevents the penetration of dirt and chips 3 Profile sealing rings
For air transmission 4 Pneumatic cylinder integrated in the chuck
Especially suited to lathes without a hydraulic cylinder 5 Very stable base jaw
With fine serration for universal clamping | <ul style="list-style-type: none"> 6 Very large through-hole
Ideal for pipe processing 7 Very stable wedge hook
For force transmission 8 Long piston guidance
Optimizes the force flow and provides optimal rigidity 9 Pressure maintenance valve
Provides for enduring clamping force during rotation 10 One-piece, rigid chuck body
For a long service life |
|--|---|

Control of the self-contained power lathe chucks

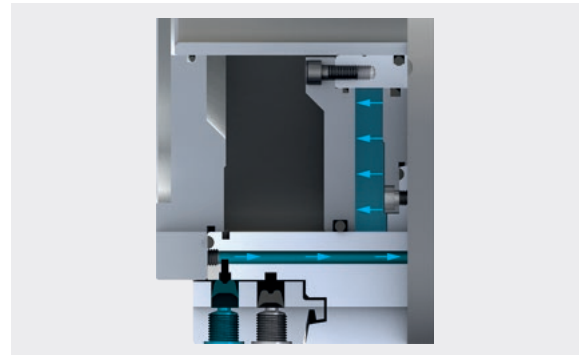
All pneumatic self-contained power lathe chucks have an integrated double check valve. The valve is responsible for pressure maintenance and thus ensures constant clamping force.

- ❶ **Double check valve**
Ensures pressure maintenance
- ❷ **Profile sealing ring**
For chuck actuation during I.D. clamping
- ❸ **Profile sealing ring**
For chuck actuation during O.D. clamping
- ❹ **Distributor ring**
For air supply of the lathe chuck
- ❺ **Distributor ring cover**
For a better sealing against contamination at the distributor ring



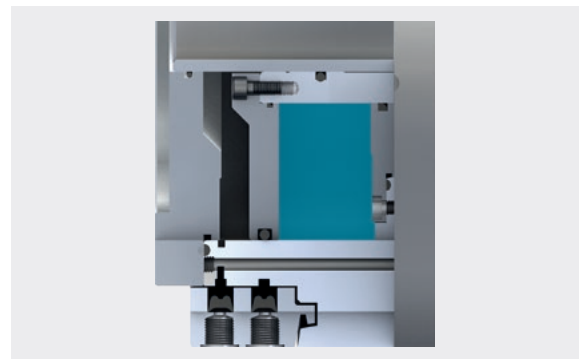
Clamping and opening is only possible during down-time

The profile seals deform radially under pneumatic pressure and seal on the chuck body to fill the cylinder chamber. The generated air pressure is permanently maintained through a double-check valve in the chuck.



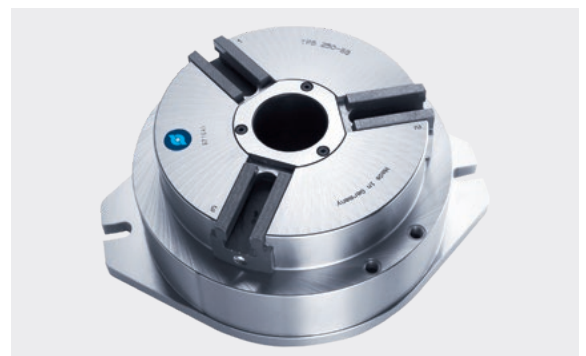
The SCHUNK profile seal lifts itself through its own elasticity

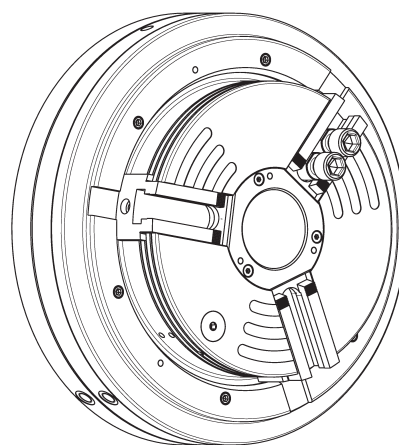
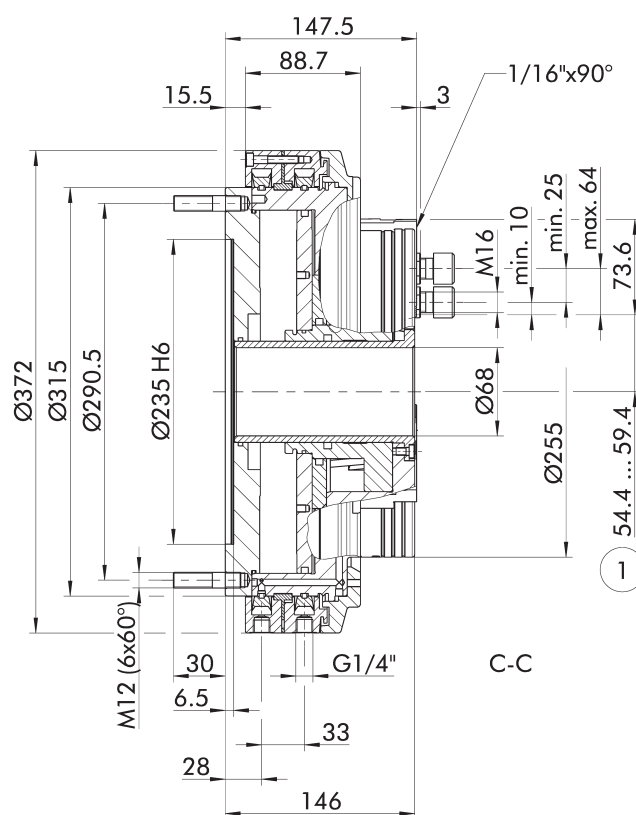
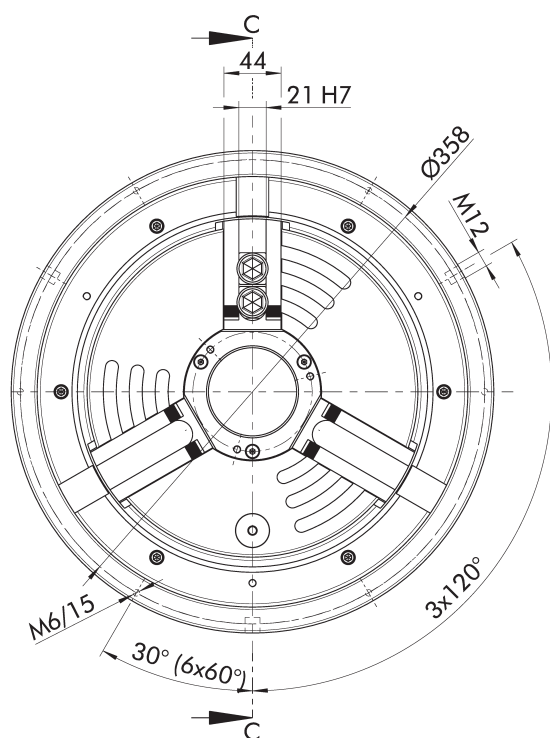
The air pressure is maintained in the cylinder, and the chuck can start to rotate.



Also available for stationary applications

The ROTA TP chuck can be also used for stationary applications. However, the so-called ROTA TPS chuck has to be permanently actuated with air and is not equipped with a distributor ring and no double check valve is integrated.





Subject to technical changes.

① Distance to center of first tooth

Technical data

Spindle type	Spindle size	ID	Max. RPM 1	Max. RPM 2	Max. clamping force (at 6 bar)	Actuation pressure	Moment of inertia	Weight
			[min ⁻¹]	[min ⁻¹]	[kN]	[bar]	[kgm ²]	[kg]
-	Z235	0816155	2200	3500	105	3 - 8	0.68	59

Scope of delivery

Chuck, distributor ring cover, T-nuts with screws, chuck mounting bolts, 2 elbow-unions R 1/4" on the distributor ring, 1 set-screw to position the distributor ring, 6 double-threaded mounting bolts, 2 couplings for connection to the electro pneumatic control block, spacer ring, operating manual; without distributor ring mounting bracket, without top jaws

Notes

Max. RPM 1

"Max. RPM 1" is the maximum RPM when using a distributor ring with centering ring.

Max. RPM 2

"Max. RPM 2" is the maximum RPM with a stationary fastening of distributor ring.

Min. actuation pressure

The minimum actuation pressure is $P_{min} = 3$ bar.

For lower clamping forces, a clamping force reduction can be offered as an option.

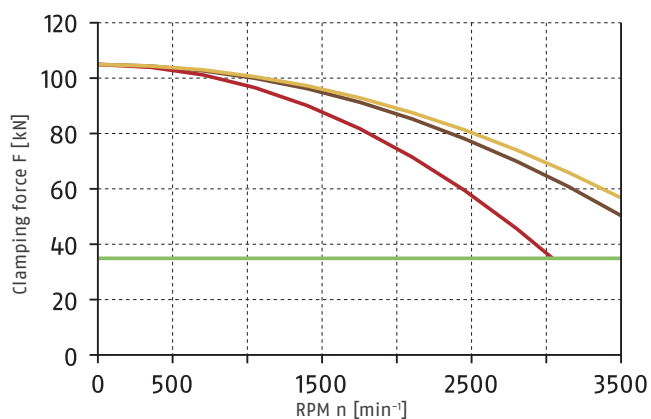
2-jaw chuck

The 2-jaw chuck version is available on request.

Further technical data

Chuck type	Through-hole	Stroke/jaw	Opening/closing time	Air consumption/jaw stroke at 6 bar	Center jaw height
	[mm]	[mm]	[s]	[l]	[mm]
ROTA TP 250-68	68	5	5	9.2	88

Clamping force-RPM-diagram



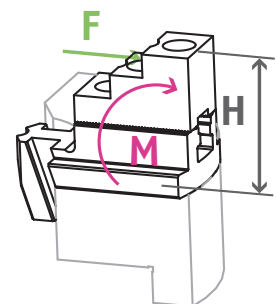
Required minimum clamping force F_{spmin} 33%

SHB 250
3.5 kg

SWB 250
9.2 kg

SWB-AL 250
3.29 kg

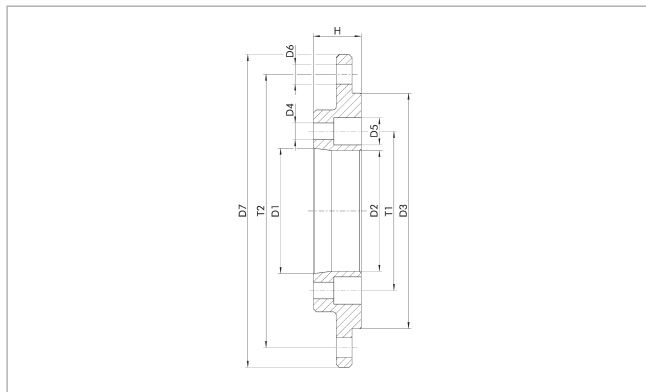
Load of base jaw guidance



$M_{max} = 3080$ Nm

Adapter plates

Z-mount on short taper ISO 702-1



Technical data

Description	ID	Suitable for	D1	D2	D3	D4	D5	D6	D7	H	T1	T2
				[mm]		[mm]	[mm]	[mm]		[mm]	[mm]	[mm]
FFV Z235-A6	0836030	ROTA TP 250-68	Nr. 6	103	Z235	13 (6 x 60°)	20	315	13 (6 x 60°)	38	133.4	290.5
FFV Z235-A8	0836031	ROTA TP 250-68	Nr. 8	136	Z235	17 (6x60°)	25	315	13 (6 x 60°)	40	171.4	290.5
FFV Z235-A11	0836032	ROTA TP 250-68	Nr. 11	192.9	Z235	21 (6x60°)	32	315	13 (6 x 60°)	34	235	290.5

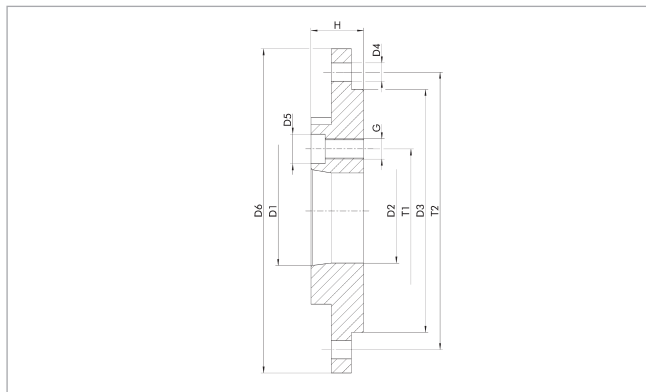
Reduction adapter plates

All flanges on the pneumatic power chuck are designed as reducing flanges.

These 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.

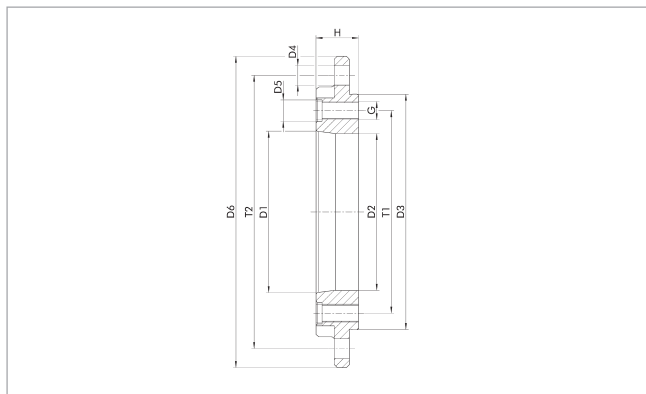
Z-mount on camlock ISO 702-2



Technical data

Description	ID	Suitable for	D1	D2	D3	D4	D5	D6	G	H	T1	T2
				[mm]		[mm]	[mm]	[mm]		[mm]	[mm]	[mm]
FFV Z235-D6	0836230	ROTA TP 250-68	Nr. 6	103.2	Z235	13 (6 x 60°)	22.6	315	M16x1.5 (6 x 60°)	29	133.4	290.5
FFV Z235-D8	0836231	ROTA TP 250-68	Nr. 8	136.2	Z235	13 (6 x 60°)	25.8	315	M20x1.5 (6 x 60°)	40	171.4	290.5
FFV Z235-D11	0836232	ROTA TP 250-68	Nr. 11	192.9	Z235	13 (6 x 60°)	30.6	315	M22x1.5 (6 x 60°)	51	235	290.5

Z-mount on bayonet ISO 702-3

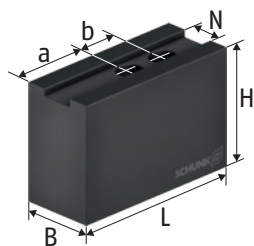


Technical data

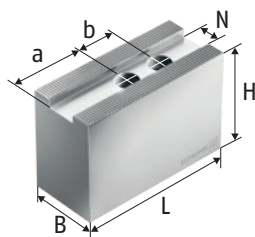
Description	ID	Suitable for	D1	D2 [mm]	D3	D4 [mm]	D5 [mm]	D6 [mm]	G	H [mm]	T1 [mm]	T2 [mm]
FFV Z235-C6	0836130	ROTA TP 250-68	Nr. 6	103	Z235	13 (6 x 60°)	14	315	M12 (4 x 90°)	30	133.4	290.5
FFV Z235-C8	0836131	ROTA TP 250-68	Nr. 8	136	Z235	13 (6 x 60°)	18	315	M16 (4 x 90°)	30	171.4	290.5
FFV Z235-C11	0836132	ROTA TP 250-68	Nr. 11	192.9	Z235	13 (6 x 60°)	22	315	M20 (6 x 60°)	30	235	290.5

Soft top jaws

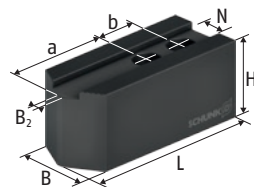
with fine serration 90°



CWB
Soft top jaws



SWB-AL
Soft top jaws



SWBL
Soft top jaws

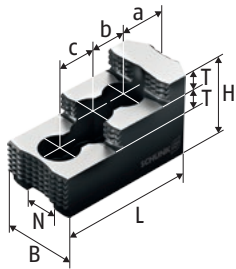
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	H [mm]	L [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA TP 250-68	SWBL 250-21	0120155	21	50	50	120	72	28	M16	5.4
ROTA TP 250-68	CWB 251	0100012	21	50	60	95	52	28	M16	5.2
ROTA TP 250-68	SWB 250	0120105	21	50	80	120	62	28	M16	9.2
ROTA TP 250-68	SWB-AL 250	0168102	21	50	80	120	62	28	M16	3.3

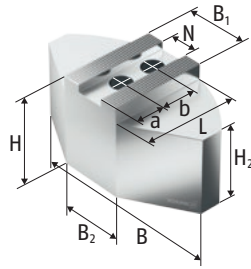
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Hard stepped top jaws, Full grip jaws

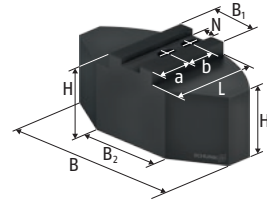
with fine serration 90°



SHB
Hard stepped top jaws



SWB-SA
Full grip jaws



SWB-SM
Full grip jaws

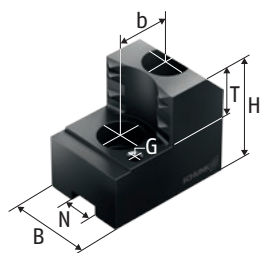
Technical data

Chuck type	Description	ID	N [mm]	B [mm]	B1 [mm]	H [mm]	H2 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	c [mm]	Screws	m/SET [kg]
ROTA TP 250-68	SWB-SA 250-21	0170103	21	180	50	78	63	87.5		40	28		M16	6.3
ROTA TP 250-68	SWB-SA 251	0170107	21	180	50	100	85	87.5		40	28		M16	8.3
ROTA TP 250-68	SWB-SM 250-21	0169103	21	180	50	70	55	80		29	28		M16	14.5
ROTA TP 250-68	SWB-SM 251	0169107	21	180	50	100	85	80		30	28		M16	22.0
ROTA TP 250-68	SHB 250	0121105	21	50		58		103.5	14	34	25	25	M16	3.5

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

Claw jaws

with fine serration 90°



SZA
Claw jaws

Technical data

Chuck type	Clamping range ØD	Swing diameter SDmax	Description	ID	N	B	H	L	T	G	b	Screws	m/SET
	[mm]	[mm]			[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		[kg]
ROTA TP 250-68	53 - 108	276	SZA 25-37	0138180	21	50	58	95.9	25	M8	28	M16	3.3
ROTA TP 250-68	93 - 148	276	SZA 25-38	0138181	21	50	58	81	25	M8	28	M16	2.9
ROTA TP 250-68	142 - 198	279	SZA 25-39	0138182	21	50	58	76.2	25	M8	28	M16	2.7
ROTA TP 250-68	189 - 245	316	SZA 25-40	0138183	21	50	58	90.5	25	M8	28	M16	3.2

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

T-nut

with fine serration 90°



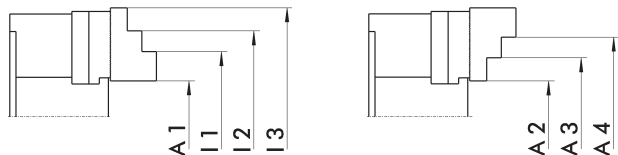
NS
T-nut

Chuck type	Description	ID	N	B	H	H1	L	Cyl.-screw	Max. adm. tightening torque
			[mm]	[mm]	[mm]	[mm]	[mm]		[Nm]
ROTA TP 250-68	NS 164	0143108	21	28.4	30	11	24.3	M16 x 35	150

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

Hard stepped top jaws

with fine serration 90°



Jaw position I

Jaw position II

O.D. clamping

Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]
ROTA TP 250-68	SHB 250	0121105	16 - 126	39 - 125	121 - 198	194 - 255

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA TP 250-68	SHB 250	0121105	69 - 146	142 - 226	222 - 325

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 TP 250-68	IFT Set	1404235

Maintenance unit

For processing the required compressed air.



Suitable for	Description	ID
ROTA TP 250-68	WEH 1/4"	0890021

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

Pressure measuring unit

For checking pressure tightness.



Suitable for	Description	ID
ROTA TP 250-68	DMG Ø20-NPT1/4"	8702679

Grease gun

Auxiliary tools for lubrication of all kinds of SCHUNK products. The grease gun can be used for cartridges of all types of SCHUNK grease.



Bundle	Description	ID
Cartridge	Grease gun	9900543



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

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