



VICES

2017

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RKE 125

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Operation guide



TYPE	RKE				RKE-M				RKE-LV		RKK		
	NC-Compact vices												
Features	- Highest clamping precision - Clamping force presetting - Precise, wear-resistant body				- Highest clamping precision - Without clamping force presetting - Precise, wear-resistant body				- Very good accessibility for 5-axis machining - Clamping force presetting - Large clamping range		- Designed to resist deformation for the highest clamping precision - Greatest repeatability - Clamping force presetting		
Clamping system	mechanical-mechanical size 92: mechanical-hydraulic				mechanical				mechanical-mechanical		mechanical-mechanical		
Force amplification													
Set-up options	3-Side, Duo-Tower Quattro-Tower				3-Side, Duo-Tower Quattro-Tower				Base		3-Side, Duo-Tower Quattro-Tower		
Machining centers with high working accuracy	 				 				 		 		
Universal milling machines with high working accuracy	 				 				 		 		
Universal milling machines standard version													
Jig boring machines	 				 				 		 		
5-axis machining									 				
Grinding machines													
Series production													
For limited space									 				
Jaw width mm	92 ¹⁾	125 ¹⁾	160 ¹⁾	200 ¹⁾	92 ¹⁾	125 ¹⁾	160 ¹⁾	200 ¹⁾	125 ¹⁾	125 ³⁾	135 ²⁾	160 ²⁾	200 ²⁾
Clamping range (max.)	208	312	451	451	208	312	451	451	192	225	215	340	340
Length (opened) mm	345	478	633	633	315	442	607	607	372	372	483	618	618
Width mm	94	126	162	162	94	126	162	162	126	126	150	205	205
Height mm	112	140	165	175	112	140	165	175	140	130	148	179	189
Clamping force (max.) kN	25	40	60	60	25	40	60	60	40	40	40	60	60
Weight kg	15	41	79	85	15	41	79	85	29	29	50	107	108
Page	4012				4020				4032		4038		



yes



suitable



very suitable

¹⁾ with stepped jaws

²⁾ with standard jaws

³⁾ with carrier jaws

⁴⁾ with claw-type jaws

⁵⁾ with heightend stepped jaws

Operation guide



TYPE	RKD-M		RZM				RKZ-M				
	NC-Compact twin vices		NC-Compact self centering vices								
Features	- Double, centric and compact wrench (removable middle jaw) - Greatest repeatability - Low rapid traverse		- Very large clamping stroke due to patented guide system - Open design for optimal chip flow - Overhead spindle for optimal power transmission				- Highest average precision and repeatability - Minimum collision contour				
Clamping system	mechanical		mechanical				mechanical				
Force amplification	*		*				*				
Set-up options	3-Side Duo-Tower, Quattro-Tower		Base				Base				
Machining centers with high working accuracy	☒		☒				☒				
Universal milling machines with high working accuracy	☒		☒				☒				
Universal milling machines standard version	☒		☒				☒				
Jig boring machines	☒		☒				☒				
5-axis machining			☒				☒				
Grinding machines	☒		☒				☒				
Series production	☒		☒				☒				
For limited space	☒		☒				☒				
Jaw width mm	92 ¹⁾	125 ¹⁾	92 ⁴⁾	92 ⁴⁾	125 ⁴⁾	125 ⁴⁾	50 ¹⁾	70 ¹⁾	92 ¹⁾	125 ¹⁾	125 ⁵⁾
Clamping range (max.)	127	180	160	100	142	222	111	153	208	269	269
Length (opened) mm	480	617	230	170	298	218	157	209	283	353	353
Width mm	94	126	94	94	125	125	52	72	94	126	126
Height mm	117	145	174	174	196,5	196,5	75	95	117	145	165
Clamping force (max.) kN	25	40	20	20	25	25	10	15	20	25	25
Weight kg	24	52	11,7	11,5	17,4	20,3	3,5	7	18	32,5	35
Page	4050		4058				4062				

* Constant clamping force for each clamping process and high repeatability in combination with a torque wrench

Operation guide



ORANGE LINE



TYPE	RB-K Orange Line					RBAW		
	Machine vices					NC-power vices		
Features	- Great accuracy due to precise jaw guidance - Fast clamping range adjustment using the pin system					- Integrated angular drive - Clamping width presetting		
Clamping system	mechanical-hydraulic					mechanical-hydraulic		
Force amplification								
Set-up options	Base					3-Side		
Machining centers with high working accuracy								
Universal milling machines with high working accuracy								
Universal milling machines standard version								
Jig boring machines								
5-axis machining								
Grinding machines								
Series production								
For limited space								
Jaw width mm	92	113	135	160	200	113	135	160
Clamping range (max.)	100	170	220	310	350	175	225	310
Length (opened) mm	490	583	679	817	1022	500	578	702
Width mm	160	160	200	240	280	115	137	162
Height mm	91	97	112	133	171	96	111	132
Clamping force (max.) kN	25	30	40	50	100	30	40	50
Weight kg	15,5	24	39	60	112	22	36	62
Page	4074					4080		



yes



suitable



very suitable

Operation guide



TYPE	MSR				RS					UZ				
	Machine vices													
Features	- Fast clamping range adjustment using the pin system				- Made of special steel casting for flexible application - Entire clamping range can be reached by turning the crank					- Centric clamping - Spindle covered in the working area				
Clamping system	mechanical				mechanical					mechanical				
Force amplification	*				*					*				
Set-up options	Base				Base					Base				
Machining centers with high working accuracy														
Universal milling machines with high working accuracy														
Universal milling machines standard version														
Jig boring machines														
5-axis machining														
Grinding machines														
Series production														
For limited space														
Jaw width mm	125	150	150	175	92	113	135	160	200	113	135	160	200	250
Clamping range (max.)	150	200	300	400	85	105	125	145	185	110	140	180	300	400
Length (opened) mm	401	487	587	701	362	423	510	575	675	358	408	495	655	767
Width mm	95	125	125	145	160	160	200	240	280	132	152	180	200	220
Height mm	80	100	100	118	79,6	89,6	103,6	119,6	144,6	92,6	105,1	123,6	141,6	147,6
Clamping force (max.) kN	30	50	50	60	18	25	35	45	55	15	22	24	25	28
Weight kg	12,7	25,6	29,5	51,2	12	13,5	25	40	65	12,4	19	31	52	71
Page	4086				4088					4092				

*Constant clamping force for each clamping process and high repeatability in combination with a torque wrench

Operation guide



TYPE	BSS		BOF				BSH							DPV				DPV 3-W
	Drilling machine vices																	
Features	- Compact and stable construction - Entire clamping range can be reached by turning the crank		- Compact and stable construction - Entire clamping range can be reached by turning the crank - Long guidance of the movable jaws also in the outer clamping range				- Do-it-yourself version		- Robust and stable version			- Covering of the threaded spindle by cover sleeve - Constructional length remains the same - Entire clamping range can be reached by turning the crank						
Clamping system	mechanical manually operated		mechanical manually operated				mechanical manually operated							mechanical manually operated				
Force amplification																		
Set-up options	Base		Base				Base							Base				3-Side
Machining centers with high working accuracy																		
Universal milling machines with high working accuracy																		
Universal milling machines standard version																		
Jig boring machines																		
5-axis machining																		
Grinding machines																		
Series production																		
For limited space																		
Jaw width mm	110	135	90	110	135	160	65	80	100	80	100	120	140	80	100	120	150	100
Clamping range (max.) mm	100	160	90	130	160	220	65	85	80	80	95	110	150	70	92	110	125	93
Length (opened) mm	510	587	195	315	365	445	125	150	170	200	215	260	300	154	175	225	238	189
Width mm	175	205	145	175	205	245	105	130	175	140	175	215	220	142	152	180	198	159
Height mm	72,5	80,5	60	72,5	80,5	95,5	43	46	47	70	75	85	85	58	63,5	63,5	65	65
Clamping force (max.) kN	10	10	8	10	12	15												
Weight kg	9,5	13,5	5,5	9,5	13,5	25	1,2	1,7	4,2	5	7	11	12,5	3,6	4,3	6,3	8,1	5,1
Page	4098		4098				4099							4100				4100



yes



suitable



very suitable

Operation guide



TYPE	PL-S micro		PL-S			PLF			PL-G			PS-SV		PS-ZD	
	Grinding and inspection vice														
Features	- Draw-down effect - Simple clamping and releasing with allen key - Clamping jaw adjustable in steps; engages automatically - No spindle					- Draw-down effect - Made of alloyed tool steel, hardened and finely ground - Horizontal and vertical ground prism - No spindle which could, become dirty during erosion			- Clamping and releasing with threaded spindle - Made of alloyed tool steel, hardened and finely ground			- Made of alloyed tool steel, hardened and finely ground - Bearing and location pins hardened and ground with a precision of 0.001 mm - The clamping device can be positively locked in any angular position		- Positive locking in any desired angular position by locking screws - Made of alloyed tool steel, hardened and finely ground - Can be rotated 360°	
Clamping system	mechanical, manually operated					mechanical, manually operated			mechanical, manually operated			mechanical, manually operated		mechanical, manually operated	
Force amplification															
Set-up options	Base					Base			Base			Base		Base	
Machining centers with high working accuracy															
Universal milling machines with high working accuracy															
Universal milling machines standard version															
Jig boring machines															
5-axis machining															
Grinding machines	✓✓					✓✓			✓✓			✓✓		✓✓	
Series production															
For limited space															
Jaw width mm	34	45	70	90	120	50	73	100	60	73	88	70	90	70	120
Clamping range (max.)	25	50	80	120	150	65	100	125	55	100	125	80	120	80	150
Length (opened) mm	75	110	160	210	280	140	190	245	110	210	250	160	210	180	270
Width mm	34	45	70	90	120	50	73	100	60	73	88	70	90	110	160
Height mm	35	45	62	80	90	50	67	90	50	67	88	93	113	137	210
Clamping force (max.) kN	2	2	2,5	3	4	1,6	2	5	2	4	4	6	7	-	-
Weight kg	0,35	1	3	5,8	13,5	1,4	4,1	7,3	1,6	4	7,6	5,3	11	11,1	43
Page	4104					4105			4105			4106		4106	

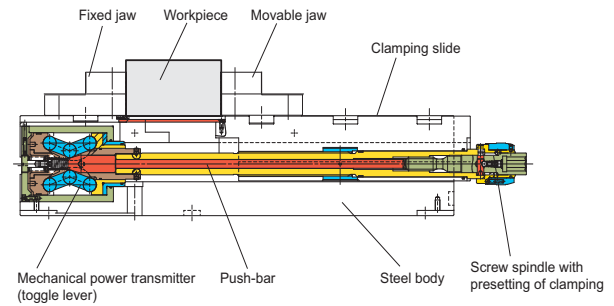
* Constant clamping force for each clamping process and high repeatability in combination with a torque wrench

Sectional view toggle lever principle

NC-COMPACT VICES RKE

High-end NC-Compact vice. Mounting of the power transmitter in the steel body. Further designs (iron cast body, hydraulic actuation etc.) on request.

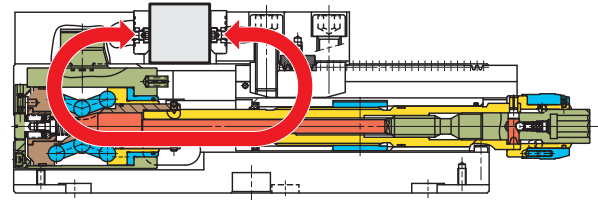
SECTIONAL VIEW RKE



RKK SIZE 3-5

NC-Compact vice for very high clamping precision. Clamping slide with tothing for continuously variable presetting. The power transmitter is mounted in the fixed jaw. This form of support enables high-precision clamping.

SECTIONAL VIEW RKK SIZE 3 - 5



Functional description

CLAMPING SYSTEM MECHANICAL-MECHANICAL WITH TOGGLE LEVER

SINGLE CLAMPING

a) Clamping with power transmission

Mechanical pretensioning is achieved by turning the hand-crank. The threaded spindle with the large incline brings the movable clamping jaw into contact with the workpiece, whereby resistance can be noted on the hand-crank. Continuing to turn the crank in clockwise direction triggers automatic disengagement and switch to mechanical transmission. Further turning of the crank moves a pressure pin axially, which generates the high clamping force through spreading of the toggle lever.

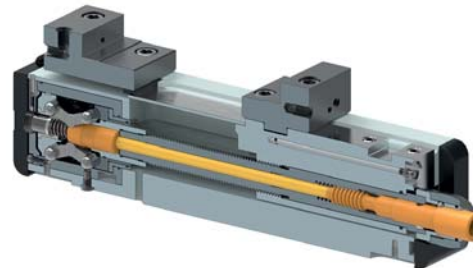
b) Presetting of different clamping forces

To avoid damage to sensitive workpieces caused by excessive clamping force, different clamping forces can be preset. The presetting can be performed simply by turning the adjustment collar on the end of the spindle.

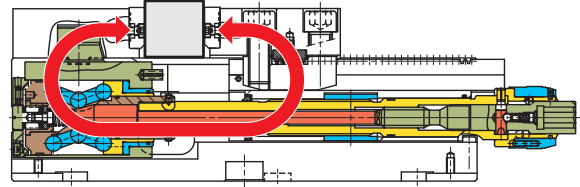
c) Mechanical clamping without power transmission

For consecutive clamping of multiple workpieces having uneven contact surfaces, greater pretensioning is required. Turning the adjustment collar to "0" deactivates the mechanical power transmission. The workpieces can then be mechanically pretensioned until the yield in the workpieces is eliminated. The adjustment collar can then be set to the desired clamping force, and the high clamping force introduced.

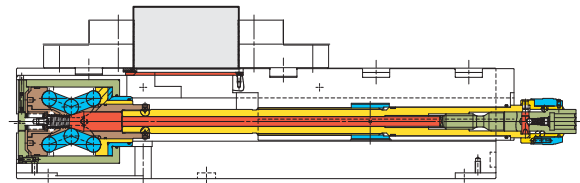
RKK: The power transmission guarantees that the body remains free from deformation; a very high clamping accuracy is achieved.



Type RKK

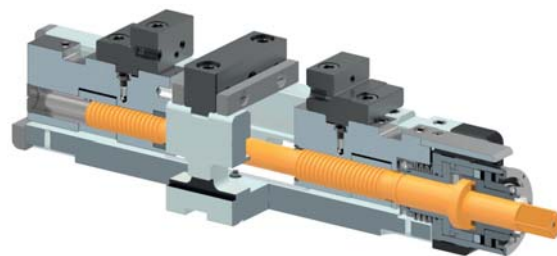


Type RKE



TWIN CLAMPING RKD-M

The anchoring nut on the drive spindle is turned to the right (delivery condition). The moveable clamping jaw 1 is adjusted up to the workpiece in station 1 by turning the spindle in a clockwise direction with the hand crank and held with ca. 1 kN (third manual function). By continuing to turn the hand crank in a clockwise direction as far as it goes, clamping jaw 2 is also placed on the workpiece on station 2. The build-up of force acts on the clamping jaws via the mechanical spindle. The balance springs compensate for dimensional differences of up to ± 3 mm from workpiece 1 to workpiece 2. When clamping, both clamping positions must be filled with the same workpieces. To induce the exact clamping force repeatedly, the exact, specified torque must be induced via a torque wrench (see clamping force chart in the BDA).



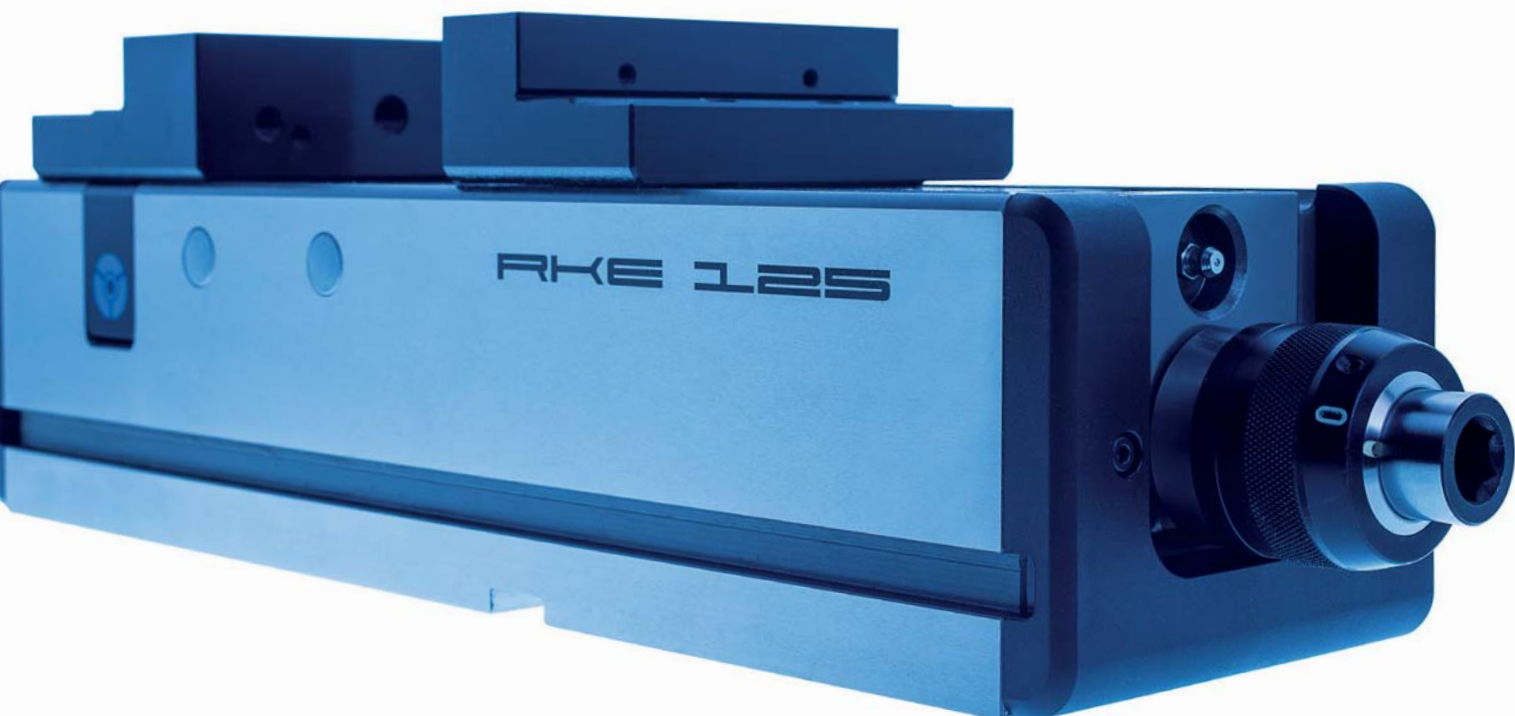
Type RKD-M

CENTRIC CLAMPING RKD-M

The anchoring nut on the drive spindle is turned to the left. The spindle is rigid. The centre jaw is removed. The moveable clamping jaws 1 and 2 are adjusted up to the workpiece by turning the spindle in a clockwise direction with the hand crank. The build-up of force acts on the clamping jaws. The position of the centre of the workpiece is always the same with respect to the transverse groove. To achieve the exact clamping force repeatedly, the exact, specified torque must be induced via a torque wrench (see clamping force chart in the BDA).

SINGLE CLAMPING RKD-M

The anchoring nut on the drive spindle is turned to the left. The spindle is rigid. A stepped jaw must be used here (not in delivery contents), and moveable clamping jaw 1 removed. Also remove the centre jaw. The moveable clamping jaw 2 is adjusted up to the workpiece in station 1 by turning the spindle in a clockwise direction with the hand crank. The build-up of force acts on the clamping jaws uniformly via the mechanical spindle. To induce the exact clamping force repeatedly, the exact, specified torque must be induced via a torque wrench (see clamping force chart in the BDA).



THE PREMIUM VICE FOR ANY AREA OF APPLICATION



The NC-compact vices from RÖHM are excellently suited for use in single or series production. Different types and constructional lengths enable the optimal adaptation to the work area, workpiece and machining task.



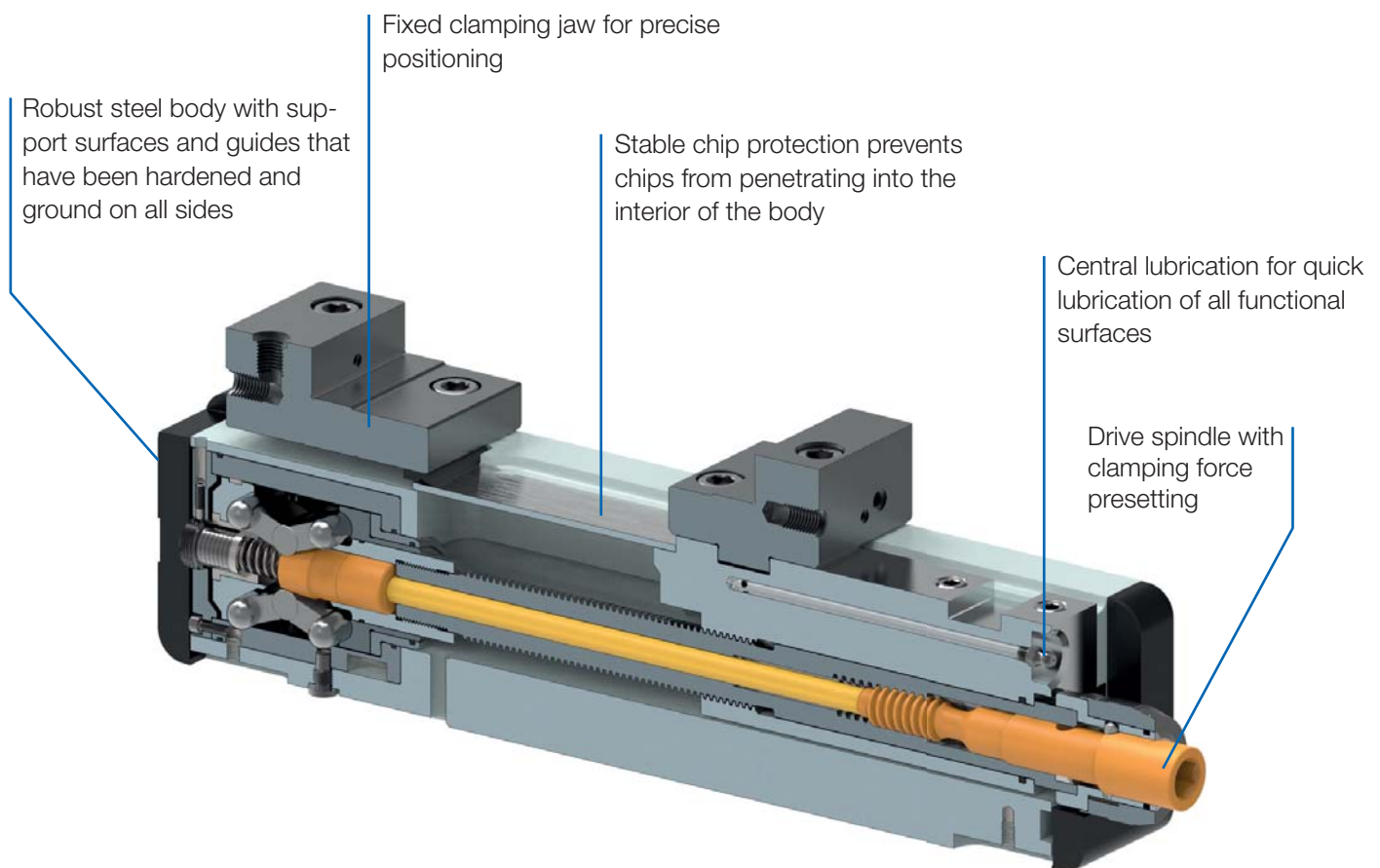
Video RKE

NC-COMPACT VICES

NC-compact vices are particularly suited for use on machining centers, milling machines and are ideal for 5-axis machining. These premium vices are very impressive with their stable and compact design for maximum clamping accuracy and optimal workpiece accessibility. By simply turning the clamping force presetting, a clamping force of up to 60 kN can be achieved. With workpieces that are sensitive to deformation, the force amplification can be disabled.

ADVANTAGES AT A GLANCE

- ⊕ Large clamping range and precise positioning due to fixed clamping jaw
- ⊕ The compact design resists deformation for the greatest possible clamping precision
- ⊕ Consistent clamping force and maximum repeatability of 0.01 mm



RKE - with power transmitter



APPLICATION

Particularly suitable for use on machining centers.

TYPE

Size 92 - clamping system mechanical-hydraulic with power transmitter, manually operated.

Size 125, 160 and 200 - clamping system mechanical-mechanical with power transmitter, manually operated.

CUSTOMER BENEFITS

- ⊕ Horizontal, side or in connection with a base plate vertical mounting, for example as DUO clamping tower (back to back)
- ⊕ Sturdy chip protection prevents chips from penetrating
- ⊕ Drive spindle with clamping force presetting
- ⊕ Clamping surface for clamping claws
- ⊕ Central lubrication of guides and spindle thread
- ⊕ Thread for fastening angle drive

TECHNICAL FEATURES

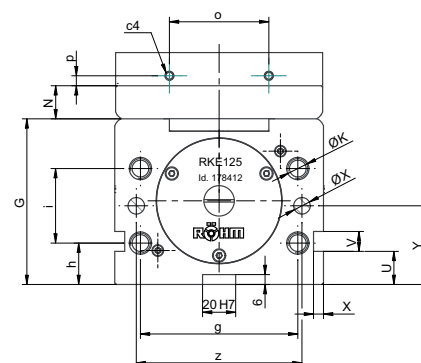
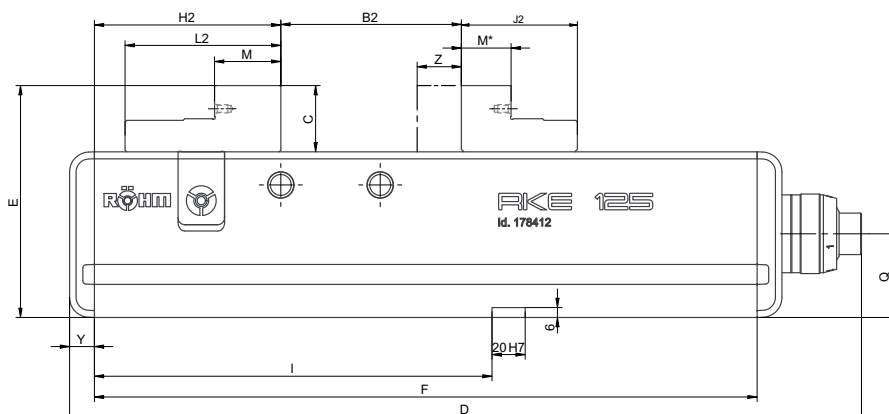
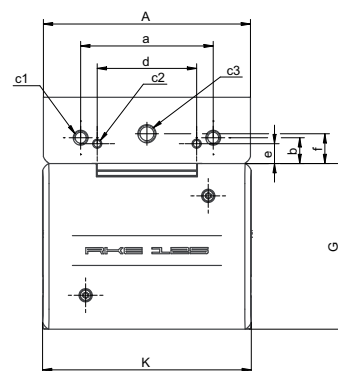
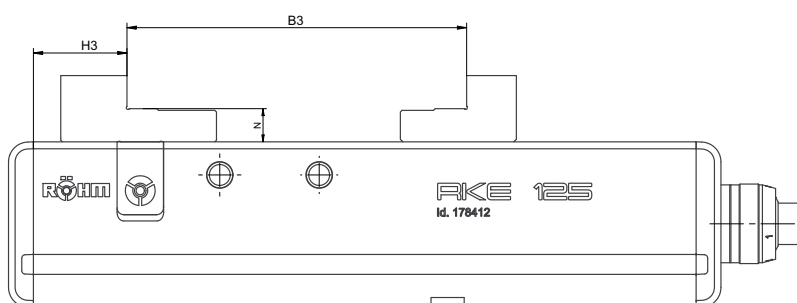
- Sturdy steel body and all guides are hardened and ground on all sides
- Long clamping slide with cross slots, hardened on all sides, functional surfaces ground
- Threaded bores for taking up all RÖHM flat clamping jaws with jaw width 125/160 mm

RKE = RÖHM, compact, single clamping

A32
RKE, with stepped jaws

Id.-Nr.	178411	178412	178413	178414
Jaw width A mm	92	125	160	200
Jaw design	stepped jaws	stepped jaws	stepped jaws	stepped jaws
B2 mm	0 - 138	0 - 216	0 - 320	0 - 315
B3 mm	71 - 208	97 - 312	131 - 451	131 - 451
C mm	32	40	50	60
D mm	345	478	633	633
E mm	112	140	165	175
F mm	276	400	530	530
G _{0,02} mm	80	100	115	115
H2 mm	80	112,5	130	135
H3 mm	41	56,5	64	64
J2 mm	56	70	97	97
K mm	94	126	162	162
L2 mm	64	94	98	103
M mm	25	40	34	39
M* mm	25	30	32,5	32,5
N _{0,01} mm	16	20	25	25
U mm	20	20	20	20
V mm	12	12	12	12
W mm	68	1x108	2x102,5	2x102,5
X mm	10	10	10	10
Y mm	15	15	15	15
Z mm	70	109	117	117
a mm	63	80	100	125
b mm	13,6	15,6	19,6	24,6
c1	M 6x14	M 8x14	M 8x14	M 10x15
c2	M 5x9	M 5x10	M 5x9	M 5x10
c3	M 10x16	M 10x18	M 10x18	M 14x20
d mm	48	60	80	110
e mm	8	12	12	12
f mm	14	18	20	25
g mm	70	95	125	125
h mm	20	25	17,5	17,5
i mm	40	45	80	80
Ø k	M10x18	M12x22	M16x25	M16x25
l mm	140	240	200	200
m2±0,02 mm	60	127,5	70	65
n±0,02 mm	99	183,5	136	136
y ^{+0,01} mm	40	47,5	57,5	57,5
z mm	72	100	135	135
Clamping force kN	25	40	60	60
Weight kg	15	41	79	85

RKE - with power transmitter



Accessories RKE

A37

Standard top jaws SA, reversible


Item no.	Contents of delivery	Size	Width mm	Height mm
162628 ▲	set	125	125	40
162629	set	160	160	50
162984	set	200	200	60

A37

Stepped jaws SB, reversible


Item no.	Contents of delivery	Size	Width mm	Height mm
178776	set	92	92	32
178230	set	125	125	40
178754	set	160	160	50
178937	set	200	200	60

A37

Double stepped jaws DSB, „smooth“


Item no.	Contents of delivery	Size	Width mm	Height mm
168698	set	92	50	48
175387 ▲	set	160	160	50
168693 ▲	set	125	62	60

A37

Carrier jaws TB, without swivelling claw inserts

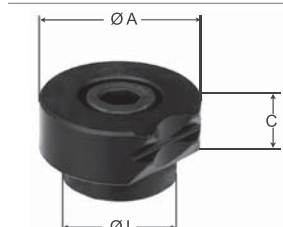

Item no.	Contents of delivery	Size	Width mm	Height mm
165856	set	125	125	20
166218 ▲	set	160/200	160	25

A37

Carrier jaws, without claw inserts


Item no.	Contents of delivery	Size	Width mm	Height mm
169383	set	92	115	20
165861	set	125	160	20
166223 ▲	set	160/200	200	25

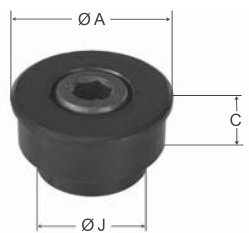
A37

Swivelling claw inserts, for carrier jaws 743-72


Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	Height mm
165854	piece	92/125	28	20	10
166216	piece	160/200	30	22	10

Accessories RKE

A37
Tensioner, for carrier jaws 743-72



Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	Height mm
169389	piece	92/125	28	20	10
169391	piece	160/200	30	22	10

A37
One-piece steel top jaws, for self-production of formed jaws or for clamping formed parts

Item no.	Contents of delivery	Size	Width mm	Height mm
160352	set	125	125	60
160353 ▲	set	160	160	70



A37
Normal jaw SGN, one side smooth, one side grooved, both sides ground

Item no.	Contents of delivery	Size	Width mm	Height mm
152752	piece	92	92	31,6
178112 ▲	piece	125	125	39,7
152755	piece	160	160	49,6
152759	piece	200	200	62,6

Including fixing screws



A37
Normal jaw finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved

Item no.	Contents of delivery	Size	Width mm	Height mm
163218 ▲	piece	92	92	31,6
180679 ▲	piece	125	125	39,7
156197	piece	160	160	49,6
156198	piece	200	200	62,6

Including fixing screws



A37
Claw jaws SKB with fine step, 2.5 mm clamping depth

Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166514	set	92	92	32	14
166520	set	125	125	40	16
166522	set	160	160	50	18

Including fixing screws



Accessories RKE

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661 ▲	set	92	92	32	14
166667	set	125	125	40	16
166669	set	160	160	50	18

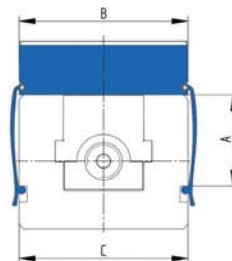
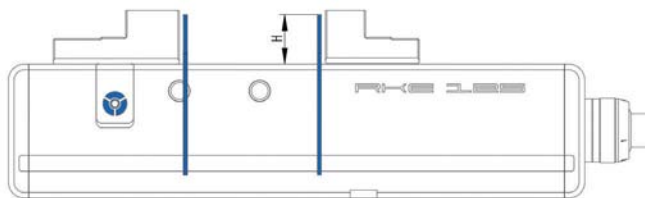
Including fixing screws

A37

Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box



Item no.	Web height A	Jaw width B mm	Rail height H	Guiding width C	Spare clamp (Set = 4 pieces)
1269621 ▲	48	92	10/16/18/20/23/25/26/27/28/29	94	1269624
1269622	68	125	10/15/20/25/28/30/33/35/36/37	126	1269625
1269623	83	160	10/15/20/25/30/35/40/43/45/47	162	1269626



A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
128770	piece	92	92	31,6	3-13	5-32
082363	piece	125	135	39,6	4-20	6-40
082364	piece	160	160	49,6	5-29	7-48
082365	piece	200	200	62,6	6-37	8-56

Including fixing screws

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground



Item no.	Contents of delivery	Width mm	Height mm
150740 ▲	piece	135	39,6
150741 ▲	piece	160	49,6

Including fixing screws

A37

Draw-down jaws SNF, with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
077105 ▲	set	125	135	39,6
077106 ▲	set	160	160	49,6
077107 ▲	set	200	200	62,6

Including fixing screws

Accessories RKE

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



Item no.	Contents of delivery	Width mm	Height mm	Chuckling capacity mm	
				Horizontal	Vertical
317260	set	135	39,8	3-13	6-40
317261	set	160	49,8	5-22	7-48

Including fixing screws

A37

Draw-down jaws RNG, with two permanent magnets



Item no.	Contents of delivery	Size	Width mm	Height mm
155237 ▲	set	92	92	32
159227	set	125	125	39,5
155240	set	160	160	50
163782 ▲	set	200	200	60

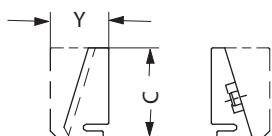
Including fixing screws

A37

Standard insert RNS, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242 ▲	set	92	92	32	21
159232	set	125	125	40	26
155245 ▲	set	160	160	50	30
163783	set	200	200	60	34

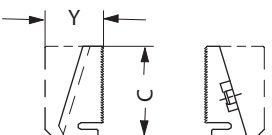


A37

Standard insert finely checkered RNSf, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163270	set	92	92	32	21
163267 ▲	set	125	125	40	26
163273 ▲	set	160	160	50	30
163784 ▲	set	200	200	60	34

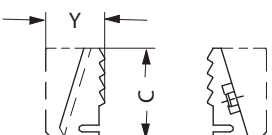


A37

Claw insert RNK, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155247	set	92	92	32	21
159235 ▲	set	125	125	40	26
155250 ▲	set	160	160	50	30
163785 ▲	set	200	200	60	34



Accessories RKE

A37

Floating jaw horizontal PEB, for clamping non-parallel workpieces



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
156190 ▲	piece	92	113	32	36
156191	piece	125	135	40	40
156192 ▲	piece	160	160	50	45
156193 ▲	piece	200	200	63	55

A37

Hand crank, turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A	L
134198	piece	92	12	60	90
134600	piece	125/160/200	14	104	160

A37

Angle drive 90°



Item no.	Contents of delivery	Size	A	B	C
154185	piece	92	113,5	90	83,5
158339	piece	125	133	106	98
158888 ▲	piece	160/200	166	111	98

A37

Single clamp SPE, for mounting vices on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw



Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

C15

Grease F91 for vices, for lubrication and conservation of chucking power



Item no.	Design	Contents
777021 ▲	Cartridge	0,4 kg

RKE-M - without power transmitter



APPLICATION

Particularly suitable for use on machining centers and palletisers.

TYPE

Clamping system mechanical without power transmitter, manually operated.

CUSTOMER BENEFITS

- Horizontal, side or in connection with a base plate vertical mounting, for example as DUO clamping tower (back to back)
- Sturdy chip protection prevents chips from penetrating
- Large clamping stroke
- Clamping surface for clamping claws
- Central lubrication of guides and spindle thread
- Constant clamping force for every clamping operation and high clamping repeatability when a torque wrench is used

TECHNICAL FEATURES

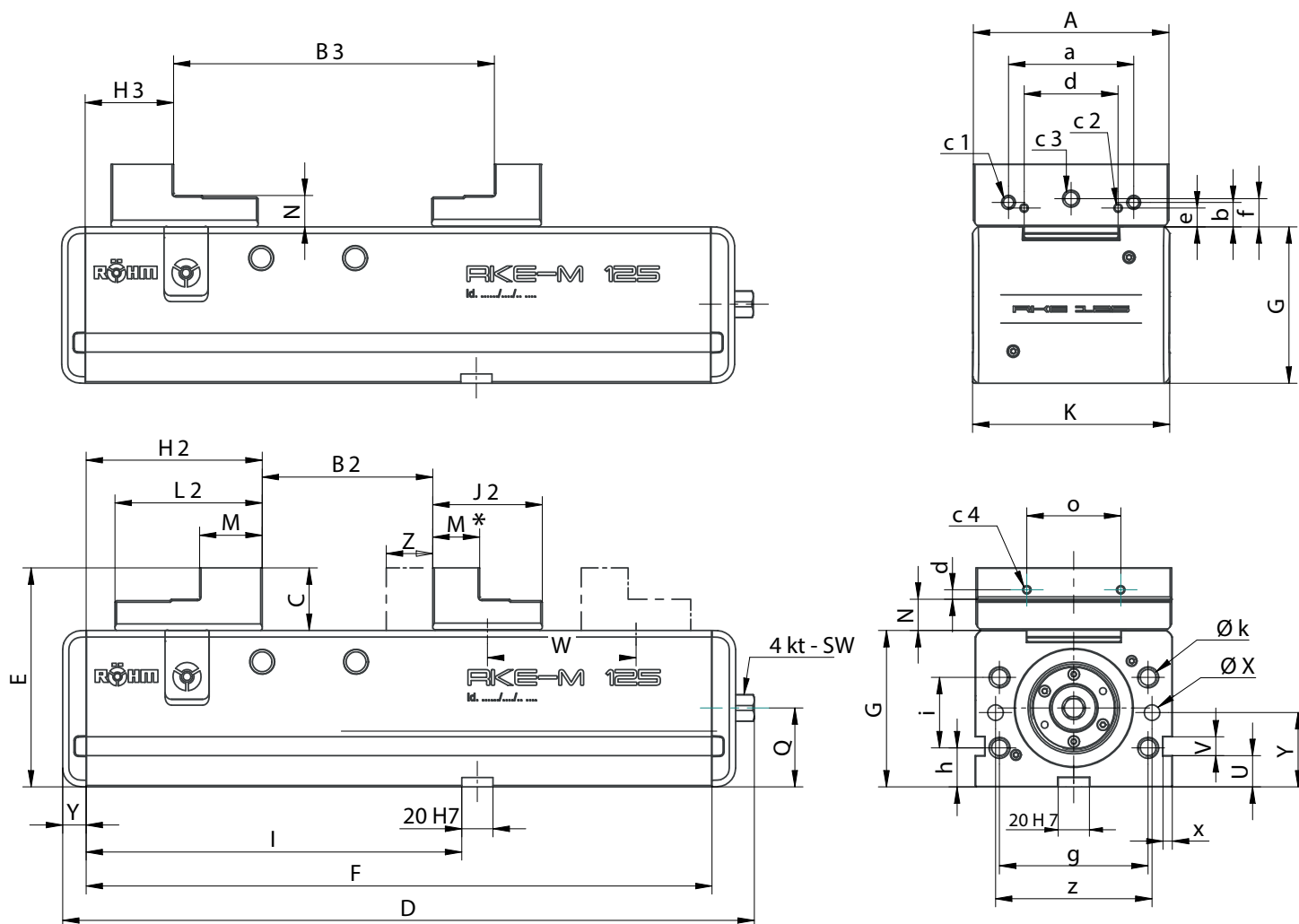
- Sturdy steel body and all guides are hardened and ground on all sides
- Long clamping slide with cross slots, hardened on all sides, functional surfaces ground
- Threaded bores for taking up all RÖHM flat clamping jaws with jaw width 125/160 mm

RKE-M = RÖHM, compact, single clamping, manual

A32
RKE-M, with stepped jaws

Id.-Nr.	182137	182138	182139	182140 ▲
Jaw width A mm	92	125	160	200
Jaw design	stepped jaws	stepped jaws	stepped jaws	stepped jaws
B2 mm	0-138	0 - 216	0 - 320	0 - 315
B3 mm	71-208	97 - 312	131 - 451	131 - 451
C mm	32	40	50	60
D mm	315	442	607	607
E mm	112	140	165	175
F mm	276	400	530	530
G _{0,02} mm	80	100	115	115
H2 mm	80	112,5	130	135
H3 mm	41	56,5	64	64
J2 mm	56	70	97	97
K mm	94	126	162	162
L2 mm	64	94	98	103
M mm	25	40	34	39
M* mm	25	30	32,5	32,5
N _{0,01} mm	16	20	25	25
U mm	20	20	20	20
V mm	12	12	12	12
W mm	68	1x108	2x102,5	2x102,5
X mm	15	15	15	15
Y mm	10	10	10	10
Z mm	70	109	117	117
a mm	63	80	100	125
b mm	13,6	15,6	19,6	24,6
c1	M 6x14	M 8x14	M 8x14	M 10x15
c2	M 5x9	M 5x10	M 5x9	M 5x10
c3	M 10x16	M 10x18	M 10x18	M 14x20
d mm	48	60	80	110
e mm	8	12	12	12
f mm	14	18	20	25
g mm	70	95	125	125
Ø k	M10x18	M 12x22	M 16x25	M 16x25
l mm	140	240	200	200
m2±0,02 mm	60	127,5	70	65
n±0,02 mm	99	183,5	136	136
y ^{0,01} mm	40	47,5	57,5	57,5
z mm	72	100	135	135
Square AF	12	14	19	19
Ø X ^{H7}	10	10	10	10
Clamping force kN	25	40	60	60
Weight kg	15	41	79	85

RKE-M - without power transmitter



Accessories RKE-M

A37

Standard top jaws SA, reversible

Item no.	Contents of delivery	Size	Width mm	Height mm
162628 ▲	set	125	125	40
162629	set	160	160	50
162984	set	200	200	60



A37

Stepped jaws SB, reversible

Item no.	Contents of delivery	Size	Width mm	Height mm
178776	set	92	92	32
178230	set	125	125	40
178754	set	160	160	50
178937	set	200	200	60



A37

Double stepped jaws DSB, „smooth“

Item no.	Contents of delivery	Size	Width mm	Height mm
168698	set	92	50	48
175387 ▲	set	160	160	50
168693 ▲	set	125	62	60



A37

Carrier jaws TB, without swivelling claw inserts

Item no.	Contents of delivery	Size	Width mm	Height mm
165856	set	125	125	20
166218 ▲	set	160/200	160	25



A37

Carrier jaws, without claw inserts

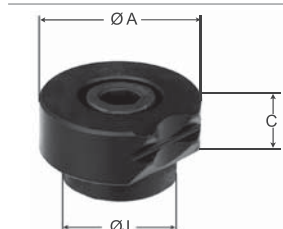
Item no.	Contents of delivery	Size	Width mm	Height mm
169383	set	92	115	20
165861	set	125	160	20
166223 ▲	set	160/200	200	25



A37

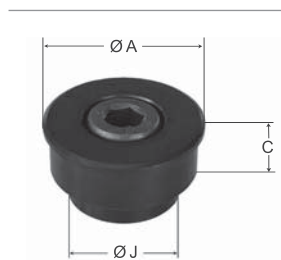
Swivelling claw inserts, for carrier jaws 743-72

Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	Height mm
165854	piece	92/125	28	20	10
166216	piece	160/200	30	22	10



Accessories RKE-M

A37
Tensioner, for carrier jaws 743-72



Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	Height mm
169389	piece	92/125	28	20	10
169391	piece	160/200	30	22	10

A37
One-piece steel top jaws, for self-production of formed jaws or for clamping formed parts

Item no.	Contents of delivery	Size	Width mm	Height mm
160352	set	125	125	60
160353 ▲	set	160	160	70



A37
Normal jaw SGN, one side smooth, one side grooved, both sides ground



Item no.	Contents of delivery	Size	Width mm	Height mm
152752	piece	92	92	31,6
178112 ▲	piece	125	125	39,7
152755	piece	160	160	49,6
152759	piece	200	200	62,6

Including fixing screws

A37
Normal jaw finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved



Item no.	Contents of delivery	Size	Width mm	Height mm
163218 ▲	piece	92	92	31,6
180679 ▲	piece	125	125	39,7
156197	piece	160	160	49,6
156198	piece	200	200	62,6

Including fixing screws

A37
Claw jaws SKB with fine step, 2.5 mm clamping depth



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166514	set	125	92	32	14
166520	set	160	125	40	16
166522	set	200	160	50	18

Including fixing screws

Accessories RKE-M

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm

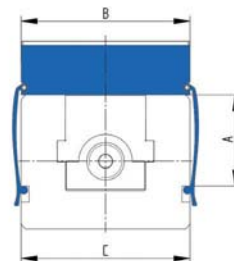
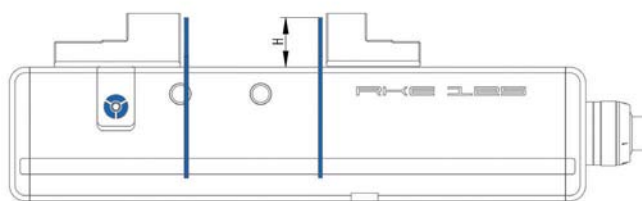

Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661 ▲	set	92	92	32	14
166667	set	125	125	40	16
166669	set	160	160	50	18

Including fixing screws

A37

Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box


Item no.	Web height A	Jaw width B mm	Rail height H	Guiding width C	Spare clamp (Set = 4 pieces)
1269621 ▲	48	92	10/16/18/20/23/25/26/27/28/29	94	1269624
1269622	68	125	10/15/20/25/28/30/33/35/36/37	126	1269625
1269623	83	160	10/15/20/25/30/35/40/43/45/47	162	1269626



A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN


Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
128770	piece	92	92	31,6	3-13	5-32
082363	piece	125	135	39,6	4-20	6-40
082364	piece	160	160	49,6	5-29	7-48
082365	piece	200	200	62,6	6-37	8-56

Including fixing screws

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground


Item no.	Contents of delivery	Size	Width mm	Height mm
150740 ▲	piece	125	135	39,6
150741 ▲	piece	160	160	49,6

Including fixing screws

A37

Draw-down jaws SNF, with spring plate, hardened and ground


Item no.	Contents of delivery	Size	Width mm	Height mm
077105 ▲	set	125	135	39,6
077106 ▲	set	160	160	49,6
077107 ▲	set	200	200	62,6

Including fixing screws

Accessories RKE-M

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support


Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
317260	set	125	135	39,8	3-13	6-40
317261	set	160	160	49,8	5-22	7-48

Including fixing screws

A37

Draw-down jaws RNG, with two permanent magnets

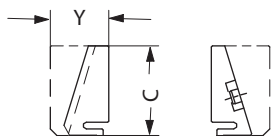

Item no.	Contents of delivery	Size	Width mm	Height mm
155237 ▲	set	92	92	32
159227	set	125	125	39,5
155240	set	160	160	50
163782 ▲	set	200	200	60

Including fixing screws

A37

Standard insert RNS, held by two permanent magnets

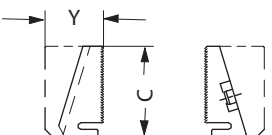

Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242 ▲	set	92	92	32	21
159232	set	125	125	40	26
155245 ▲	set	160	160	50	30
163783	set	200	200	60	34



A37

Standard insert finely checkered RNSf, held by two permanent magnets

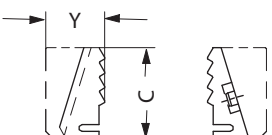

Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163270	set	92	92	32	21
163267 ▲	set	125	125	40	26
163273 ▲	set	160	160	50	30
163784 ▲	set	200	200	60	34



A37

Claw insert RNK, held by two permanent magnets


Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155247	set	92	92	32	21
159235 ▲	set	125	125	40	26
155250 ▲	set	160	160	50	30
163785 ▲	set	200	200	60	34



Accessories RKE-M

A37

Floating jaw horizontal PEB, for clamping non-parallel workpieces


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
156190 ▲	piece	92	113	32	36
156191	piece	125	135	40	40
156192 ▲	piece	160	160	50	45
156193 ▲	piece	200	200	63	55

C15

Hand crank HKU, with octagon socket


Item no.	Contents of delivery	Size	Octagon	Key-width SW	L
009151 ▲	piece	92	12		100
009152	piece	125	14	Octagon	125
009154	piece	160/200	19	Octagon	200

A37

Single clamp SPE, for mounting vices on end and on the base


Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw


Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

A26

Torque wrench

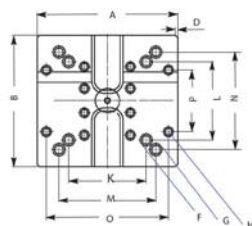

Item no.	Torque Nm	Length mm	Output	Working accuracy
10004116	20-120	435	12,7=1/2"	3%
10004117	60-320	659	12,7=1/2"	3%

A37

Drive adapter ATA


Item no.	Contents of delivery	Size	Square
168721	piece	92	12-1/2"
161103	piece	125	14-1/2"
161730	piece	160/200 125	19-1/2"

Accessories RKE / RKE-M / RKK



APPLICATION

Suitable for the complete setup of two NC compact clamps, back-to-back.

TYPE

With centering for machine table/pallet.
Without mounting or height adjustment of the clamps.
Incl. T-nuts, clamping claws and screws for aligning and fastening the clamps on the basic plate.

TECHNICAL FEATURES

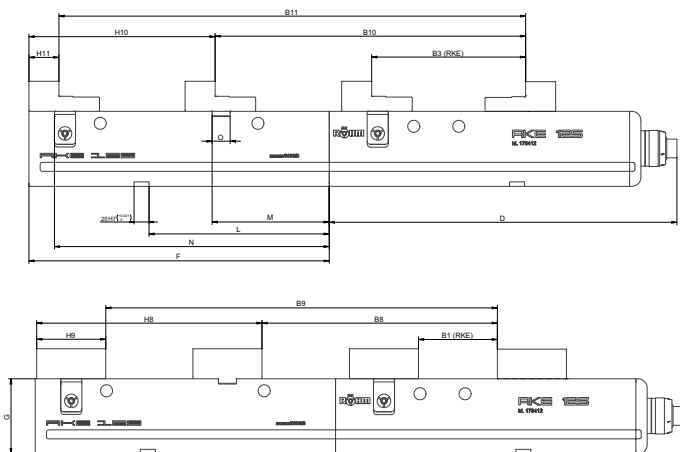
- Bores for modular grid 40/50/63
- Without aligning groove/bore (machine side)

A37

Standard basic plate GP, for DUO-tower for NC-compact vices

Item no.	164016 ▲	164018 ▲	164020 ▲	164022 ▲	164024 ▲	164026 ▲
For	RKD-M 92	RKE 92 / RKE-M 92	RKE 125 / RKE-M 125	RKK 135	RKK 160 / RKK 200	RKE 160 / (RKE 200) / RKE-M 160 / (RKE-M 200)
A mm	250	250	290	290	350	350
B mm	250	250	270	270	350	350
C mm	45	45	45	45	45	45
D mm	5x45°	5x45°	5x45°	5x45°	5x45°	5x45°
E mm	20	20	20	20	20	20
F	KM 12	KM 12	KM 16	KM 16	KM 16	KM 16
G	KM 16	KM 16	KM 16	KM 16	KM 12	KM 12
H	KM 16	KM 16	KM 12	KM 12	KM 16	KM 16
J mm	50	50	50	50	50	50
K mm	126	126	160	200	240	240
L mm	126	126	160	200	160	160
M mm	160	160	200	240	252	252
N mm	160	160	200	240	252	252
O mm	200	200	252	252	300	300
P mm	200	200	126	126	300	300
Weight kg	24	24	29	29	45	45

Accessories RKE / RKE-M



A37

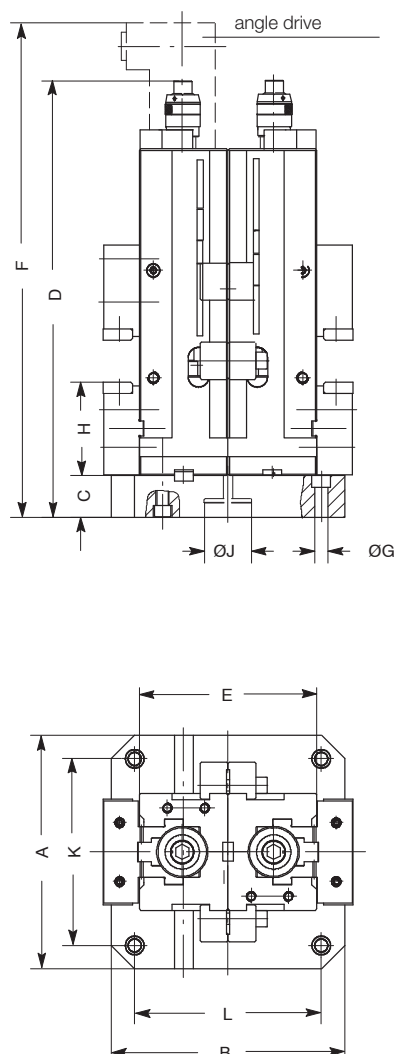
Extension GKV, for extension of clamping capacity for extra-long workpieces (**only RKE, RKE-M**) Fastening with screws (included in the scope of delivery)

Item no.	178418	178419 ▲	178420	178421 ▲	178422 ▲	178423 ▲
For	RKE 125 / RKE-M 125	RKE 125 / RKE-M 125	RKE 125 / RKE-M 125	RKE 160 / RKE-M 160	RKE 160 / RKE-M 160	RKE 160 / RKE-M 160
D	463	463	463	618	618	618
F	105	200	400	190	295	530
G	100	100	100	115	115	115
L	-	-	240	-	-	200
M	-	-	156	-	-	225
N	68	160	364	150	253	493
O	24	24	24	30	30	30
B1	0-215	0-215	0-215	0-320	0-320	0-320
B3 mm	97-312	97-312	97-312	131-451	131-451	131-451
B8	-	-	208-422	-	-	290-605
B9	121-335	213-427	416-630	215-535	318-638	560-875
B10	-	-	306-520	-	-	421-736
B11	218-432	310-524	514-728	346-666	449-769	681-1006
H8	-	-	302	-	-	370
H9	95	98	94	105	107	102
H10	-	-	248	-	-	304
H11	41	44	40	39	41	36
Weight kg	6,5	13	26	18	27	49

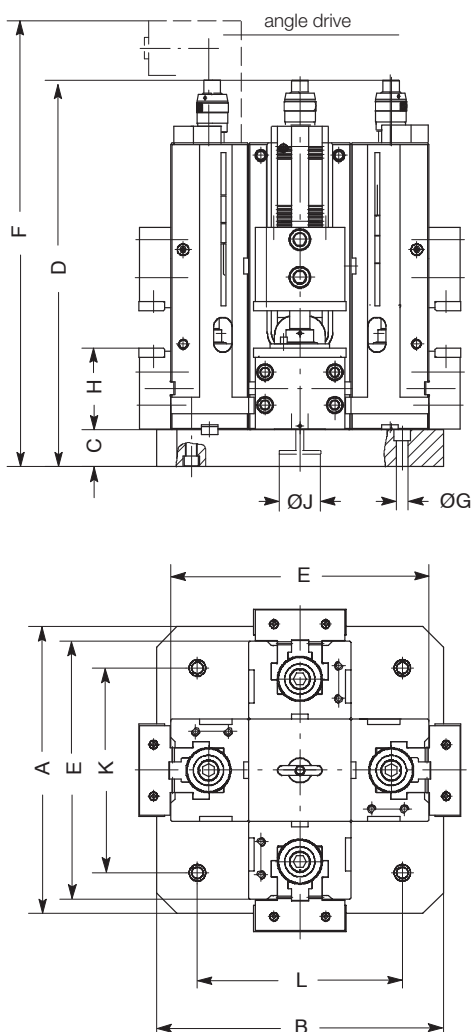
Accessories RKE / RKE-M

Duo and Quattro clamping towers RKE / RKE-M

Duo-clamping towers (on request)



Quattro-clamping towers (on request)



Technical data

Size	125	160 / 200
Jaw width	125	160
A	250	350
B	250	350
C	45	45
D	508	663
E	200	230
F	578	741
G*		
H	110,5	130
J*		
K*		
L*		
kg	105	200

* On inquiry insert dimensions please

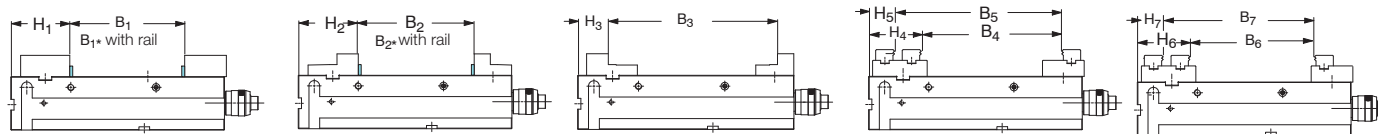
Technical data

Size	125	160 / 200
Jaw width	125	160
A	350	400
B	350	400
C	45	45
D	508	663
E	325	392
F	578	741
G*		
H	110,5	130
J*		
K*		
L*		
kg	210	375

* On inquiry insert dimensions please

Find dual clamp in the sector General accessories.

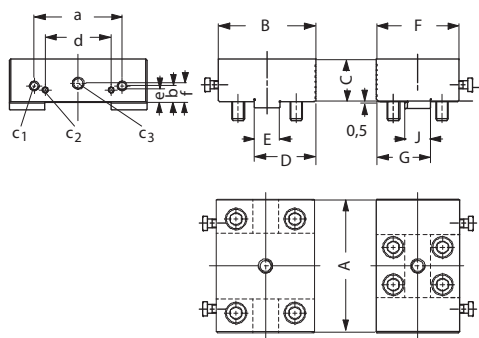
Clamping range RKE / RKE-M



	Standard jaws		Stepped jaws				Carrier jaws with pronged inserts			
	H1	B1 B1* with rail	H2	B2 B2* with rail	H3	B3	H4/H5	B4/B5	H6/H7	B6/B7
Size 125	110,5	0-215	112,5	0-216	56,5	97-312	H4: 98 H5: 48	B4: 50-262 B5: 100-321	H6: 98 H7: 48	B6: 20-232 B7: 70-282
Size 160	130	0-320	130	0-320	64	131-451	H4: 122	B4: 67-383	H6: 122	B6: 18-334

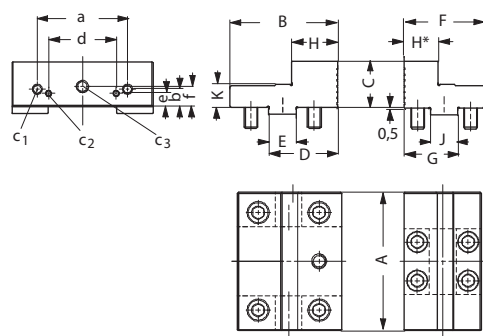
Clamping jaw dimensions for NC-Compact vices

Standard top jaws - set



Jaw width	125	160	200
Item No.	162628	162629	162984
B	92	100	105
C	40	50	60
D	58	65	65
E _{h7}	24	30	30
F	78	100	100
G	51	65	65
J _{g6}	24	30	30
a	80	100	125
b	15,6	19,6	24,6
c1	M8	M8	M10
c2	M5	M5	M5
c3	M10	M10	M14
d	60	80	110
e	12	12	12
f	18	20	25

Stepped jaws - set



Jaw width	92	125	160	200
Item No.	162851	160343	162630	162985
B	64	94	98	103
C	32	40	50	60
D	42	60	65	70
E _{h7}	20	24	30	30
F	56	70	97	97
G	38	47	63,5	63,5
H/H*	25/25	40/30	34/32,5	39/32,5
J _{g6}	20	24	30	30
K	16	20	25	25
a	63	80	100	125
b	13,6	15,6	19,6	24,6
c1	M6	M8	M8	M10
c2	M5	M5	M5	M5
c3	M10	M10	M10	M14
d	48	60	80	110
e	8	12	12	12
f	14	18	20	25

RKE-LV - with power transmitter, short design



APPLICATION

Optimized for collision-free 5-axis machining in one set-up.
Specially suited for 5-axis machines in combination with a base plate.

TYPE

Clamping system mechanical-mechanical with power transmitter, manually operated.
Short, compact design.

CUSTOMER BENEFITS

- ☑ With tension clamping, zero point of the workpiece on the operator side
- ☑ Large clamping range
- ☑ High-precision positioning
- ☑ Stable chip guard for longer life

TECHNICAL FEATURES

- Sturdy steel body and all guides are hardened and ground on all sides
- Carrier jaws incl. swivelable claw inserts for round and rectangular workpieces
- **Clamping ranges carrier jaws:**
Rightangular workpieces: 35 - 215 mm
Circular workpieces: 65 - 225 mm

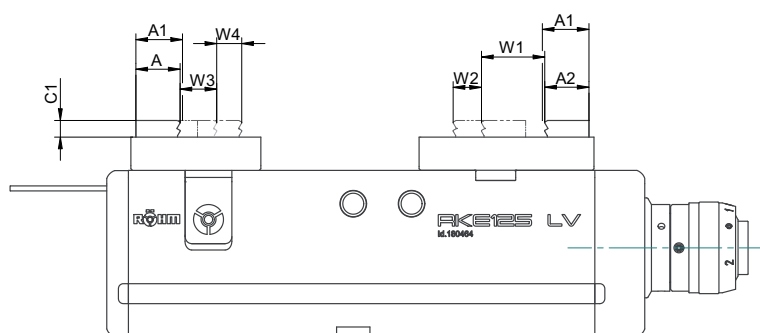
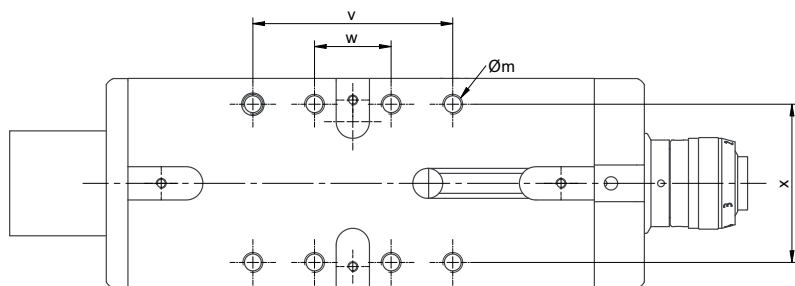
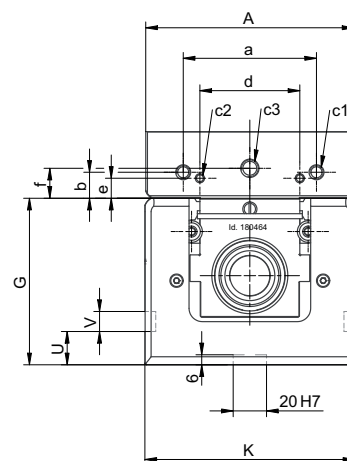
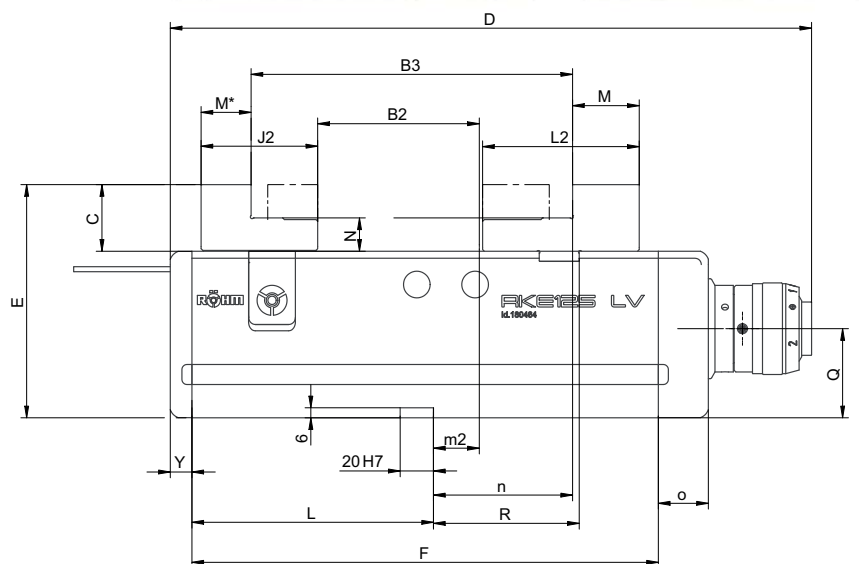
RKE-LV = RÖHM, compact, single clamping, light design, short design

A32

RKE-LV, with reversible stepped jaws or carrier jaws

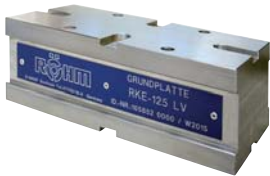
Id.-Nr.	180464 ▲	180465 ▲
Jaw width A mm	125	125
Jaw design	stepped jaws	carrier jaws
B2 mm	0-96	35-215
B3 mm	96-192	65-225
C mm	40	20
D mm	385	385
E mm	140	130
F mm	280	280
G _{0,02} mm	100	100
J2 mm	70	78
K mm	126	126
L mm	145	145
L2 mm	94	105
M mm	40	-
M* mm	30	-
N _{0,01} mm	20	20
O mm	30	30
Q mm	53,5	53,5
R mm	87,5	87,5
U mm	20	20
V mm	40	40
Y mm	13	13
a mm	60	-
b mm	15,6	-
c1	M8	-
c2	M5	-
c3	M10	-
d mm	80	-
e mm	12	-
f mm	18	-
m2±0,02 mm	27,5	-
n±0,02 mm	83,5	-
o mm	30	30
v mm	120	120
w mm	46	46
x mm	95	95
Øm x depth	M12x20	M12x20
Clamping force kN	40	40
A1 mm	-	28
A2 mm	-	26,5
C1 mm	-	10
W1 mm	-	38
W2 mm	-	17
W3 mm	-	22
W4 mm	-	15
Weight kg	29	29

RKE-LV - with power transmitter, short design



Accessories RKE-LV

A37

Standard base plate GP


Item no.	Contents of delivery	Size	Length	Width	Height	Weight kg
165852 ▲	piece	125	280	126	90	24

A37

Standard top jaws SA, reversible


Item no.	Contents of delivery	Size	Width mm	Height mm
162628 ▲	set	125	125	40

A37

One-piece steel top jaws, for self-production of formed jaws or for clamping formed parts


Item no.	Contents of delivery	Size	Width mm	Height mm
160352	set	125	125	60

A37

Stepped jaws SB, reversible


Item no.	Contents of delivery	Size	Width mm	Height mm
178230	set	125	125	40

A37

Double stepped jaws DSB, „smooth“


Item no.	Contents of delivery	Size	Width mm	Height mm
168693 ▲	set	125	62	60

A37

Carrier jaws TB, without swivelling claw inserts


Item no.	Contents of delivery	Size	Width mm	Height mm
165856	set	125	125	20

A37

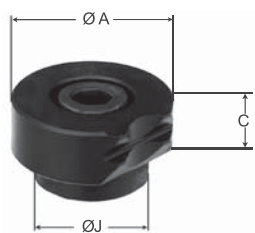
Carrier jaws, without claw inserts


Item no.	Contents of delivery	Size	Width mm	Height mm
165861	set	125	160	20

Accessories RKE-LV

A37

Swivelling claw inserts, for carrier jaws 743-72



Item no.	Contents of delivery	Size	Height mm
165854	piece	125	10

A37

Tensioner, for carrier jaws 743-72



Item no.	Contents of delivery	Size	Height mm
169389	piece	125	10

A37

Claw jaws SKB with fine step, 2.5 mm clamping depth



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166520	set Including fixing screws	125	125	40	16

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm



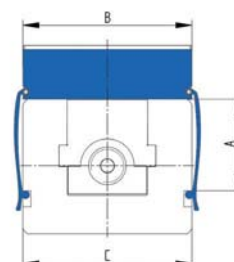
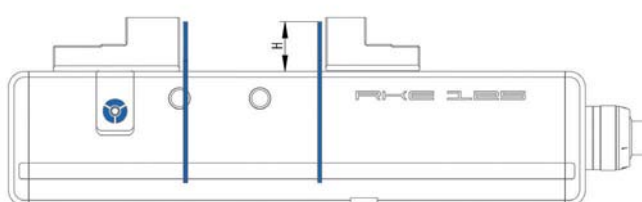
Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166667	set Including fixing screws	125	125	40	16

A37

Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box



Item no.	Web height A	Jaw width B mm	Rail height H	Guiding width C	Spare clamp (Set = 4 pieces)
1269622	68	125	10/15/20/25/28/30/33/35/36/37	126	1269625



Accessories RKE-LV

A37

Standard jaws SGN, one side smooth, one side grooved, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
158897	set	125	125	39,7

A37

Standard jaws finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved



Item no.	Contents of delivery	Size	Width mm	Height mm
163225	set	125	125	39,7

A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
082363	piece	125	135	39,6	4-20	6-40

Including fixing screws

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
150740 ▲	piece	125	135	39,6

Including fixing screws

A37

Draw-down jaws SNF, with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
077105 ▲	set	125	135	39,6

Including fixing screws

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
317260	set	125	135	39,8	3-13	6-40

Including fixing screws

Accessories RKE-LV

A37

Hand crank, turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A	L
134600	piece	125	14	104	160

A37

Angle drive 90°



Item no.	Contents of delivery	Size	A	B	C
158339	piece	125	133	106	98

A37

Single clamp SPE, for mounting vices on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw



Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

RKK - with power transmitter, high precision



APPLICATION

Optimized for modern CNC milling machines and machining centers with very high working precision.

TYPE

Size 1: clamping system mechanical-hydraulic.

Size 2-5: clamping system mechanical-mechanical.

CUSTOMER BENEFITS

- ③ Drive spindle with clamping force presetting
- ③ Deformation-resistant design for maximum clamping precision
- ③ Fastening thread for workpiece stop
- ③ Clamping surface for clamping claws
- ③ With grease nipples installed on both sides, that all guides and the spindle thread can be lubricated quickly and easily

TECHNICAL FEATURES

- Sturdy steel body and all guides are hardened and ground on all sides
- **Size 1:** long clamping slide with slot and tenon, hardened on all sides, functional surface ground
- **Sizes 2-5:** long clamping slide with toothing

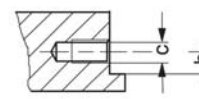
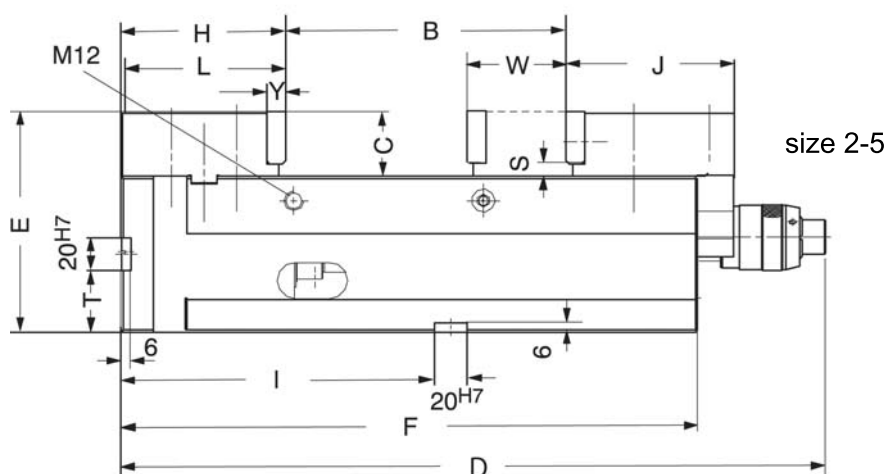
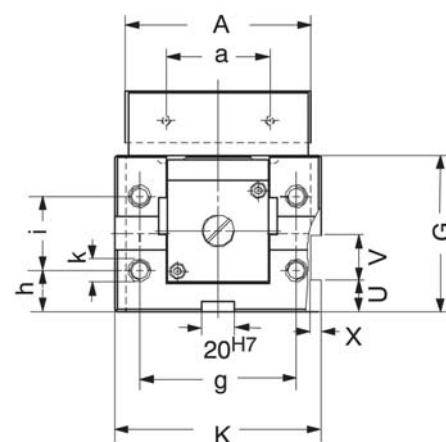
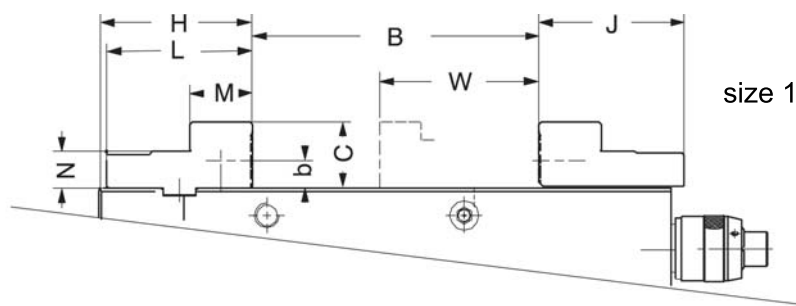
RKK = RÖHM, compact, power amplified

A32

RKK, with standard jaws SA and SGN normal jaw

Id.-Nr.	148545	148682 ▲	149371 ▲
Size	3	4	5
Jaw width A mm	135	160	200
Clamping capacity B mm	0-215	0-340	0-340
C mm	49	60	70
D mm	483	618	618
E mm	148	179	189
F mm	400	525	525
G _{0,02} mm	100	120	120
H-0,05 mm	110,5	130	130
J mm	102	110	110
K mm	150	205	205
L mm	109	128	128
S mm	9,4	10,4	7,4
T _{-0,02} mm	40	50	50
U mm	20	20	20
V mm	40	40	40
W mm	168	235	235
X mm	6,5	6,5	6,5
Y mm	15,6	15,6	19,6
Clamping travel mm	60	108	108
a mm	80	100	125
b mm	15,6	19,6	24,6
c mm	M8x13	M8x13	M10x15
g mm	110	145	145
h mm	22,5	20	20
i mm	55	80	80
k x depth	M12x22	M16x20	M16x20
I _{-0,02} mm	240	365	365
Clamping force kN	40	60	60
Weight kg	50	107	108

RKK - with power transmitter, high precision



Accessories RKK

A37

Standard top jaws SA, reversible, for screwing on clamping jaws, with fixing screws

Item no.	Contents of delivery	Size	Width mm	Height mm
149236	set	3	132	49
149373	set	4	157	60
149374	set	5	197	70



A37

Top jaws SN, reversible, for hooking in quick-change clamping inserts and for screwing on clamping jaws, with fixing screws

Item no.	Contents of delivery	Size	Width mm	Height mm
149240 ▲	set	3	133	53
149375	set	4	158	67
149376 ▲	set	5	198	67



A37

Carrier jaws TB, reversible, for screwing on claw inserts or special jaws, with fixing screws

Item no.	Contents of delivery	Size	Width mm	Height mm
147748 ▲	set	3	135	30
148688 ▲	set	4	160	30
149384 ▲	set	5	200	30



A37

Claw insert KRE, for carrier jaws 743-70, with fixing screw

Item no.	Contents of delivery	Size	Width mm	Height mm
146070	piece	3/4/5	30	20



A37

Claw jaws SKB with fine step, 2.5 mm clamping depth

Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166520	set	3	125	40	16
166522	set	4/5	160	50	18



Including fixing screws

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm

Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166667	set	3	125	40	16
166669	set	4/5	160	50	18



Including fixing screws

Accessories RKK

A37

Normal jaw SGN, one side smooth, one side grooved, both sides ground



Item no.	Contents of delivery	Size	Width mm	Height mm
152754	piece	3	135	39,6
152755	piece	4	160	49,6
152759	piece	5	200	62,6

Including fixing screws

A37

Normal jaw finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved



Item no.	Contents of delivery	Size	Width mm	Height mm
156196	piece	3	135	39,6
156197	piece	4	160	49,6
156198	piece	5	200	62,6

Including fixing screws

A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
082363	piece	3	135	39,6	4-20	6-40
082364	piece	4	160	49,6	5-29	7-48
082365	piece	5	200	62,6	6-37	8-56

Including fixing screws

A37

Draw-down jaws SNF, with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
077106 ▲	set	4	160	49,6
077107 ▲	set	5	200	62,6

Including fixing screws

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
317260	set	3	135	39,8	3-13	6-40
317261	set	4	160	49,8	5-22	7-48

Including fixing screws

Accessories RKK

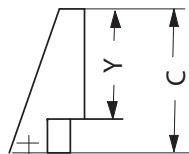
A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground


Item no.	Contents of delivery	Size	Width mm	Height mm
150740 ▲	piece	3	135	39,6
150741 ▲	piece	4	160	49,6

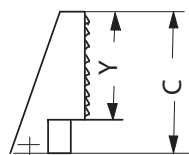
Including fixing screws

A37

Standard inserts NCS, hardened and ground, for machined workpieces without angular error


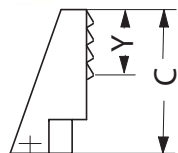
Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
147954	set	3	135	53	40
147955	set	4	160	67	50
158823	set	5	200	67	50

A37

Standard inserts finely checkered NCSf, with small surface area to increase the specific surface clamping (higher holding Forces)


Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163228 ▲	set	3	135	53	40
163229	set	4	160	67	50
163230 ▲	set	5	200	67	50

A37

Claw inserts NCK, hardened and ground, for unmachined workpieces


Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
148917	set	3	135	53	24
148918 ▲	set	4	160	67	45
159447 ▲	set	5	200	67	45

Accessories RKK

A37

Hand crank, turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A	L
134600	piece	3/4/5	14	104	160

A37

90° Angle drive, for RKK 3-5



Item no.	Contents of delivery	Size	A	B	C
151651 ▲	piece	3	161	101	98
151652 ▲	piece	4/5	174	111	98

A37

Single clamp SPE, for mounting vices on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

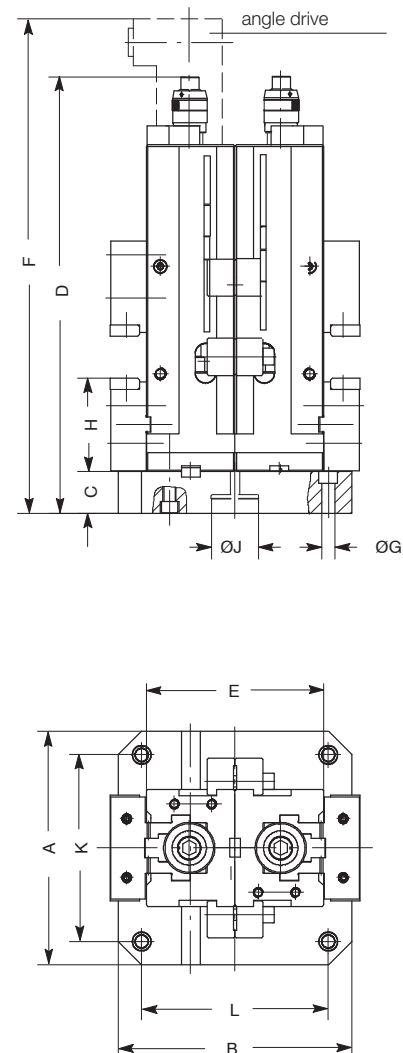
Fixed slot nuts NTS, hardened and ground, with fixing screw



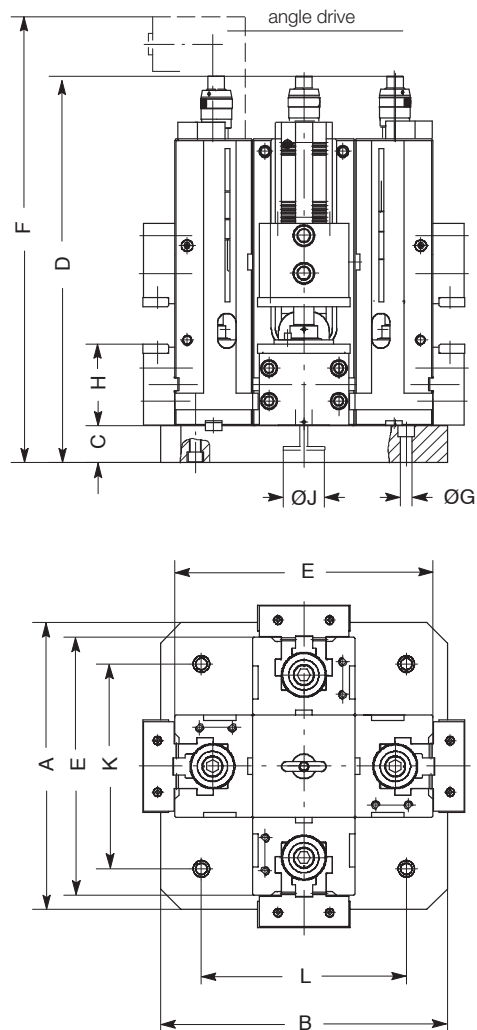
Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

Duo and Quattro clamping towers RKK

Duo-clamping towers (on request)



Quattro-clamping towers (on request)



Technical data

Size	RKK 135	RKK 160	RKK 200
Jaw width	135	160	200
A	290	350	350
B	270	350	350
C	45	45	45
D	528	663	663
E	200	240	240
F	606	744	744
G*			
H	110,5	130	130
J*			
K*			
L*			
kg	125	260	260

* On inquiry insert dimensions please

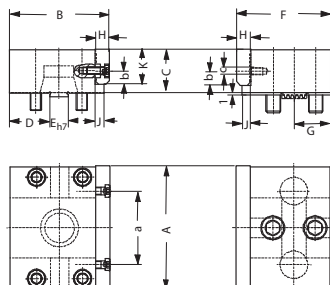
Technical data

Size	RKK 135	RKK 160	RKK 200
Jaw width	135	160	200
A	400	500	500
B	400	500	500
C	45	45	45
D	528	663	663
E	350	445	445
F	606	744	744
G*			
H	110,5	130	130
J*			
K*			
L*			
kg	250	530	530

* On inquiry insert dimensions please

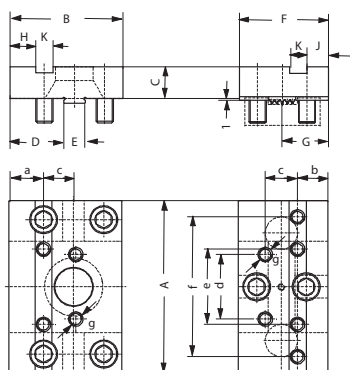
Jaw dimensions and clamping range RKK

Standard top jaws SA, reversible



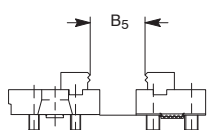
Size	3	4	5
A	135	160	200
B	109	128	128
C	49	60	70
D	44	50	50
E _{h7}	20	20	20
F	102	110	110
G	39	42	42
H	15,6	15,6	19,6
J	9,6	9,6	13,6
K	39,6	49,6	62,6
a	80	100	125
b	15,6	19,6	24,6
c	M8	M8	M10

Carrier jaws, reversible

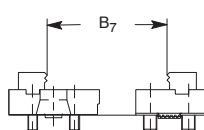


Size	3	4	5
A	135	160	200
B	95	105	105
C	30	30	30
D	44	50	50
E _{h7}	20	20	20
F	83	83	83
G	43	43	43
H	21	24	24
J	20	20	20
K _{h7}	16	16	16
a	29	32	32
b	28	28	28
c	25	30	30
d	60	70	70
e	60	70	110
f	110	130	160
g	M12	M12	M12

Clamping ranges: External clamping RKK



Carrier jaws with pronged inserts



Carrier jaws with pronged inserts

Size

3	30-257	110-337
4+5	59-395	144-481



SET-UP AND WORKING TIME REDUCTION BY TWIN CLAMPING



Function description

Two movable clamping jaws and a fixed middle jaw allow a set-up and working time reducing twin clamping. The movable clamping jaw is placed by turning the spindle with the crank against the workpiece and held with about 1 kN (third-hand function).

Then the crank is turned further, the other movable clamping jaw is placed against the workpiece, fixed and force is built up via the mechanical spindle.

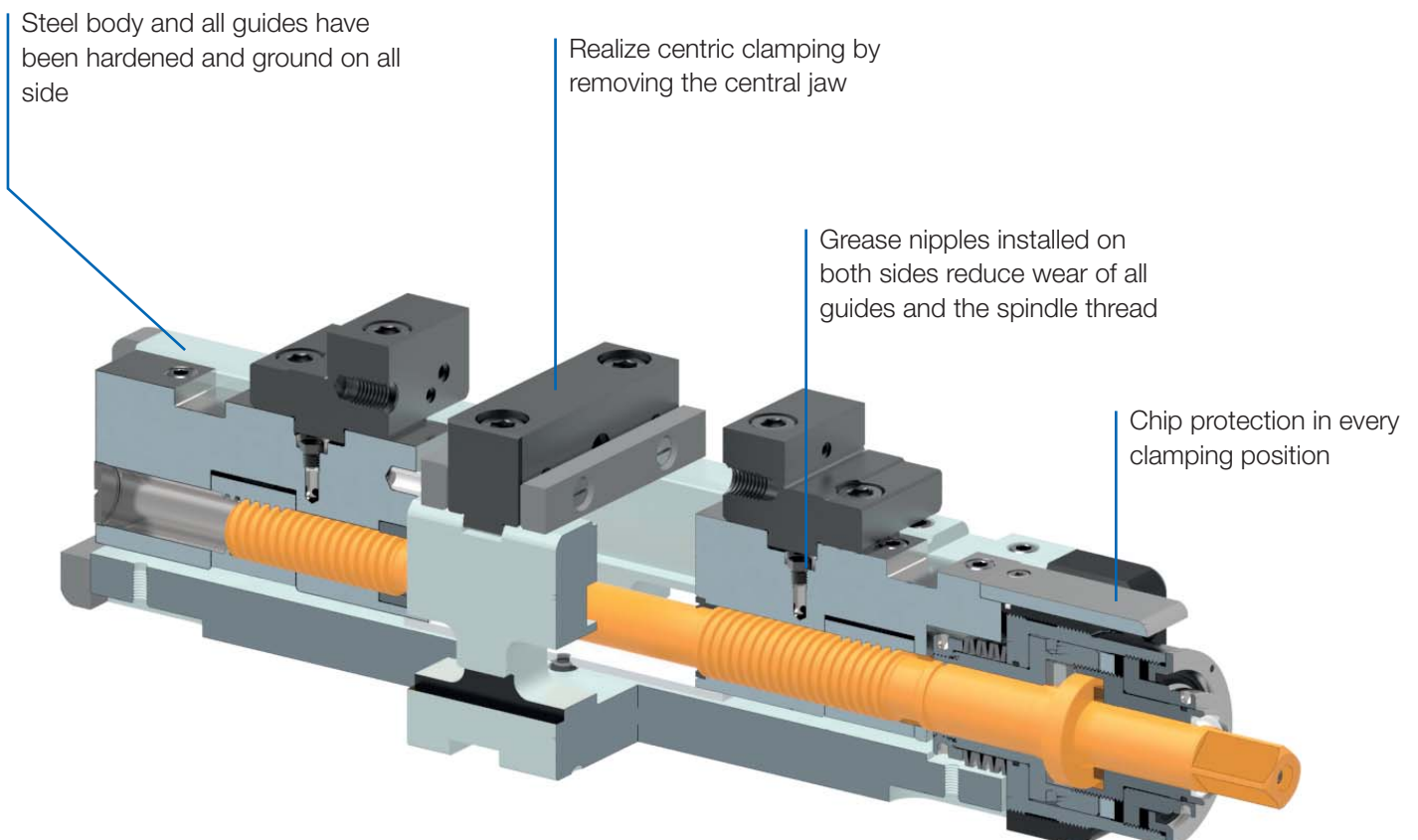
Balance springs compensate dimensional discrepancies from up to ± 3 mm between workpiece I and workpiece II.

NC-COMPACT TWIN VICES

Especially for the series production, setting up and cycle times are the critical factors. Due to their twin clamping, the NC-compact twin vices from RÖHM are ideally suited for efficient machining. Two movable clamping jaws and a fixed middle jaw enable a high repeatability of 0.01 mm and constant clamping force during every clamping operation.

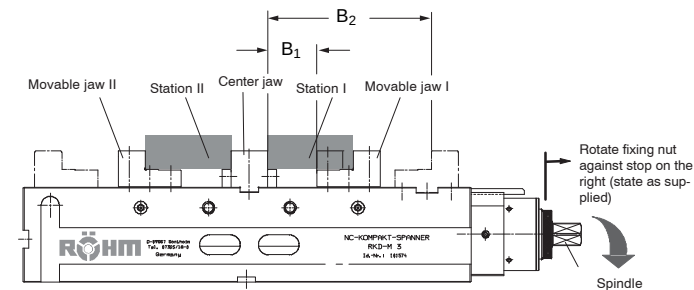
ADVANTAGES AT A GLANCE

- ⊕ Maximum flexibility and versatile thanks to the possibility of 3-sided clamping
- ⊕ High repeatability of 0.01 mm as well as consistent clamping force for each clamping process
- ⊕ Set-up and working time reduction by double clamping



Clamping versions RKD-M

Clamping ranges: Twin clamping



Function:

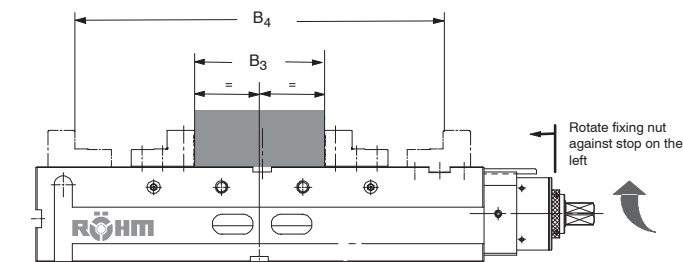
To adjust mobile jaw I with regard to the workpiece of station I turn the spindle to the right by means of the handle (left-right handed thread). About 1 kN are applied to keep the jaw in the adjusted position (third-hand function). By further turning the lever, mobile jaw II is adjusted with regard to workpiece in station II, locked and power via the mechanical spindle is transmitted. By means of compensating springs, variations between workpiece I and II of up to ± 3 mm are compensated.

Both stations must always be equipped with identical workpieces for clamping!

Fixing nut - stop on the right (spindle provides compensation)
Jaw stroke: "Z" Station I: 50 mm
Station II: 56 mm

Size		92	125
B ₁	Groove 1	0 - 48	0 - 48
	Groove 2	48 - 96	46 - 94
	Groove 3	-	92 - 140
B ₂	Groove 1	42 - 79	51 - 88
	Groove 2	79 - 127	86 - 134
	Groove 3	-	132 - 180

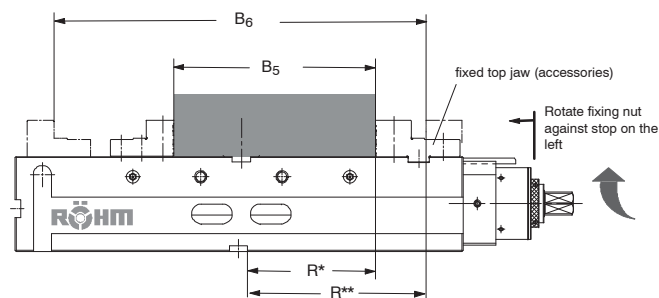
Clamping ranges: Centric clamping



Remove central jaw
Fixing nut - stop on the left (spindle rigid)
Stroke per jaw: "Z" 53 mm

Size		92	125
B ₃	Groove 1	30 - 132	40 - 142
	Groove 2	126 - 228	132 - 235
	Groove 3	-	224 - 327
B ₄	Groove 1	92 - 195	120 - 222
	Groove 2	188 - 290	212 - 315
	Groove 3	-	304 - 407

Clamping ranges: Single clamping



Remove central jaw and movable mounting jaw I.
Install fixed mounting jaw (accessory - not in scope of delivery).
Fixing nut - stop on the left (spindle rigid)
Stroke of moving jaw: "Z" 53 mm

Size		92	125
B ₅	Groove 1	126 - 177	171 - 222
	Groove 2	174 - 225	217 - 268
	Groove 3	-	263 - 314
B ₆	Groove 1	196 - 247	267 - 318
	Groove 2	244 - 295	313 - 364
	Groove 3	-	360 - 410
	R*	101	141
	R**	140	197

RKD-M - double clamping, without power transmitter

APPLICATION

For flexible clamping tasks on machining centers and other production systems.
Triple clamping function: Double clamping - Centric clamping - Single clamping.

TYPE

Clamping system mechanical without power transmitter, manually operated.

With one-sided drive spindle.

CUSTOMER BENEFITS

- Large clamp stroke (50 mm per jaw)
- The clamping thread of the spindle is protected from dirt and chips in every basic jaw position
- With grease nipples installed on both sides, that all guides and the spindle thread can be lubricated quickly and easily
- Horizontal, vertical or side mounting

TECHNICAL FEATURES

- Vice with two movable clamping jaws and a stationary center jaw
- Steel basic body as well as all guides hardened and ground on all sides
- Fastening only possible with clamping claws (direct fastening on request)
- Constant clamping force for every clamping operation and high repeatability when a torque wrench is used

RKD-M = RÖHM, compact, double clamping, manual

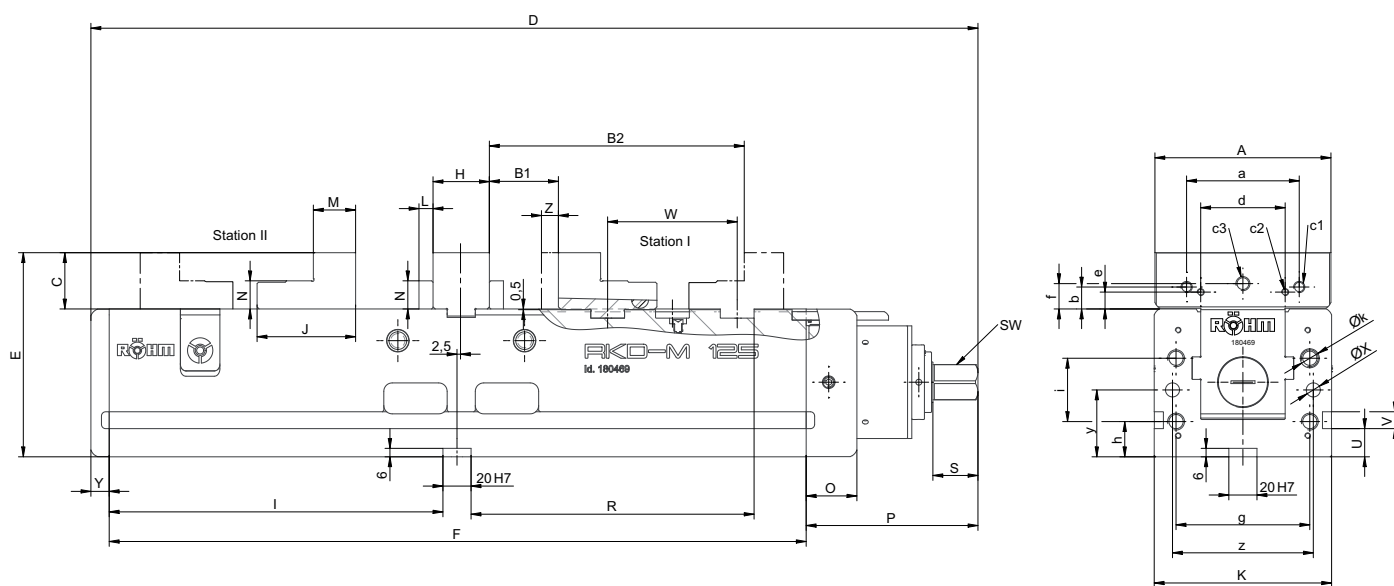
A32

RKD-M, with reversible stepped jaws and centre jaw

Id.-Nr.	180468 ▲	180469
Jaw width A mm	92	125
B1 slot 1 mm	0-48	0-48
B1 slot 2 mm	48-96	46-94
B1 slot 3 mm	-	92-140
B2 slot 1 mm	42-79	51-88
B2 slot 2 mm	79-127	86-134
B2 slot 3 mm	-	132-180
C mm	32	40
D mm	492	630
E mm	117	145
F mm	366	495
G _{0,02} mm	85	105
H _{0,02} mm	30	40
J mm	56	70
K mm	94	126
L mm	10	10
M mm	25	30
N _{0,01} mm	16	20
O mm	36	36
P mm	114	122
R mm	143	201
S mm	31	32
T _{0,02} mm	30	37,5
U mm	20	20
V mm	12	12
W mm	1 x 48	2 x 46
Y mm	12	13
Z mm	50/53	50/53
Key-width SW	17	19
a mm	63	80
b mm	13,6	15,6
c1	M6 x 14	M8 x 14
c2	M5 x 9	M5 x 10
c3	M10 x 16	M10 x 18
d mm	48	60
e mm	8	12
f mm	14	18
g mm	70	95
h mm	20	25
i mm	50	45
k x depth	M10 x 18	M12 x 22
l _{0,02} mm	177	237
y±0,01 mm	40	47,5
z mm	72	100
Clamping force kN	25	40
Weight kg	24	52



RKD-M - double clamping, without power transmitter



Accessories RKD-M

A37

Stepped jaws SB, reversible, with fixing screws


Item no.	Contents of delivery	Size	Width mm	Height mm
161831 ▲	set	92	92	32
162631	set	125	125	40

A37

Standard jaws SGN, one side smooth, one side grooved, hardened and ground


Item no.	Contents of delivery	Size	Width mm	Height mm
162363	set	92	92	32
158897	set	125	125	39,7

A37

Standard jaws finely checkered SGNf, one side finely checkered, one side grooved, hardened and ground


Item no.	Contents of delivery	Size	Width mm	Height mm
163223	set	92	92	32
163225	set	125	125	39,7

A37

V-jaw PB, horizontal and vertical


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm	Height prism mm	Chuckling capacity mm	
							horizontal	vertical
162365 ▲	set	92	92	32	16	19,5	12-36	12-36
158641	set	125	125	40	20	24	15-40	18-60

A37

Claw jaws SKB with fine step, 2.5 mm clamping depth


Item no.	Contents of delivery	Width mm	Height mm	Thickness mm
166514	set	92	32	14
166520	set	125	40	16

Including fixing screws

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm


Item no.	Contents of delivery	Width mm	Height mm	Thickness mm
166661 ▲	set	92	32	14
166667	set	125	40	16

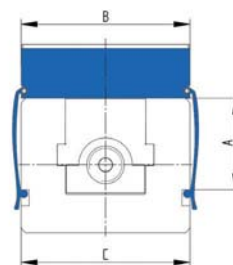
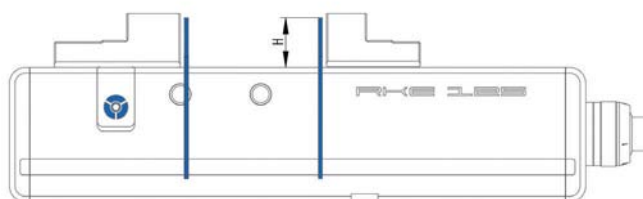
Including fixing screws

Accessories RKD-M

A37

Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box


Item no.	Web height A	Jaw width B mm	Rail height H	Spare clamp (Set = 4 pieces)
1295913 ▲	53	92	10/16/18/20/23/25/26/27/28/29	1295916
1295914 ▲	73	125	10/15/20/25/28/30/33/35/36/37	1295917



A37

Draw-down jaws RNG, with two permanent magnets

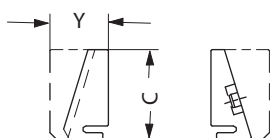

Item no.	Contents of delivery	Width mm	Height mm
155237 ▲	set	92	32
159227	set	125	39,5

Including fixing screws

A37

Standard insert RNS, held by two permanent magnets

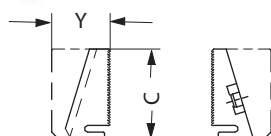

Item no.	Contents of delivery	Width mm	C mm	Y mm
155242 ▲	set	92	32	21
159232	set	125	40	26



A37

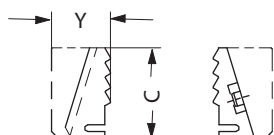
Standard insert finely checkered RNSf, held by two permanent magnets


Item no.	Contents of delivery	Width mm	C mm	Y mm
163270	set	92	32	21
163267 ▲	set	125	40	26



Accessories RKD-M

A37

Claw insert RNK, held by two permanent magnets


Item no.	Contents of delivery	Width mm	C mm	Y mm
155247	set	92	32	21
159235 ▲	set	125	40	26

A37

Drive adapter ATA


Item no.	Contents of delivery	Size	Square
162192	piece	92	17-1/2"
161730	piece	125	19-1/2"

A37

Fixed stepped jaw FSB, for single clamping, reversible


Item no.	Contents of delivery	Size	Width mm
178777	piece	92	92
178231	piece	125	125

A37

Center jaws MBA


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
161833 ▲	piece	92	92	32	30
162632	piece	125	125	40	40

C15

Hand crank HKU, with octagon socket


Item no.	Contents of delivery	Size	Octagon	Key-width SW	L
009153	piece	92	17	Octagon	160
009154	piece	125	19	Octagon	200

Accessories RKD-M

A37

Single clamp SPE, for mounting vices on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw



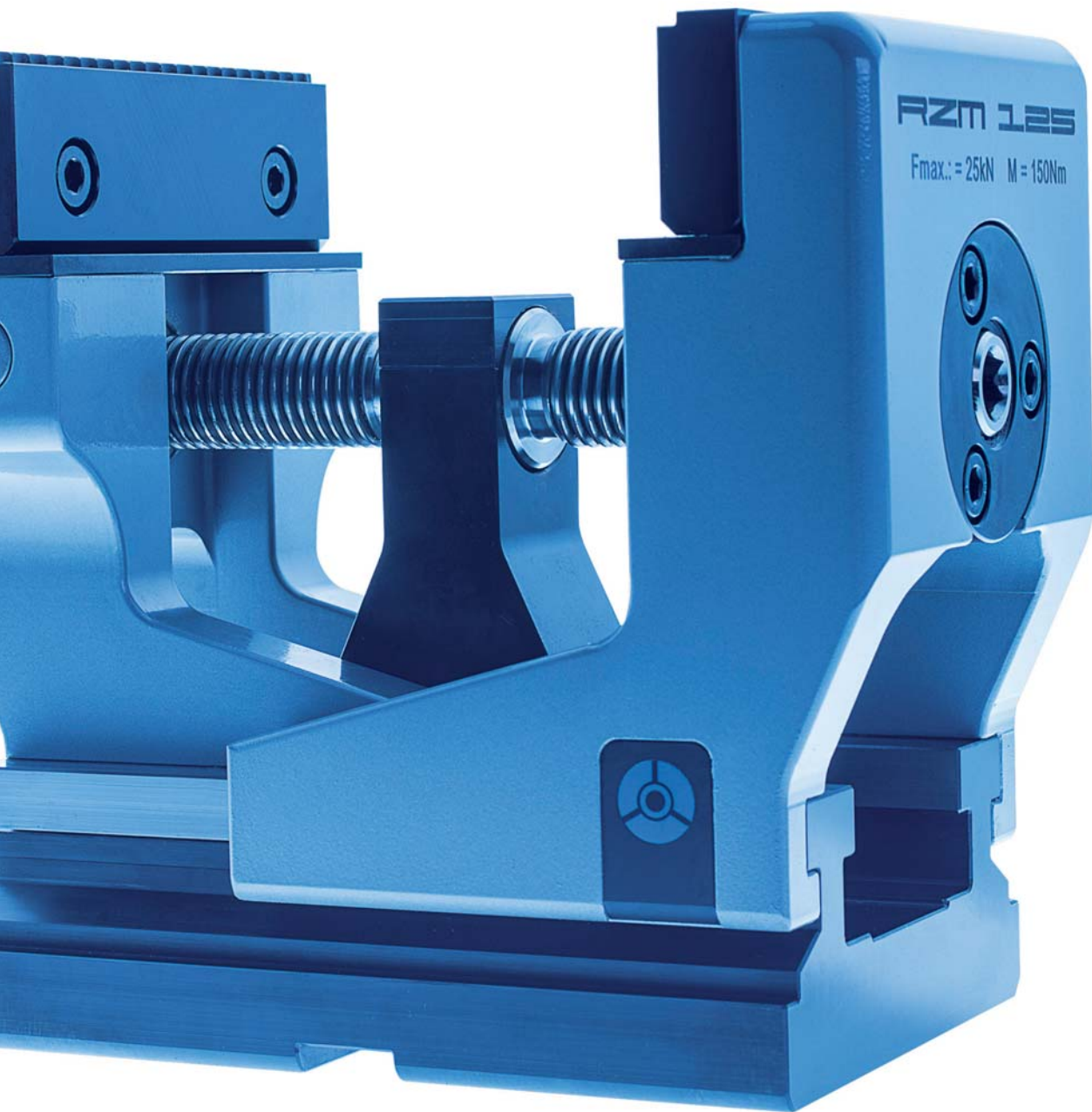
Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

A26

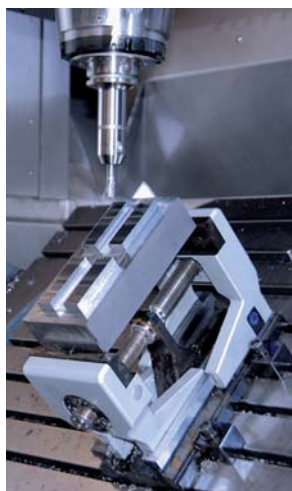
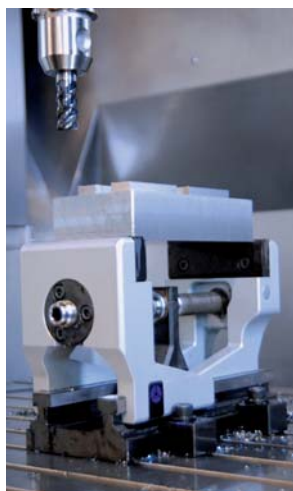
Torque wrench



Item no.	Torque Nm	Length mm	Output	Working accuracy
10004116	20-120	435	12,7=1/2"	3%
10004117	60-320	659	12,7=1/2"	3%



IDEAL FOR 5-AXIS MACHINING



Without additional foundations or special jaws, the RZM centric vice holds the workpiece securely – and does this with a minimal interference contour. The clamping spindle is located very close to the workpiece, creating an effective force flow and providing an extremely rigid clamping. The patented guide system of the jaws makes a very large clamping range possible.



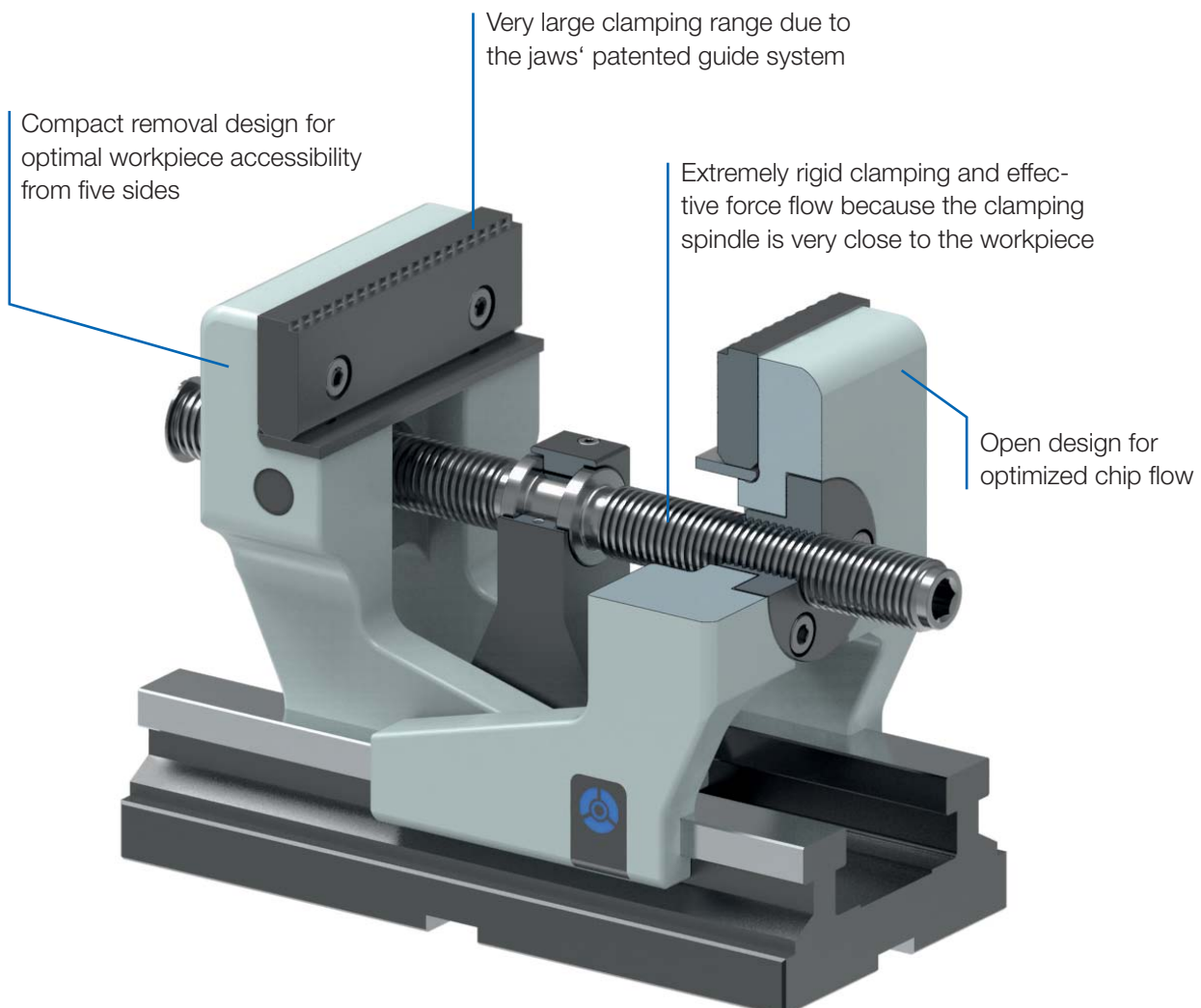
Video RZM

NC-COMPACT SELF CENTERING VICES

Thanks to its compact and robust design, the NC-compact self centering vices from RÖHM have a minimal interference contour, enabling optimal workpiece accessibility in 5-axis machining. Two movable clamping jaws ensure a constant clamping force, high repeatability and large clamping stroke.

ADVANTAGES AT A GLANCE

- ⊕ Ideal for 5-axis machining due to its minimal collision contour
- ⊕ Hardened and ground on all sides for long service life
- ⊕ Constant clamping force and high repeatability



RZM - central, without power transmitter



APPLICATION

Optimized for 5-axis machining.

TYPE

Clamping system mechanical without power transmitter, manually operated.

Centric clamping with two moving jaws.

CUSTOMER BENEFITS

- Ideal guidance characteristics of the jaws thanks to patented guidance system
- Very large clamping stroke
- Open design for optimized chip flow, which permits easy cleaning, even after heavy duty machining
- Constant clamping force for every clamping operation and high clamping repeatability when a torque wrench is used
- Optimally suitable for use of SKB clawed jaws. These top jaws can securely clamp raw and sawed parts with a max. strength of up to 900 N/mm² to a cutting depth of 2.5 mm

TECHNICAL FEATURES

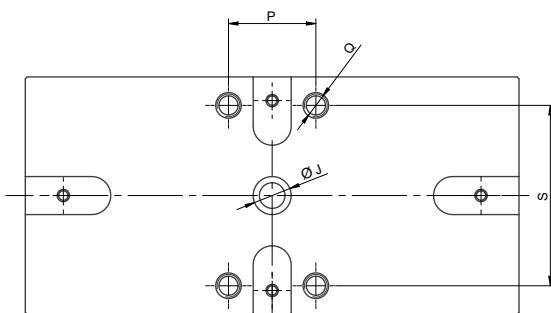
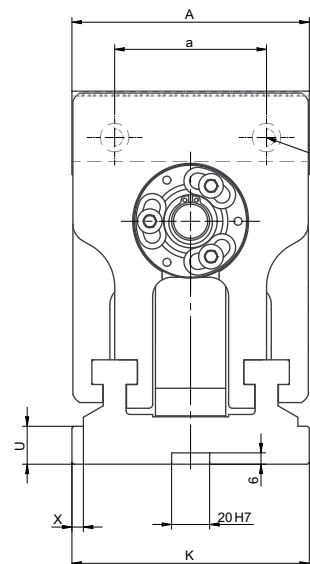
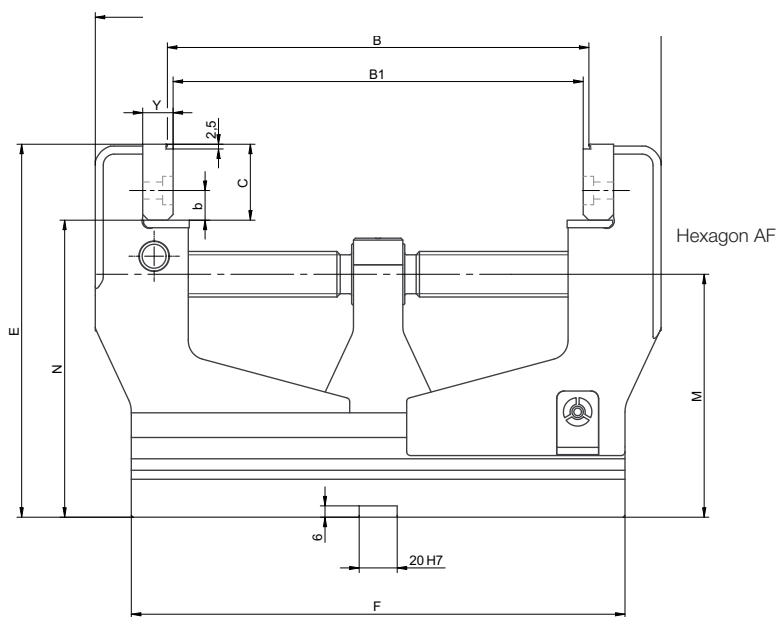
- Steel basic body hardened and ground
- Highly positioned clamping jaw
- Top spindle lying near the clamping jaws for optimal force transfer
- Long jaw guide and compact design
- Including SKB clawed jaws
- Clamping repeatability 0.02 mm

RZM = RÖHM, central, manual

A32
RZM, with SKB clawed jaws

Id.-Nr.	182230	182231	178910	178911
Jaw width A mm	92	92	125	125
Design	long design	short design	long design	short design
B min.	24	24	23	23
B max.	160	100	222	142
B1 mm	18-154	18-94	17-216	17-136
C mm	32	32	40	40
D mm	230	170	298	218
E mm	174	174	196,5	196,5
F mm	200	200	260	180
Ø J x depth mm	Ø20 ^{H7} /6	Ø20 ^{H7} /6	Ø20 ^{H7} /6	Ø20 ^{H7} /6
K mm	94	94	125	125
M mm	120	120	128	128
N mm	142	142	156,5	156,5
U mm	20	20	20	20
X mm	6	6	6	6
Hexagon AF	10	10	12	12
Clamping force kN	20	20	25	25
Tightening torque Nm			150	150
Weight kg	11,7	11,5	20,3	17,4

RZM - central, without power transmitter



Accessories RZM

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661 ▲	set	92	92	32	14
166667	set	125	125	40	16

Including fixing screws

A37

Claw jaws SKB with fine step, 2.5 mm clamping depth


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166514	set	92	92	32	14
166520	set	125	125	40	16

Including fixing screws

A37

Normal jaw SGN, one side smooth, one side grooved, both sides ground


Item no.	Contents of delivery	Size	Width mm	Height mm
152752	piece	92	92	31,6
158897	set	125	125	39,7

Including fixing screws

A37

Normal jaw finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved


Item no.	Contents of delivery	Size	Width mm	Height mm
163223	set	92	92	32
163225	set	125	125	39,7

Including fixing screws

A37

V-jaw PB, horizontal and vertical


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm	Height prism mm	Chuckling capacity mm	
							horizontal	vertical
162365 ▲	set	92	92	32	16	19,5	12-36	12-36
158641	set	125	125	40	20	24	15-40	18-60

Accessories RZM

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground


Item no.	Contents of delivery	Size	Width mm	Height mm
150739 ▲	piece	92	113	31,6
150740 ▲	piece	125	135	39,6

Including fixing screws

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support


Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
317259	set	92	110	31,8	3-12	5-32
317260	set	125	135	39,8	3-13	6-40

Including fixing screws

A37

Spindle, for shortening the clamping range of the long RZM version


Item no.	Contents of delivery	Size	Length mm	Diameter mm
178958	piece	125	218	24
182233	piece	92	168	24

A37

Single clamp SPE, for mounting vices on end and on the base


Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw


Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

A26

Torque wrench


Item no.	Torque Nm	Length mm	Output	Working accuracy
10004116	20-120	435	12,7=1/2"	3%
10004117	60-320	659	12,7=1/2"	3%

RKZ-M - central, without power transmitter



APPLICATION

Optimized for 5-axis machining.

TYPE

Clamping system mechanical without power transmitter, manually operated.

Centric clamping with two moving jaws.

CUSTOMER BENEFITS

- ③ Short, compact design
- ③ Large clamping stroke
- ③ Constant clamping force for every clamping operation and high clamping repeatability when a torque wrench is used
- ③ Clamping accuracy at the centre: ± 0.02 - clamping repeatability: 0.01

TECHNICAL FEATURES

- Steel basic body as well as all guides hardened and ground on all sides
- Standard-equipped with stepped top jaws

RKZ-M = RÖHM, compact, central, manual

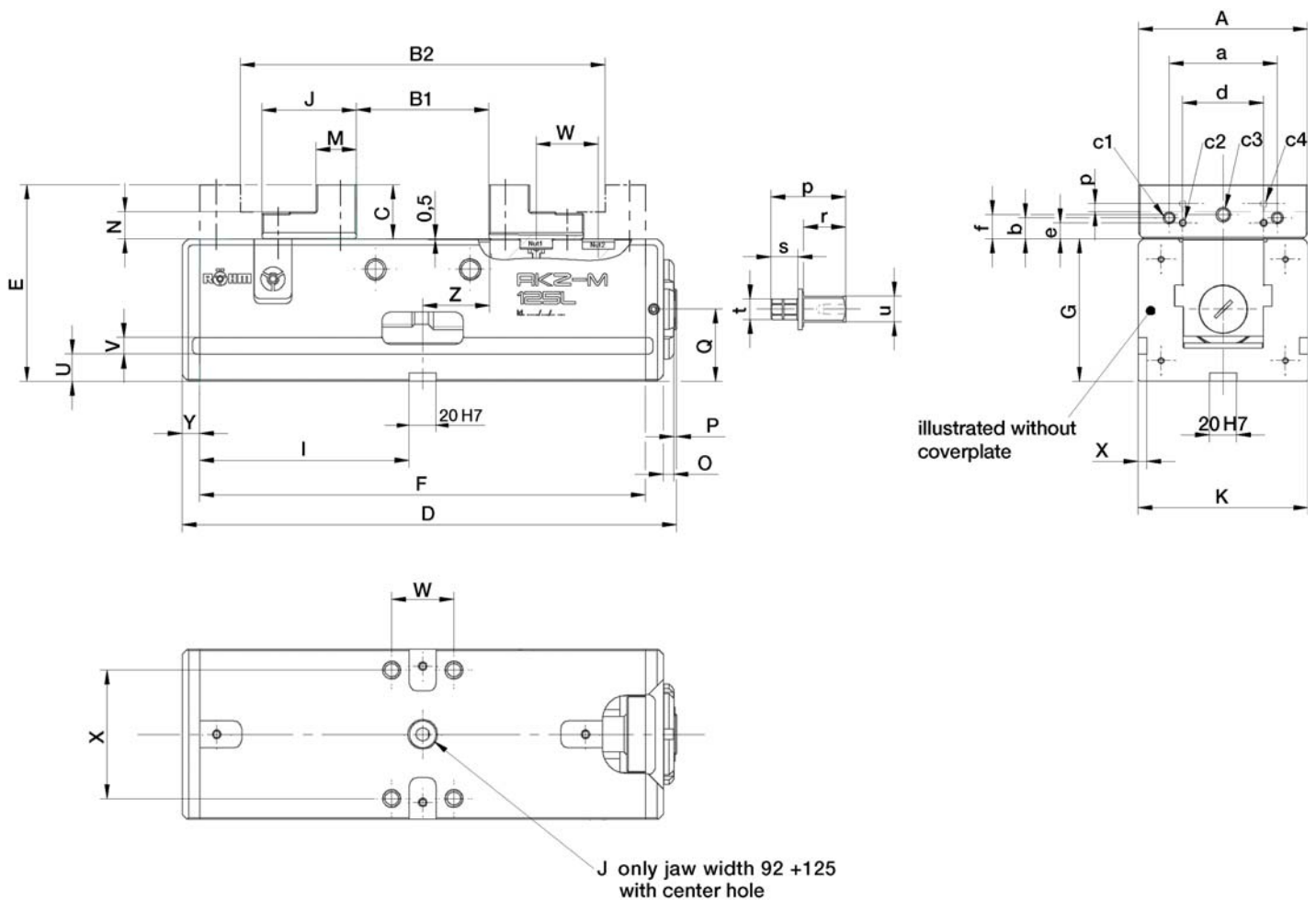
A32

RKZ-M, with stepped jaws

Id.-Nr.	180190 ▲	180191 ▲	180192 ▲	180193 ¹⁾ ▲
Jaw width A mm	50	70	92	125
B1 slot 1 mm	0-39	0 - 58	0 - 76	0 - 97
B1 slot 2 mm	36-75	48-106	70-146	92-189
B2 slot 1 mm	37-75	48-105	78-138	81-177
B2 slot 2 mm	72-111	95-153	132-208	172-269
C mm	20	25	32	40
Dmax mm	167	219	295	366
E mm	75	95	117	145
F mm	140	190	260	330
G ± 0.02 mm	55	70	85	105
J mm	32	41	56	70
K mm	52	72	94	126
M mm	14	17,5	25	30
N ± 0.01 mm	10	12	16	20
O mm	10	10	13	13
P mm	1	1	2	2
Q mm	31	40	41,5	53
U mm	15	20	20	20
V mm	12	12	12	12
W mm	18	24	35	46
Y mm	10	10	12	13
Z mm	20,5	30	39	49,5
a mm	-	-	63	80
b mm	-	-	13,6	15,6
c1	-	-	M6x10	M8x14
c2	M 4 x 8	M 5 x 8	M5x8	M5x8
c3	-	-	M10x16	M10x18
c4	M3x6	M4x8	M5x8	M5x8
d mm	26	37	48	60
e mm	5	6	8	12
f mm	-	-	14	18
l mm	60	85	120	155
o mm	32	52	55	55
p mm	3,5	4,5	6	6
q mm	38	52	55	55
r mm	20	30	32	32
s mm	15	19	20	20
t mm	6 kt-SW 8	6 kt-SW 10	6 kt-SW 14	6 kt-SW 14
u mm	4 kt-SW 12	4 kt-SW 14	4 kt-SW 19	4 kt-SW 19
Ø J x depth mm	-	-	Ø20H7/8	Ø20H7/8
Clamping force kN	10	15	20	25
Weight kg	3,5	7	18	32,5

¹⁾ With enlarged stepped-jaws

RKZ-M - central, without power transmitter



Accessories RKZ-M

A37

Stepped jaws SB, reversible, with fixing screws

Item no.	Contents of delivery	Size	Width mm	Height mm
164864 ▲	set	50	50	20
164844 ▲	set	70	70	25
161831 ▲	set	92	92	32
162631	set	125	125	40



A37

Raised stepped jaws ESB

Item no.	Contents of delivery	Size	Width mm	Height mm
164399 ▲	set	125	125	60



A37

Double V-jaw, reversible, with fine step, for jaw dimensions of the double V-jaws please see page 4068!

Item no.	Contents of delivery	Size	Width mm	Height mm	Length mm	Height prism mm	Size prism mm	Clamping dia. D1 mm		Clamping dia. D2 mm	
								slot 1	slot 2	slot 1	slot 2
169754 ▲	set	92	92	64,5	67	39	41,3	12-36	-	30-75*	-
169756 ▲	set	125	125	84,5	86	54	56	15-40	-	30-92**	89-105



A37

Standard jaws SGN, one side smooth, one side grooved, hardened and ground

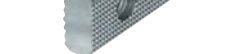
Item no.	Contents of delivery	Size	Width mm	Height mm
165161 ▲	set	50	50	19,6
165163	set	70	70	24,6
162363	set	92	92	32
158897	set	125	125	39,7



A37

Standard jaws finely checkered SGNf, one side finely checkered, one side grooved, hardened and ground

Item no.	Contents of delivery	Size	Width mm	Height mm
165165 ▲	set	50	50	19,6
165167	set	70	70	24,6
163223	set	92	92	32
163225	set	125	125	39,7



Accessories RKZ-M

A37

V-jaw PB, horizontal and vertical


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm	Height prism mm	Chuckling capacity mm	
							horizontal	vertical
165169	set	50	50	20	10	12	6-16	6-16
165171	set	70	70	25	12	14	8-24	8-24
162365 ▲	set	92	92	32	16	19,5	12-36	12-36
158641	set	125	125	40	20	24	15-40	18-60

A37

Claw jaws SKB with fine step, 2.5 mm clamping depth


Item no.	Contents of delivery	Width mm	Height mm	Thickness mm
166514	set	92	32	14
166520	set	125	40	16

Including fixing screws

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm


Item no.	Contents of delivery	Width mm	Height mm	Thickness mm
166661 ▲	set	92	32	14
166667	set	125	40	16

Including fixing screws

C15

Hand crank HKU, with octagon socket


Item no.	Contents of delivery	Size	Octagon	Key-width SW	L
009150	piece	50	12	Octagon	80
009152	piece	70	14	Octagon	125
382112 ¹⁾	piece	92	19	Square	160
009154	piece	125	19	Octagon	200

A37

Drive adapter ATA


Item no.	Contents of delivery	Size	Square	Hexagon
164971 ▲	piece	50	12	8
164842 ▲	piece	70	14	10
164625	piece	92/125	19	14

Accessories RKZ-M

A37

Single clamp SPE, for mounting vices on end and on the base


Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw


Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

A26

Torque wrench


Item no.	Torque Nm	Length mm	Output	Working accuracy
10004116	20-120	435	12,7=1/2"	3%
10004117	60-320	659	12,7=1/2"	3%

A37

Drive adapter ATA


Item no.	Contents of delivery	Size	Square
168721	piece	92	12-1/2"
161103	piece	125	14-1/2"
161730	piece	125	19-1/2"

General accessories - Cliparc



Fixed during machining and when released!
The precision support rails with the Cliparc-System remain in their original position during the machining and releasing process. No more time intensive repositioning necessary. Insert the Cliparc clamps into the rails and snap them into the vice. No tools necessary.

Technical features:

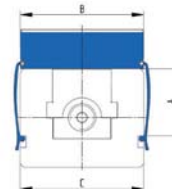
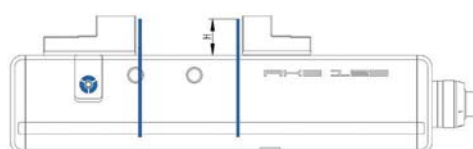
- Different height steppings
- Width only 3 mm (from size 160: 4 mm width)
- Rim near through holes can be machined without step jaws or problems due the slim precision support rails.
- Precision and quality parallelism better than 0.005 mm
- Quick cleaning

Contents of delivery: Set with 10 different pair of rails and 4 clamps in wooden box

Support rails Cliparc

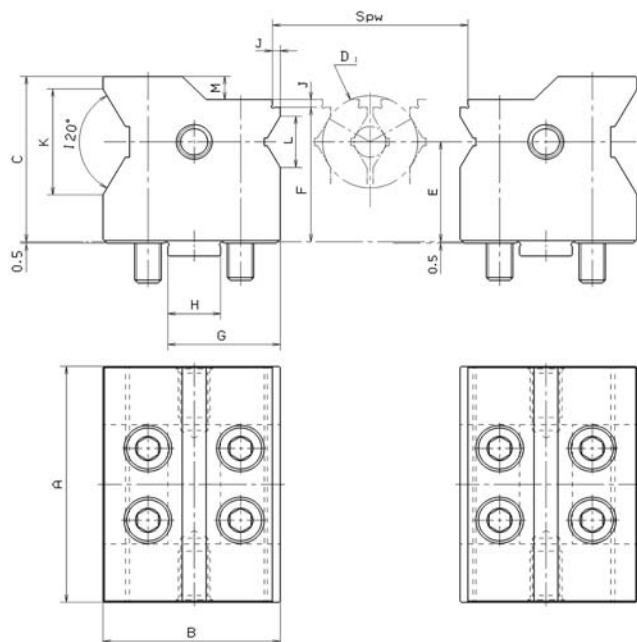


Item no.	1269621	1269622	1269623	1295913	1295914
For	RKE 92 / RKE-M 92	RKE 125 / RKE-M 125 / RKE-LV 125	RKE 160/200 / RKE-M 160/200	RKD-M, RKZ-M 92	RKD-M, RKZ-M 125
Web height	A 48	68	83	53	73
Jaw width	B 92	125	160	92	125
Rail height	H 10/16/18/20/23/25/26/27/28/29	10/15/20/25/28/30/33/35/36/37	10/15/20/25/30/35/40/43/45/47	10/16/18/20/23/25/26/27/28/29	10/15/20/25/28/30/33/35/36/37
Guidance width	C 94	126	162	94	126
Spare clamp (Set = 4 pieces)	1269624	1269625	1269626	1295916	1295917



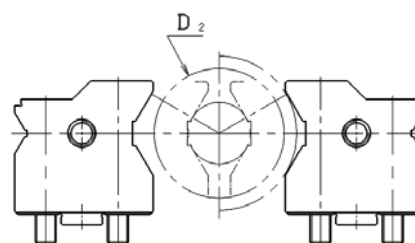
Jaw dimensions

Double V-jaw, reversible, with fine step



Item no.	169754	169756
Content of delivery	set	set
Size A	92	125
B	67	86
C	64,5	84,5
D1	Nut 1 12-36	15-40
	Nut 2 -	-
D2	Nut 1 30-75*	30-92**
	Nut 2 -	89-105
E	39	54
F	52,5	69,5
G	42,5	51,5
H	20	24
J	3	3
K	41,3	56
L	20	22,6
M	9	12
Clamping range ¹⁾	7-143	7-186

* Ø 63-75 side loading only ** Ø 72-92 side loading only ¹⁾ Clamping range example RKZ-M



General accessories

A37

Dual clamp DSP for mutual support in the case of front-sided set-up, in pairs


Item no.	Contents of delivery
149125 ▲	piece

A37

Single clamp SPE, for mounting vices on end and on the base


Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw


Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

A37

Work locator WSA, universally adjustable, for screwing onto the NC-compact vice or machine vice, connecting thread M12


Item no.	Contents of delivery
320400	piece

A37

Work locator WSA, universally adjustable, for fastening to the machine table (size 14 T-slot) or for screwing onto the NC-compact vice / machine vice (M12)


Item no.	Contents of delivery
320401	piece

A37

Precision vice locator PSA, universally adjustable, for screwing onto the NC-compact vice or machine vice, connecting thread M12


Item no.	Contents of delivery
681192 ▲	piece

Clamping jaws

Clamping jaws to screw onto stepped jaws and standard top jaw

Clamping jaws compatible with NC-compact vices, NC-power vices and machine vices with the same jaw width

APPLICATION

Depending on the application and the workpiece to be machined, the clamping jaws shown on the right can be screwed onto the stepped jaw and standard top jaw.

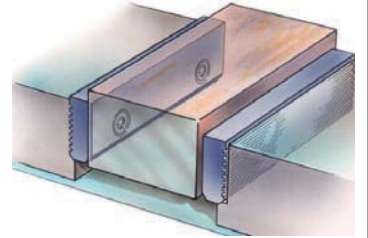
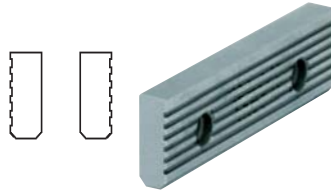
General accessories
NC Compact Vices

With stepped jaws¹⁾

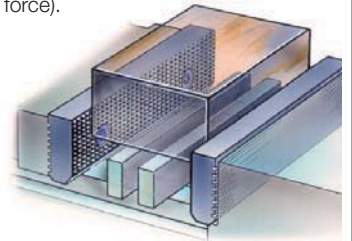
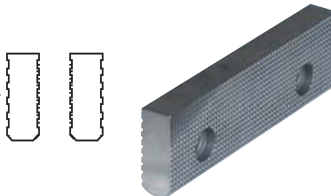


Standard top jaws¹⁾

SGN normal jaw – reversible, one side smooth, one side longitudinally
Serrated for precise clamping of parallel parts with delicate clamping surfaces.



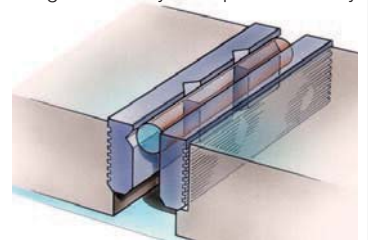
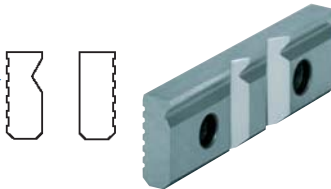
SGN normal jaw, finely checkered– reversible, one side finely checkered, one side longitudinally
Serrated to increase the specific surface pressure (high holding force).



SPR prism jaw

For precise clamping of round material in vertical and horizontal position.

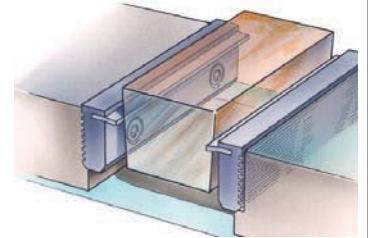
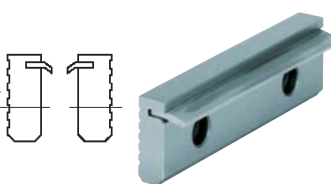
The jaws are to be used in combination with a normal jaw, since a geometrically clear position is only achieved with a three-point clamping.



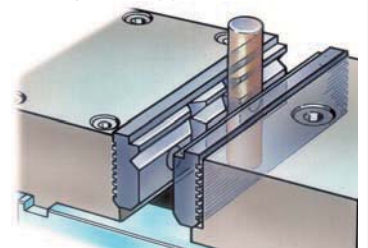
Pull-down jaws with SNF

Spring leaf are especially suitable for clamping raw parts.

The leaf springs are pressed by the clamping force downwards, thereby causing pull-down force.



SBO prism and normal jaw – non-hardened, with prism and workpiece support



¹⁾ not suitable for RZM

Quick change clamping inserts

Draw-down base jaws with permanent magnet and quick changeable clamping inserts

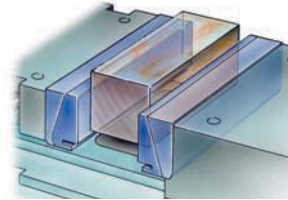
Clamping jaw comparable to the NC-compact vice and machine vices with the same jaw width



RNG base jaw with permanent magnet
for taking up of quick changeable draw-down clamping inserts.
For screwing on at the fixed and movable jaws.

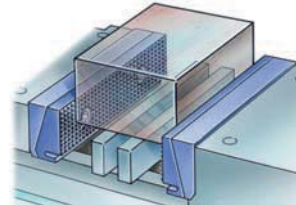
RNS standard insert

For machined workpieces without angle error.



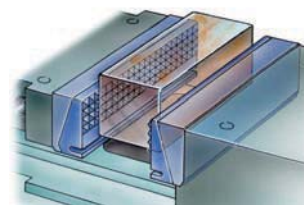
RNS standard insert, finely checkered

To increase the specific surface pressure (higher holding force).



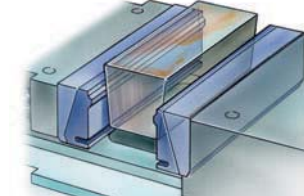
RNK claw insert

To increase the specific surface pressure (higher holding force).



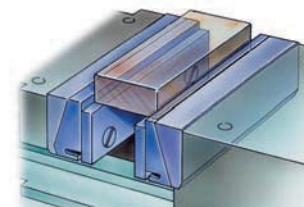
Insert with round RNR clamping base – line-shaped clamping base

For machined workpieces with and without angle error.

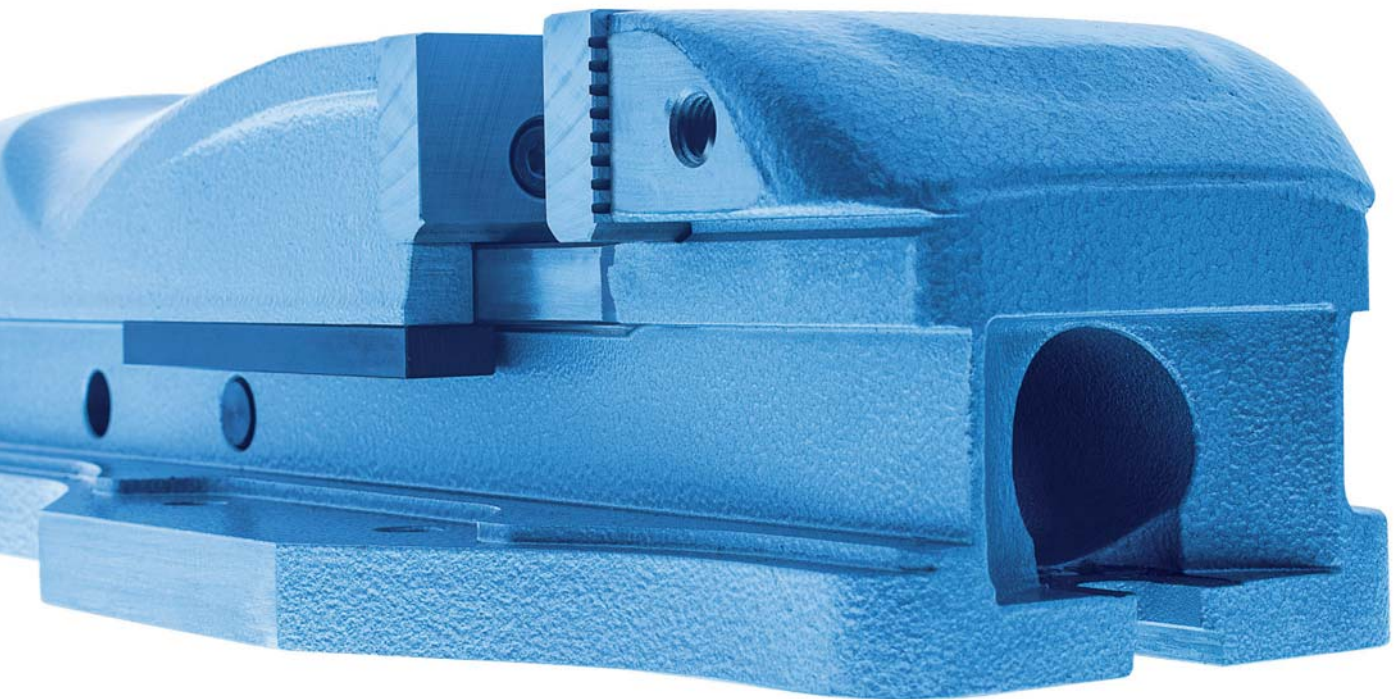


RWA workpiece support

For fastening to the standard inserts. For raising the height of the workpieces during the clamping process.



Other sizes and versions available upon request.



UNIVERSALLY USABLE AND PROVEN MANY TIMES OVER



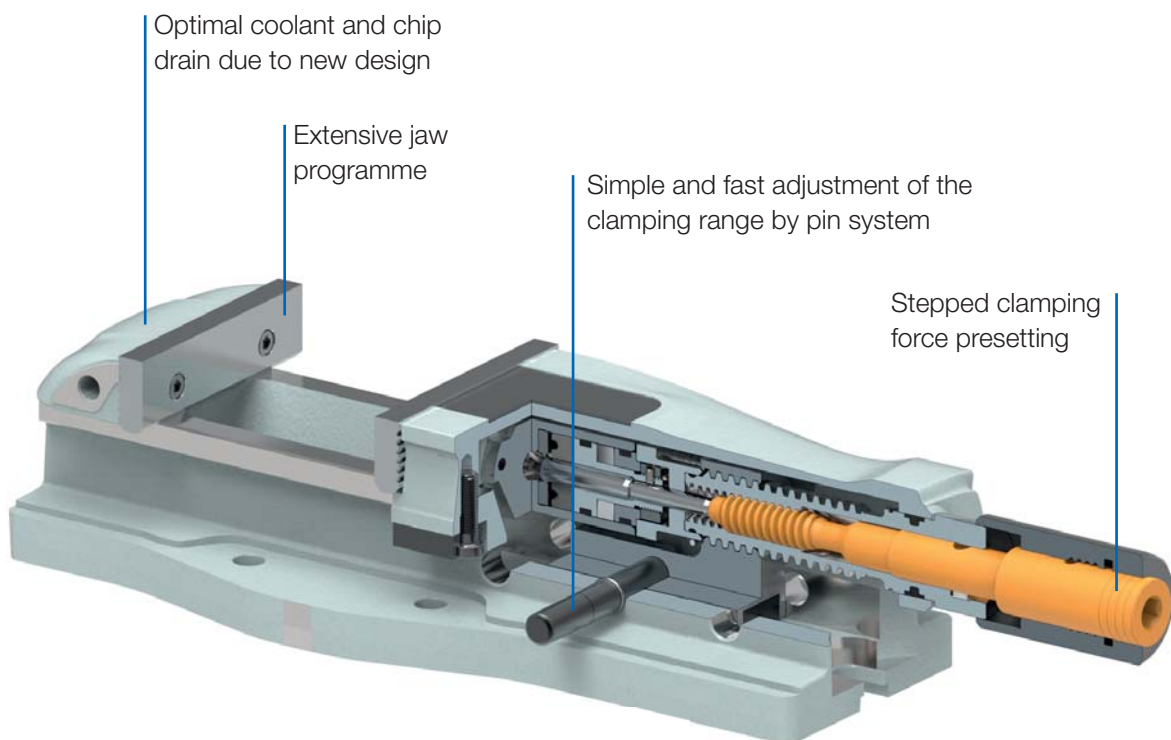
The RÖHM machine vice is suitable for universal application on milling machines and machining centers. The base is equipped with grooves to ensure a precise fastening on the machine table.

MACHINE VICES

RÖHM machine vices are ideally suited for universal use on milling machines and machining centers and feature impressively high reliability and long service lives. The clamping area above the pin system can be quickly and easily adjusted and the precise jaw guide enables great precision.

ADVANTAGES AT A GLANCE

- Universally usable and proven many times over for numerous machining processes
- Impressive reliability, service life and precision
- Fast and simple adjustment of the clamping range by pin system



RB-K - with power transmitter



APPLICATION

For universal use on milling machines and machining centers.

TYPE

Manual clamping system with power transmitter.

CUSTOMER BENEFITS

- ⊕ Stepped clamping force presetting
- ⊕ High precision thanks to precise jaw guides
- ⊕ Fast clamping range adjustment via bolt system
- ⊕ Optimal coolant and chip drain
- ⊕ High wear-resistance thanks to hardened jaw guides
- ⊕ Use without force amplification possible for sensitive clamping

TECHNICAL FEATURES

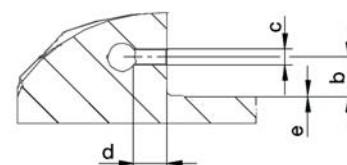
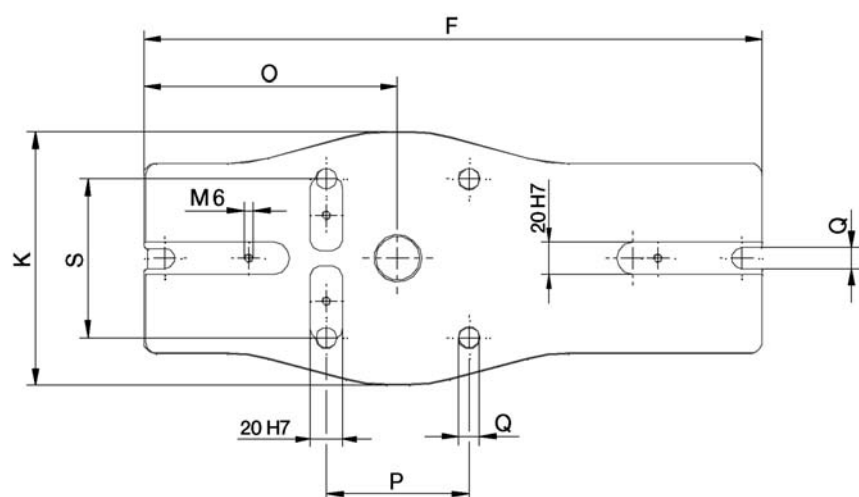
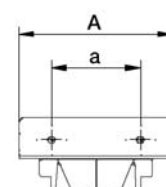
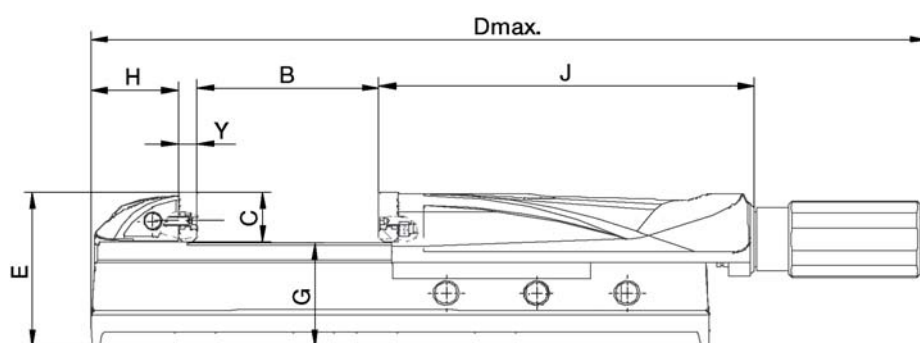
- Base with longitudinal and transversal groove for exact fixation on the machine table
- Use on rotary plate with graduation
- Set-up option with clamping claws
- Encapsulated spindle

A10

RB-K, with SGN normal jaws and hand crank

Id.-Nr.	179075	179076	179077	179078	179079
Size	1	2	3	4	5
Jaw width A mm	92	113	135	160	200
Clamping capacity B mm	100	170	220	310	350
C mm	31,6	31,6	39,6	49,6	66,6
D mm	493	583	679	817	1022
E mm	95	97	112	133	171
F mm	320	390	468	574	685
G±0,02 mm	63	65,5	72,5	83,5	104,5
H mm	54	55	70	80	90
J mm	218	236,5	262	298	375
K mm	160	160	200	240	280
O mm	119	160	180	220	230
P mm	90	90	90	90	160
Q mm	13	13	13	17	21
S mm	100	100	135	180	180
Y mm	12	12	16	16	20
a mm	63	63	80	100	140
b mm	13,6	13,6	15,6	19,6	25
c	M6	M6	M8	M8	M10
d mm	12	12	13	13	16
Clamping force kN	25	30	40	50	100
Weight kg	15,5	24	39	60	112

RB-K - with power transmitter



Accessories RB-K

A37

Draw-down jaws RNG, with two permanent magnets

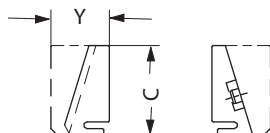

Item no.	Contents of delivery	Size	Width mm	Height mm
155237 ▲	set	1	92	32
155238	set	2	110	32
155239 ▲	set	3	135	40
155240	set	4	160	50
155241	set	5	200	67

Including fixing screws

A37

Standard insert RNS, held by two permanent magnets

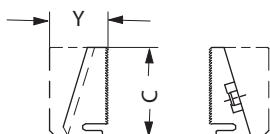

Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242 ▲	set	1	92	32	21
155243	set	2	110	32	21
155244 ▲	set	3	135	40	26
155245 ▲	set	4	160	50	30
155246	set	5	200	67	36



A37

Standard insert finely checkered RNSf, held by two permanent magnets

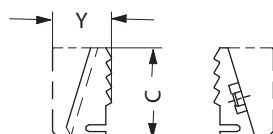

Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163270	set	1	92	32	21
163271	set	2	110	32	21
163272	set	3	135	40	26
163273 ▲	set	4	160	50	30
163274	set	5	200	67	36



A37

Claw insert RNK, held by two permanent magnets


Item no.	Contents of delivery	Size	Width mm	C mm	Y mm	a mm
155247	set	1	92	32	21	
155248	set	2	110	32	21	
155249	set	3	135	40	26	80
155250 ▲	set	4	160	50	30	
155251	set	5	200	67	36	



Accessories RB-K

A37

Insert with round clamping shoulder RNR, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155252 ▲	set	1	92	32	21
155253 ▲	set	2	110	32	21
155254 ▲	set	3	135	40	26
155255 ▲	set	4	160	50	30
155256 ▲	set	5	200	67	36

A37

Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
134826 ▲	set	2	110	32
134830 ▲	set	3	135	40
134834 ▲	set	4	160	50
134854 ▲	set	5	200	67

A37

Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors



Item no.	Contents of delivery	Size	Width mm	Height mm
077097 ▲	set	2	110	38
077098 ▲	set	3	135	46
077099 ▲	set	4	160	56
141791 ▲	set	5	200	68

A37

Draw-down jaws SNF, with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
077104 ▲	set	2	113	31,6
077105 ▲	set	3	135	39,6
077106 ▲	set	4	160	49,6
141794 ▲	set	5	200	64,6

Including fixing screws

A37

Normal jaw SGN, one side smooth, one side grooved, both sides ground



Item no.	Contents of delivery	Size	Width mm	Height mm
152752	piece	1	92	31,6
152753	piece	2	113	31,6
152754	piece	3	135	39,6
152755	piece	4	160	49,6
152756	piece	5	200	64,6

Including fixing screws

Accessories RB-K

A37

Normal jaw finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved



Item no.	Contents of delivery	Size	Width mm	Height mm
163218 ▲	piece	1	92	31,6
156195	piece	2	113	31,6
156196	piece	3	135	39,6
156197	piece	4	160	49,6
156199 ▲	piece	5	200	64,6

Including fixing screws

A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
128770	piece	1	92	31,6	3-13	5-32
082362	piece	2	113	31,6	3-13	5-32
082363	piece	3	135	39,6	4-20	6-40
082364	piece	4	160	49,6	5-29	7-48
129734 ▲	piece	5	200	64,6	6-37	8-56

Including fixing screws

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
150739 ▲	piece	2	113	31,6
150740 ▲	piece	3	135	39,6
150741 ▲	piece	4	160	49,6

Including fixing screws

A37

Floating jaw horizontal PEB, for clamping non-parallel workpieces



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
156190 ▲	piece	2	113	32	36
156191	piece	3	135	40	40
156192 ▲	piece	4	160	50	45

A37

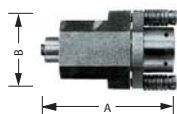
Hand crank, turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A	L
134593	piece	1/2	12	48	80
134198	piece	3	12	60	90
134499	piece	4	12	117	90
134600	piece	5	14	104	160

Accessories RB-K

A37 Hydraulic unit HDE



Item no.	Contents of delivery	Size	A	B
094170	piece	1	102	56
226502	piece	2	109	62
226503	piece	3	114	70
226504	piece	4	115	70
226505	piece	5	147	98

A37 Spindle, complete



Item no.	Contents of delivery	Size	L
134185	piece	1	91
134186	piece	2	99
134187	piece	3	116
134188	piece	4	151
134189	piece	5	182

A37 Standard rotation plate DP, with fixing screws and T-slot nuts ground contact edge, graduation



Item no.	Size	External Ø mm	Height	Center Ø	Weight
082441	1/2	242	30	28	7,5
082442	3	280	30	28	11
082443	4	340	34	28	18

A37 Universal rotation plate DP, with fixing screws and T-slot nuts ground contact edge, graduation



Item no.	Size	External Ø mm	Height	Center Ø	Weight
090854 ▲	5	420	40	28	23

RBAW - with angle drive, with power transmitter

APPLICATION

For universal use on milling machines and machining centers.

TYPE

Clamping system mechanical-hydraulic with power transmitter, manually operated.

CUSTOMER BENEFITS

- ⊕ Horizontal, vertical and laterally clampable with height adjustment ± 0.02
- ⊕ Sturdy, maintenance-free spindle
- ⊕ Additional stepped jaws or special form jaws can be fastened to the surface of the stationary and moving jaw
- ⊕ Drive spindle is protected against dirt and chips
- ⊕ Large clamping range
- ⊕ Short version of moving jaw (made of steel) results in short design length, even for max. clamping width
- ⊕ With angle drive

TECHNICAL FEATURES

- Steel body with stationary clamping jaw
- Automatic reclamping in the hydraulic unit by means of built-in disc springs
- All wear parts, especially the jaw guides, are hardened and ground
- Robust flat-trajectory guide of moving jaw
- With normal jaws and hand crank



A27

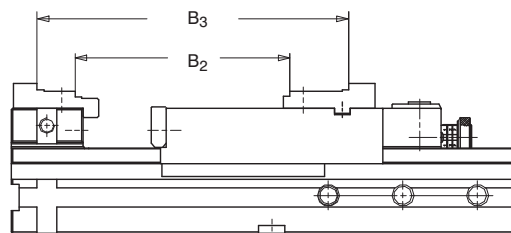
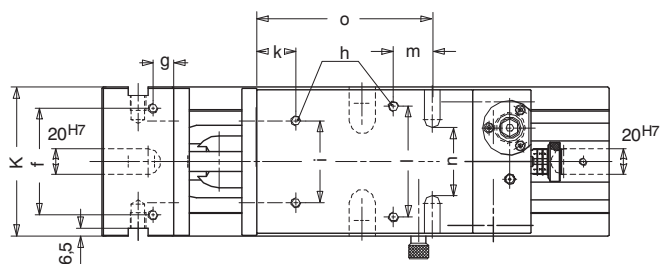
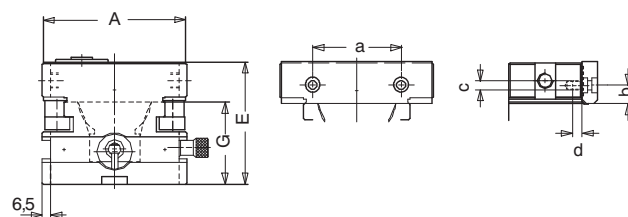
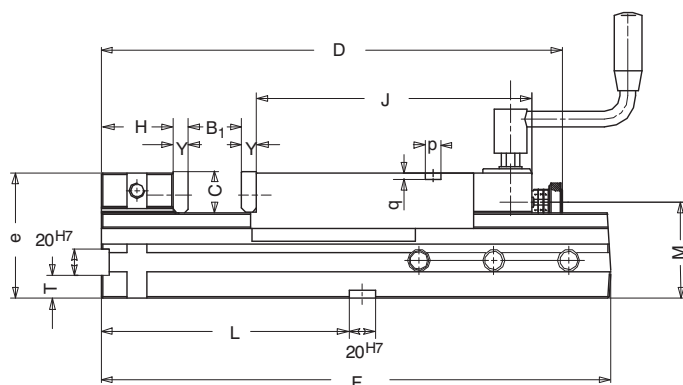
RBAW, with SGN normal jaws, hand crank and angle drive

Id.-Nr.	154763	154764	154765 ▲
Size	2	3	4
Jaw width A mm	113	135	160
B1 mm	0-175	0-225	0-310
B2 mm	125-300	138-363	146-454
B3 mm	199-374	220-445	248-556
C mm	31,6	39,6	49,6
Dmax mm	500	578	702
E $\pm 0,02$ mm	97,7	112,7	133,7
F mm	390	468	574
G $\pm 0,02$ mm	65,5	72,5	83,5
H $\pm 0,02$ mm	55	70	80
J mm	211	213	240
K $\pm 0,02$ mm	115	137	162
L $\pm 0,02$ mm	190	190	240
M mm	73,5	80,5	96
T $\pm 0,02$ mm	17,5	17,5	22,5
V $_{-0,01}$ mm	11,6	15,6	15,6
a mm	63	80	100
b mm	13,6	15,6	19,6
c mm	M6	M8	M8
d mm	12	13	13
e $\pm 0,02$ mm	96	111	132
f mm	82	80	100
g mm	16	30	30
h mm	M 8 x 14	M10x16	M12x20
i mm	63	80	100
k mm	30	30	30
l mm	85	105	120
m mm	30	35	35
n mm	52	70	96
o mm	135	135	142
pH7 mm	12	14	14
q mm	5	5	5
Clamping force kN	30	40	50
Weight kg	22	36	62

RBAW - with angle drive, with power transmitter



NC power vices RBAW



Accessories RBAW

A37

Draw-down jaws SNF, with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
077104 ▲	set	2	113	31,6
077105 ▲	set	3	135	39,6
077106 ▲	set	4	160	49,6

Including fixing screws

A37

Normal jaw SGN, one side smooth, one side grooved, both sides ground



Item no.	Contents of delivery	Size	Width mm	Height mm
152753	piece	2	113	31,6
152754	piece	3	135	39,6
152755	piece	4	160	49,6

Including fixing screws

A37

Normal jaw finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved



Item no.	Contents of delivery	Size	Width mm	Height mm
156195	piece	2	113	31,6
156196	piece	3	135	39,6
156197	piece	4	160	49,6

Including fixing screws

A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuck capacity mm	
					Horizontal	Vertical
082362	piece	2	113	31,6	3-13	5-32
082363	piece	3	135	39,6	4-20	6-40
082364	piece	4	160	49,6	5-29	7-48

Including fixing screws

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuck capacity mm	
					Horizontal	Vertical
317259	set	2	110	31,8	3-12	5-32
317260	set	3	135	39,8	3-13	6-40
317261	set	4	160	49,8	5-22	7-48

Including fixing screws

Accessories RBAW

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
150739 ▲	piece	2	113	31,6
150740 ▲	piece	3	135	39,6
150741 ▲	piece	4	160	49,6

Including fixing screws

A37

Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
134826 ▲	set	2	110	32
134830 ▲	set	3	135	40
134834 ▲	set	4	160	50

A37

Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors



Item no.	Contents of delivery	Size	Width mm	Height mm
077097 ▲	set	2	110	38
077098 ▲	set	3	135	46
077099 ▲	set	4	160	56

A37

Stepped top jaw ASB, for stationary jaw



Item no.	Contents of delivery	Size	Width mm	Height mm
153403 ▲	piece	2	113	19
153405 ▲	piece	3	135	22
153407 ▲	piece	4	160	25

A37

Stepped top jaw ASB, for movable jaw



Item no.	Contents of delivery	Size	Width mm	Height mm
153404 ▲	piece	2	113	19
153406 ▲	piece	3	135	22
153408	piece	4	160	25

A37

Floating jaw horizontal PEB, for clamping non-parallel workpieces



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
156190 ▲	piece	2	113	32	36
156191	piece	3	135	40	40
156192 ▲	piece	4	160	50	45

Accessories RBAW

A37

Hand crank, turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A	L
134499	piece	2/3/4	12	117	90

A37

Single clamp SPE, for mounting vices on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw



Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

General accessories

A37

Dual clamp DSP, for mutual support in the case of front-sided set-up, in pairs



Item no.	Contents of delivery
149125 ▲	piece

A37

Single clamp SPE, for mounting vices on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw



Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

A37

Work locator WSA, universally adjustable, for screwing onto the NC-compact vice or machine vice, connecting thread M12



Item no.	Contents of delivery
320400	piece

A37

Work locator WSA, universally adjustable, for fastening to the machine table (size 14 T-slot) or for screwing onto the NC-compact vice / machine vice (M12)



Item no.	Contents of delivery
320401	piece

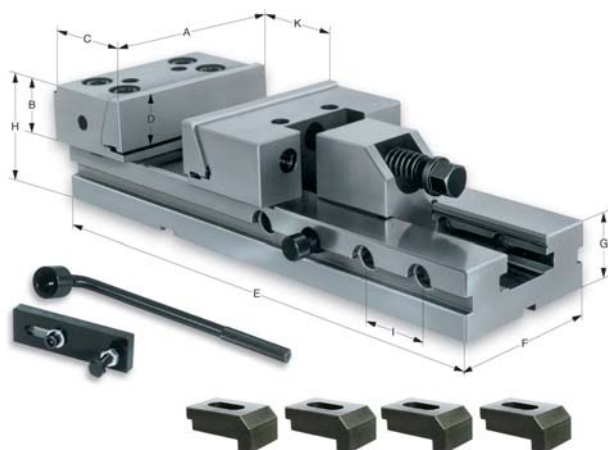
A37

Precision vice locator PSA, universally adjustable, for screwing onto the NC-compact vice or machine vice, connecting thread M12



Item no.	Contents of delivery
681192 ▲	piece

MSR - with draw-down jaws



APPLICATION

For universal use on milling machines and machining centers.

TYPE

Clamping system mechanical without power transmitter, manually operated.

CUSTOMER BENEFITS

- ③ Optimal price/performance ratio
- ③ Fast clamping range adjustment via bolt system

TECHNICAL FEATURES

- Scope of delivery, complete with clamping wrench, workpiece stop and four clamping claws
- With draw-down jaws
- Hardened steel body (60 HRC)
- Clamping repeatability 0.02 mm

A11

MSR, with draw-down jaws

Item no.	Jaw width A mm	B mm	C mm	D mm	E mm	E max mm	F mm	G mm	H mm	I mm	K mm	Clamping force kN	Weight kg
161828	125	40	78	32	345	401	95	40	80	50	150	30	12,7
161827	150	50	90	40	420	487	125	50	100	50	200	50	25,6
161826	150	50	90	40	520	587	125	50	100	50	300	50	29,5
161825	175	60	97	43	655	701	145	58	118	50	400	60	51,2

A37

Clamping jaw, for movable jaw



Item no.	Contents of delivery	Size	Width mm	Height mm
006589	piece	125	125	38
006616	piece	150	150	48
006684	piece	175	171	58

A37

Clamping jaw, for fixed jaw



Item no.	Contents of delivery	Size	Width mm	Height mm
006590	piece	125	120	38
006617	piece	150	146	48
006687	piece	175	171	58

A37

Step jaw SB, for stationary jaw with jaw steps 5x5 mm



Item no.	Contents of delivery	Size	Width mm	Height mm
1043226 ▲	piece	125	120	38
1043228	piece	150	146	48
1043230 ▲	piece	175	171	58

A37

Step jaw SB, for movable jaw with jaw steps 5x5 mm



Item no.	Contents of delivery	Size	Width mm	Height mm
1043227	piece	125	120	38
1043229	piece	150	146	48
1043231 ▲	piece	175	171	58

Accessories MSR

A37

V-jaw PB with jaw steps, for movable jaw



Item no.	Contents of delivery	Size	Width mm	Height mm
1043409	piece	125	120	38
1043410	piece	150	146	48
1043411 ▲	piece	175	171	58

A37

Inclinde jaw WB, for circular parts for movable jaw



Item no.	Contents of delivery	Size	Width mm	Height mm
1043412 ▲	piece	125	120	38
1043413 ▲	piece	150	146	48
1043414 ▲	piece	175	171	58

A37

Single clamp SPE



Item no.	Contents of delivery	Size	T-slot	Thread
163329	piece	125	12	M10x45
163330	piece	125	14	M12x50
163331	piece	125	16	M12x50
163332	piece	125	18	M16x50
163333 ▲	piece	150/175	12	M10x50
163334 ▲	piece	150/175	14	M12x55
163335	piece	150/175	16	M12x55
163336	piece	150/175	18	M16x60

A37

Rotation plate DP



Item no.	Size	External Ø mm	Height
476867 ▲	125	226	23
476868 ▲	150	290	28
476870 ▲	175	320	28

RS - without power transmitter



APPLICATION

For conventional machine tools.

TYPE

Clamping system mechanical without power transmitter, manually operated.

CUSTOMER BENEFITS

- ⊕ Optimal price/performance ratio
- ⊕ Entire clamping range can be bridged over by turning the handcrank
- ⊕ Spindle is protected from dirt and chips
- ⊕ Extensive assortment of jaws

TECHNICAL FEATURES

- Made of special cast iron for versatile use
- Long guidance of moving jaw
- Force transfer by means of threaded spindle
- With normal jaws SGN and handcrank
- Use on rotary plate with graduation

A11

RS, with SGN normal jaws and hand crank

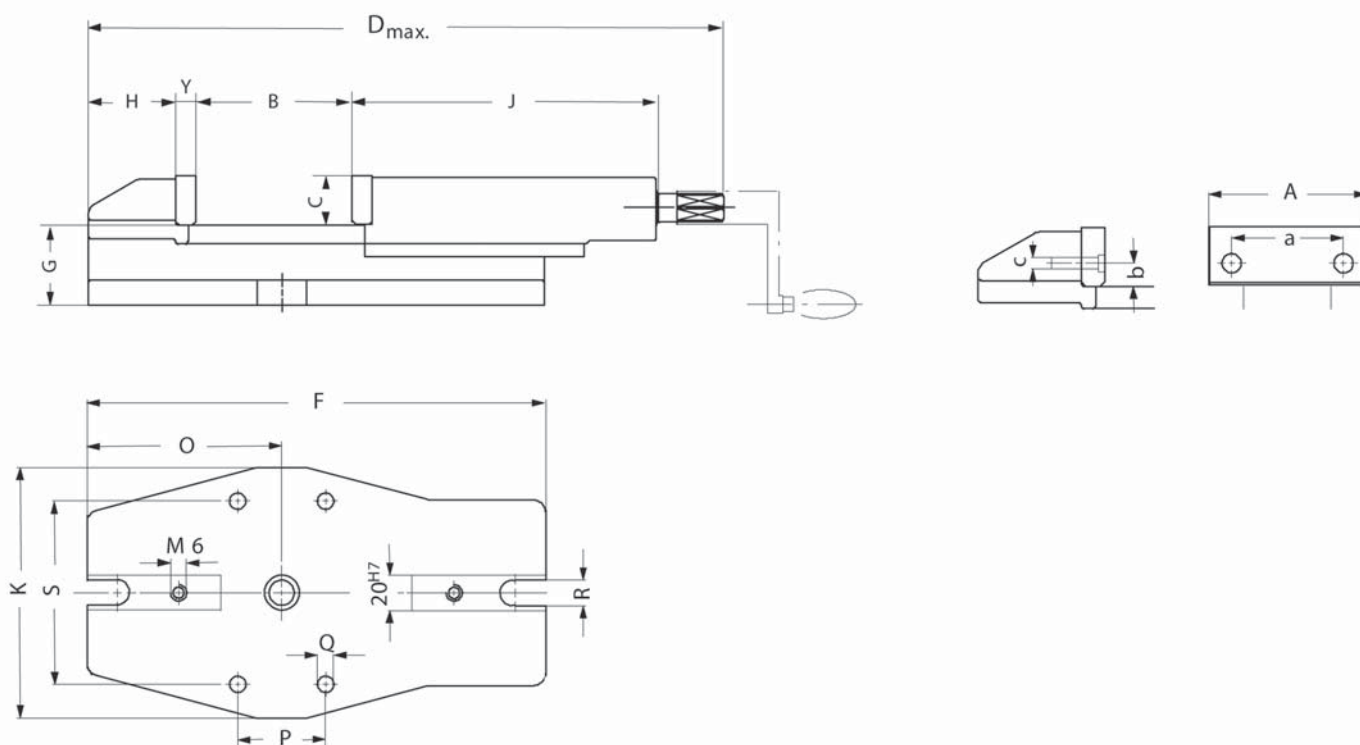
RS machine vice

Id.-Nr.	128031	128032	128033	128034	111648
Size	1	2	3	4	5
Jaw width A mm	92	113	135	160	200
B mm	85	105	125	145	185
C mm	31,6	31,6	39,6	49,6	62,6
D mm	362	423	510	575	675
F mm	260	300	365	410	460
G mm	48	58	64	70	82
H mm	50	55	70	80	90
J mm	174	200	242	273	322
K mm	160	160	200	240	280
O mm	115	125	155	175	200
P mm	60	60	70	80	118
Q mm	13	13	13	17	21
R mm	14	14	14	18	22
S mm	120	120	146	184,5	210
Y mm	12	12	16	16	20
a mm	63	63	80	100	125
b mm	13,6	13,6	15,6	19,6	24,6
c	M6	M6	M8	M8	M10
Clamping force kN	18	25	35	45	55
Weight kg	12	13,5	25	40	65

RS - without power transmitter



RS machine vice



Accessories RS

A37

Draw-down jaws SNF, with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
077104 ▲	set	2	113	31,6
077105 ▲	set	3	135	39,6
077106 ▲	set	4	160	49,6
077107 ▲	set	5	200	62,6

Including fixing screws

A37

Normal jaw SGN, one side smooth, one side grooved, both sides ground



Item no.	Contents of delivery	Size	Width mm	Height mm
152752	piece	1	92	31,6
152753	piece	2	113	31,6
152754	piece	3	135	39,6
152755	piece	4	160	49,6
152759	piece	5	200	62,6

A37

Normal jaw finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved



Item no.	Contents of delivery	Size	Width mm	Height mm
163218 ▲	piece	1	92	31,6
156195	piece	2	113	31,6
156196	piece	3	135	39,6
156197	piece	4	160	49,6
156198	piece	5	200	62,6

Including fixing screws

A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
128770	piece	1	92	31,6	3-13	5-32
082362	piece	2	113	31,6	3-13	5-32
082363	piece	3	135	39,6	4-20	6-40
082364	piece	4	160	49,6	5-29	7-48
082365	piece	5	200	62,6	6-37	8-56

Including fixing screws

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
150739 ▲	piece	2	113	31,6
150740 ▲	piece	3	135	39,6
150741 ▲	piece	4	160	49,6

Including fixing screws

Accessories RS

C15

Hand crank HKU, with octagon socket


Item no.	Contents of delivery	Size	Octagon	Key-width SW	L
009150	piece	1	12	Octagon	80
009152	piece	2	14	Octagon	125
009153	piece	3	17		160
009154	piece	4/5	19	Octagon	200

A37

Standard rotation plate DP, with fixing screws and T-slot nuts, ground contact edge, graduation


Item no.	Size	External Ø mm	Height	Center Ø	Weight
129814	1/2	242	30	28	7,5
082442	3	280	30	28	11
082443	4	340	34	28	18

A37

Universal rotation plate DP, with fixing screws and T-slot nuts, ground contact edge, graduation


Item no.	Size	External Ø mm	Height	Center Ø	Weight
090854 ▲	5	420	40	28	23

UZ - central, without power transmitter



APPLICATION

For conventional machine tools.

TYPE

Clamping system mechanical without power transmitter, manually operated.

CUSTOMER BENEFITS

- ⊕ Optimal price/performance ratio
- ⊕ Spindle covered in the work area
- ⊕ Extensive assortment of jaws
- ⊕ Low design
- ⊕ The lateral jaw guides allow the vice to be easily and exactly aligned

TECHNICAL FEATURES

- Made of special cast iron for versatile use
- Use on rotary plate with graduation
- With normal jaws SGN and handcrank
- Centric clamping through the left-hand and right-hand thread of the spindle

A11
UZ, self-centering vice

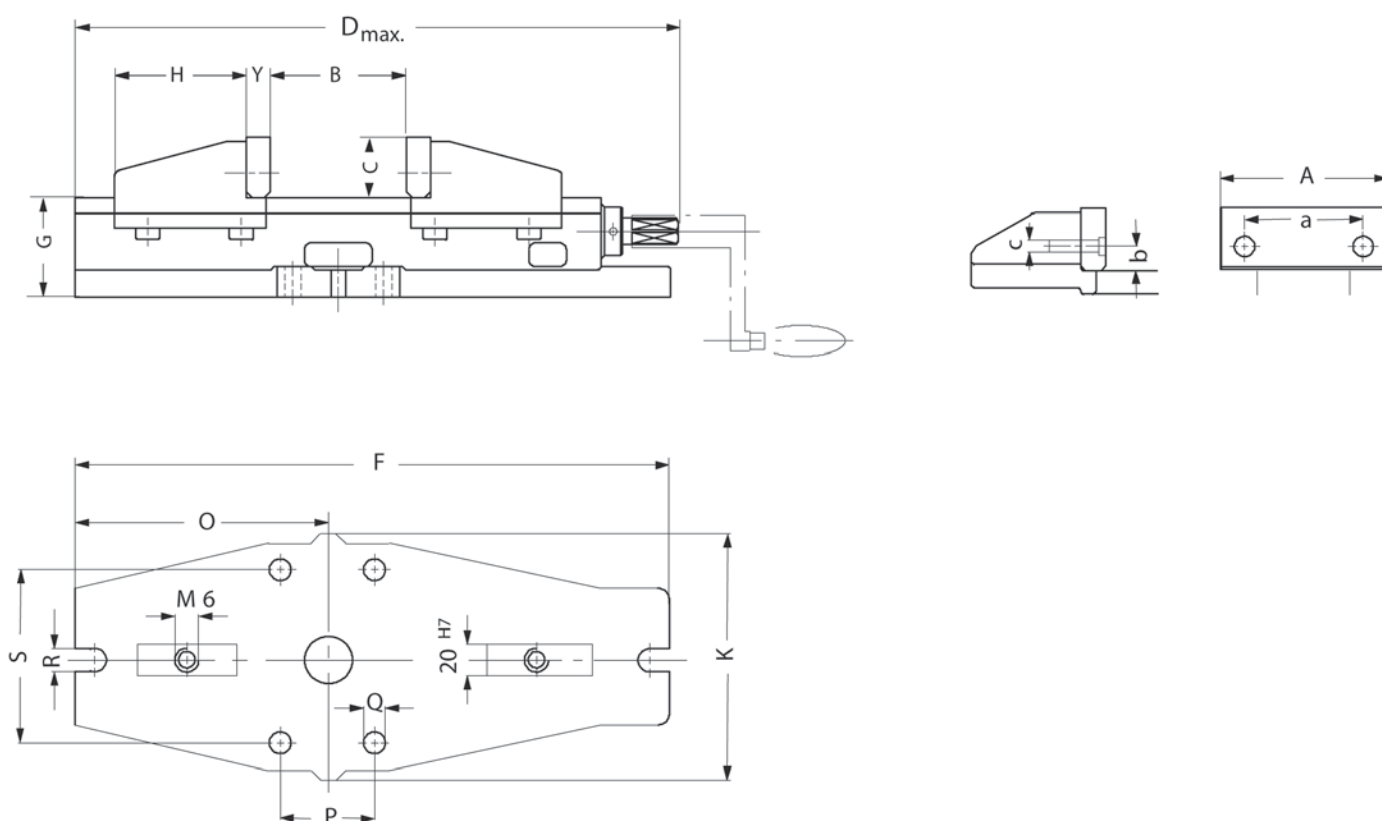
UZ machine vice

Id.-Nr.	014523	014740	014752	014802 ▲	014807 ▲
Size	2	3	4	5	6
Jaw width A mm	113	135	160	200	250
B mm	110	140	180	300	400
C mm	31,6	39,6	49,6	62,6	62,6
D mm	358	408	495	655	767
F mm	344	394	480	640	751
G mm	61	65,5	74	79	85
J mm	81	87	107	123	123
K mm	132	152	180	200	220
O mm	149	174	214	294	344
P mm	50	60	60	70	80
Q mm	11	11	17	17	17
R mm	13	13	17	17	21
S mm	101	118,5	142	158	175
Y mm	12	16	16	20	20
a mm	63	80	100	125	160
b mm	13,6	15,6	19,6	24,6	24,6
c	M6	M8	M8	M10	M10
Clamping force kN	15	22	24	25	28
Weight kg	12,4	19	31	52	71

UZ - central, without power transmitter



UZ machine vice



Accessories UZ

A37

Draw-down jaws SNF, with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
077103	set	2	90	24,6
077104 ▲	set	2	113	31,6
077105 ▲	set	3	135	39,6
077106 ▲	set	4	160	49,6
077107 ▲	set	5	200	62,6

Including fixing screws

A37

Normal jaw SGN, one side smooth, one side grooved, both sides ground



Item no.	Contents of delivery	Size	Width mm	Height mm
152767	piece	2	90	24,6
152753	piece	2	113	31,6
152754	piece	3	135	39,6
152755	piece	4	160	49,6
152759	piece	5	200	62,6
152760 ▲	piece	6	250	62,6
152762 ▲	piece		300	79,6

Including fixing screws

A37

Normal jaw finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved



Item no.	Contents of delivery	Size	Width mm	Height mm
156195	piece	2	113	31,6
156196	piece	3	135	39,6
156197	piece	4	160	49,6
156198	piece	5	200	62,6

Including fixing screws

A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
082361	piece	2	90	24,6	3-13	5-32
082362	piece	2	113	31,6	3-13	5-32
082363	piece	3	135	39,6	4-20	6-40
082364	piece	4	160	49,6	5-29	7-48
082365	piece	5	200	62,6	6-37	8-56
082366 ▲	piece	6	250	62,6	7-45	9-65

Including fixing screws

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
317259	set	2	110	31,8	3-12	5-32
317260	set	3	135	39,8	3-13	6-40
317261	set	4	160	49,8	5-22	7-48

Including fixing screws

Accessories UZ

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
150739 ▲	piece	2	113	31,6
150740 ▲	piece	3	135	39,6
150741 ▲	piece	4	160	49,6

Including fixing screws

C15

Hand crank HKU, with octagon socket



Item no.	Contents of delivery	Size	Octagon	Key-width SW	L
009152	piece	2/3	14	Octagon	125
009153	piece	4	17	Octagon	160
009154	piece	5/6	19	Octagon	200

A37

Universal rotation plate DP, with T-slot screws and nuts ground contact edge, graduation



Item no.	Size	External Ø mm	Height	Center Ø	Weight
014709 ▲	2	245	25	28	5
014712 ▲	3	295	27	38	8
014715 ▲	4	345	30	38	11,5
014718 ▲	5	450	30	38	16,5
014721 ▲	6	450	30	38	17,3

General accessories

A37

Work locator WSA, universally adjustable, for fastening to the machine table (size 14 T-slot) or for screwing onto the NC-compact vice / machine vice (M12)



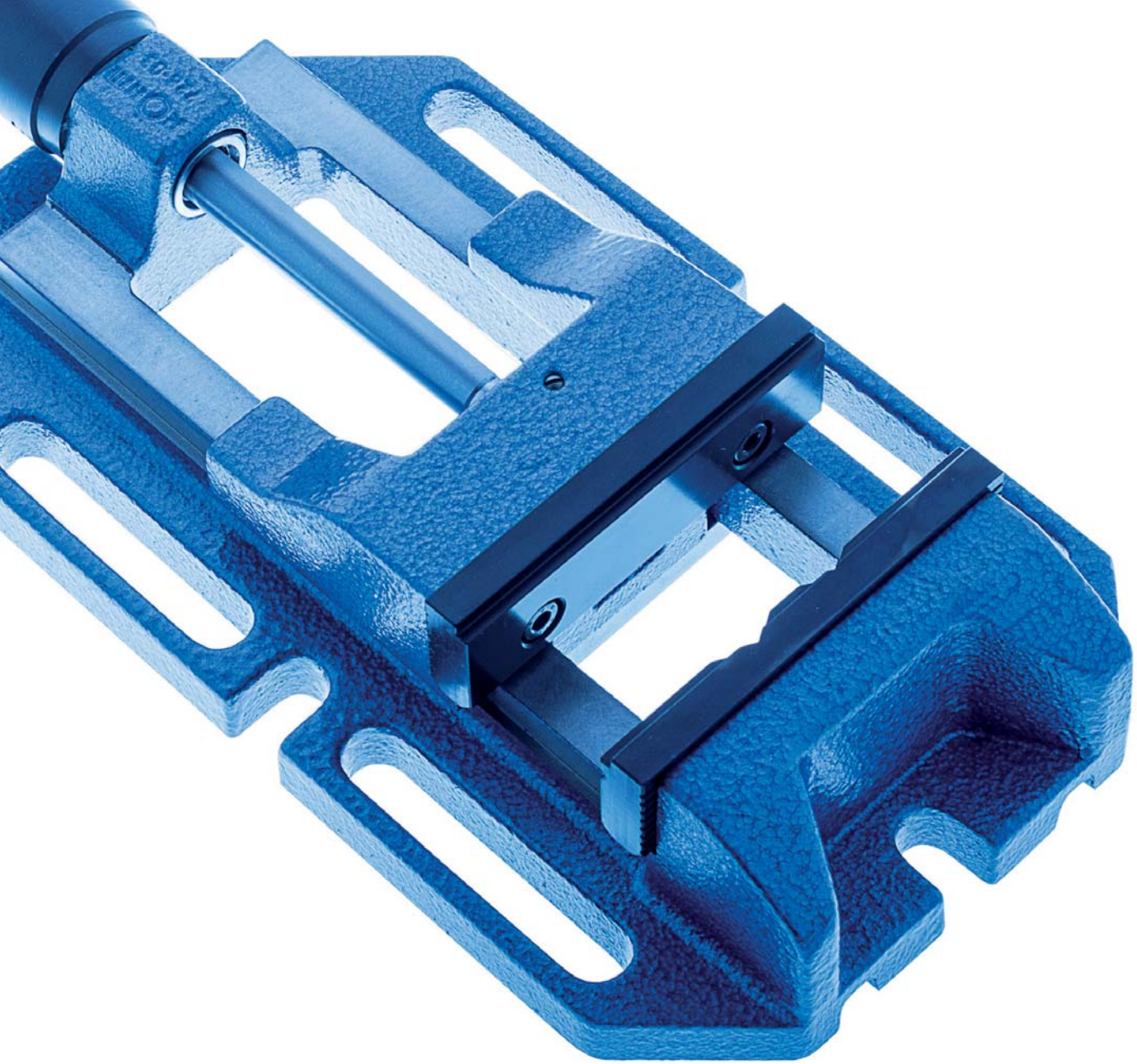
Item no.	Contents of delivery
320401	piece

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw



Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32



IDEAL FOR DRILLING AND MEASURING MACHINES



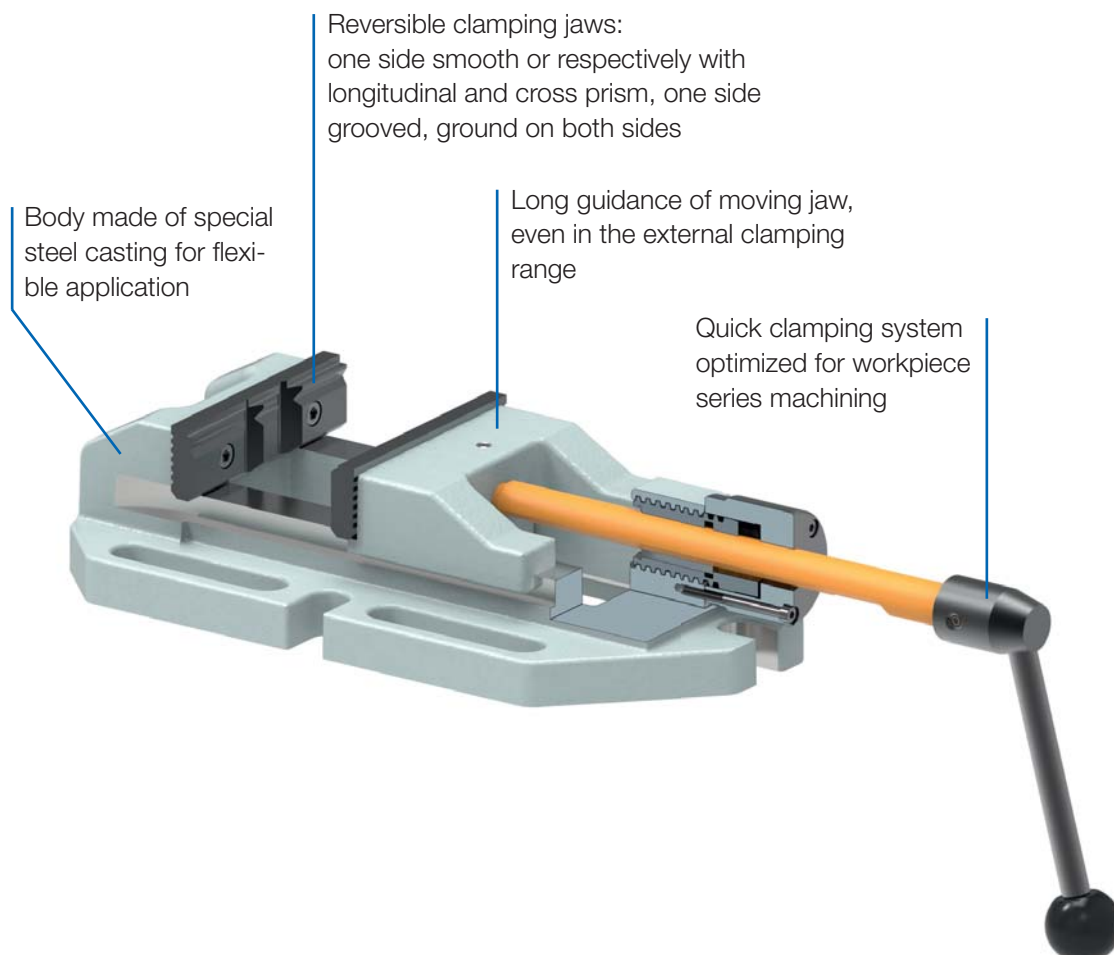
For decades, RÖHM drilling machine vices have been enabling reliable and quick clamping of workpieces on drilling and measuring machines. The entire clamping range can be set by one-handed turning.

DRILLING MACHINE VICES

The drilling machine vices from RÖHM have seen decades of use in machine shops and production facilities. The vices are especially impressive in drilling and measuring machines thanks to their simple and fast attachment on the machine table as well as their easy and single-handed operation.

ADVANTAGES AT A GLANCE

- Reliable and fast clamping of workpieces on drilling and measuring machines
- Vice has proven itself over the decades with good price/performance ratio
- Entire clamping range can be set by single-handed turning



BMS



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

Clamping system mechanical, manually operated.
Standard version.

CUSTOMER BENEFITS

- ⌚ **Quick-clamping vice**
- ⌚ For quick clamping and unclamping, particularly in the case of series workpiece machining
- ⌚ Optimal price/performance ratio
- ⌚ One-hand operation
- ⌚ Long guidance of moving jaw, even in the external clamping range
- ⌚ Clamping jaws are reversible, one side smooth and ground on both sides
- ⌚ Solid clamping jaw with one longitudinal prism and two transverse prisms

TECHNICAL FEATURES

- Body made out of special steel casting
- One-hand operation
- Positive locking

A12

BSS, with V-jaw and normal jaw SBO

Item no.	Size	Jaw width mm	Clamping capacity mm	Jaw height mm	Length mm	Height mm	Length body mm	Slot width	Slot distance	Weight kg
134158	2	110	130	32	510	72,5	315	17	140	9,5
134159	3	135	160	40	587	80,5	365	17	170	13,5



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

Clamping system mechanical, manually operated.
Standard version.

CUSTOMER BENEFITS

- ⌚ Optimal price/performance ratio
- ⌚ Entire clamping range within reach by turning
- ⌚ Mounting possibilities on the side and frontal
- ⌚ Long guidance of moving jaw, even in the external clamping range
- ⌚ Clamping jaws are reversible, one side smooth and ground on both sides
- ⌚ Solid clamping jaw with one longitudinal prism and two transverse prisms
- ⌚ Both jaws with support surface for clamping flat workpieces

TECHNICAL FEATURES

- Body made out of special steel casting
- Low, stable design with thread spindle

A12

BOF, with V-jaw and normal jaw SBO

Item no.	Size	Jaw width mm	Clamping capacity mm	Jaw height mm	Length mm	Height mm	Length body mm	Slot width	Slot distance	Weight kg
142835	1	90	90	25	356	60	195	14	115	5,5
111595	2	110	130	32	470	72,5	315	17	140	9,5
111596	3	135	160	40	550	80,5	365	17	170	13,5
111597	4	160	220	50	692	95,5	445	17	210	25

BMS



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

D.I.Y. design for small drill stands.

Clamping system mechanical, manually operated.

CUSTOMER BENEFITS

- ⌚ Lever movable (included in scope of delivery)
- ⌚ Both jaws have a seat for retaining flat workpieces

TECHNICAL FEATURES

- Solid clamping jaw with three vertical prisms and one horizontal prism
- Jaws and spindle gunmetal-finished
- Body made out of cast metal
- Long mounting slots

A12

BSH, small, light D.I.Y. design

Item no.	Size	Jaw width mm	Clamping capacity mm	Length body mm	Width body mm	Height mm	Jaw height mm	Slot distance	Weight kg
007193	1	65	65	125	105	43	25	80	1,2
007194	2	80	85	150	130	46	25	100	1,7
007196	3	100	80	170	175	57	25	135	4,2



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

Sturdy version for drill stands, table drills and box column drills.

Clamping system mechanical, manually operated.

CUSTOMER BENEFITS

- ⌚ Long lever for maximal clamping force
- ⌚ Both jaws have a seat for retaining flat workpieces

TECHNICAL FEATURES

- Moving steel jaw is supported by a cast iron jaw with inner guidance
- Solid clamping jaw with three vertical prisms and one horizontal prism
- Jaws and spindle gunmetal-finished
- Body made out of cast metal
- Long mounting slots

A12

BSH, sturdy craftsman design

Item no.	Size	Jaw width mm	Clamping capacity mm	Length body mm	Width body mm	Height mm	Jaw height mm	Slot distance	Weight kg
007197	4	80	80	200	140	70	40	100	5
007201	5	100	95	215	175	75	40	125	7
007202	6	120	110	260	215	85	40	160	11
007207	7	140	150	300	220	85	40	165	12,5

BMS



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

Clamping system mechanical, manually operated.
Standard version.

CUSTOMER BENEFITS

- ⌚ Entire clamping range within reach by turning
- ⌚ Constant design length, spindle moves protected in the handle
- ⌚ The thread spindle is covered by a protecting sleeve

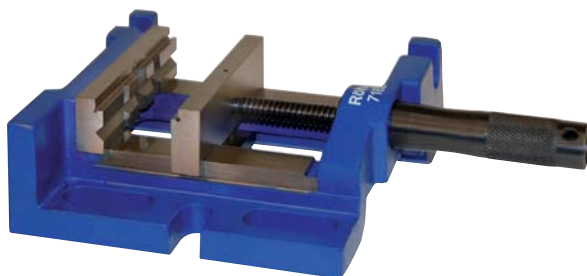
TECHNICAL FEATURES

- Solid and handy version
- Body made out of cast metal
- Movable jaw, guided on side
- Solid clamping jaw with three vertical prisms and one horizontal prism
- Both jaws with support surface for clamping flat workpieces
- Jaws and spindle gunmetal-finished
- Long mounting slots

A12

DPV, with V-jaw and normal jaw SBO

Item no.	Size	Jaw width mm	Clamping capacity mm	Jaw height mm	Length mm	Height mm	Length body mm	Width mm	Slot width	Slot distance	Weight kg
863421	1	80	70	30	234	58	174	142	12,5	105	3,6
863422	2	100	88	30	272	63,5	188	188	14	125	4,3
863423	3	120	110	30	345	63,5	225	223	14	150	6,3
1132597	4	150	125	30	378	65	238	242	14	170	8,1



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

Clamping system mechanical, manually operated.
Standard version.

3 set-up options thanks to two additional, perpendicularly machined support surfaces: bottom, right and front.

CUSTOMER BENEFITS

- ⌚ Entire clamping range within reach by turning
- ⌚ Constant design length, spindle moves protected in the handle
- ⌚ The thread spindle is covered by a protecting sleeve
- ⌚ Mounting slots

TECHNICAL FEATURES

- Solid and handy version
- Body made out of cast metal
- Movable jaw, guided on side
- Solid clamping jaw with three vertical prisms and one horizontal prism
- Both jaws with support surface for clamping flat workpieces
- Jaws and spindle gunmetal-finished
- Long mounting slots

A12

DPV 3-W, with V-jaw and normal jaw SBO

Item no.	Size	Jaw width mm	Clamping capacity mm	Jaw height mm	Length mm	Height mm	Length body mm	Width mm	Slot width	Slot distance	Weight kg
007182	2	100	93	30	279	65	189	159	15	122	5,1

Accessories BMS

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support für BOF und BSS


Item no.	Contents of delivery	Size	Width mm	Height mm	Chuck capacity mm	
					Horizontal	Vertical
332714	set	1	90	24,8	4-17	4-25
317259	set	2	110	31,8	3-12	5-32
317260	set	3	135	39,8	3-13	6-40
317261	set	4	160	49,8	5-22	7-48

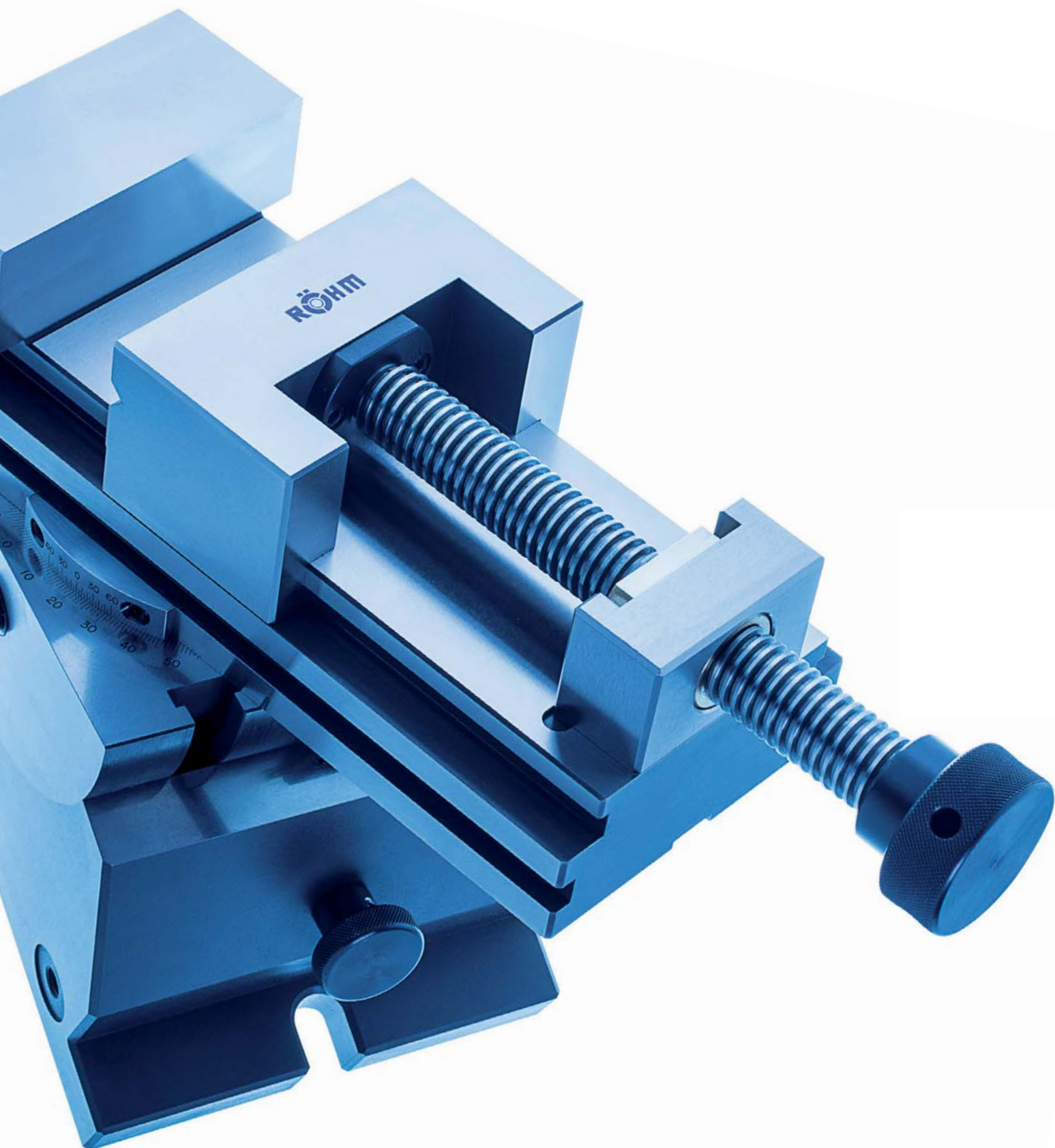
Including fixing screws

A37

V-jaw and standard jaw SBO, soft and gunmetal-finished, with work support, for DPV


Item no.	Contents of delivery	Size	Width mm
1128341	set	1	85
1128342	set	2	100
1128344 ¹⁾	set	2	100
1128343	set	3	120
1193108	set	4	150

¹⁾ Only for DPV 3-W

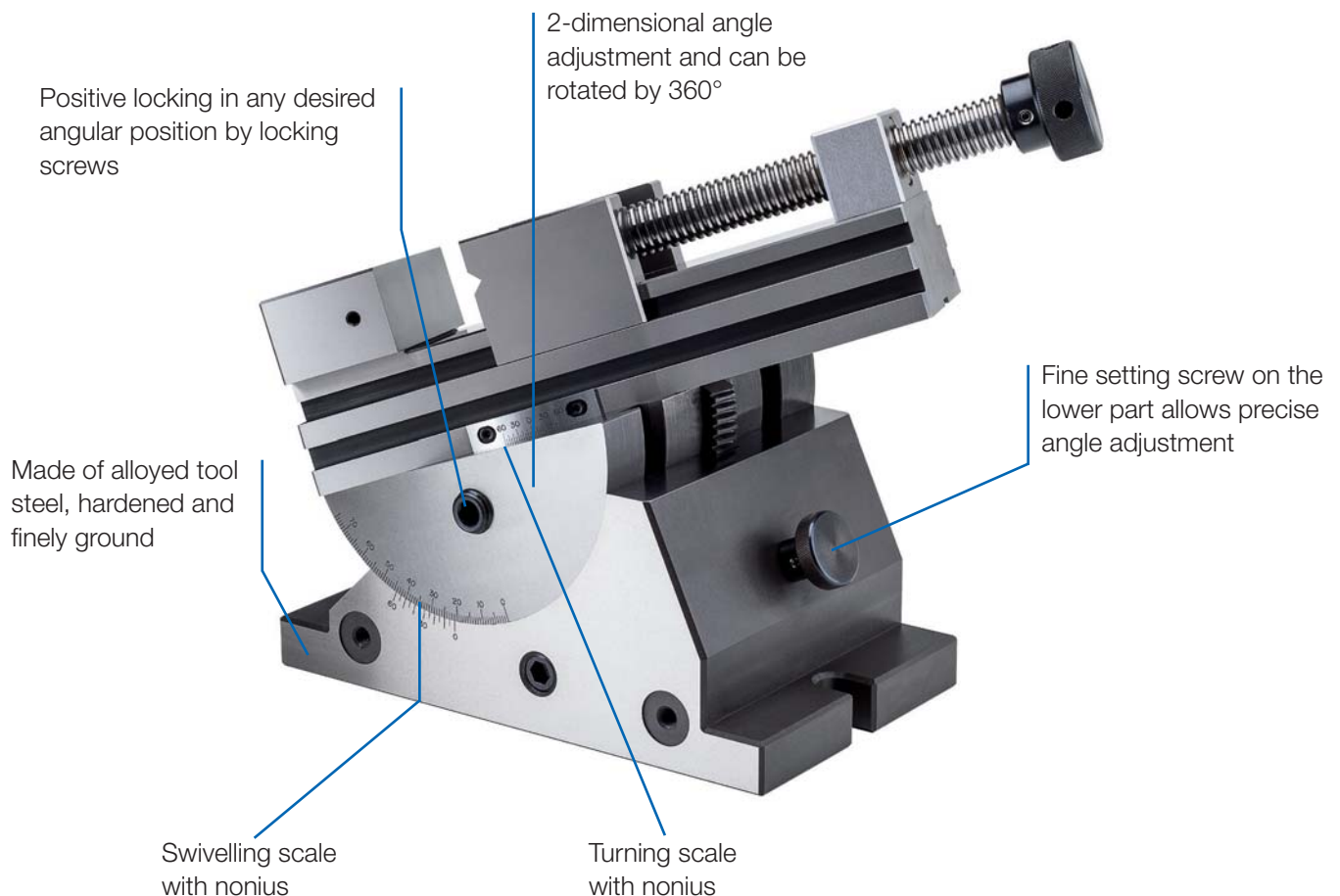


GRINDING AND INSPECTION VICES

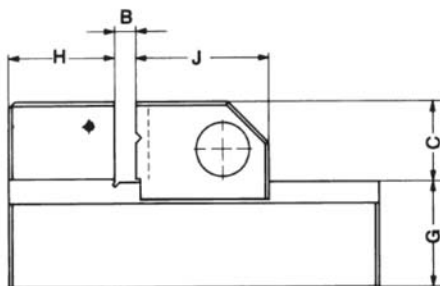
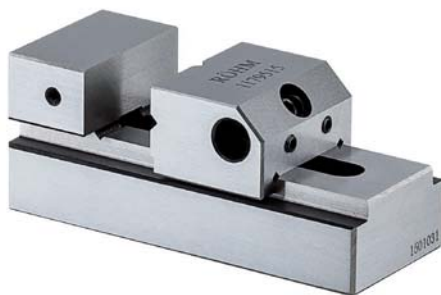
RÖHM grinding and inspection vices are primarily used in grinding, milling and engraving machines, at jig boring machines, for measurement and inspection work and for manufacturing processes which require the highest standards of clamping precision.

ADVANTAGES AT A GLANCE

- Special vices for measuring, testing and engraving
- Easy to use and universally applicable
- Made of alloyed tool steel, hardened and finely ground



Grinding and inspection vices



A29

PL-S micro, with quick adjustment

Item no.	Size	Squareness ¹⁾ / 100 mm	Parallelism ²⁾ / 100 mm	Jaw width mm	B mm	Total height mm	C mm	Length body mm	G mm	H mm	J mm	Work locator	Weight kg
1179514	1	0,005	0,002	34	25	35	15	75	20	20	25	M5x17	0,35
1179515	2	0,005	0,002	45	50	45	20	110	25	25	35	M5x17	1

1) Base to stationary jaw clamping surface

2) Base to upper guide edge

APPLICATION

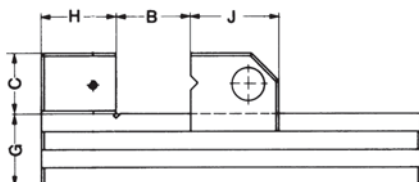
Mainly in tool construction on grinding, milling and engraving machines, on jig boring machines, for measuring and control work and for production operations requiring high clamping precision.

CUSTOMER BENEFITS

- Easy clamping and unclamping with allen key
- Clamping jaw adjustable in stages, snaps in automatically

TECHNICAL FEATURES

- With draw-down effect
- Made of alloyed tool steel, hardened and very finely ground
- Horizontally and vertically ground prism
- No spindle which could cause contamination during electric discharge machining, for example



A29

PL-S, with quick adjustment

Item no.	Size	Squareness ¹⁾ / 100 mm	Parallelism ²⁾ / 100 mm	Jaw width mm	B mm	Total height mm	C mm	Length body mm	G mm	H mm	J mm	Work locator	Weight kg
1179516	1	0,005	0,002	70	80	62	30	160	32	33	45	M6	3
1179517	2	0,005	0,002	90	120	80	40	210	40	40	50	M5	5,8
1179518	3	0,005	0,002	120	150	90	40	280	50	60	70	M5	13,5

1) Base to stationary jaw clamping surface

2) Base to upper guide edge

APPLICATION

Mainly in tool construction on grinding, milling and engraving machines, on jig boring machines, for measuring and control work and for production operations requiring high clamping precision.

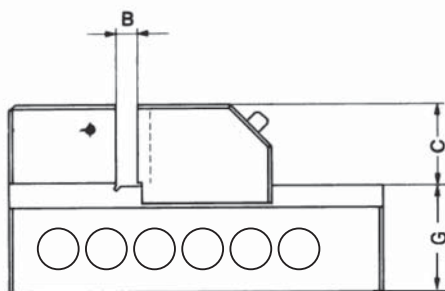
CUSTOMER BENEFITS

- Easy clamping and unclamping with allen key
- Clamping jaw adjustable in stages, snaps in automatically

TECHNICAL FEATURES

- With draw-down effect
- Made of alloyed tool steel, hardened and very finely ground
- Horizontally and vertically ground prism
- No spindle which could cause contamination during electric discharge machining, for example

Grinding and inspection vices



A29

PLF, with quick adjustment in gauge accuracy

Item no.	Size	Squareness ¹⁾ / 100 mm	Parallelism ²⁾ / 100 mm	Jaw width mm	B mm	Total height mm	C mm	G mm	Length body mm	Weight kg
1111185	0	0,005	0,005	50	65	50	25	25	140	1,4
1111186	1	0,005	0,005	73	100	67	35	32	190	4,1
1111187	2	0,005	0,005	100	125	90	45	45	245	7,3

1) Base to stationary jaw clamping surface

2) Base to upper guide edge

APPLICATION

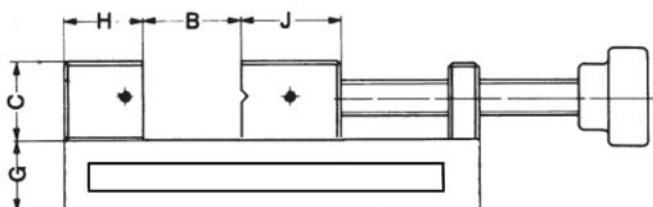
Mainly in tool construction on grinding, milling and engraving machines, on jig boring machines, for measuring and control work and for production operations requiring high clamping precision.

CUSTOMER BENEFITS

- ⌚ Easy clamping and unclamping with allen key
- ⌚ Clamping jaw adjustable in stages, snaps in automatically

TECHNICAL FEATURES

- With draw-down effect
- Made of alloyed tool steel, hardened and very finely ground
- Horizontally and vertically ground prism
- No spindle which could cause contamination during electric discharge machining, for example



A29

PL-G

Item no.	Size	Squareness ¹⁾ / 100 mm	Parallelism ²⁾ / 100 mm	Jaw width mm	B mm	Total height mm	C mm	Length body mm	G mm	H mm	J mm	Weight kg
1111182	0	0,005	0,002	60	55		25	110	25	25	33	1,6
1111183	1	0,005	0,002	73	100	74	35	210	32	33	45	4
1111184	2	0,005	0,002	88	125	88	40	250	48	40	50	7,6

1) Base to stationary jaw clamping surface

2) Base to upper guide edge

APPLICATION

Mainly in tool construction on grinding, milling and engraving machines, on jig boring machines, for measuring and control work and for production operations requiring high clamping precision.

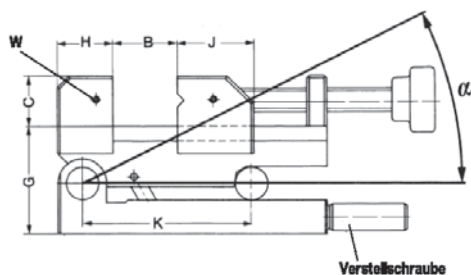
TYPE

- ⌚ Clamping and unclamping with threaded spindle

TECHNICAL FEATURES

- Horizontally and vertically ground prism
- Made of alloyed tool steel, hardened and very finely ground

Grinding and inspection vices



A29
PS-SV, front swivelling axis

Item no.	Size	Squareness / 100 mm	Parallelism / 100 mm	Angular accuracy	Jaw width mm	B mm	Total height mm	C mm	Length body mm	G mm	H mm	J mm	K mm	α	W	Weight kg
370778	1	0,005	0,002	bei 45° ± 15°	70	80	93	30	160	63	33	45	100	0° - 46°	2xM5x15	5,3
370779	2	0,005	0,002	bei 45° ± 15°	90	120	113	40	210	73	40	50	150	0° - 46°	2xM5x15	11

APPLICATION

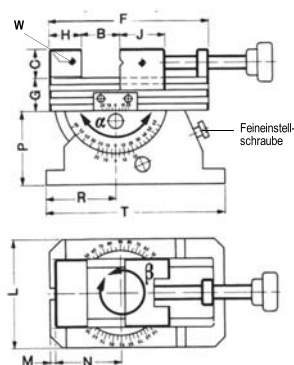
Mainly in tool construction on grinding, milling and engraving machines, on jig boring machines, for measuring and control work and for production operations requiring high clamping precision.

CUSTOMER BENEFITS

- ☺ The clamping device can be positively locked in any angular position

TECHNICAL FEATURES

- Made of alloyed tool steel, hardened and very finely ground
- Bearing and support pins hardened and ground to a precision of 0.001 mm



APPLICATION

Mainly in tool construction on grinding, milling and engraving machines, on jig boring machines, for measuring and control work and for production operations requiring high clamping precision.

CUSTOMER BENEFITS

- ☺ 2-dimensional angle adjustment via vernia, for size 1 with 3'-vernia, for size 2 with 5'-vernia
- ☺ 360° turnable

TECHNICAL FEATURES

- Fine adjustment screw on bottom section makes exact angular adjustment possible
- Size 2 for heavy machining
- Positive locking in any desired angular position using fixing screws
- Made of alloyed tool steel, hardened and very finely ground

A29
PS-ZD 2-dimensional

Item no.	Size	Squareness / 100 mm	Parallelism / 100 mm	Jaw width mm	B mm	Total height mm	C mm	Length body mm	G mm	H mm	J mm	L mm	M mm	N mm	P mm	R mm	T mm	β	α	W	Weight kg
370782	1	0,005	0,002	70	80	137	30	160	32	33	45	110	5	65	75	70	180	360°	0° - 120°	2xM5x15	11,1
370783 ▲	2	0,005	0,002	120	150	210	40	270	50	55	70	160	10	105	120	105	270	360°	0° - 70°	2xM6x20	43

Stationary power clamping devices



KZS-P

APPLICATION

Optimally suitable for rational clamping in automated work procedures.

CUSTOMER BENEFITS

- Compact design for best possible use of work area
- High repeatability due to stable, low-play jaw guides

NOTE

For more information, see power clamping technology – stationary power clamping equipment



KZS-PG

APPLICATION

Optimally suitable for rational clamping in automated work procedures.

CUSTOMER BENEFITS

- Compact design for best possible use of work area
- High repeatability due to stable, low-play jaw guides

NOTE

For more information, see power clamping technology – stationary power clamping equipment



SSP

APPLICATION

For stationary centric clamping of workpieces on milling machines or machining centers.

CUSTOMER BENEFITS

- High repeatability due to stable chuck design
- Compact design for best possible use of work area

NOTE

For more information, see power clamping technology – stationary power clamping equipment

F-senso chuck clamping force measuring device

APPLICATION

Suitable for 3 jaw chucks and vices.

The F-senso clamping force measurement device enables you to check the clamping force as well as the rotational speed of your clamping tools.
The centrifugal behavior is thus directly related to the accompanying software evaluated.

TYPE

- ④ Broad clamping range of 75 - 175 mm through interchangeable pressure pins
- ④ Broad measuring range from 0 - 100 kN per jaw
- ④ Dynamic clamping force measurement under rotation up to 8250 rpm
- ④ Real-time data transmission via Bluetooth to included tablet
- ④ Delivered in the practical hard-shell case

TECHNICAL FEATURES

- No additional attachments necessary on the machine
- Easy positioning through positioning aid
- Automated switch-off



Video F-senso chuck



F-senso chuck

ADVANTAGES AT A GLANCE

- ④ Direct output of the centrifugal force behavior through combined measurement of clamping force and speed
- ④ Flexibility through large clamping and measuring range
- ④ Easy handling without additional set-ups on the machine

Included in the scope of delivery:

- Base with foam insert
- Clamping force measuring head, F-senso chuck
- Pressure bolts in lengths 5 mm, 15 mm, 25 mm and 30 mm
- Pressure bolt elongation in length 25 mm
- Practical insertion aid
- Tablet PC with pre-installed measuring and evaluation program



C 15

Clamping force measurement device F-senso chuck

Id.-Nr.	179800
Measuring range / Clamping force kN	2 jaws: 0 - 200; 3 jaws: 0 - 300
Measuring range / Rotation speed min-1	0 - 8250
Accuracy	Force <0.5% / Rotation speed ±10 rpm within the complete measuring range
Clamping Ø mm	75 - 175
Dimensions (base unit)	Ø 75/80 x 130

Power-Grip zero-point clamping system



Palletizing systems, such as the Power-Grip zero-point clamping system from RÖHM, achieve a drastic increase in production. This modular system meets the demands for customized solutions with the best possible utilization of the machine capacity. While the machine tool was stopped for the time of the set-up operation before, now the workpiece can be clamped and positioned on the pallet outside of the machine tool. The set-up time is now only limited to the changing in and out of the pallet within a few seconds. If several production processes are necessary for machining, the pallet can be used along with the workpiece without a zero-point loss. Due to the robust and rust-resistant design, the Power-Grip zero-point clamping system is universally suitable for applications ranging from cutting machining to electrical discharge machining all the way to measuring machines.

ADVANTAGES AT A GLANCE

- ⌚ Increase in productivity thanks to set-up time reduction up to 90%
- ⌚ Maximum precision and repeatability of 0.002 mm
- ⌚ Palletizing and clamping device from one source

SET-UP TIME REDUCTION BY UP TO 90%

Without palletising system

Machine run-time

Set-up of the workpiece

With Power-Grip zero point clamping system

Simultaneous setting up on the pallet

Machine run-time

Pallet exchange

Additional machine capacity

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