SCHUNK



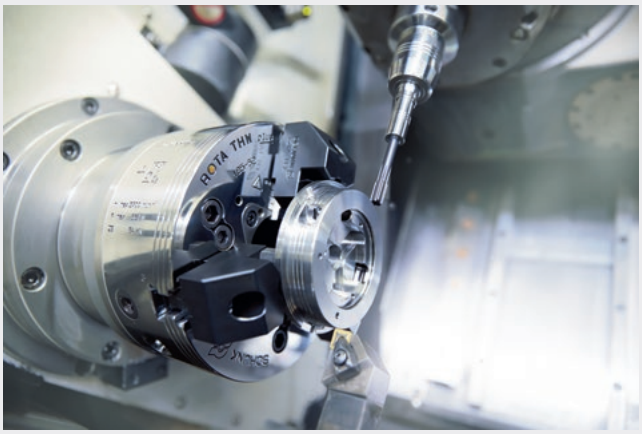
ROTA THW*plus*

Jaw quick-change chuck with straight serrated base jaw interface

Hand in hand for tomorrow

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

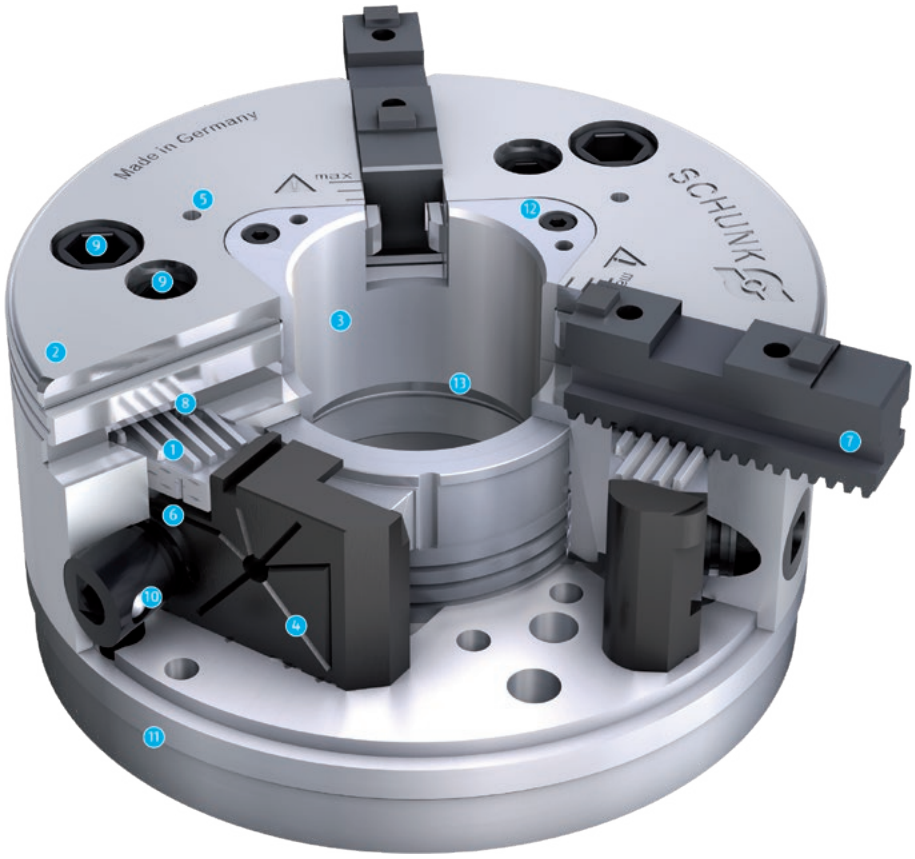
- **Convenient jaw quick-change system**
  Minimizing set-up times and costs
- **Large through-hole**
  Machining all standard pipe diameters
- **High efficiency of the wedge bar system**
  Process-reliable clamping due to high clamping forces
- **High jaw quick-change repeat accuracy**
  No reboring 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 [min^{-1}]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Piston stroke [mm]	Through-hole [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

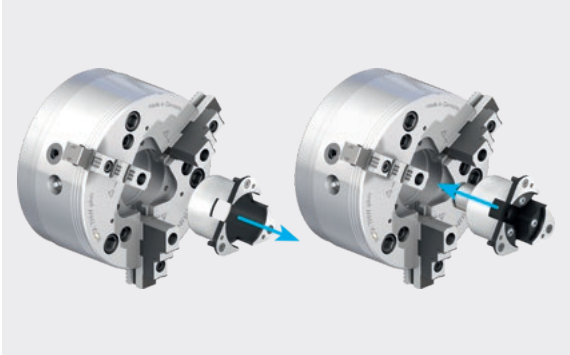
The wedge bars that can be tangentially moved in the chuck are driven via slanted effective surfaces of an axially guided piston. The wedge bars transmit the force to the base jaws, generating a jaw movement that is synchronous and radial to the rotational axis. The jaw change occurs by drawing back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



1. **Wedge bar actuation system**
   It offers high run-out accuracies even at high speeds
2. **Hardened and extremely rigid base body**
   Therefore a longer service life at highest precision. Even with maximum clamping force
3. **Large through-hole**
   For machining of all standard raw material diameters
4. **Optimized lubrication system**
   For a high level of efficiency
5. **Mounting thread**
   For workpiece stops or cover plates
6. **Jaw quick-change system**
   Shortest set-up times due to individual unlocking of jaws
7. **Base jaws with straight serration (GBK)**
   Compatible with the ROTA THW and ROTA-G
8. **Locking mechanism**
   Enables a safe base jaw position and thus ensures secure intermeshing of the base jaw serration with the wedge-bar serration
9. **Two mounting bolt circles**
   For fast and direct attachment to all commercially available spindle heads
10. **Admissible jaw locking**
    The jaw change wrench can only be removed if the wedge bar is properly engaged in the base jaw.
11. **Various direct mountings**
    Without additional flange
12. **Modular center sleeve system**
    Therefore optimal adjustment to new clamping tasks
13. **Additional seals**
    For sealing against coolants and chips

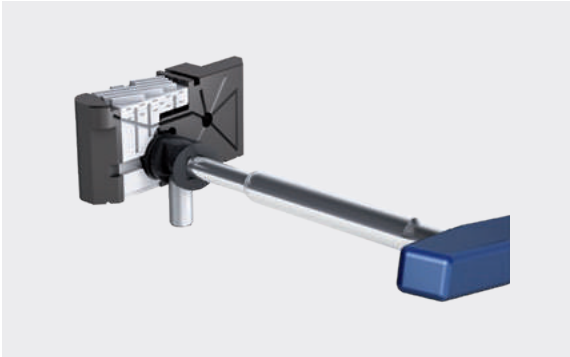
Changing the center sleeve

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.



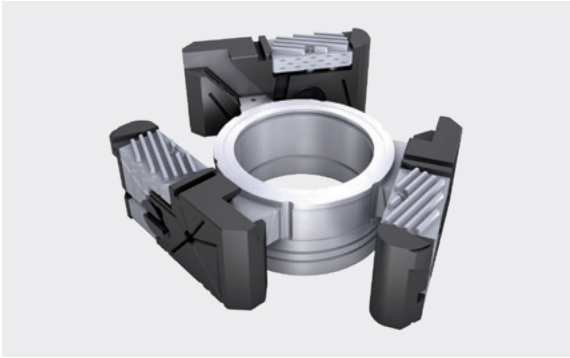
Quick jaw change

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.



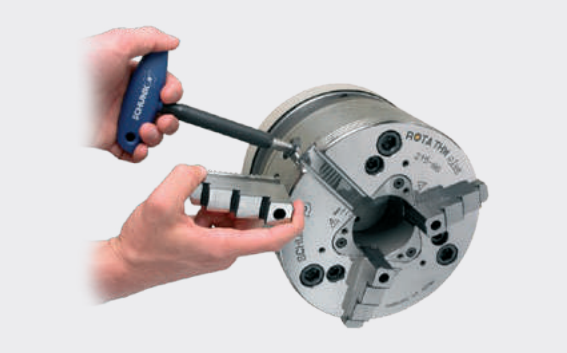
Insertion of the chuck jaws

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.

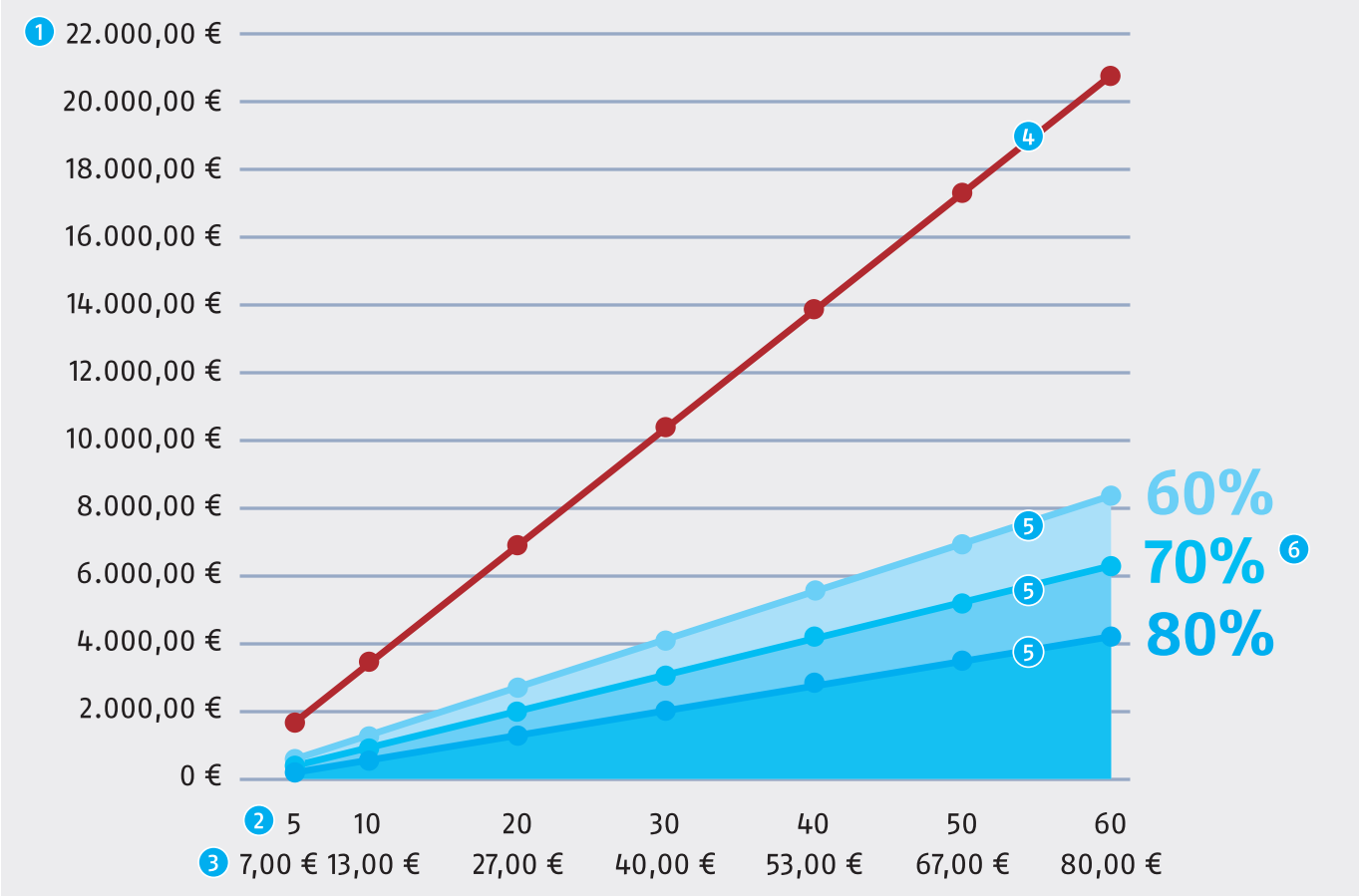


The jaws are interchangeable

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

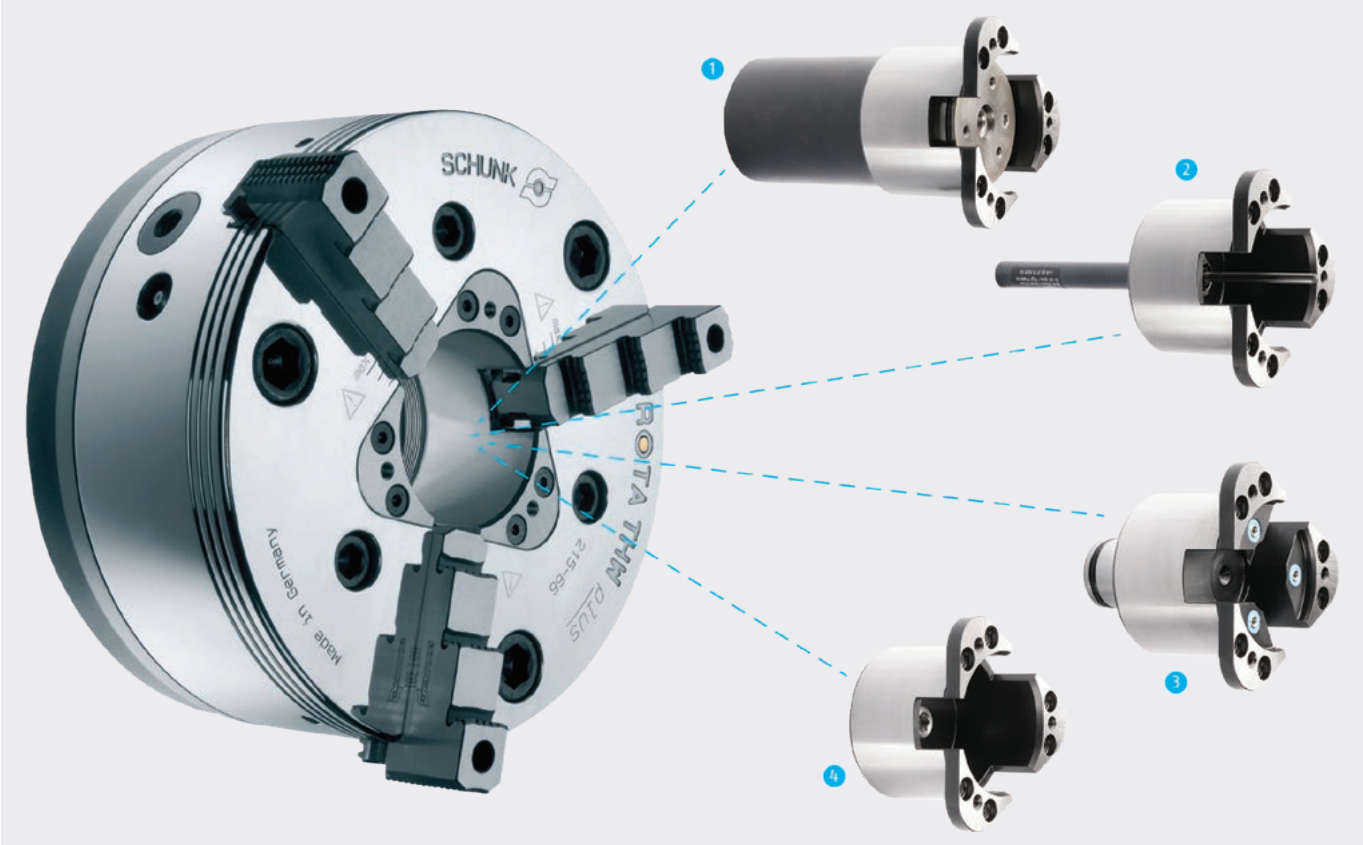


The jaw quick-change system is the ideal clamping tool for clamping tasks even up from batch size 1. Ideally the set-up times can be reduced – depending on the number of jaw changes – by up to 80% in comparison to power lathe chucks with fine serration.

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

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

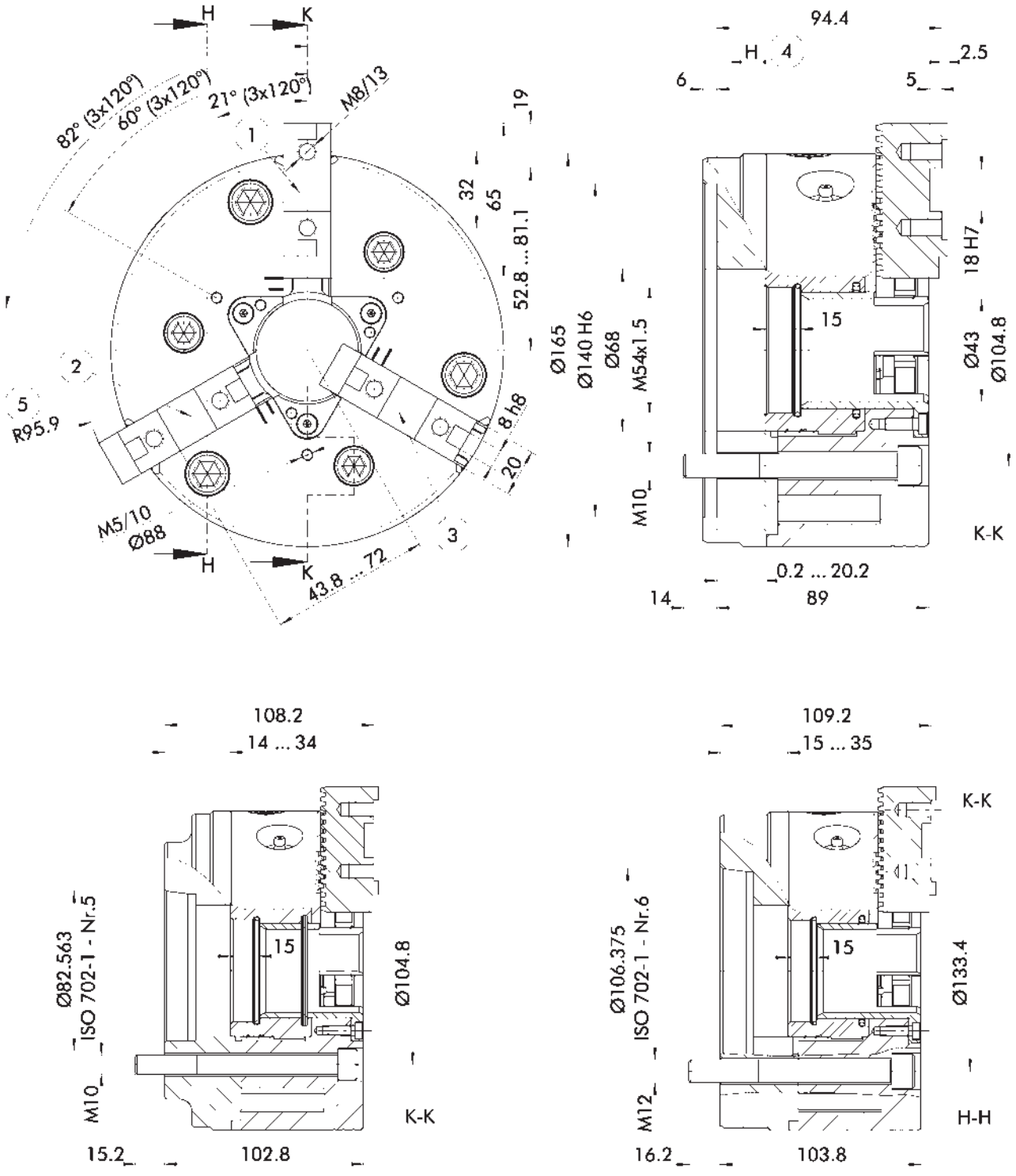
Modular center sleeve system



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.

ⓘ Modular center sleeve system up to size 315 possible.



Chuck for shaft clamping drawn in open position.
Subject to technical changes.

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

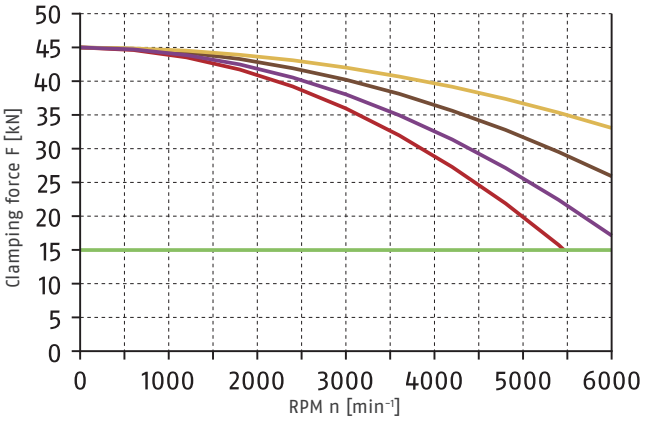
Technical data

Spindle type	Spindle size	ID	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Tooth pitch [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm²]	Weight [kg]
ISO 702-4	Nr. 5 (Z140)	0800600	6000	45	30	5.9	4.712	20	0.05	13
ISO 702-1	Nr. 5	0800601	6000	45	30	5.9	4.712	20	0.05	13
ISO 702-1	Nr. 6	0800602	6000	45	30	5.9	4.712	20	0.05	14

Scope of delivery

Chuck, 1 set of base jaws with screws, jaw change wrench, chuck mounting screws and operating manual

Clamping force-RPM-diagram



Required minimum clamping force F_{spmin} 33%

SHF 160
0.6 kg



SFA 160
1.2 kg



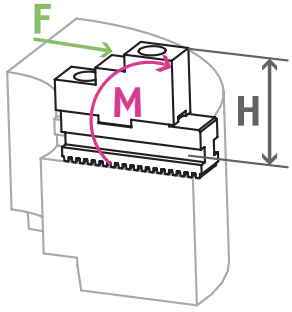
GST 140-160 I
0.7 kg



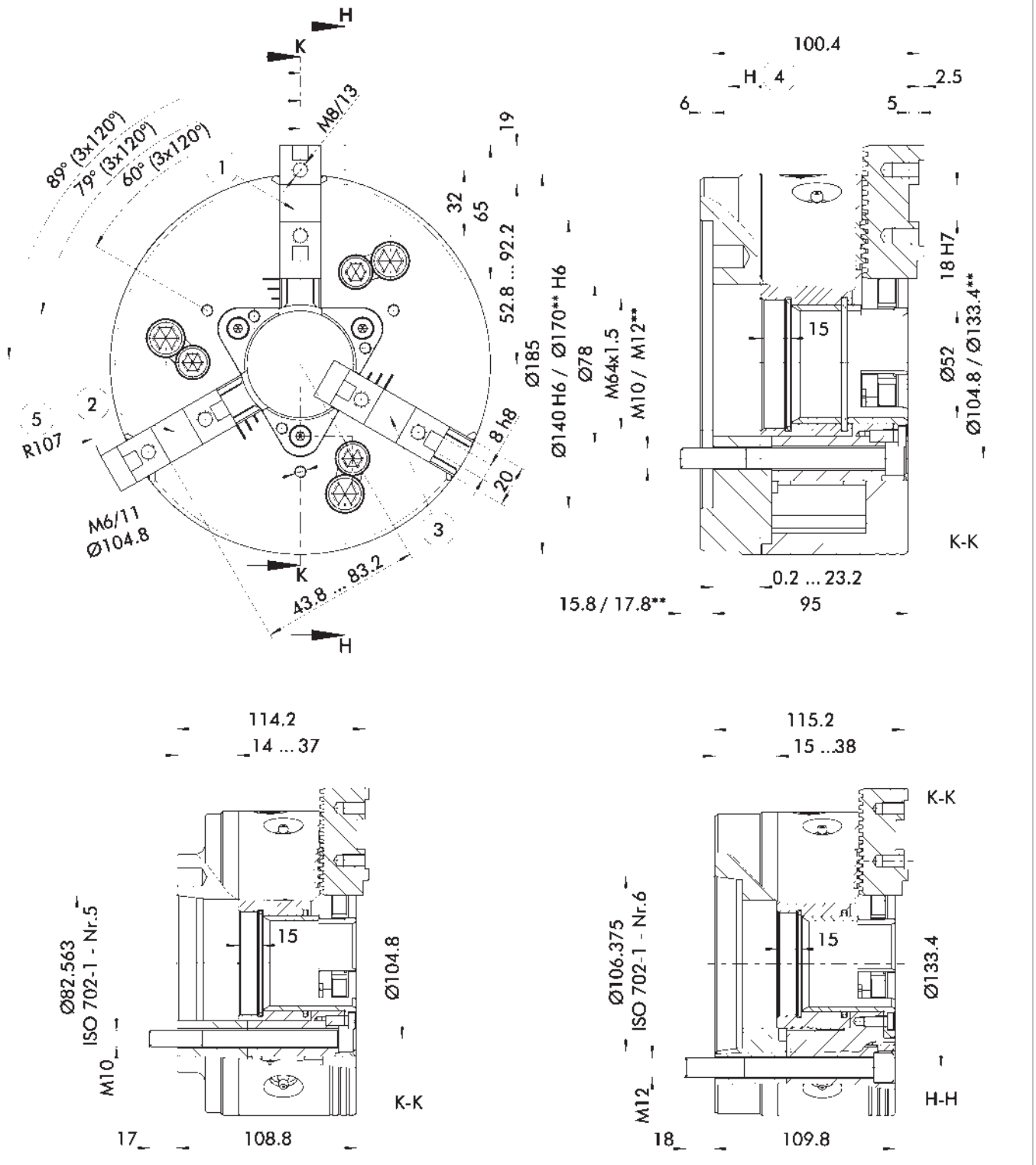
UVB 160
1.6 kg



Load of base jaw guidance



M_{max} = 774 Nm



Chuck for shaft clamping drawn in open position.
** For straight recess mount 170.
Subject to technical changes.

(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

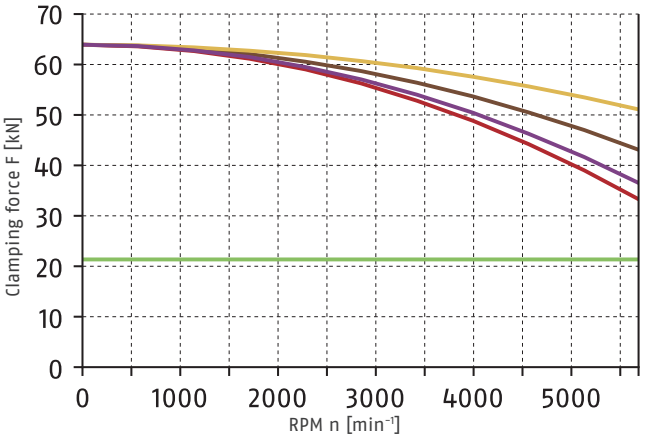
Technical data

Spindle type	Spindle size	ID	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Tooth pitch [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm²]	Weight [kg]
ISO 702-4	Nr. 5 (Z140)	0800610	5700	64	36	6.7	4.712	23	0.08	16
ISO 702-4	Nr. 6 (Z170)	0800611	5700	64	36	6.7	4.712	23	0.08	16
ISO 702-1	Nr. 5	0800612	5700	64	36	6.7	4.712	23	0.08	17
ISO 702-1	Nr. 6	0800613	5700	64	36	6.7	4.712	23	0.08	18

Scope of delivery

Chuck, 1 set of base jaws with screws, jaw change wrench, chuck mounting screws and operating manual

Clamping force-RPM-diagram



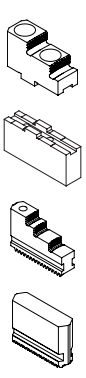
Required minimum clamping force F_{spmin} 33%

SHF 160
0.6 kg

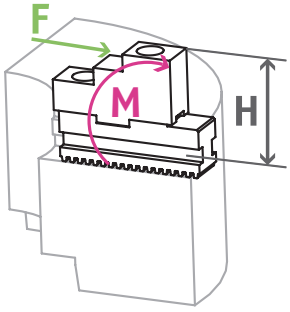
SFA 160
1.2 kg

GST 140-160 I
0.7 kg

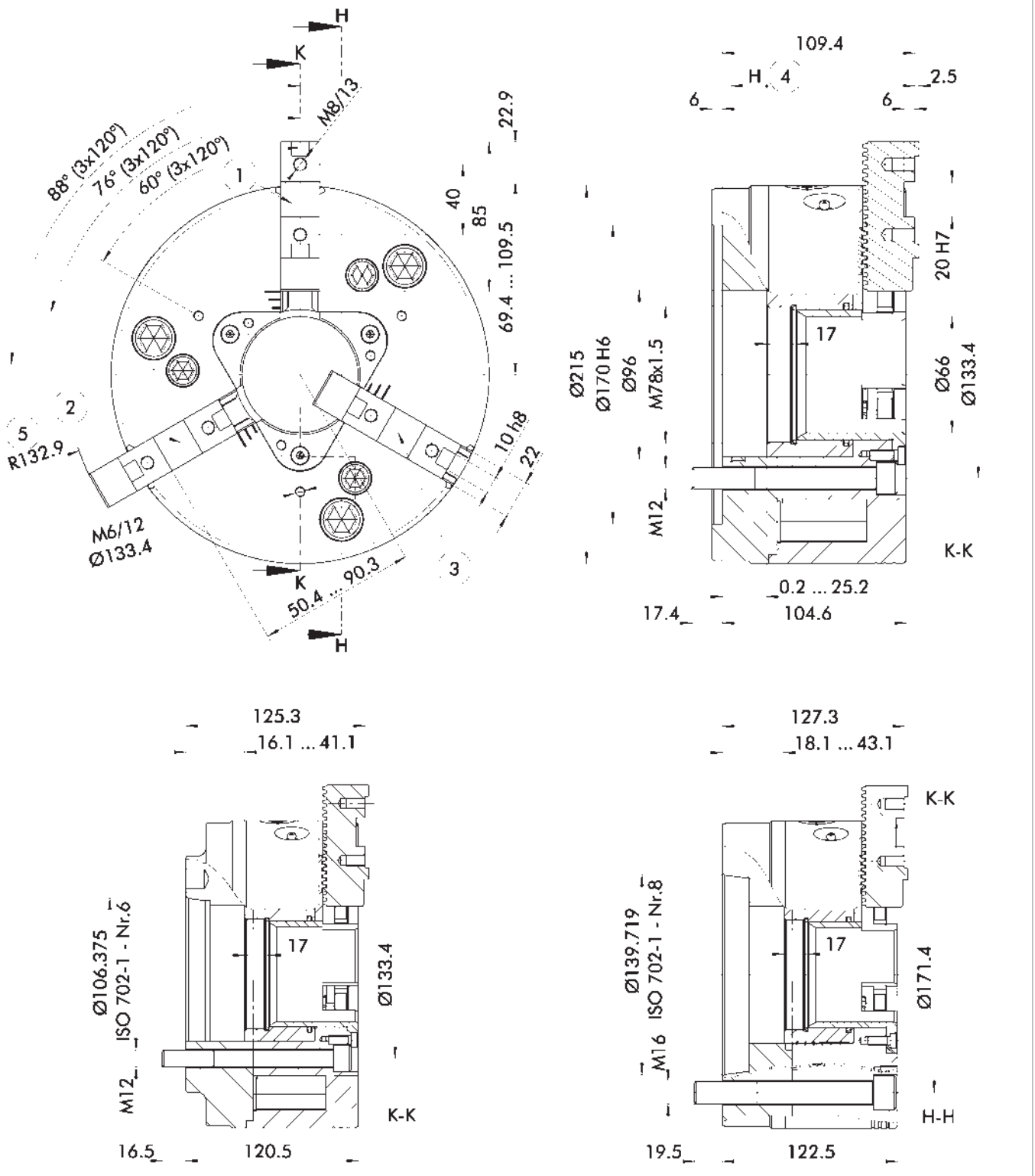
UVB 160
1.6 kg



Load of base jaw guidance



M_{max} = 917 Nm



Chuck for shaft clamping drawn in open position.
Subject to technical changes.

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

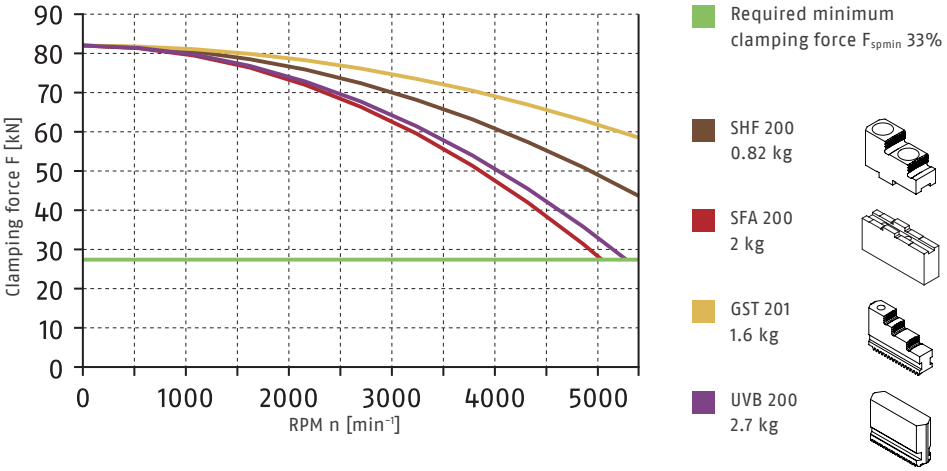
Technical data

Spindle type	Spindle size	ID	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Tooth pitch [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm²]	Weight [kg]
ISO 702-4	Nr. 6 (Z170)	0800620	5400	82	46	7.4	4.712	25	0.16	24
ISO 702-1	Nr. 6	0800621	5400	82	46	7.4	4.712	25	0.16	25
ISO 702-1	Nr. 8	0800622	5400	82	46	7.4	4.712	25	0.16	26

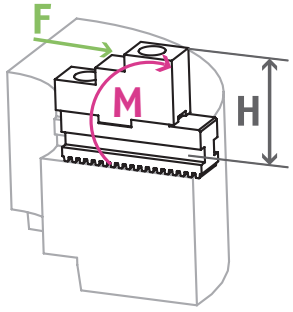
Scope of delivery

Chuck, 1 set of base jaws with screws, jaw change wrench, chuck mounting screws and operating manual

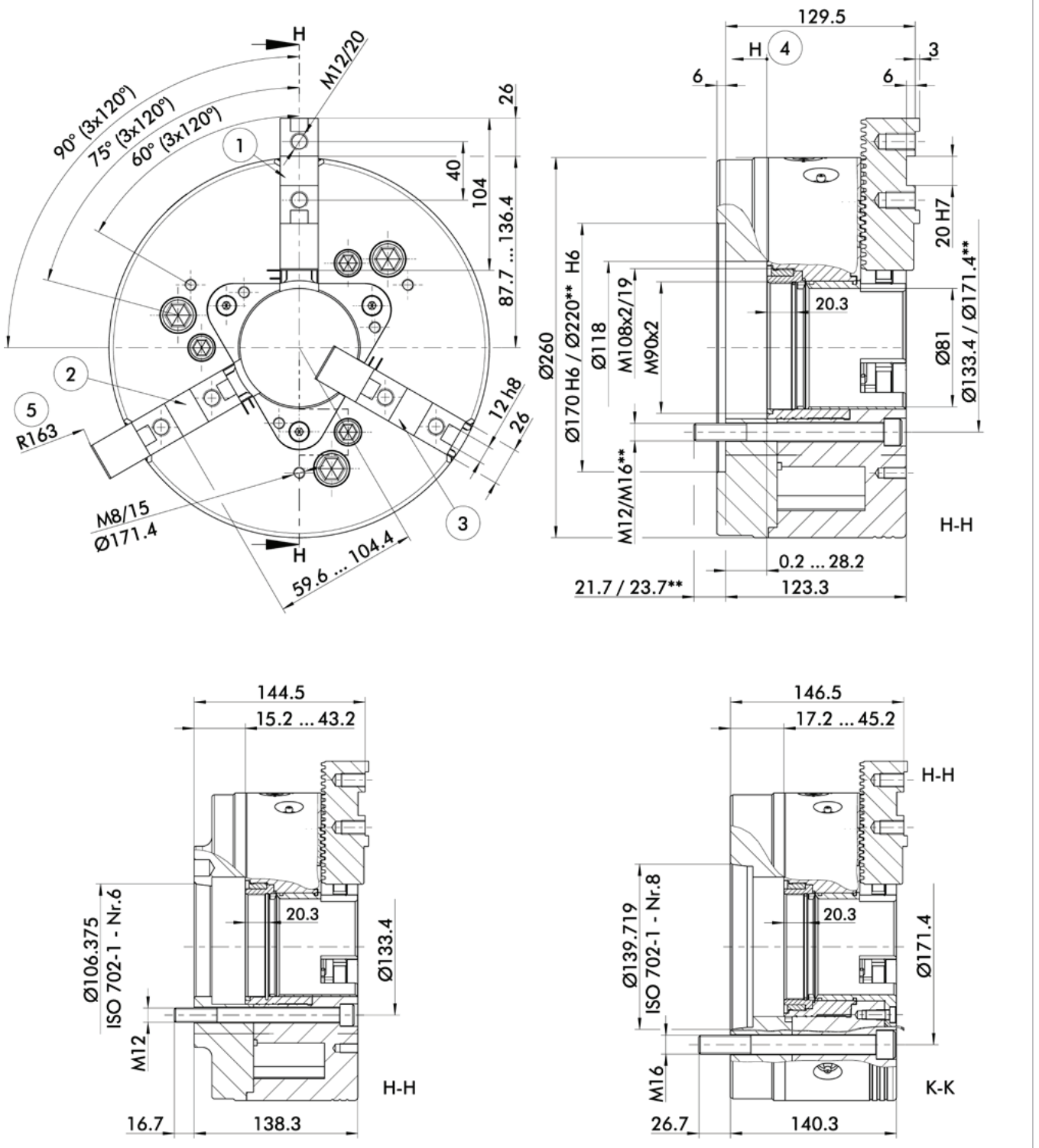
Clamping force-RPM-diagram



Load of base jaw guidance



M_{max} = 1367 Nm



Chuck for shaft clamping drawn in open position.
** For straight recess mount 220.
Subject to technical changes.

(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

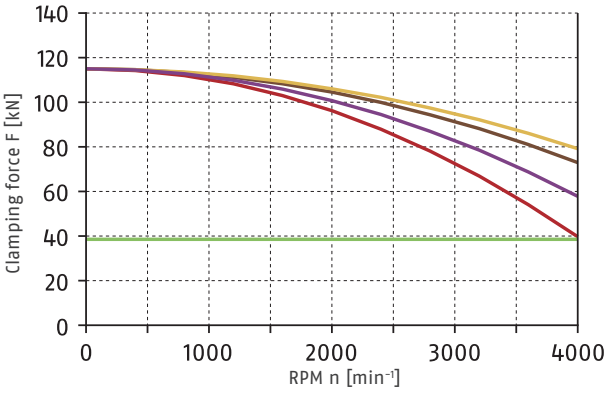
Technical data

Spindle type	Spindle size	ID	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Tooth pitch [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm²]	Weight [kg]
ISO 702-4	Nr. 6 (Z170)	0800630	4000	115	65	8.2	5.498	28	0.41	42
ISO 702-4	Nr. 8 (Z220)	0800631	4000	115	65	8.2	5.498	28	0.41	42
ISO 702-1	Nr. 6	0800632	4000	115	65	8.2	5.498	28	0.41	42
ISO 702-1	Nr. 8	0800633	4000	115	65	8.2	5.498	28	0.41	45

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

Clamping force-RPM-diagram



Required minimum clamping force F_{spmin} 33%

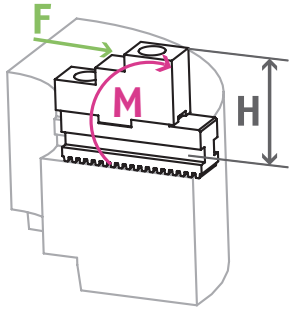
SHF 250
1.9 kg

SFA 250
3.7 kg

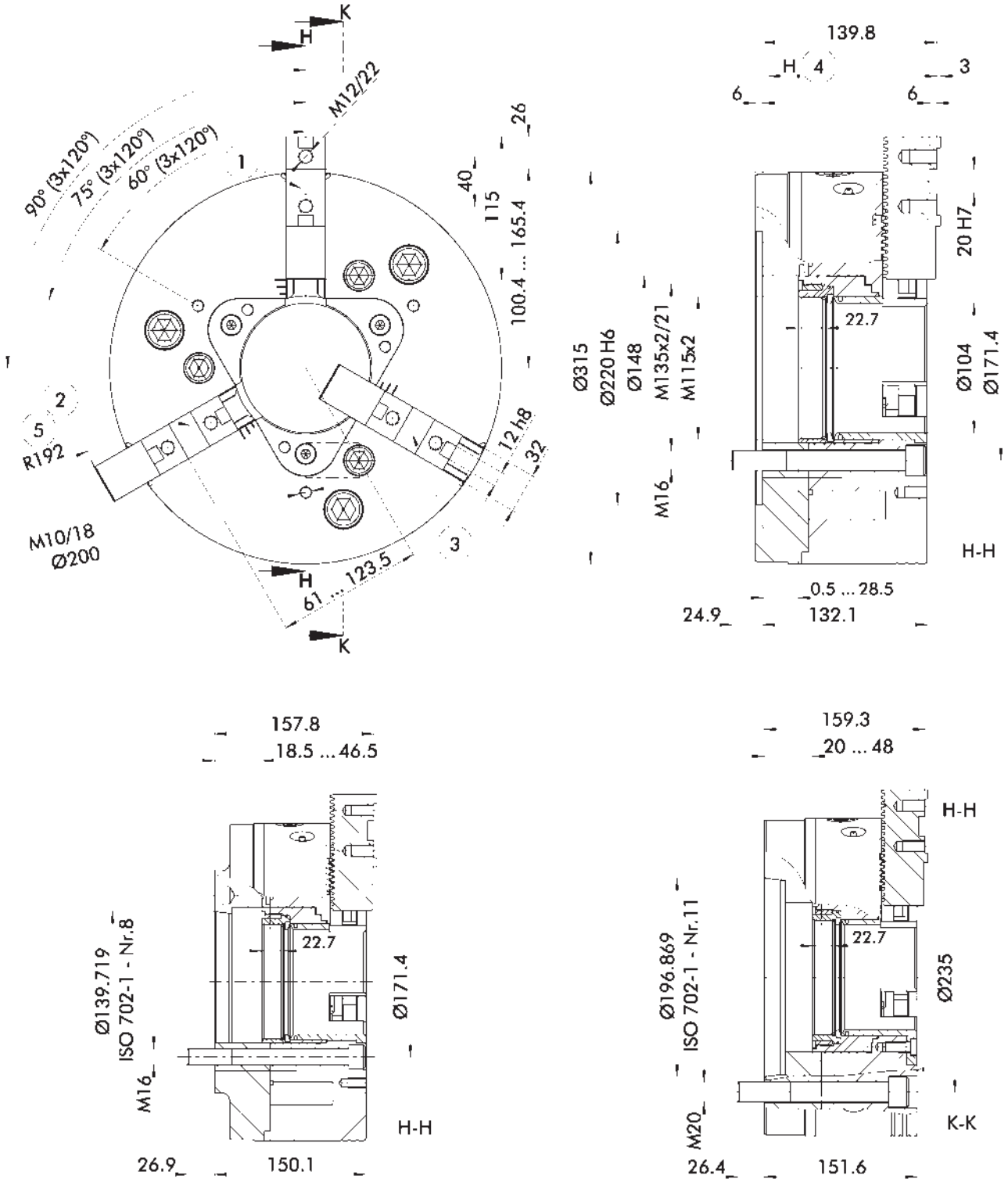
GST 251
2.8 kg

UVB 250
4.8 kg

Load of base jaw guidance



M_{max} = 2549 Nm



Chuck for shaft clamping drawn in open position.
Subject to technical changes.

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

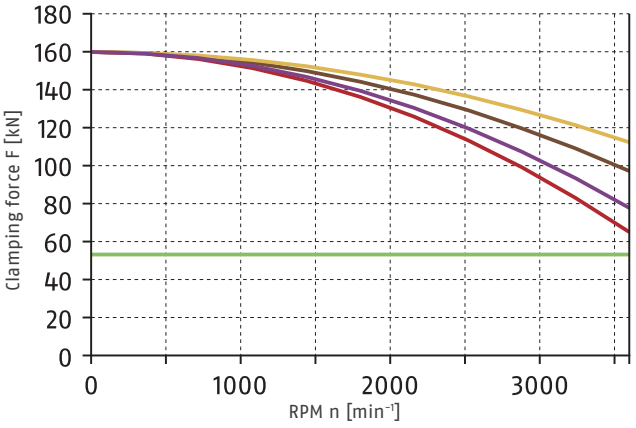
Technical data

Spindle type	Spindle size	ID	Max. rotational speed [min⁻¹]	Max. clamping force [kN]	Max. actuating force [kN]	Stroke/jaw [mm]	Tooth pitch [mm]	Piston stroke (H) [mm]	Moment of inertia [kgm²]	Weight [kg]
ISO 702-4	Nr. 8 (Z220)	0800640	3600	160	90	8.6	5.498	28	0.97	66
ISO 702-1	Nr. 8	0800641	3600	160	90	8.6	5.498	28	0.97	67
ISO 702-1	Nr. 11	0800642	3600	160	90	8.6	5.498	28	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

Clamping force-RPM-diagram



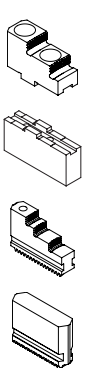
Required minimum clamping force F_{spmin} 33%

SHF 250
1.9 kg

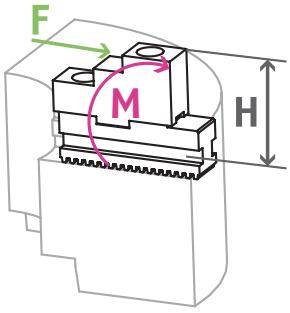
SFA 250
3.7 kg

GST 315
3.5 kg

UVB 315
7.6 kg



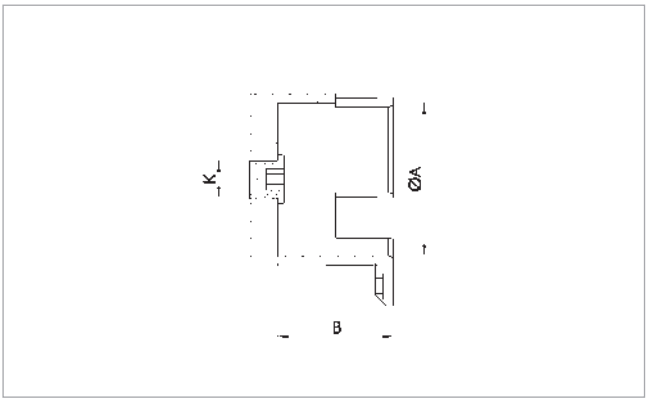
Load of base jaw guidance



M_{max} = 4000 Nm

Center sleeves

Center sleeve closed

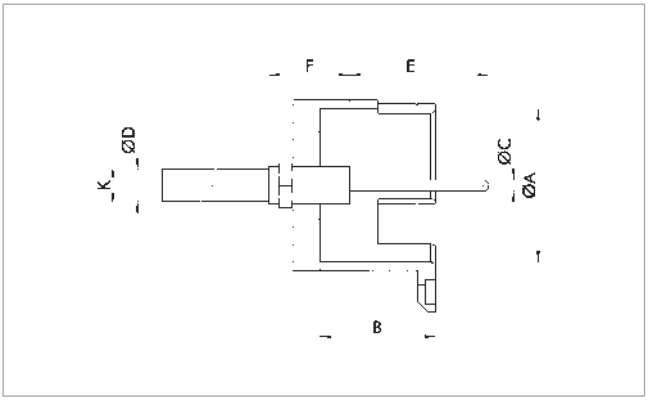


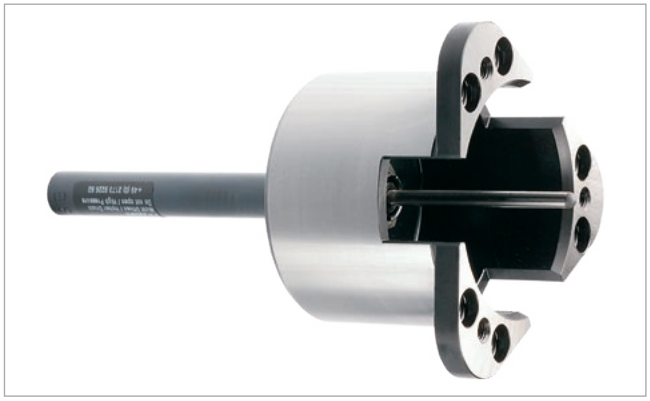


Technical data

Description	ID	Suitable for	ØA [mm]	B [mm]	K	Weight [kg]
SBS-G-W 165	8703507	ROTA THW plus 165-43	43	41.5	M16x1.5	0.3
SBS-G-W 185	8703506	ROTA THW plus 185-52	52	44.6	M16x1.5	0.4
SBS-G-W 215	8703395	ROTA THW plus 215-66	66	50	M16x1.5	0.8
SBS-G-W 260	8703537	ROTA THW plus 260-81	81	56.6	M16x1.5	1.3
SBS-G-W 315	8703538	ROTA THW plus 315-104	104	63	M16x1.5	2.1

Protection sleeve with ejector



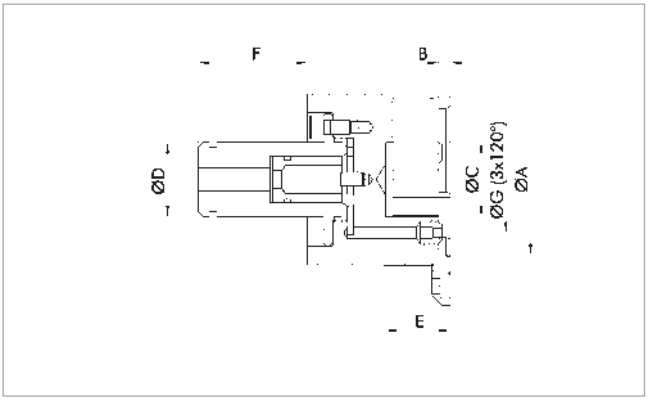


Technical data

Description	Suitable for	ØA [mm]	B [mm]	ØC [mm]	ØD [mm]	E [mm]	F [mm]	K
SBS-A-W 165	ROTA THW plus 165-43	43	41.5	4.8	14	10 - 100	35	M16x1.5
SBS-A-W 185	ROTA THW plus 185-52	52	44.6	4.8	14	10 - 100	35	M16x1.5
SBS-A-W 215	ROTA THW plus 215-66	66	50	4.8	14	10 - 100	35	M16x1.5
SBS-A-W 260	ROTA THW plus 260-81	81	56.6	4.8	14	10 - 100	35	M16x1.5
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

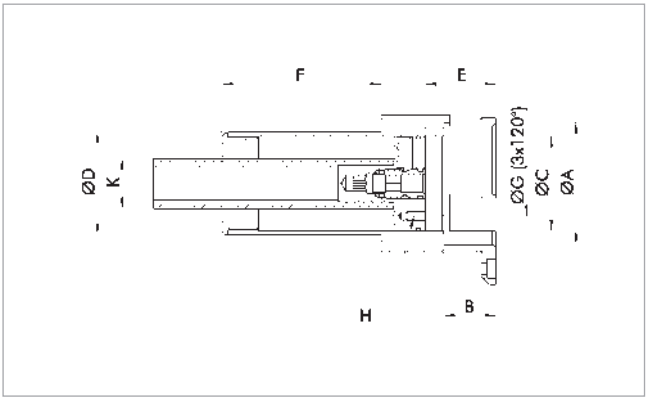


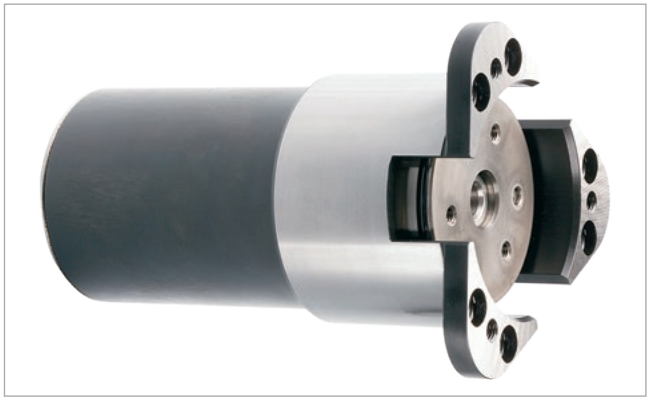


Technical data

Description	ID	Suitable for	ØA [mm]	B [mm]	ØC [mm]	ØD [mm]	F [mm]	ØG [mm]	K	Weight [kg]
SBS-S-W 165	8703498	ROTA THW plus 165-43	44	5	25	32	34	36	M16x1.5	0.6
SBS-S-W 185	8703249	ROTA THW plus 185-52	52	5	28	32	34	41	M16x1.5	1.1
SBS-S-W 215	8703164	ROTA THW plus 215-66	66	5	32	32	47	46	M16x1.5	1.7
SBS-S-W 260	8703308	ROTA THW plus 260-81	81	5	48	32	47	62	M16x1.5	2.8
SBS-S-W 315	8703251	ROTA THW plus 315-104	104	5	70	32	47	85	M16x1.5	4.6

Center sleeve with adjustable stop





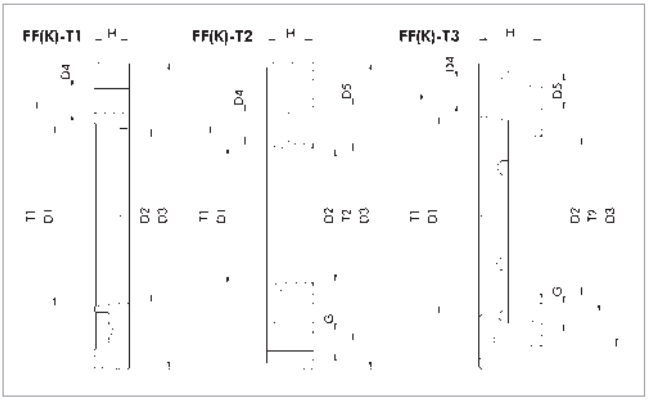
Technical data

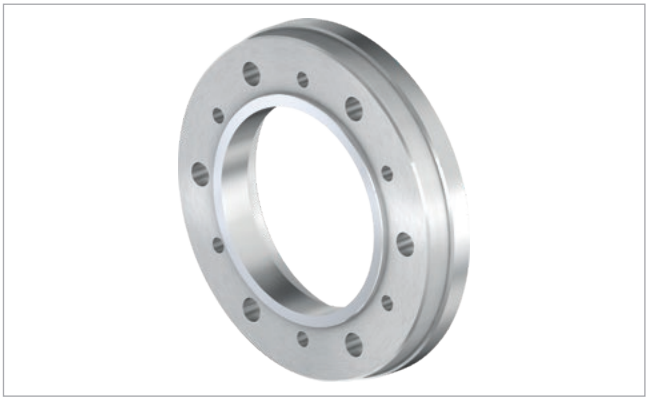
Description	ID	Suitable for	ØA [mm]	B [mm]	ØC [mm]	ØD [mm]	E [mm]	F [mm]	ØG [mm]	H	K	Weight [kg]
SBS-T-W 165	8703501	ROTA THW plus 165-43	43	23.5	42	46.5	23.5 - 110.8	91.5	30	M4x8	M27	1
SBS-T-W 185-46	8703690	ROTA THW plus 185-52	52	23.5	42	46.5	23.5 - 110.8	88.4	30	M4x8	M27	1.2
SBS-T-W 185-55	8703235	ROTA THW plus 185-52	52	23.5	51	55.5	23.5 - 110.8	88.4	35	M5x10	M27	1.3
SBS-T-W 215-55	8703691	ROTA THW plus 215-66	66	28	51	55.5	28 - 110.8	83	35	M5x10	M27	2
SBS-T-W 215-65	8703240	ROTA THW plus 215-66	66	28	61	65.5	28 - 110.8	83	40	M5x10	M27	2
SBS-T-W 260-56	8703692	ROTA THW plus 260-81	81	33	51	56.5	33 - 110.8	76.4	35	M5x10	M27	2.9
SBS-T-W 260-65	8703693	ROTA THW plus 260-81	81	33	61	65.5	33 - 110.8	76.4	40	M5x10	M27	2.9
SBS-T-W 260-80	8703310	ROTA THW plus 260-81	81	33	75	80.5	33 - 105.8	85.4	50	M6x12	M27	3.1
SBS-T-W 315-80	8703694	ROTA THW plus 315-104	104	37	75	80.5	38 - 105.8	78	50	M6x12	M27	4.5
SBS-T-W 315-103	8703260	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 Ø D + 0.5 mm

Adapter plates

Z-mount on short taper ISO 702-1





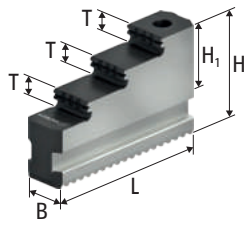
Technical data

Description	Adapter plate type	ID	Suitable for	D1	D2	D3	D4	D5	G	H	T1	T2
					[mm]		[mm]	[mm]		[mm]	[mm]	[mm]
FF-T2 Z140-A4	FF-T2	0805000	ROTA THW plus 165-43 ROTA THW plus 185-52	Nr. 4	61	Z140	11 (6x60°)	17	M10 (6x60°)	21	82.6	104.8
FF-T1 Z140-A5	FF-T1	0803000	ROTA THW plus 165-43 ROTA THW plus 185-52	Nr. 5	79.6	Z140	11 (6x60°)			16	104.8	
FF-T3 Z140-A6	FF-T3	0801000	ROTA THW plus 165-43 ROTA THW plus 185-52	Nr. 6	85	Z140	13 (6x60°)	20	M10 (6x60°)	34	133.4	104.8
FF-T2 Z170-A5	FF-T2	0805001	ROTA THW plus 185-52 ROTA THW plus 215-66 ROTA THW plus 260-81	Nr. 5	79.6	Z170	11 (6x60°)	18	M12 (12 x 30°)	25	104.8	133.4
FF-T1 Z170-A6	FF-T1	0803001	ROTA THW plus 185-52 ROTA THW plus 215-66 ROTA THW plus 260-81	Nr. 6	103.2	Z170	13 (6x60°)			17	133.4	
FF-T3 Z170-A8	FF-T3	0801001	ROTA THW plus 185-52 ROTA THW plus 215-66 ROTA THW plus 260-81	Nr. 8	113	Z170	17 (6x60°)	26	M12 (6x60°) M12 (2x180°)	40	171.4	133.4
FF-T2 Z220-A5	FF-T2	0805002	ROTA THW plus 260-81 ROTA THW plus 315-104	Nr. 5	79.6	Z220	11 (6x60°)	17	M16 (6x60°) M16 (2x180°)	28	104.8	171.4
FF-T2 Z220-A6	FF-T2	0805003	ROTA THW plus 260-81 ROTA THW plus 315-104	Nr. 6	103.2	Z220	13 (6x60°)	20	M16 (6x60°) M16 (2x180°)	28	133.4	171.4
FF-T1 Z220-A8	FF-T1	0803002	ROTA THW plus 260-81 ROTA THW plus 315-104	Nr. 8	136.2	Z220	17 (6x60°) 17 (2x180°)			19	171.4	
FF-T3 Z220-A11	FF-T3	0803003	ROTA THW plus 260-81 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	0803020	ROTA THW plus 260-81 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	0803021	ROTA THW plus 260-81 ROTA THW plus 315-104	Nr. 15	145	Z220	23 (6x60°)	35	M16 (6x60°)	55	330.2	171.4

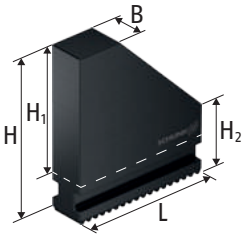
Direct adapter plates
Direct adapter plates are used if the spindle mounting bolt circle has the same size as the lathe chuck mounting bolt circle. The adapter plate has to be mounted on to the spindle together with the lathe chuck. The adapter plate is preassembled on the lathe chuck.
Reduction adapter plates FF-T2
Reduction adapter plates are used if the mounting bolt circle of the spindle is smaller than the 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 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

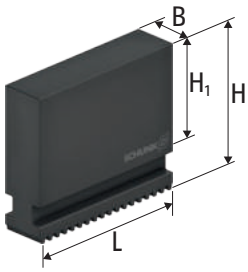
with straight serration



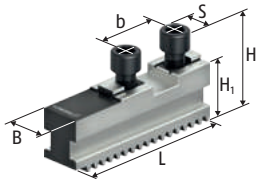
GST
Hard stepped block jaws



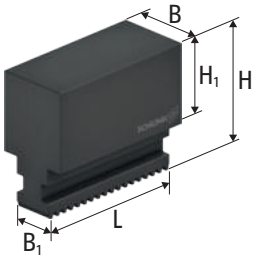
UVB-HS
Soft monoblock jaws



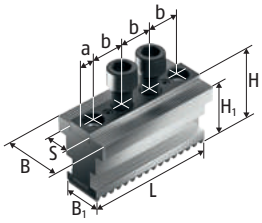
UVB
Soft monoblock jaws



GBK
Base jaws



UVB-B
Soft monoblock jaws



STNJ
Base jaws

Technical data

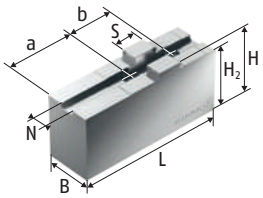
Chuck type	Description	ID	N [mm]	S [mm]	B [mm]	B1 [mm]	H [mm]	H1 [mm]	H2 [mm]	L [mm]	T [mm]	a [mm]	b [mm]	Screws	m/SET [kg]
ROTA THW plus 165-43	UVB 160	0164106			20		55.5	35		65					1.6
ROTA THW plus 165-43	GBK 160	0159106	18	8	20		30	27.5		65			32	M8	0.6
ROTA THW plus 165-43	GBK-V 160	0159156	18	8	20		30	27.5		65			32	M8	0.6
ROTA THW plus 165-43	GST 140-160 I	0162097			20		43.5	22		58	7				0.7
ROTA THW plus 165-43	GST 140-160 II	0162098			20		43.5	22		58	7				0.7
ROTA THW plus 185-52	UVB 160	0164106			20		55.5	35		65					1.6
ROTA THW plus 185-52	GBK 160	0159106	18	8	20		30	27.5		65			32	M8	0.6
ROTA THW plus 185-52	GBK-V 160	0159156	18	8	20		30	27.5		65			32	M8	0.6
ROTA THW plus 185-52	GST 140-160 I	0162097			20		43.5	22		58	7				0.7
ROTA THW plus 185-52	GST 140-160 II	0162098			20		43.5	22		58	7				0.7
ROTA THW plus 215-66	UVB 200	0164100			22		65	40		84					2.7
ROTA THW plus 215-66	UVB-B 200	0164113			40	22	65	38		84					3.9
ROTA THW plus 215-66	UVB-H 200	0164116			22		85	60		84					3.5
ROTA THW plus 215-66	UVB-HS 200	0164119			22		85	60	29	84					2.7
ROTA THW plus 215-66	GBK 200	0159100	20	10	22		32	29.5		85			40	M8	1.0
ROTA THW plus 215-66	GBKL 200	0159120	20	10	22		32	29.5		105			40	M8	1.2
ROTA THW plus 215-66	GBK-V 200	0159150	20	10	22		32	29.5		85			40	M8	1.0
ROTA THW plus 215-66	STNJ 200-5	0160650		14	40	22	49.5	47		95		10	25	M12	2.6
ROTA THW plus 215-66	GST 201	0162106			22		54	29		84.9	8				1.6
ROTA THW plus 260-81	UVB 250	0164101			26		84	55		99					4.8
ROTA THW plus 260-81	UVB-B 250	0164114			46	26	84	52		99					7.2
ROTA THW plus 260-81	UVB-H 250	0164117			26		115	86		99					6.6
ROTA THW plus 260-81	UVB-HS 250	0164120			26		115	86	48	99					5.2
ROTA THW plus 260-81	GBK 250	0159101	20	12	26		40	37		104			40	M12	1.8
ROTA THW plus 260-81	GBKL 250	0159121	20	12	26		40	37		125			40	M12	2.2
ROTA THW plus 260-81	GBK-V 250	0159151	20	12	26		40	37		104			40	M12	1.8
ROTA THW plus 260-81	STN 250-5	0160600		17	40	26	50.5	48		86		10	22	M12	2.6
ROTA THW plus 260-81	STN 250-6	0160601		21	45	26	54.5	52		110		13	28	M16	4.0

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 THW plus 260-81	GST 251	0162105			26		65	36		107.5	10				2.8
ROTA THW plus 315-104	UVB 315	0164102			32		90	56		121					7.6
ROTA THW plus 315-104	UVB-B 315	0164115			46	32	90	52		121					9.6
ROTA THW plus 315-104	UVB-H 315	0164118			32		135	101		121					11.6
ROTA THW plus 315-104	UVB-HS 315	0164121			32		135	101	52	121					9.0
ROTA THW plus 315-104	GBK 315	0159102	20	12	32		46	43		115			40	M12	3.0
ROTA THW plus 315-104	GBKL 315	0159122	20	12	32		46	43		137			40	M12	3.5
ROTA THW plus 315-104	GBK-V 315	0159152	20	12	32		46	43		115			40	M12	3.0
ROTA THW plus 315-104	STN 315-6	0160603		21	45	32	58.5	56		110		13	28	M16	4.5
ROTA THW plus 315-104	STNJ 315-5	0160652		18	50	32	56	54		120		15	30	M14	4.9
ROTA THW plus 315-104	STNJ 315-6	0160665		21	50	32	60	58		125		17.5	30	M16	5.5
ROTA THW plus 315-104	GST 315	0162102			32		66	32		116.3	10				3.5

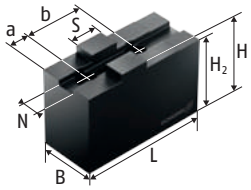
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Soft top jaws

with tongue and groove



SFA-AL
Soft top jaws



SFA
Soft top jaws

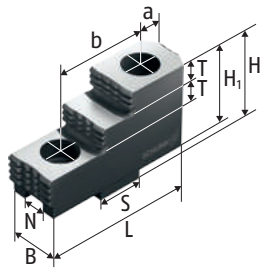
Technical data

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 THW plus 165-43	SFA 160	0153100	8	18	20	40	36	85	18	32	M8	1.2
ROTA THW plus 165-43	SFA-AL 160	0172100	8	18	25	50	46	85	35	32	M8	0.7
ROTA THW plus 165-43	SFA 160-C1	0154121	8	18	30	55.5	51.5	85	12	32	M8	2.7
ROTA THW plus 165-43	SFA 160-C2	0154127	8	18	35	40	36	63	12	32	M8	1.6
ROTA THW plus 165-43	SFA 160-C3	0154131	8	18	40	60	56	70	12	32	M8	3.3
ROTA THW plus 165-43	SFA 160-C4	0154133	8	18	40	80	76	85	12	32	M8	5.6
ROTA THW plus 185-52	SFA 160	0153100	8	18	20	40	36	85	18	32	M8	1.2
ROTA THW plus 185-52	SFA-AL 160	0172100	8	18	25	50	46	85	35	32	M8	0.7
ROTA THW plus 185-52	SFA 160-C1	0154121	8	18	30	55.5	51.5	85	12	32	M8	2.7
ROTA THW plus 185-52	SFA 160-C2	0154127	8	18	35	40	36	63	12	32	M8	1.6
ROTA THW plus 185-52	SFA 160-C3	0154131	8	18	40	60	56	70	12	32	M8	3.3
ROTA THW plus 185-52	SFA 160-C4	0154133	8	18	40	80	76	85	12	32	M8	5.6
ROTA THW plus 215-66	SFA 200	0153101	10	20	22	47	43	105	25	40	M8	2.0
ROTA THW plus 215-66	SFA-AL 200	0172102	10	20	25	50	46	105	40	40	M8	0.9
ROTA THW plus 215-66	SFA 200-C1	0154100	10	20	30	55.5	51.5	100	13	40	M8	3.2
ROTA THW plus 215-66	SFA 200-C2	0154124	10	20	22	55.5	51.5	100	13	40	M8	2.2
ROTA THW plus 215-66	SFA 200-C3	0154128	10	20	40	40	36	70	13	40	M8	2.1
ROTA THW plus 215-66	SFA 200-C4	0154130	10	20	40	60	56	85	13	40	M8	4.0
ROTA THW plus 215-66	SFA 200-C5	0154132	10	20	40	80	76	95	13	40	M8	6.1
ROTA THW plus 260-81	SFA 250	0153102	12	20	30	55.5	50.5	125	25	40	M12	3.7
ROTA THW plus 260-81	SFA-AL 250	0172103	12	20	40	60	55	125	60	40	M12	2.1
ROTA THW plus 260-81	SFA 250-C1	0154101	12	20	40	60	55	90	16	40	M12	3.9
ROTA THW plus 260-81	SFA 250-C2	0154102	12	20	40	60	55	125	16	40	M12	5.6
ROTA THW plus 260-81	SFA 250-C3	0154103	12	20	40	80	75	125	16	40	M12	7.7
ROTA THW plus 260-81	SFA 250-C4	0154104	12	20	40	100	95	125	69	40	M12	9.8
ROTA THW plus 260-81	SFA 250-C5	0154105	12	20	40	120	115	125	16	40	M12	11.8
ROTA THW plus 260-81	SFA 250-C6	0154106	12	20	60	60	55	90	16	40	M12	6.0
ROTA THW plus 260-81	SFA 250-C7	0154107	12	20	80	60	55	90	16	40	M12	8.5
ROTA THW plus 260-81	SFA 250-C8	0154134	12	20	80	100	95	125	16	40	M12	20.6
ROTA THW plus 315-104	SFA 250	0153102	12	20	30	55.5	50.5	125	25	40	M12	3.7
ROTA THW plus 315-104	SFA 250-C1	0154101	12	20	40	60	55	90	16	40	M12	3.9
ROTA THW plus 315-104	SFA 250-C2	0154102	12	20	40	60	55	125	16	40	M12	5.6
ROTA THW plus 315-104	SFA 250-C3	0154103	12	20	40	80	75	125	16	40	M12	7.7
ROTA THW plus 315-104	SFA 250-C4	0154104	12	20	40	100	95	125	69	40	M12	9.8
ROTA THW plus 315-104	SFA 250-C5	0154105	12	20	40	120	115	125	16	40	M12	11.8
ROTA THW plus 315-104	SFA 250-C6	0154106	12	20	60	60	55	90	16	40	M12	6.0
ROTA THW plus 315-104	SFA 250-C7	0154107	12	20	80	60	55	90	16	40	M12	8.5
ROTA THW plus 315-104	SFA 250-C8	0154134	12	20	80	100	95	125	16	40	M12	20.6

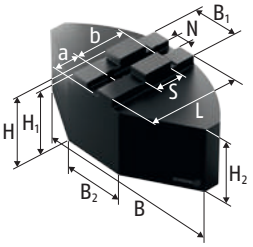
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Hard stepped top jaws, Full grip jaws

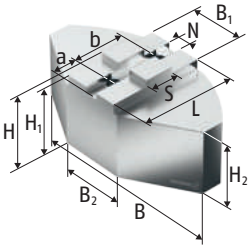
with tongue and groove



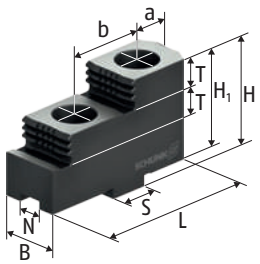
SHF
Hard stepped top jaws



SFA-SM
Full grip jaws



SFA-SA
Full grip jaws



SHF
Hard stepped top jaws

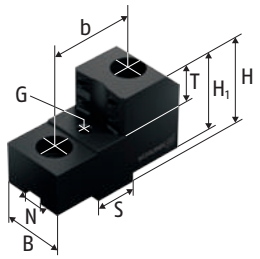
Technical data

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 THW plus 165-43	SFA-SA 160	0174100	8	18	120	35	50	46	40	59.5		15.75	32	M8	1.4
ROTA THW plus 165-43	SFA-SM 160	0173100	8	18	120	30	50	46	40	60		16.5	32	M8	4.8
ROTA THW plus 165-43	SHF 160	0155100	8	18	20		36.5	32.5		63	7.5	16.8	32	M8	0.6
ROTA THW plus 185-52	SFA-SA 160	0174100	8	18	120	35	50	46	40	59.5		15.75	32	M8	1.4
ROTA THW plus 185-52	SFA-SM 160	0173100	8	18	120	30	50	46	40	60		16.5	32	M8	4.8
ROTA THW plus 185-52	SHF 160	0155100	8	18	20		36.5	32.5		63	7.5	16.8	32	M8	0.6
ROTA THW plus 215-66	SFA-SA 200	0174101	10	20	140	35	58	54	48	72.5		21.75	40	M8	2.4
ROTA THW plus 215-66	SFA-SA 201	0174105	10	20	140	35	80	76	70	72.5		21.75	40	M8	3.5
ROTA THW plus 215-66	SFA-SM 200	0173101	10	20	140	35	60	56	50	70		18	40	M8	9.0
ROTA THW plus 215-66	SFA-SM 201	0173105	10	20	140	35	80	76	70	70		18	40	M8	12.5
ROTA THW plus 215-66	SHF 200	0155101	10	20	22		42	38		71.7	10	16	40	M8	0.8
ROTA THW plus 260-81	SFA-SA 250	0174102	12	20	180	40	58	53	43	87.5		33.75	40	M12	3.4
ROTA THW plus 260-81	SFA-SA 251	0174106	12	20	180	40	80	75	65	87.5		33.75	40	M12	5.0
ROTA THW plus 260-81	SFA-SM 250	0173102	12	20	180	40	60	55	45	90		34.5	40	M12	12.8
ROTA THW plus 260-81	SFA-SM 251	0173106	12	20	180	40	80	75	65	90		35	40	M12	18.9
ROTA THW plus 260-81	SHF 250	0155102	12	20	30		55	50		90	14	21.1	40	M12	1.9
ROTA THW plus 315-104	SFA-SA 250	0174102	12	20	180	40	58	53	43	87.5		33.75	40	M12	3.4
ROTA THW plus 315-104	SFA-SA 251	0174106	12	20	180	40	80	75	65	87.5		33.75	40	M12	5.0
ROTA THW plus 315-104	SFA-SM 250	0173102	12	20	180	40	60	55	45	90		34.5	40	M12	12.8
ROTA THW plus 315-104	SFA-SM 251	0173106	12	20	180	40	80	75	65	90		35	40	M12	18.9
ROTA THW plus 315-104	SHF 250	0155102	12	20	30		55	50		90	14	21.1	40	M12	1.9

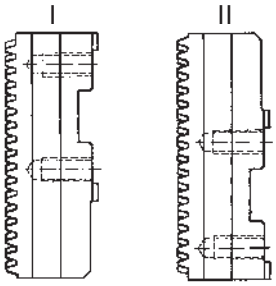
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Claw jaws

with tongue and groove



SZKA
Claw jaws



Position of base jaws

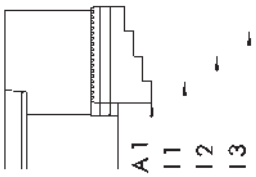
Technical data

Chuck type	Clamping range ØD	Swing diameter SDmax	Position of base jaws	Description	ID	N	S	B	H	H1	T	G	b	Screws	m/SET
	[mm]	[mm]				[mm]	[mm]	[mm]	[mm]	[mm]	[mm]		[mm]		[kg]
ROTA THW plus 165-43	73 - 116	197	I	SZKA 163	0165146	8	18	40	44	40	20	M6	32	M8	1.5
ROTA THW plus 165-43	123 - 167	229	I	SZKA 167	0165150	8	18	30	44	40	20	M6	32	M8	1.3
ROTA THW plus 165-43	28 - 68	190	I	SZKA 169	0165174	8	18	26	44	40	20	M6	32	M8	1.0
ROTA THW plus 165-43	55 - 98	190	II	SZKA 163	0165146	8	18	40	44	40	20	M6	32	M8	1.5
ROTA THW plus 165-43	105 - 149	211	II	SZKA 167	0165150	8	18	30	44	40	20	M6	32	M8	1.3
ROTA THW plus 185-52	75 - 138	219	I	SZKA 163	0165146	8	18	40	44	40	20	M6	32	M8	1.5
ROTA THW plus 185-52	28 - 90	212	I	SZKA 169	0165174	8	18	26	44	40	20	M6	32	M8	1.0
ROTA THW plus 185-52	112 - 176	233	II	SZKA 168	0165151	8	18	30	44	40	20	M6	32	M8	1.3
ROTA THW plus 215-66	26 - 96	264	I	SZKA 212	0139153	10	20	26	49	45	25	M6	40	M8	1.4
ROTA THW plus 215-66	97 - 172	264	I	SZKA 213	0139154	10	20	30	49	45	25	M6	40	M8	1.3
ROTA THW plus 215-66	132 - 207	269	I	SZKA 216	0139159	10	20	30	49	45	25	M6	40	M8	1.2
ROTA THW plus 260-81	145 - 221	316	I	SZKA 266	0139163	12	20	40	55	50	25	M6	40	M12	1.9
ROTA THW plus 260-81	178 - 255	330	I	SZKA 268	0139165	12	20	40	55	50	25	M6	40	M12	2.2
ROTA THW plus 260-81	31 - 101	313	II	SZKA 263	0139160	12	20	30	55	50	25	M6	40	M12	1.5
ROTA THW plus 260-81	83 - 158	313	II	SZKA 266	0139163	12	20	40	55	50	25	M6	40	M12	1.9
ROTA THW plus 315-104	203 - 313	388	I	SZKA 268	0139165	12	20	40	55	50	25	M6	40	M12	2.2
ROTA THW plus 315-104	31 - 138	373	II	SZKA 263	0139160	12	20	30	55	50	25	M6	40	M12	1.5
ROTA THW plus 315-104	120 - 230	373	II	SZKA 268	0139165	12	20	40	55	50	25	M6	40	M12	2.2

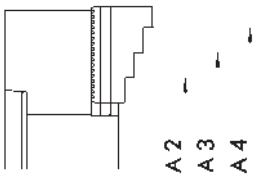
Our complete range of chuck jaws can be found online in our Chuck Jaw Quickfinder and on schunk.com

Hard stepped block jaws

with tongue and groove



Jaw position I



Jaw position II

O.D. clamping

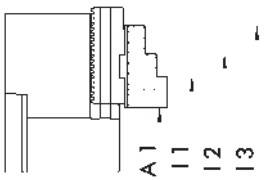
Chuck type	Description	ID	A1 [mm]	A2 [mm]	A3 [mm]	A4 [mm]
ROTA THW plus 165-43	GST 140-160 I	0162097	12 - 59	43 - 89	74 - 120	105 - 151
ROTA THW plus 165-43	GST 140-160 II	0162098	3 - 74	30 - 94	61 - 125	92 - 156
ROTA THW plus 185-52	GST 140-160 I	0162097	5 - 86	32 - 107	63 - 138	94 - 169
ROTA THW plus 185-52	GST 140-160 II	0162098	3 - 87	30 - 107	61 - 138	92 - 169
ROTA THW plus 215-66	GST 201	0162106	9 - 86	41 - 122	90 - 170	138 - 218
ROTA THW plus 260-81	GST 251	0162105	9 - 111	61 - 161	116 - 216	171 - 271
ROTA THW plus 315-104	GST 315	0162102	27 - 140	93 - 206	149 - 262	205 - 318

I.D. clamping

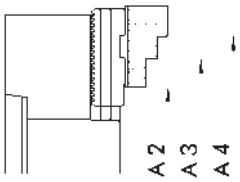
Chuck type	Description	ID	I1 [mm]	I2 [mm]	I3 [mm]
ROTA THW plus 165-43	GST 140-160 I	0162097	44 - 89	74 - 120	105 - 151
ROTA THW plus 165-43	GST 140-160 II	0162098	35 - 106	66 - 137	97 - 168
ROTA THW plus 185-52	GST 140-160 I	0162097	38 - 116	67 - 147	98 - 178
ROTA THW plus 185-52	GST 140-160 II	0162098	35 - 119	66 - 150	97 - 181
ROTA THW plus 215-66	GST 201	0162106	56 - 131	103 - 179	150 - 227
ROTA THW plus 260-81	GST 251	0162105	70 - 170	124 - 225	179 - 280
ROTA THW plus 315-104	GST 315	0162102	86 - 196	140 - 252	196 - 308

Hard stepped top jaws

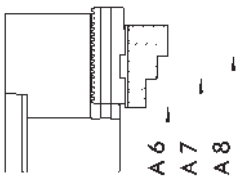
with tongue and groove



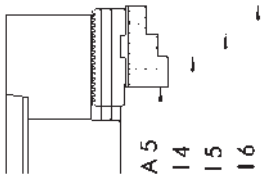
Position of base jaws II



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 THW plus 165-43	SHF 160	0155100	7 - 61	29 - 84	74 - 130	99 - 155	23 - 79	15 - 67	60 - 112	85 - 137
ROTA THW plus 185-52	SHF 160	0155100	7 - 83	29 - 106	74 - 152	99 - 177	23 - 101	15 - 89	60 - 134	85 - 159
ROTA THW plus 215-66	SHF 200	0155101	10 - 89	49 - 128	101 - 180	128 - 207	48 - 127	16 - 90	68 - 142	95 - 169
ROTA THW plus 260-81	SHF 250	0155102	11 - 107		79 - 174	159 - 255	75 - 170		41 - 111	121 - 191
ROTA THW plus 315-104	SHF 250	0155102	14 - 145		104 - 232	184 - 313	100 - 229		44 - 149	124 - 229

I.D. clamping

Chuck type	Description	ID	I1 [mm]	I2 [mm]	I4 [mm]	I5 [mm]
ROTA THW plus 165-43	SHF 160	0155100	63 - 114	87 - 139	78 - 132	103 - 157
ROTA THW plus 185-52	SHF 160	0155100	63 - 137	87 - 162	78 - 155	103 - 180
ROTA THW plus 215-66	SHF 200	0155101	74 - 151	100 - 178	111 - 189	138 - 216
ROTA THW plus 260-81	SHF 250	0155102	92 - 186	171 - 266	154 - 250	
ROTA THW plus 315-104	SHF 250	0155102	97 - 224	175 - 304	179 - 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 165-43		
ROTA THW plus 185-52		
ROTA THW plus 215-66		
ROTA THW plus 260-81		
ROTA THW plus 315-104	IFT Set	1404235

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 165-43		
ROTA THW plus 185-52		
ROTA THW plus 215-66	SSH-A SW8-148	8703298
ROTA THW plus 260-81		
ROTA THW plus 315-104	SSH-A SW10-148	8703302

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 260-81	SSH-MR Ø81-150	8703906
ROTA THW plus 315-104	SSH-MR Ø104-150-1	8703907

Grease

LINOMAX plus

High-performance grease as standard for regularly lubricating SCHUNK manual and power lathe chucks and steady rests.



Bundle	Weight [kg]	Description	ID
Cartridge	0.5	LINOMAX plus cartridge	1342585
Can	1	LINOMAX plus can	1342586
Bucket	21.5	LINOMAX plus bucket	1342587

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	Weight [kg]	Description	ID
Cartridge	1.46	Grease gun	9900543

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