Superior Clamping and Gripping

Jens Lehmann stands for safe, precise gripping and holding. As a brand ambassador of the SCHUNK team, the No. 1 goalkeeper represents our global competence leadership for clamping technology and gripping systems. The top performance of SCHUNK and Jens Lehmann are characterized by dynamics, precision, and reliability.

For more information visit our website:
www.gb.schunk.com/Lehmann
Top Performance in the Team

SCHUNK is the world’s No. 1 for clamping technology and gripping systems – from the smallest parallel gripper to the largest chuck jaw program.

In order to boost efficiency, SCHUNK customers have bought more than 2,000,000 precision toolholders, 1,000,000 SCHUNK grippers, and 100,000 lathe chucks and stationary workholding systems so far.

This makes us proud and motivates us to attain new top performances.

As a competence leader, we recognize and develop standards with a large potential for the future, which will drive the rapid progress in many industries.

Our customers profit from the expert knowledge, the experience, and the team spirit of more than 2,500 employees in our innovative family-owned company.

The Schunk family wishes you improved end results with our quality products.
From the universal manual chuck to power lathe chucks with jaw quick-change systems and maximum clamping forces, SCHUNK offers the most versatile lathe chucks for every application. They feature outstanding quality based on innovative technology and more than 40 years of experience built up by our highly specialized employees.

Chuck jaws, steady rests, toolholders and clamping cylinders complete the range of products designed to meet the demanding requirements of modern machining. By continuous development of technology and products as well as by rigorous compliance with the quality management system DIN EN ISO 9001/2000, SCHUNK is your competent partner for high-quality lathe chucks!

Even for customized or complete solutions which are combined with chuck jaws SCHUNK shows highest competence as a “single-source supplier” of effective and economic solutions.
It's time to use your machine's full potential!

Our superior components can unlock potential you didn't even know you had. In your machine. SCHUNK Synergy – the perfectly harmonized relationship between clamping technology and gripping systems turns our customers into productivity champions …

... in your Automated Handling System
... in your Automated Machine Loading
... in your Machining Center
... in your Automated Assembly Line
... in your Service Robotics Application

Steady rests
A plus for any lathe in shaft machining. Permanently excellent centering and repeat accuracy combined with maximum clamping forces.

- Clamping range 4 – 460 mm

Toolholders
TENDturn – unique vibration damping for excellent workpiece surfaces.

- Up to 300% improved surface finish
- Run-out and repeat accuracy < 0.003 mm

Accessories
The ideal accessories for every lathe for greater process reliability and efficiency.

- Clamping force tester and control unit
- Special grease
- Clamping cylinder

ZENTRICO THL plus
Steady Rests

TIE IN HYDRAURAL
Hydraulic Expansion Technology

OPUS-V
Closed-center Hydraulic Cylinder
### Chuck Jaws

<table>
<thead>
<tr>
<th>Chuck jaws</th>
<th>Soft top jaws</th>
<th>Jaw blanks</th>
<th>Full grip top jaws</th>
<th>Block jaws</th>
</tr>
</thead>
<tbody>
<tr>
<td>&lt;image&gt;</td>
<td>&lt;image&gt;</td>
<td>&lt;image&gt;</td>
<td>&lt;image&gt;</td>
<td>&lt;image&gt;</td>
</tr>
</tbody>
</table>

#### Fields of application
- Unfinished part clamping
- Finished part clamping
- I.D. Clamping
- O.D. Clamping

#### Characteristics
- **Jaw interface/design (as standard)**
  - Fine serration 90° Tongue and groove
  - Fine serration 60° Tongue and groove
  - Fine serration 60° Tongue and groove
  - Straight and diagonal wedge-bar serration
- **Available for lathe chuck sizes (as standard)**
  - 80 – 1200 mm
  - 160 – 800 mm
  - 80 – 630 mm
  - 140 – 800 mm
- **Material**
  - 16MnCr5 steel suitable for case hardening or high-tensile aluminum
  - 16MnCr5 steel suitable for case hardening
  - 16MnCr5 steel suitable for case hardening or high-tensile aluminum
  - C65, tempered, suitable for induction hardening
- **Highlights**
  - Depending on version: ground groove and fine serration or finely milled tongue and groove
  - Can be turned to the required clamping diameter
  - Available drilled or undrilled
  - Ground groove and fine serration
  - Can be turned to the required clamping diameter
  - The large locating surface ensures that clamping forces are evenly distributed over the workpiece area, thereby reducing deformation of the workpiece
  - Inductively hardened serration and guides can increase the life span of the lathe chuck
  - Available in different versions
<table>
<thead>
<tr>
<th>Claw jaws</th>
<th>Stepped top jaws</th>
<th>Stepped block jaws</th>
<th>PRONTO jaw quick-change system</th>
<th>Pendulum jaws</th>
<th>QUENTES fiber glass jaws</th>
</tr>
</thead>
<tbody>
<tr>
<td><img src="image1" alt="Claw jaws" /></td>
<td><img src="image2" alt="Stepped top jaws" /></td>
<td><img src="image3" alt="Stepped block jaws" /></td>
<td><img src="image4" alt="PRONTO jaw quick-change system" /></td>
<td><img src="image5" alt="Pendulum jaws" /></td>
<td><img src="image6" alt="QUENTES fiber glass jaws" /></td>
</tr>
</tbody>
</table>

- **Material**
  - Available for lathe chuck sizes (as standard)
  - Jaw interface/design characteristics:
    - Jaw quick change
    - Low-deformation clamping adjusted by turning
    - Clamping diameter can be compensated for shape tolerances
    - O.D. Clamping
    - I.D. Clamping
    - Finished part clamping
    - Unfinished part clamping

Fields of application:
- High-tensile aluminum for case hardening or 16MnCr5 steel suitable

Jaw blanks:
- 160 – 630 mm
- 140 – 1000 mm
- 110 – 1200 mm

Jaw interface/design:
- Tongue and groove
- Fine serration 60°
- Fine serration 90°

- Clamping inserts with:
  - Serrated jaws
  - Serrated jaws for bar clamping
  - Serrated jaws for bar clamping
  - Serrated jaws for bar clamping

- Suitable for O.D., I.D., and bar clamping
- Suitable for O.D., I.D., and bar clamping
- Suitable for O.D., I.D., and bar clamping
- Suitable for O.D., I.D., and bar clamping

- The diamond serration allows for an initial set-up in which the clamping teeth penetrate only slightly into the workpiece
- Suitable for O.D., I.D., and bar clamping
- Variety of large clamping ranges can be implemented

- For clamping rough and finished parts
- 700% expansion of clamping range without displacement of the supporting jaws in intervals of 5 seconds per jaw
- For clamping thin-walled and deformation-sensitive workpieces
- Shape errors compensated through oscillation
- Clamping inserts are available in hardened and unhardened versions
- With soft and hard clamping inserts with diamond serration

- The lightweight and stable design ensures minimal loss of clamping force
- No clamping marks, therefore ideal for clamping on highly sensitive, already ground or finished surfaces
- Low-priced system due to changeable clamping inserts

<table>
<thead>
<tr>
<th>Fine serration 90°</th>
<th>Fine serration 60°</th>
<th>Tongue and groove</th>
<th>Fine serration 90°</th>
<th>Fine serration 60°</th>
<th>Tongue and groove</th>
<th>Fine serration 90°</th>
<th>Fine serration 60°</th>
<th>Tongue and groove</th>
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<td>Tongue and groove</td>
<td>Fine serration 90°</td>
<td>Fine serration 60°</td>
<td>Tongue and groove</td>
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<tr>
<td>140 – 1000 mm</td>
<td>110 – 1200 mm</td>
<td>160 – 630 mm</td>
<td>200 – 315 mm</td>
<td>200 – 500 mm</td>
<td>160 – 315 mm</td>
<td>160 – 315 mm</td>
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<td>160 – 315 mm</td>
<td>160 – 315 mm</td>
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<td>160 – 315 mm</td>
</tr>
<tr>
<td>16MnCr5 steel, case-hardened</td>
<td>16MnCr5 steel, case-hardened</td>
<td>16MnCr5 suitable for case hardening or 16MnCr5 steel</td>
<td>Tempered or case-hardened steel</td>
<td>Case-hardened steel</td>
<td>Glass-fiber-reinforced plastic</td>
<td>Glass-fiber-reinforced plastic</td>
<td>Glass-fiber-reinforced plastic</td>
<td>Glass-fiber-reinforced plastic</td>
<td>Glass-fiber-reinforced plastic</td>
<td>Glass-fiber-reinforced plastic</td>
<td>Glass-fiber-reinforced plastic</td>
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</tbody>
</table>
**Customized solutions**

Over 30 years of experience developing and manufacturing special chuck jaws make us a sought-after partner for special applications. From modified standard jaws to complex custom designs, our team of experts develops the right solution for every application.

Challenge us – we will win you over!

**Examples of customized solutions**

1. Clamping a lifting hook using a rigid jaw with workpiece stops and a jaw with axial and radially oscillating clamping inserts
2. Square clamping on a 2-jaw chuck with two customized prism jaws
3. 4-point clamping solution for a conrod eye in a 2-jaw chuck with a rigid jaw and a pendulum jaw
4. 6-point pendulum jaw for conrods in a 3-jaw chuck
5. I.D. clamping of a thin-walled ring by a 12-point pendulum jaw with changeable clamping inserts

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**Serrated jaws**

<table>
<thead>
<tr>
<th>Jaw type</th>
<th>Base jaw type</th>
</tr>
</thead>
<tbody>
<tr>
<td>Fine serration 90°</td>
<td>Straight and diagonal</td>
</tr>
<tr>
<td>Fine serration 60°</td>
<td>wedge-bar serration</td>
</tr>
<tr>
<td>125 – 800 mm</td>
<td>125 – 1000 mm</td>
</tr>
<tr>
<td>Steel or aluminum</td>
<td>Hardened and precision</td>
</tr>
<tr>
<td></td>
<td>ground steel</td>
</tr>
</tbody>
</table>

- For universal use
- Standard length 420 mm undrilled for custom cutting
- For producing long chuck jaws; this allows any custom length to be implemented quickly and economically
- Hardened and precision ground base jaws for top jaws
- With mount for top jaw with tongue and groove or fine serration

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**Base jaws**

- 125 - 800 mm
- 140 – 1000 mm
- 125 - 1000 mm
- Block jaws
- 6-point pendulum jaw for conrods in a 3-jaw chuck
- Stepped top jaws
- Stepped block jaws
- Hardened and precision ground steel
SCHUNK Chuck Jaw Quickfinder on the Internet

At www.schunk.com/chuck-jaw-quickfinder, you will receive an overview on possible chuck jaw solutions, including accessory products such as T-nuts and screws.

- Faster through guided product searches
  Prescribed selection menus facilitate the search.
- Find the right jaw faster
  In just seconds the suitable chuck jaws with the associated accessory products are presented.

- A faster qualified enquiry
  An online form enables a clear enquiry.
- A faster standard chuck jaw quotation
  Quotations for standard chuck jaws are guaranteed within 55 minutes after receipt of the enquiry on all working days between 7 a.m. and 5 p.m.
- Faster – around the clock
  Information retrieval and requests are possible online 24 hours a day.
- Faster, individual product configuration and modification
  Just enter your desire changes and send them. You will then receive an individual quotation within 24 hours.

The new SCHUNK Chuck Jaw-App – any time available via mobile phone

Everything under Control – the new Chuck Jaw-App
With our new app for your smartphone, the complete SCHUNK chuck jaw assortment is always available and easy to order.

Downloads at iTunes or Android
### Lathe Chucks

<table>
<thead>
<tr>
<th>Manual lathe chucks</th>
<th>Power lathe chucks with jaw quick-change system</th>
</tr>
</thead>
<tbody>
<tr>
<td>ROTA-S plus 2.0</td>
<td>ROTA-S flex</td>
</tr>
</tbody>
</table>

**Fields of application**

- Large spindle bore
- Max. RPM
- Modular center sleeve system
- Large jaw stroke
- Jaw quick-change system
- High jaw change repeat accuracy
- High clamping repeat accuracy
- Centrifugal force compensation
- Media feed-through
- Clamping smallest workpieces
- Bar machining
- Overlap clamping
- Wedge-bar power chuck
- Wedge-hook chuck
- Fine serration in inches:
  - Tongue and groove
  - Tube ends machining
- Lever chuck
- Active jaw pull-down function
- Hermetically sealed

**Characteristics**

<table>
<thead>
<tr>
<th>Size</th>
<th>Design</th>
<th>Jaw interface</th>
</tr>
</thead>
<tbody>
<tr>
<td>160 – 1400</td>
<td>Wedge–bar power chuck</td>
<td>Base jaws with angled serration</td>
</tr>
<tr>
<td>550 – 1400</td>
<td>Wedge–bar power chuck</td>
<td>Base jaws with straight serration</td>
</tr>
<tr>
<td>180 – 260</td>
<td>Base jaws with serration in inches</td>
<td>Base jaw with straight serration</td>
</tr>
<tr>
<td>165 – 315</td>
<td>or tongue and groove</td>
<td></td>
</tr>
<tr>
<td>215</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Highlights**

- Quick–change jaw chuck
- Large toolholder through bore
- Excellent accuracy
- Modular centersleeve system (up to size 315)
- Can be combined with arbor (up to size 315)
- Steel body
- Sealed against dirt
- Variable gauge clearance
- High clamping forces
- Quick–change jaw chuck
- Large toolholder through bore
- High changing repeat accuracy
- Modular center sleeve system
- Collet chuck or arbor mountable
<table>
<thead>
<tr>
<th>Power lathe chucks with through-hole</th>
<th>Power lathe chucks without through-hole</th>
</tr>
</thead>
<tbody>
<tr>
<td>ROTA NCX</td>
<td>ROTA NCD</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
<tr>
<td>![Image](36x637 to 89x689)</td>
<td>![Image](107x652 to 183x674)</td>
</tr>
<tr>
<td>![Image](107x652 to 183x674)</td>
<td>![Image](198x635 to 252x688)</td>
</tr>
<tr>
<td>![Image](198x635 to 252x688)</td>
<td>![Image](280x635 to 335x689)</td>
</tr>
<tr>
<td>![Image](362x634 to 419x694)</td>
<td>![Image](441x633 to 504x697)</td>
</tr>
</tbody>
</table>

- 165 – 315
- 132 – 630
- 185 – 315/400 – 630
- 185 – 315/400 – 1000
- 165 – 315
- 165 – 1000

- **Wedge-bar power chuck**
- **Wedge-hook chuck**
- **Jaw connection with serration in metric and inch units**
- **Jaw connection with serration in metric and inch units**
- **Jaw connection with serration in metric and inch units**
- **Jaw connection with serration in inches or tongue and groove**

- **Quick-change jaw chuck**
- **High changing repeat accuracy**
- **Interface compatible with Kitagawa BB 200 series**
- **Easy replacement of existing chucks with fine serration**
- **Very large toolholder through bore**
- **Integrated centrifugal force compensation**
- **Patent collet jaw system**
- **Double base jaw guidance with ROTA NCF plus**
- **Modular center sleeve system**
- **Special optimized pump lubrication system**
- **Very large toolholder through bore**
- **Double base jaw guidance with ROTA NC plus**
- **Modular center sleeve system**
- **Special optimized pump lubrication system**
- **Jaw connection metric or inches**
- **Interface 100% compatible with Kitagawa B200 series**
- **Integrated center sleeve blank**
- **Very small chuck size**
- **High clamping force and large jaw stroke**
- **Additional dirt seal**
## Lathe Chucks

### Power lathe chucks without through-hole
- **ROTA 2B**
- **ROTA NCR**
- **ROTA NCS**
  - 3- or 6-jaws

### Pneumatic power chucks
- **ROTA TP**
- **ROTA TB/TB-LH**
- **ROTA TB2**

<table>
<thead>
<tr>
<th></th>
<th>ROTA 2B</th>
<th>ROTA NCR</th>
<th>ROTA NCS 3- or 6-jaws</th>
<th>ROTA TP</th>
<th>ROTA TB/TB-LH</th>
<th>ROTA TB2</th>
<th>ROTA TB-LH</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Image</strong></td>
<td>![Image](102x635 to 156x693)</td>
<td>![Image](184x635 to 239x693)</td>
<td>![Image](264x636 to 321x692)</td>
<td>![Image](424x636 to 478x688)</td>
<td>![Image](484x44 to 538x96)</td>
<td>![Image](553x43 to 607x96)</td>
<td>![Image](622x43 to 676x96)</td>
</tr>
<tr>
<td><strong>125 – 500</strong></td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
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<tr>
<td><strong>165 – 1600</strong></td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
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<td>✔</td>
</tr>
<tr>
<td><strong>175 – 500</strong></td>
<td>✔</td>
<td>✔</td>
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<td>✔</td>
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<tr>
<td><strong>125 – 350</strong></td>
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<tr>
<td><strong>400 – 1200</strong></td>
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<tr>
<td><strong>600 – 1200</strong></td>
<td>✔</td>
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<td>✔</td>
<td>✔</td>
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</tr>
</tbody>
</table>

- **Wedge-hook chuck**
  - 6-jaw pendulum compensation chuck, central clamping
  - Lever chuck (for NCS 3-jaw) pendulum compensation chuck, central clamping (for NCS 6-jaw)

- **Active jaw pull-down function**
- **Hermetically sealed**
- **Low maintenance**
- **With integrated pneumatic cylinder**
- **Very large through-hole**
- **With fast stroke and clamping stroke**
- **Seal of the base jaw guide**
- **Chemical coating for corrosion protection**
- **Wireless clamping pressure control**

### Additional features
- **Very large jaw stroke**
- **Lightweight design**
- **Mounting thread for workpiece stops**
Lathe Chucks

**ROTA FSW Chuck quick-change system.**
Complete chuck change in less than three minutes.

**Changing of clamping devices in no time**
The patented SCHUNK ROTA FSW quick-change chuck system allows rapid chuck changes up to a size of 630 mm in under three minutes, with excellent repeat accuracy. It can be undone and locked with full process reliability using just one clamping screw. Using a flexible adapter, the draw tube of the lathe chuck can be automatically connected to the lathe chuck, and centered with great precision due to a patented flexible taper. A patented dual stroke system ensures enormous pull-down forces, an optimal flat work surface, and maximum rigidity in the connection.

**Versatile in use and easy to retrofit**
The SCHUNK quick-change chuck system can be retrofitted to almost any lathe. It is suitable for manual as well as power chucks. Their actuating force and maximum rotational speed remain fully preserved. Due to the low height, there are few restrictions in installation space. With its large through-hole, the SCHUNK ROTA FSW can be also used in modern turning centers. Clamping devices that are already in place can be adapted to the system relatively straightforwardly and continue to be used.

**Your benefits**
- High pull-down force for maximum actuating forces
- Low height
- Form-fit locking with self-locking
- Patented drive
- Actuation of the entire system by means of one setscrew
- High rigidity due to flat work surface
- Patented centering via flex cone
- Locking status indicator
- Easy to operate
- Retrofittable for almost every lathe
- Available in three sizes for chucks up to Ø 630 mm
Steady Rests


ZENTRICO THL plus Steady Rests

Due to optimized lever kinematics, central lubrication, integrated roller rinsing, and stopping contamination, the new SCHUNK ZENTRICO plus steady rest achieves maximum clamping forces for each roller, as well as constantly excellent centering and repeat accuracy.

Clamping range 4 – 460 mm
Steady Rests

Equipment and options

Standard design:
• Cylindrical rollers
• Roller rinsing
• Central lubrication
• Hydraulic connections on the side and rear on the cylinder
• Payload compatible with competing products
• Extra stable double chip protection on rollers
• Check valve in the cylinder
• Air purge connection
• Stroke monitoring (without limit switch)

Optional:
• Swing-out lever arm
• Spherical rollers (no surcharge)
• Manual lubrication
• Pneumatic version
• Side cylinder
• Adapter plates for fastening the steady rests

Your advantages:
• High centering and repeat accuracy due to optimized lever kinematics
• Much lower contamination, less chip nesting
• Simple attachment, fits on almost every machine
• Existing steady rests can be replaced easily, no special parts required
• Slim cylindrical build, no interfering contour on the steady rest
• Easy supply and long lifetime
• Process reliable operation and longer maintenance intervals
• High process and operating safety

Steady rest open with swung-out lever arm
Steady rest open (standard)
Steady rest closed
Low–vibration! Improved of surface finish by up to 300%

**TENDOturn**

With TENDOturn, you benefit from the advantages of the innovative hydraulic expansion toolholder technology – even with applications on lathes/milling centers. Along with highlights such as the versatile clamping range by virtue of intermediate sleeves, the run–out and repeat accuracy of $< 0.003$ mm (DSE double clamping insert), and the easy handling, TENDOturn convinces primarily through its unique vibration damping. This helps you to realize excellent workpiece surfaces.

**TENDO hydraulic expansion toolholders with CAPTO mountings for turning/milling centers and milling/turning centers.**
Your benefits

- All TENDOturn versions have an axial length-adjustment screw
- All shank types can be clamped, including Weldon and Whistle Notch
- Improvement of vibration damping and thus visible improvement in the surface finish by up to 300%

TENDOturn with VDI interface
The compact solution for direct use in the turret of a lathe. Suitable for internal coolant supply and additionally equipped with axial length-setting screw for comfortable pre-setting outside the machine.

TENDOturn DKE lathe clamping insert
Increase the productivity of your existing equipment by using the DKE lathe clamping insert. TENDOturn DKE does not require any specific interface and can be held in any customary VDI bore rod holders in order to absorb vibrations.

TENDOturn DSE double clamping insert
Modular insert for driven tools, for perfect performance on existing equipment. Maximum run-out quality and great vibration damping ensure optimal results. The uniform internal/external clamping force centers the insert providing maximum holding forces and correct and precise clamping of your tool.
Accessories

Exact measurement for process-reliable workpiece clamping.

**GFT-X clamping force tester**
Clamping force tester for static and dynamic measurement of clamping forces

**Your benefits**
- Easy measurement of clamping forces on lathe chucks in rest position (static) or during dynamic operation via non-contact data transmission.
- The clamping force behavior of 2-, 3- 4-jaw chucks can be checked.
- If necessary, the measured clamping force and speed values can be analyzed via a laptop or PC (see “Technical data” for information).
- Scope of delivery: control unit with all accessories and attachments, including software, in a dirt-resistant case for immediate use.

**Extension solutions for every lathe.**

**Flanges and draw tube adapters**
Lathe chucks, flanges and draw tube adapters – all from a single source. So you can begin production right away.

For use under extreme conditions.

LINOMAX is a homogeneous, water-resistant grease based on a particularly selected mineral oil-/synthetic oil combination with a high proportion of matched, very efficient micro-white solid lubricant.

**Your benefits**
- Ideal in the boundary- and mixed friction ranges, especially with **oscillating, vibrating movements**
- Extremely **high capability of pressure absorption**
- Minimizes the risk of **frictional corrosion** and improves lubrication characteristics.
Large Control Range, extremely short Switching Times.

**OPUS-V | OPUS-H hydraulic cylinders**

SCHUNK hydraulic solid and through-hole cylinders for actuation of power chucks.

**OPUS-V closed-center hydraulic cylinder**

- Large pressure range of 7 – 70 bar
- Through-hole for coolant, oil or air with thread for rotary supply
- Quick actuation through large oil feeding channels
- Smooth rotation due to axial non moving distribution unit and long piston guidance
- Mounting from the rear or from the front side
- A 10 µm filter in pressure line is requested
- Use oil HM32 ISO 3448

**OPUS-H open-center hydraulic cylinder**

- Pressure range of 7 – 45 bar
- Short design/low mass
- Large through-hole
- Two safety valves, two max. pressure valves and piston stroke control
- Low power consumption
- Mounting from the rear side with bolts
- A 10 µm filter in pressure line is requested
- Use oil HM32 ISO 3448

**Your benefits**

- For actuation of power chucks
- For assembly with closed or open center

- For actuation of clamping devices with through-hole
- For machining of bars and tubes
- For machining of long workpieces
**Application Examples**

**Turning Technology**

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**Set-up time optimized for clamping of unmachined parts**

**Task**
Different unmachined parts need to be clamped on a multitasking machine (turning and milling) for an automation production line.

**SCHUNK solution**
A ROTA THW plus 185-52 jaw quick-change chuck with claw jaws is used for this application. This clamping device meets all the requirements of state-of-the-art production technologies. Due to its jaw quick-change system, it enables faster retooling for flexible and fully automated production of small batch sizes and a large variety of parts. The claw jaws transmit high torques, allowing for cost-effective machining at high cutting speeds.

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**Efficient clamping of easily deformed parts**

**Task**
Clamping solution for small batches of easily deformed parts or recurring components

**SCHUNK solution**
The ideal solution for this task is the ROTA NCD 255-86 power chuck, which allows for maximum speeds with excellent centrifugal force and hysteresis behavior. This universal high-performance chuck is a multifunctional solution for everyday use. The SCHUNK PRONTO jaw quick-change system expands the clamping range by up to 300% without having to reset the supporting jaws. Due to a change-over time of less than 5 seconds per jaw, faster set-up times for small batches and recurring parts are ensured.

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**SCHUNK products**

- **ROTA THW**
  - Power chuck
- **Claw jaw**
- **Wedge-bar power chuck**
- **Jaw quick-change system**

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Flexible clamping of individual components

Task
Faster set-up times for clamping in single-item production.

SCHUNK solution
A ROTA-S plus 250–52 3-jaw manual chuck with jaw quick-change system and claw jaws is used for this application. The ROTA-S plus delivers maximum clamping forces and maximum precision and is the flexible solution for minimizing set-up times for production of single items on conventional lathes. The claw jaws transmit high torques.

Safe clamping of long components

Task
Long components need to be clamped safely and precisely on a lathe.

SCHUNK solution
The solution is a ROTA THW 630 power chuck along with a self-centering, hydraulic ZENTRICO THL plus steady rest that supports the long components. The steady rest features optimized interfering contours and a large clamping range and is equipped with options like central lubrication, built-in KSS roller rinsing and stopping contamination. Maximum clamping forces combined with continuously excellent centering and repeat accuracy are achieved with this solution. The THL plus is also available with spherical and cylindrical rollers as well as a side cylinder.
Competent and skilled personnel ensure optimal availability of your SCHUNK products, and make sure that their value will be maintained.

Your advantage:
- Fast supply of original spare parts
- Reduction of down-times
- The complete spectrum of components from one source
- Quality and availability that can only be guaranteed by the original manufacturer
- 12-month warranty

Initial operation
- Professional assembly
- Fast and trouble-free

Inspection
- Inspection is carried out by skilled service engineers
- Avoiding unplanned failures of workholding and toolholding equipment

Maintenance
- Regular maintenance carried out by skilled service engineers
- Increasing and ensuring the availability of your workholding and toolholding equipment

Repairs
- Short down-times due to fast intervention of the SCHUNK service engineers
- Spare parts and accessories

SCHUNK Service Line +49-7133-103-2333
Training

- Fast and practical training
- Efficient use of your SCHUNK products by training of the operating personnel
- The basis for proper machining of workpieces
- Ensures longevity of your SCHUNK products

Individual service – for better results

- Hotline to our inside technical consultants weekdays from 7 a.m. to 6 p.m.
- Project-oriented and on-site technical advice at your location
- Training on innovations and SCHUNK products – across the world in our local subsidiaries

Online service – for a fast overview

All information in digital form, clearly structured and up-to-date on our website at www.schunk.com

- List of contact persons
- Online product search based on product descriptions
- Product news and trends
- Data sheets
- Order forms for easy and convenient ordering
- Free download area for pages from our product catalogs and technical data, for software and calculation programs for your gripping and rotary modules
- Free 2D / 3D CAD design models, provided in a wide range of different CAD formats – for easy integration into your design!
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852 minutes without a goal against him in the Champions League
681 minutes without a goal against him in the national team
2 intercepted penalties in the 2006 World Cup
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and

More than 2,000,000 sold precision toolholders
About 1,000,000 delivered SCHUNK grippers
More than 100,000 lathe chucks and stationary workholding systems are in use worldwide
More than 16,000,000 sold standard chuck jaws
More than 75,000 implemented hydraulic expansion customer-specific solutions

Jens Lehmann, German goalkeeper legend, SCHUNK brand ambassador since 2012
for safe, precise gripping and holding.

www.gb.schunk.com/Lehmann