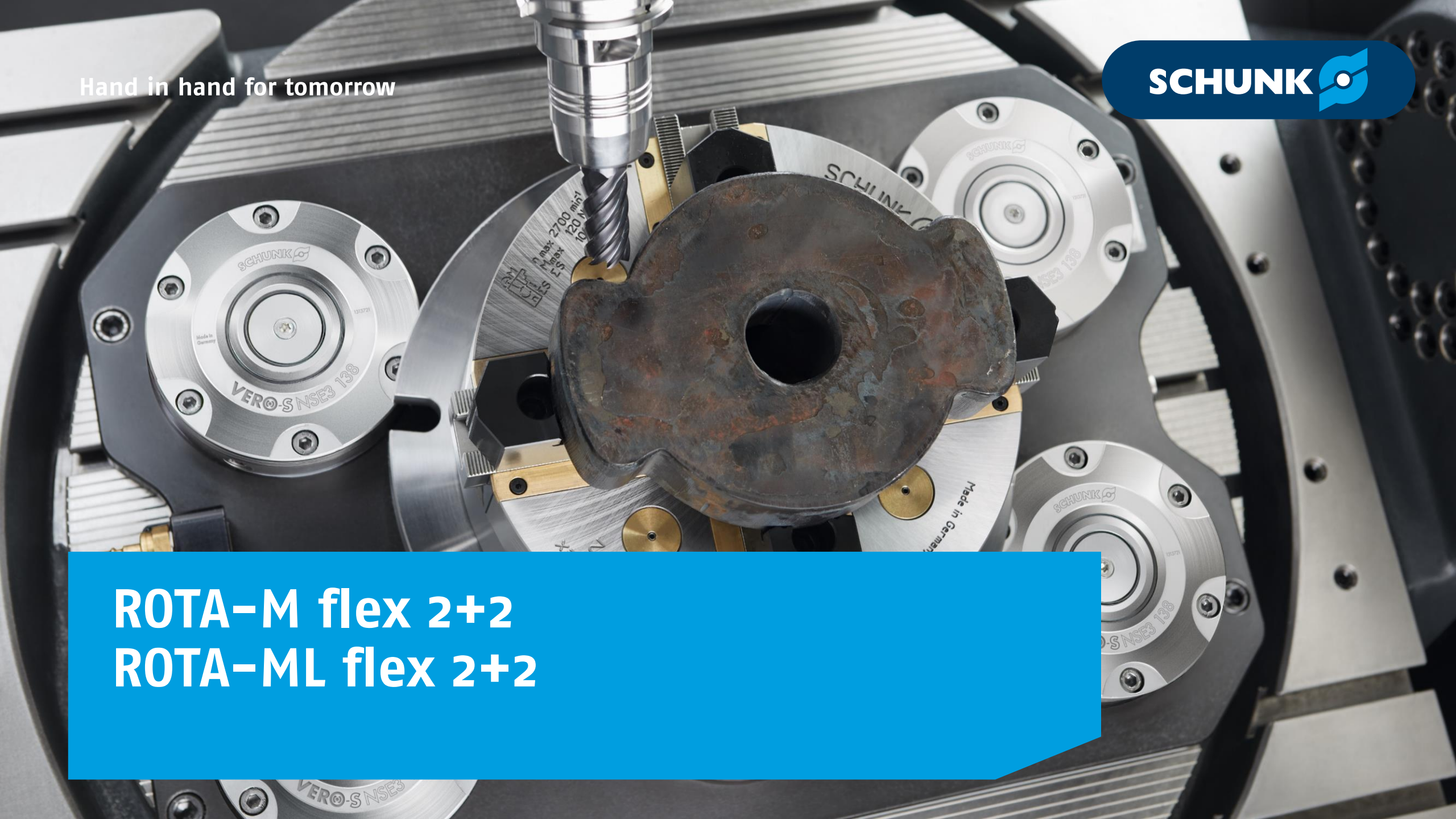


Hand in hand for tomorrow



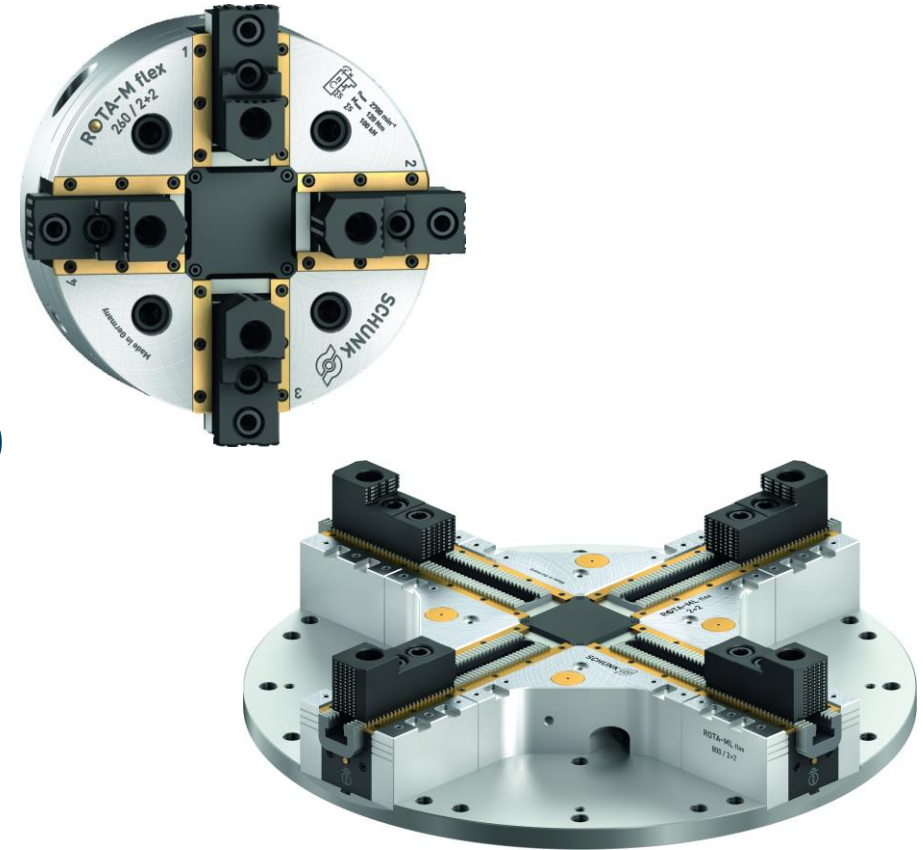
ROTA-M flex 2+2
ROTA-ML flex 2+2



Lathe Chucks

ROTA-M flex 2+2 ROTA-ML flex 2+2

- + Extremely flexible 4-jaw manual lathe chuck



Highlights | Field of application

Extremely flexible clamping system for gripping any workpieces

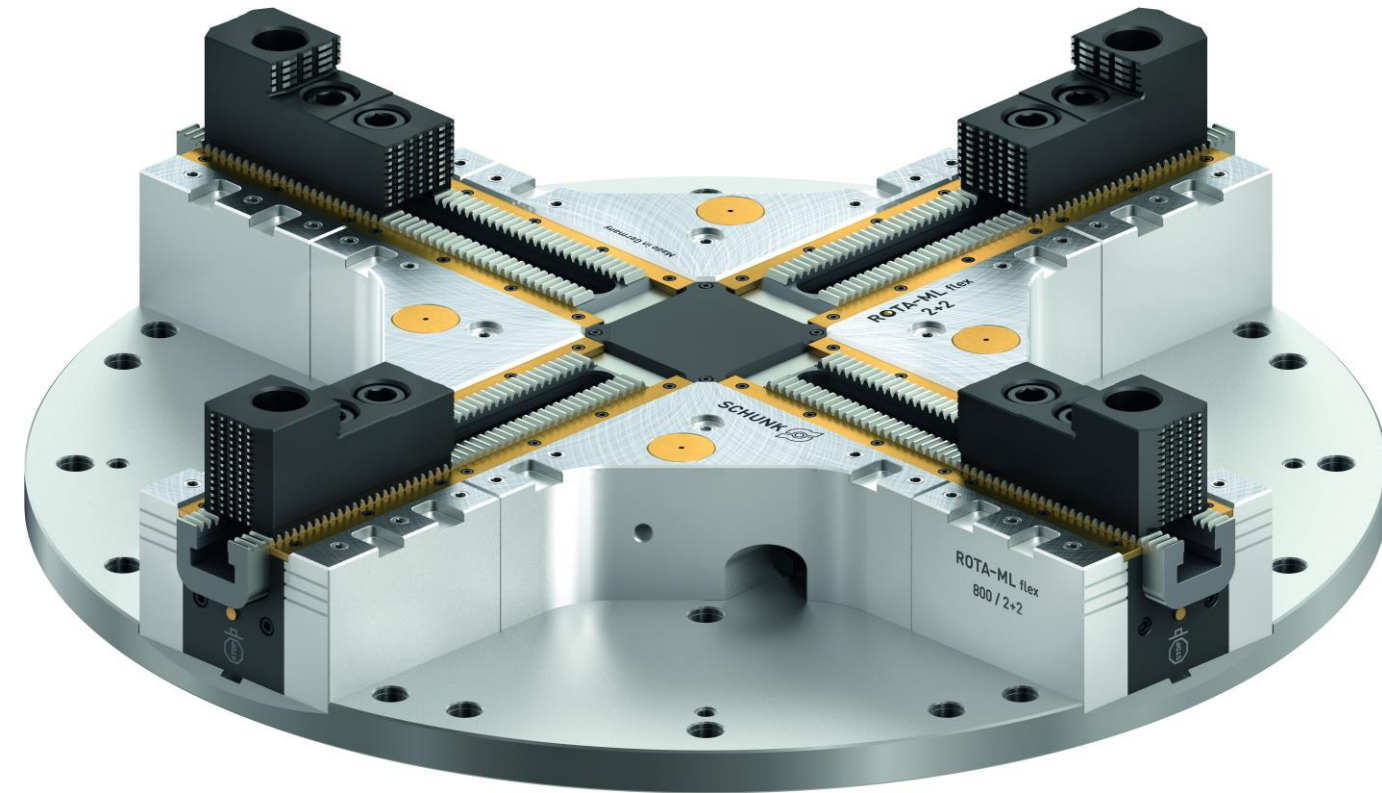
Patented drive concept with compensation mechanism

Sealed manual lathe chuck

Mill/turn machines

Storage solutions

From size 500



Facelift of the ML variants from size 500:
Significant reduction in lining height and weight

For clamping round, cubic or geometrically bulky
workpieces

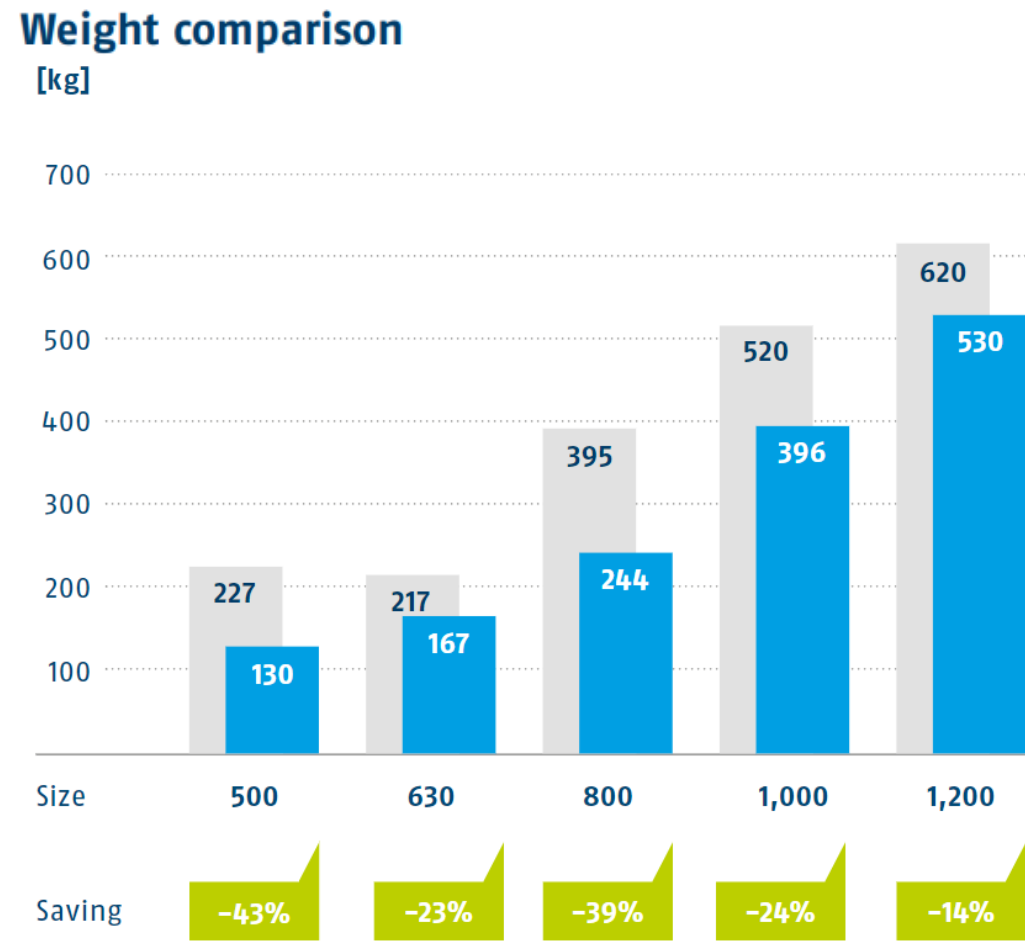
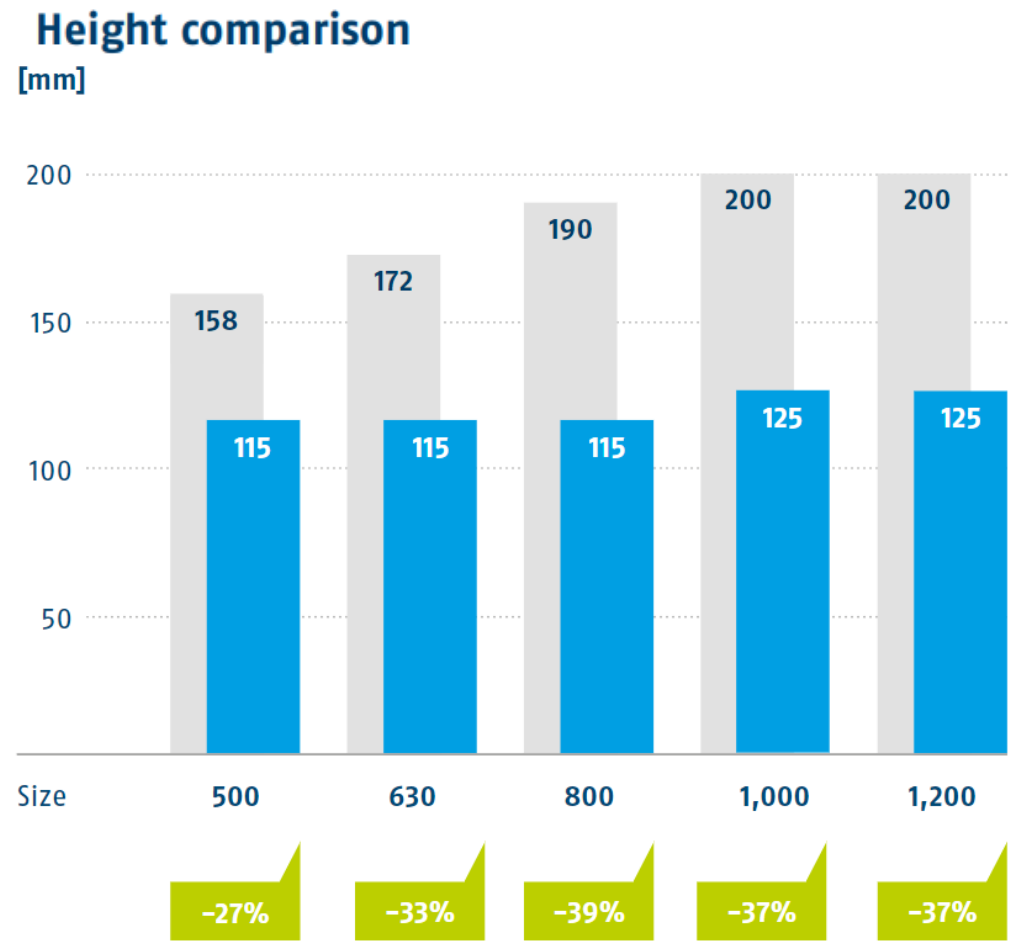
Easy and efficient retrofitting also to 2-jaw chuck
and fixed jaw clamp

Significant weight reduction in the new generation – Facelift ROTA-ML flex 2+2



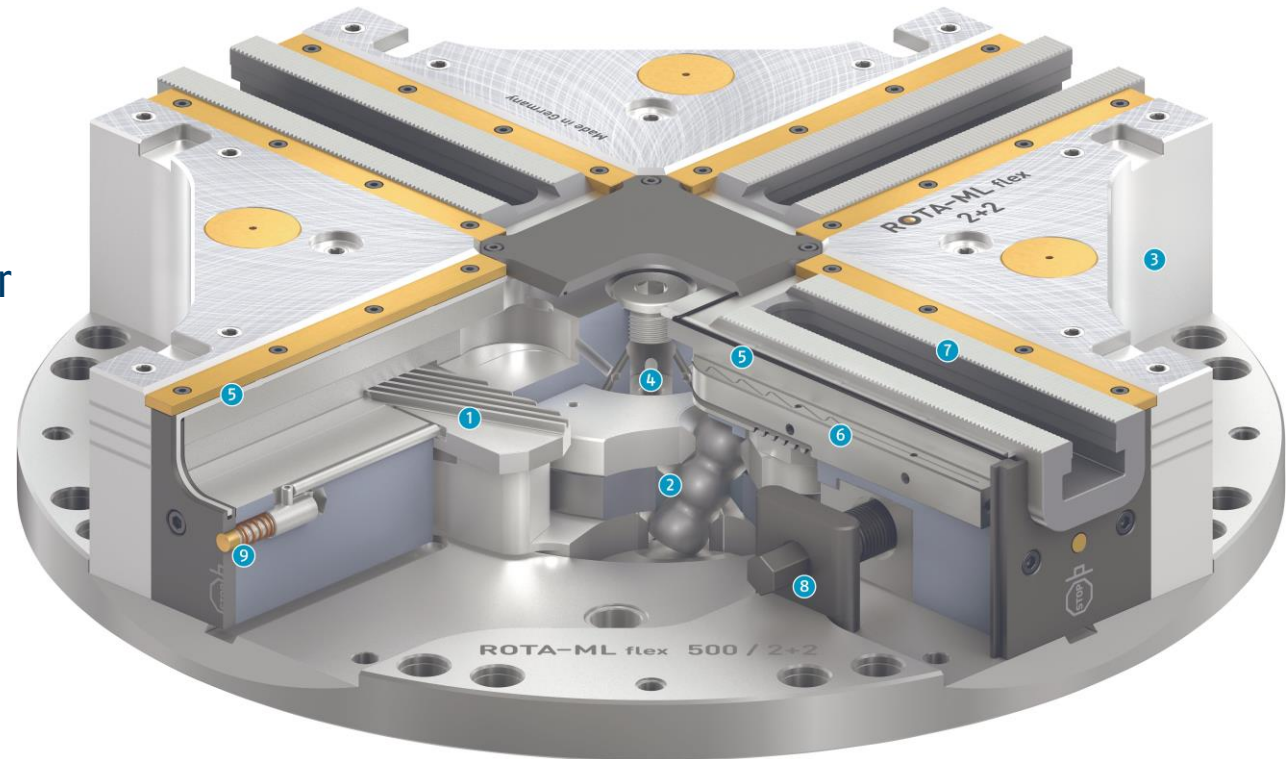
- up to 30% smaller
- up to 40% less weight
- machining of larger and heavier workpieces possible

Significant weight reduction in the new generation – Facelift ROTA-ML flex 2+2

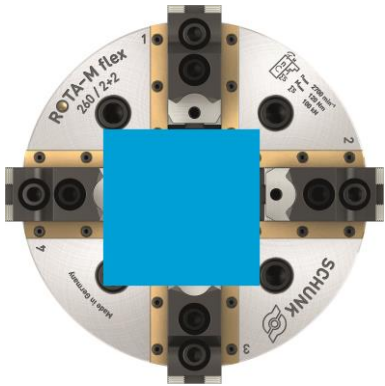


Function

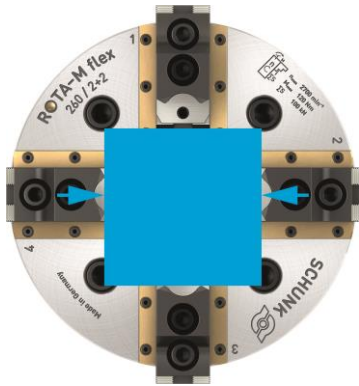
1. Wedge bar actuation system
2. Patented drive concept
3. Hardened and extremely rigid base body
4. Central lubrication system with grease reservoir
5. Sealing the lathe chuck
6. Long jaw guidance
7. Standard jaw interface
8. Operation via hexagon connection
9. Indicator pin



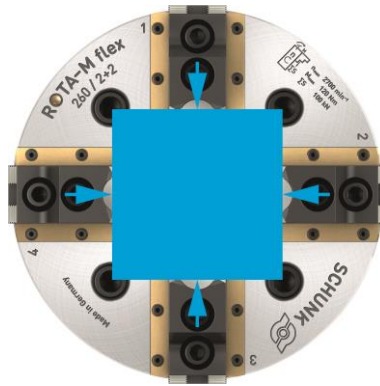
Function



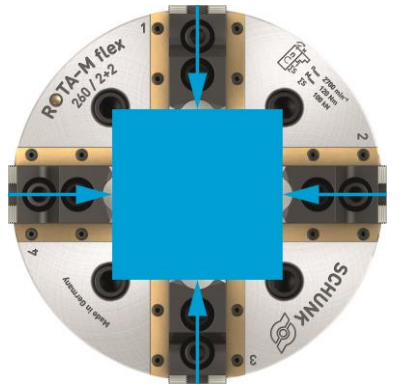
Insert the workpiece
Round, cubic or geometrically unshaped parts can be inserted in open state.



Install the first pair of jaws
By actuating the manual lathe chuck, the first pair of jaws contacts the workpiece. The workpiece is now centered in this plane.



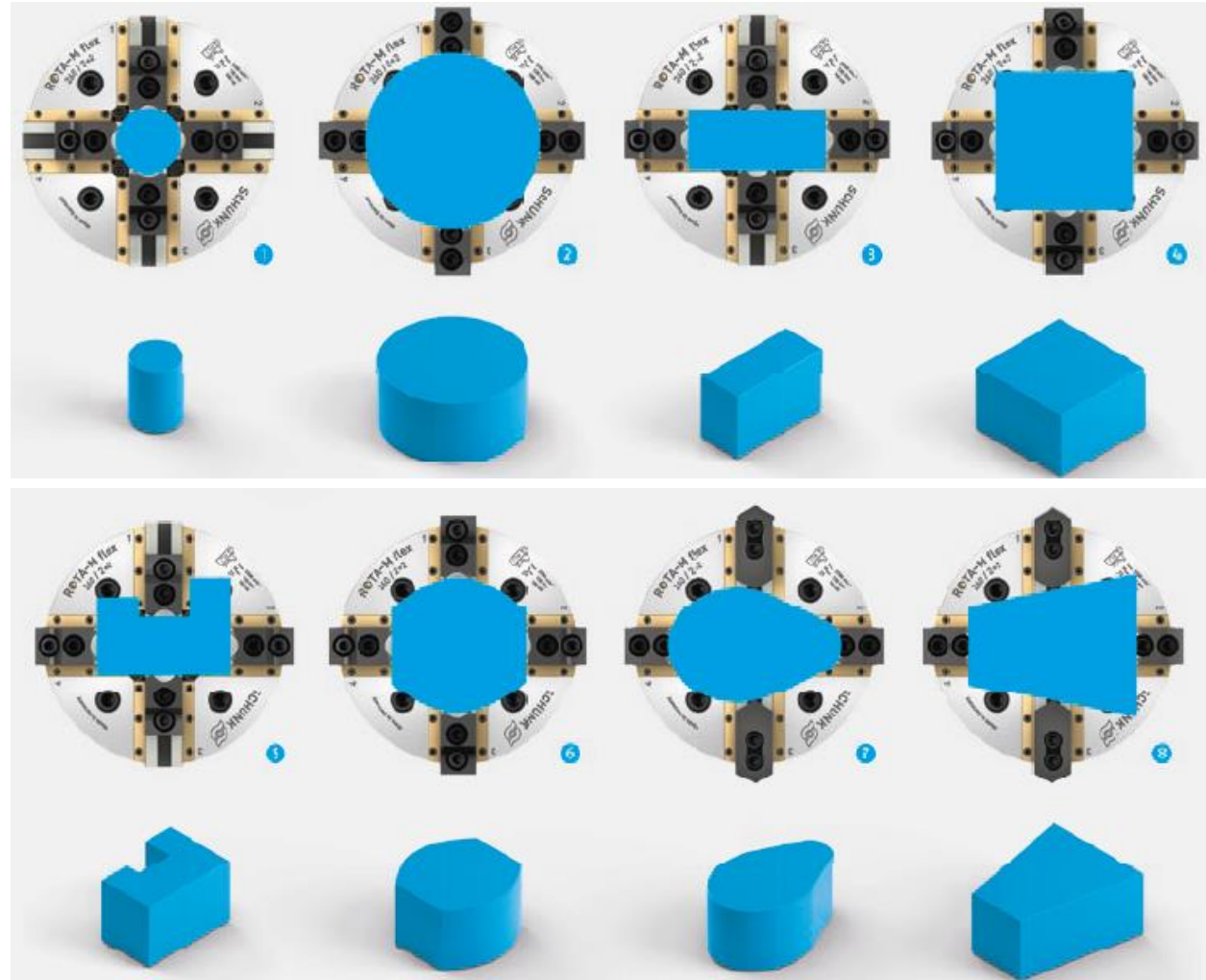
Install the second pair of jaws
During further actuation, the second pair of jaws also contacts the workpiece and moves the workpiece in this plane to the center.



Clamp the workpiece
If both pairs of jaws are in contact with the workpiece, the workpiece is clamped evenly and centrally with the fully clamping force.

Maximum flexibility

1. small workpieces
2. large workpieces
3. rectangular workpieces
4. square workpieces
5. free-form parts
6. semicircular and angular workpieces
7. cams
8. inclined workpieces

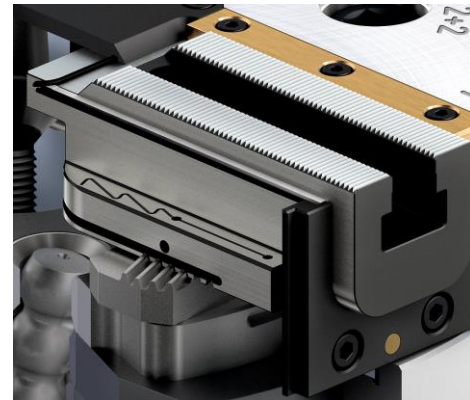


Highlights

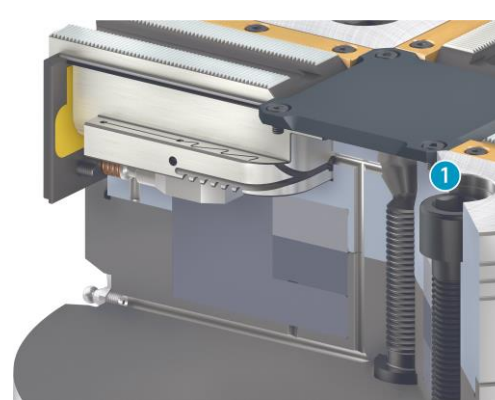


Compensating workpiece clamping

1. First pair of jaws
2. Second pair of jaws



Sealed manual lathe chuck



Central lubrication system with grease reservoir

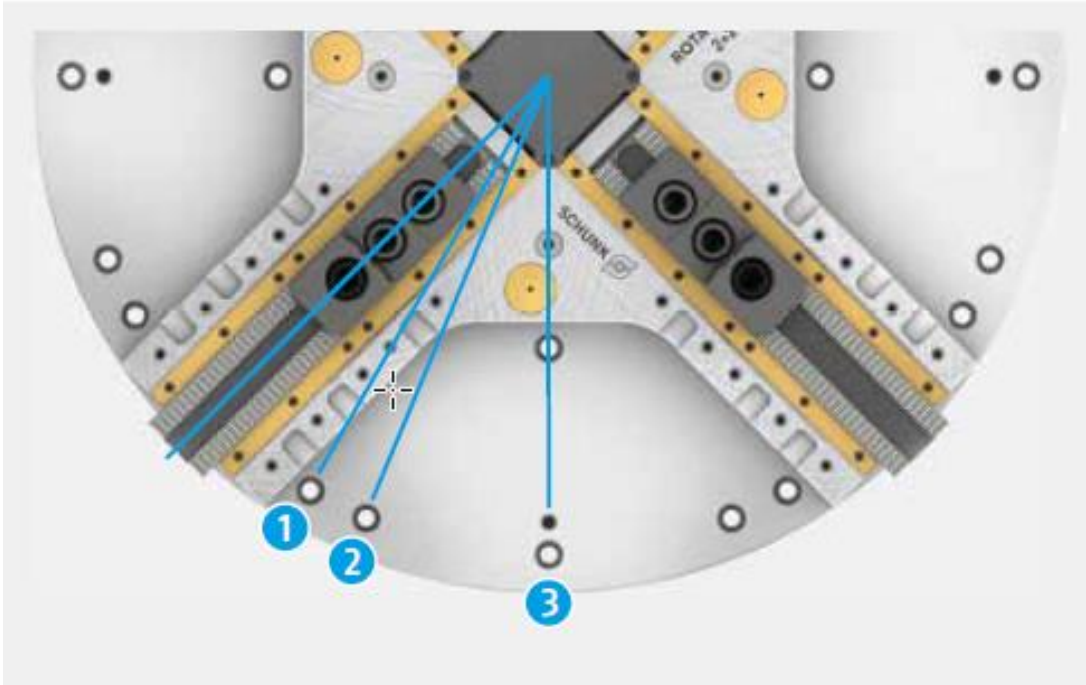
1. Grease reservoir



Visual clamping release

1. Indicator pin

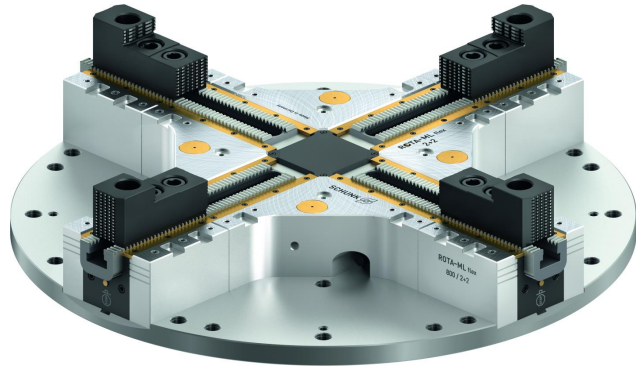
Highlights



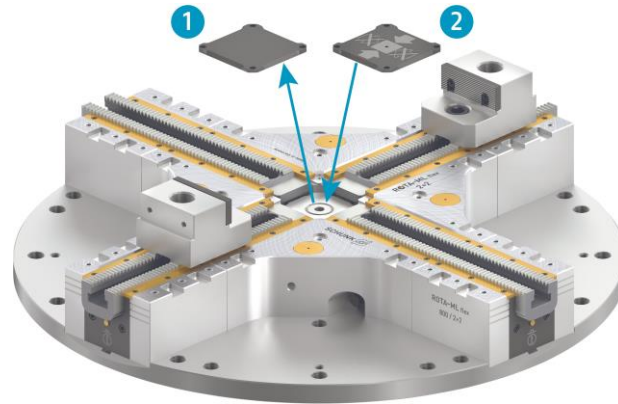
Various mounting preparation in Standard

1. 22,5° star T-nut design
2. 30° star T-nut design
3. 45° star T-nut design

Highlights

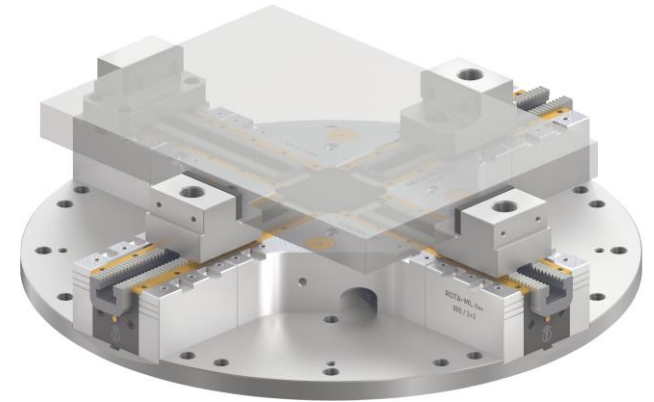


Weight-reduced design



2-jaw clamping

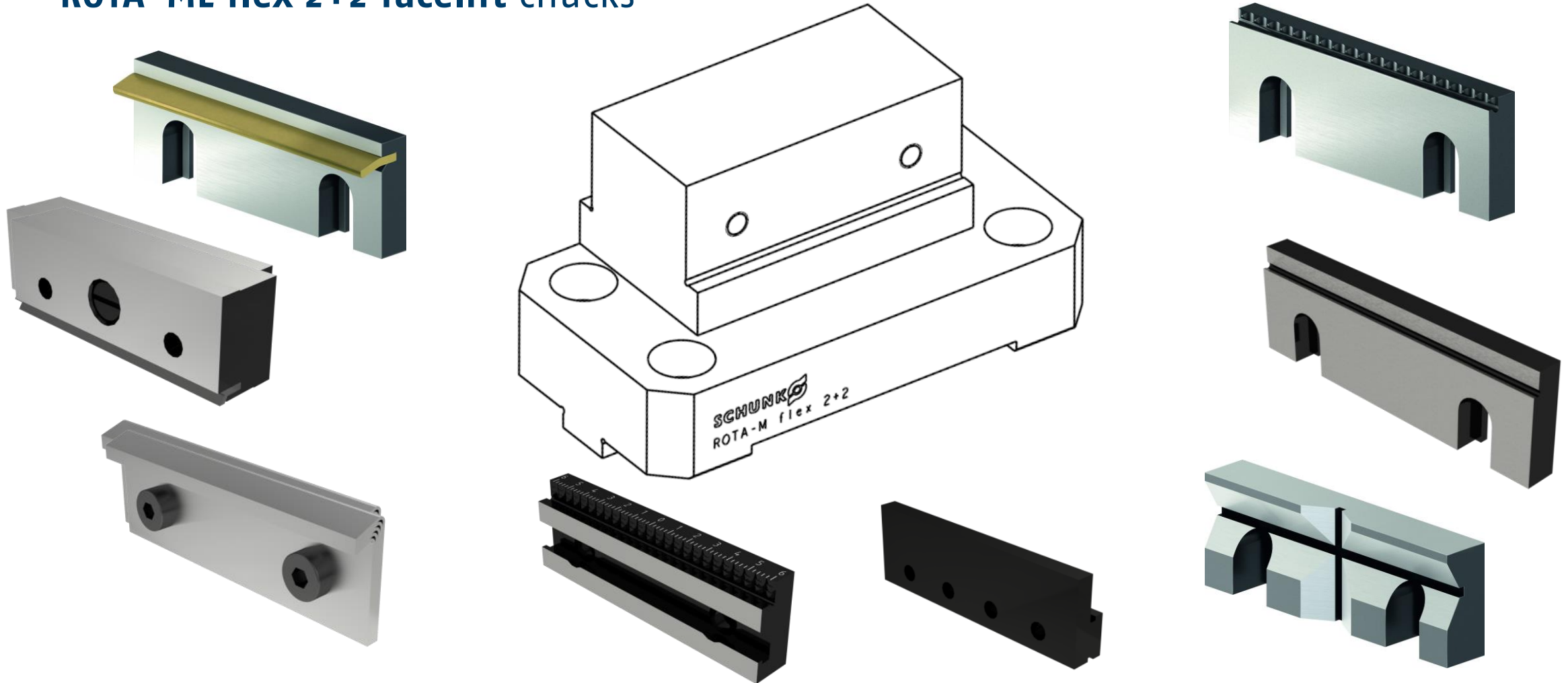
1. Locking cover without stop
2. Locking cover with stop



Console clamping

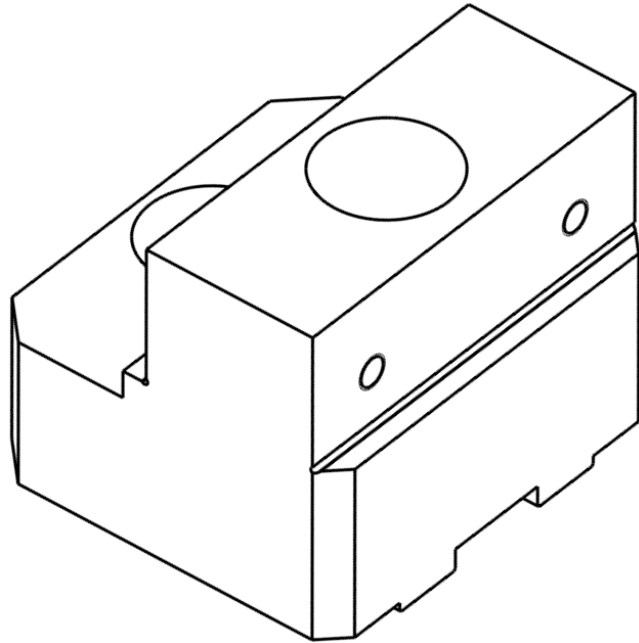
Top console jaws

One type of fixed console jaws **SKB-F 100 (ID 1572658)** suitable for all **ROTA-ML flex 2+2 facelift chucks**

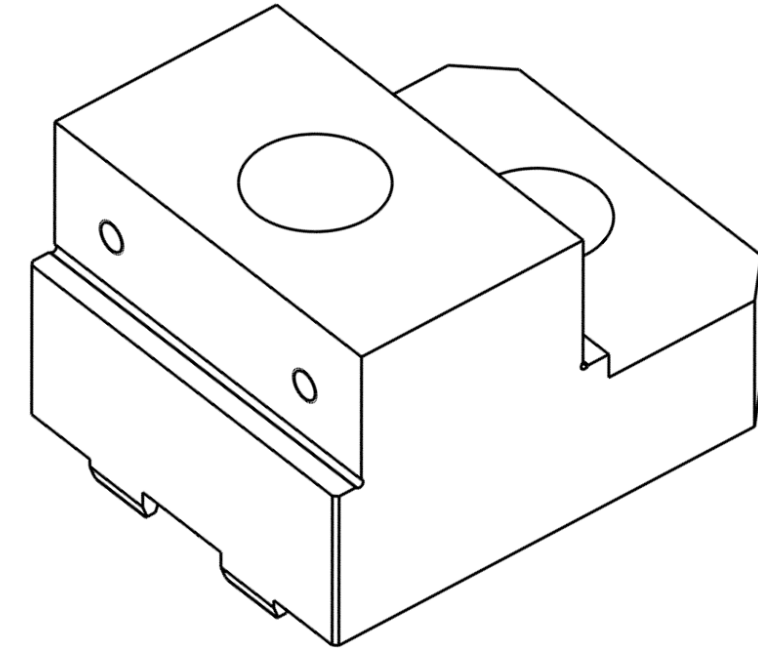
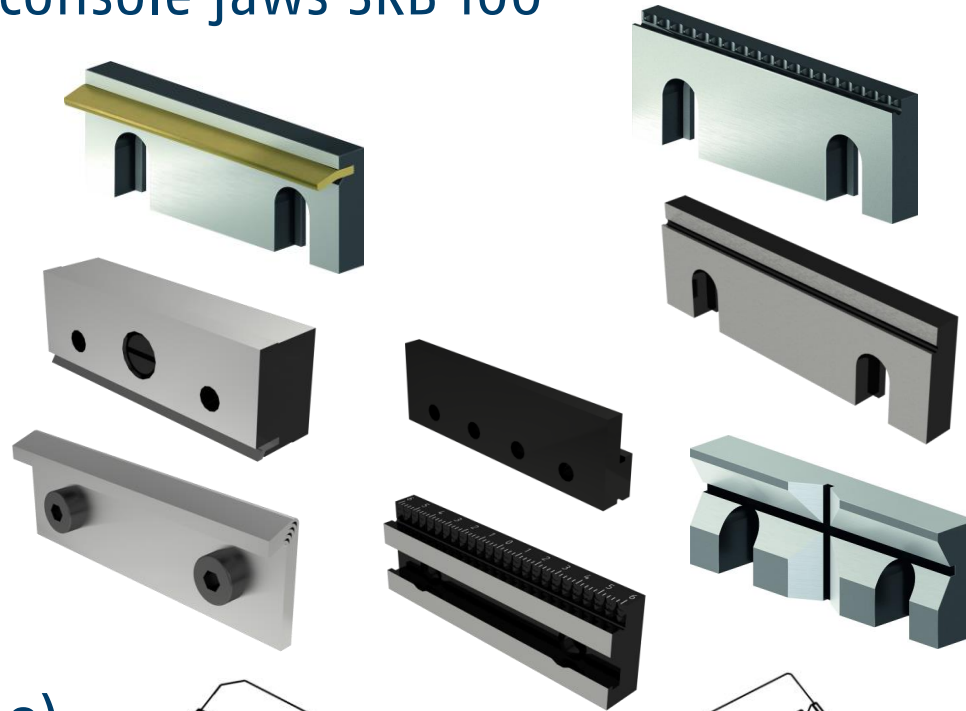


Top console jaws

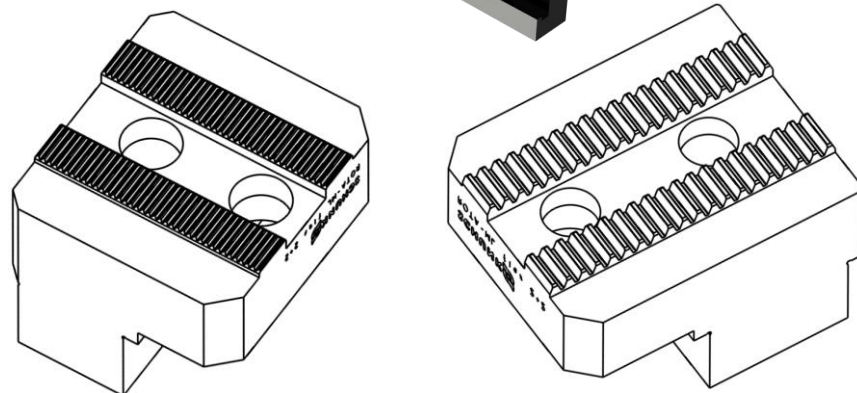
Two types of movable console jaws SKB 100



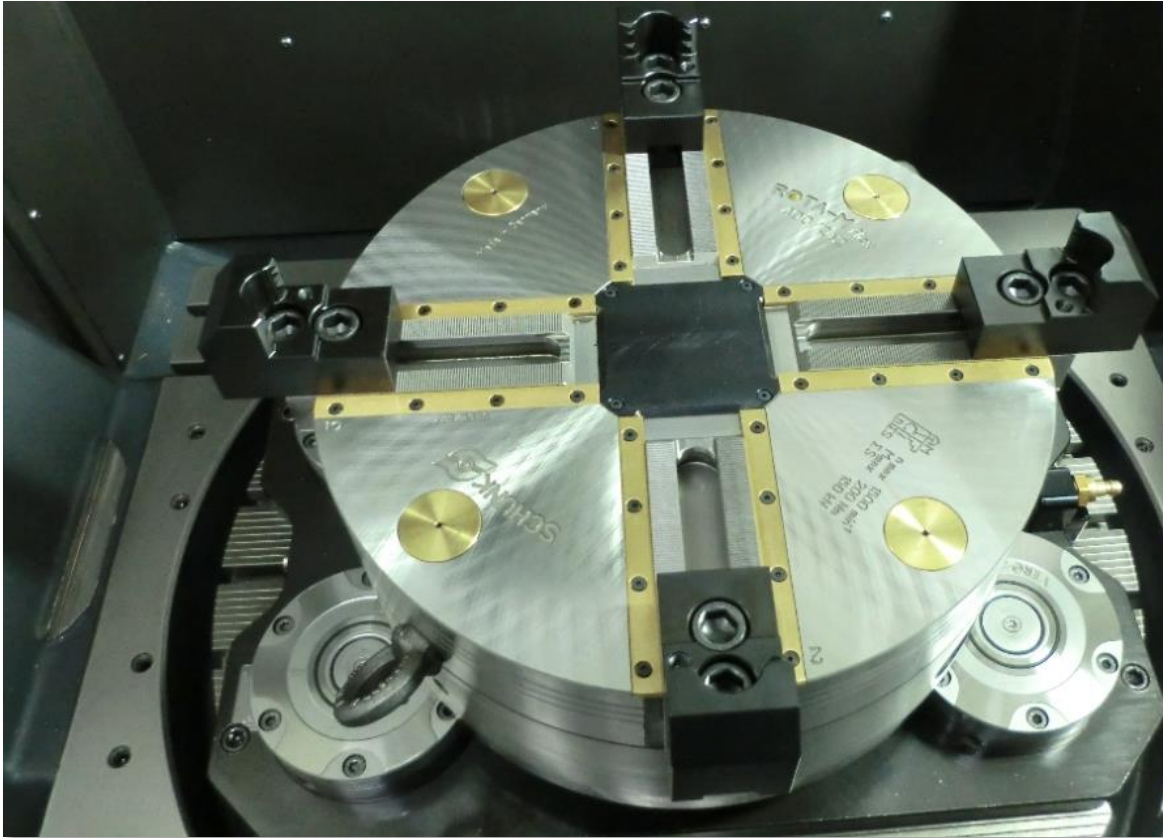
SKB-SV90° 100 (ID 1572700)
suitable for ROTA-ML flex
2+2 500 and 630 with fine
serration 3/32" x 90°



SKB-M2 100 (ID 1572701)
suitable for ROTA-ML flex
2+2 800, 1000 and 1200
with serration Module 2



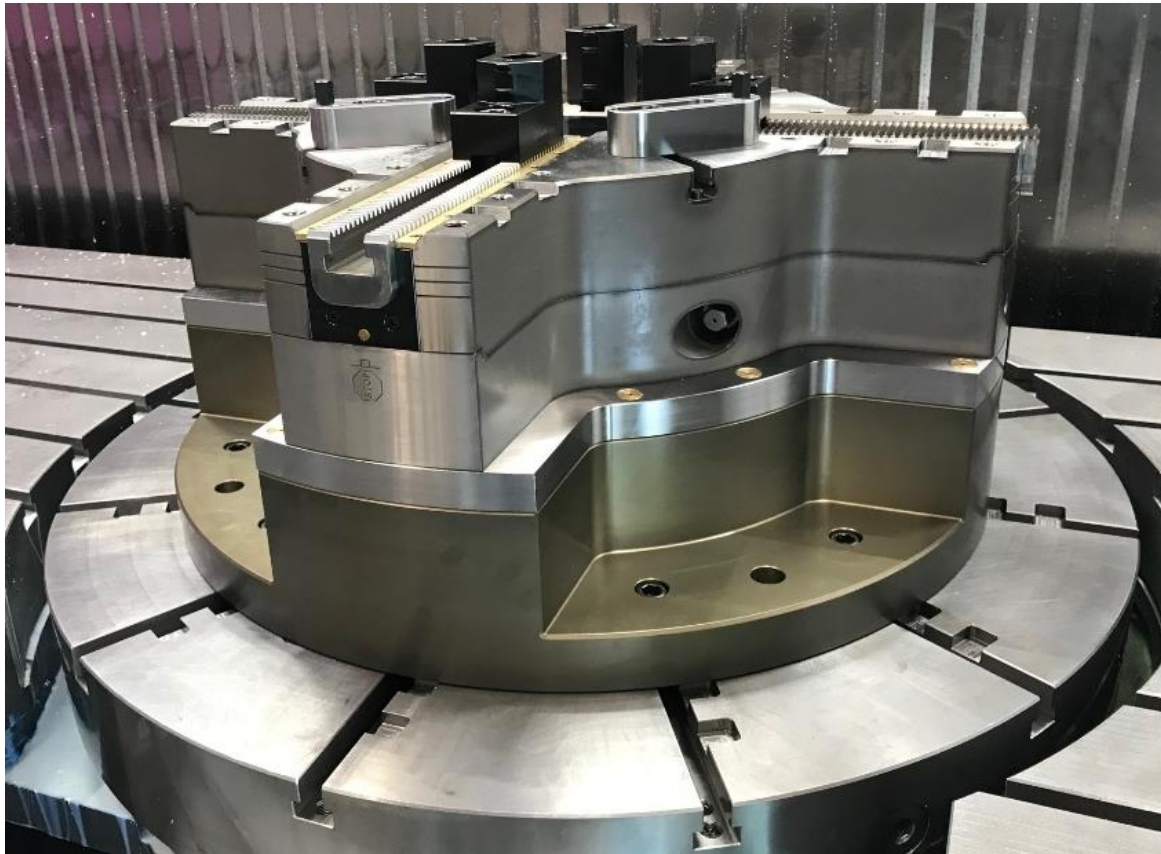
Example of application



ROTA-M flex 2+2 400 on a DMG Mori DMU 75

- Production of pallets in 2 setups
- Compensating workpiece clamping of blank plate in claw jaws in OP10 in 2+2 jaw chuck
- OP20: clamping on machined surface with soft jaws

Example of application



ROTA-ML flex 2+2 800 on the rotary table of an Ibarma ZVH 58

- For accessibility, a special console was manufactured by the customer at a height of 150 mm
- With the 4-jaw adapter, a clamping force measurement can be carried out with the IFT on a 2+2 jaw chuck

Example of applicaton



ROTA-ML flex 2+2 800 to DMG MORI DMC 85 mB FD with Integral pallet

- Clamping of cubic and rotationally symmetrical components
- The console plate of the ROTA-ML flex also serves as a machine pallet with clamping cones on the underside. The advantage is the reduction in height and weight.
- For milling on a 5-axis machine

Technical data

Description	Max. RPM [min ⁻¹]	Max. clamping force [kN]	Max. torque [Nm]	Stroke/jaw [mm]	Compensation stroke/jaw [mm]
ROTA-M flex 2+2 260	2700	100	120	9.5	5.1
ROTA-M flex 2+2 315	2200	100	120	9.5	5.1
ROTA-M flex 2+2 400	1500	150	200	14.5	7.9
ROTA-ML flex 2+2 500	1500	180	210	17.3	12
ROTA-ML flex 2+2 630	1300	180	210	17.3	12
ROTA-ML flex 2+2 800	1100	180	210	17.3	12
ROTA-ML flex 2+2 1000	850	180	210	17.3	12
ROTA-ML flex 2+2 1200	750	180	210	17.3	12



Hand in hand for tomorrow

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