



VICES

2015/2016

**RÖHM**  
driven by technology

# We work for customers who have a weakness for our strengths.

Companies intent on making a difference are obliged to develop constantly as well as deploy their strengths to the benefit of customers. At RÖHM, we have set ourselves high targets and are doing our very best to achieve them. This is why we support our customers all over the world by means of the six performance indicators so typical of RÖHM:



Dynamism

Variety

Security

Partnership

Globality

Innovation



RKE 125

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# Operation guide



Operation guide

TYPE	RKE				RKE-LV		RKK					
NC-Compact vices												
<b>Features</b>	- Highest clamping precision - 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					
<b>Clamping system</b>	mechanical-mechanical size 92: mechanical-hydraulic				mechanical-mechanical		mechanical-mechanical size 92: mechanical-hydraulic					
<b>Force amplification</b>	✓				✓		✓					
<b>Set-up options</b>	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	✓				✓✓		✓					
<b>Jaw width mm</b>	92 <sup>1)</sup>	125 <sup>1)</sup>	160 <sup>1)</sup>	200 <sup>1)</sup>	125 <sup>1)</sup>	125 <sup>3)</sup>	92 <sup>1)</sup>	113 <sup>2)</sup>	113 <sup>2)</sup>	135 <sup>2)</sup>	160 <sup>2)</sup>	200 <sup>2)</sup>
Clamping range (max.)	208	312	451	451	192	225	138	170	170	215	340	340
Length (opened) mm	346	479	634	634	372	372	330	424	424	483	618	618
Width mm	94	126	162	200	126	126	94	125	125	150	205	205
Height mm	112	140	165	175	140	130	112	133	133	148	179	189
Clamping force (max.) kN	25	40	60	60	40	40	25	30	40	40	60	60
Weight kg	15	41	79	85	29	29	15	35	35	50	107	108
<b>Page</b>	4012				4024		4030					



yes



suitable



very suitable

<sup>1)</sup> with stepped jaws  
<sup>2)</sup> with standard jaws  
<sup>3)</sup> with carrier jaws

<sup>4)</sup> with claw-type jaws  
<sup>5)</sup> with heightend stepped jaws

# Operation guide



TYPE	RKD		RKD-M		RZM		RKZ		RKZ-M			
	NC-Compact twin vices				NC-Compact self centering vices							
<b>Features</b>	- Double clamping - Greatest repeatability - Low rapid traverse		- 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 force presetting		- Highest average precision and repeatability - Minimum collision contour			
<b>Clamping system</b>	mechanical-mechanical		mechanical		mechanical		mechanical-mechanical		mechanical			
<b>Force amplification</b>	<input checked="" type="checkbox"/>		*		*		<input checked="" type="checkbox"/>		*			
<b>Set-up options</b>	3-Side Duo-Tower Quattro-Tower		3-Side Duo-Tower Quattro-Tower		Base		3-Side Duo-Tower Quattro-Tower		Base			
Machining centers with high working accuracy	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>			
Universal milling machines with high working accuracy	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>			
Universal milling machines standard version	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>			
Jig boring machines	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>			
5-axis machining					<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>			
Grinding machines	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>			
Series production	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>			
For limited space	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>			
<b>Jaw width mm</b>	92 <sup>1)</sup>	125 <sup>1)</sup>	92 <sup>1)</sup>	125 <sup>1)</sup>	125 <sup>4)</sup>	125 <sup>4)</sup>	125 <sup>1)</sup>	50 <sup>1)</sup>	70 <sup>1)</sup>	92 <sup>1)</sup>	125 <sup>1)</sup>	125 <sup>5)</sup>
Clamping range (max.)	127	180	127	180	142	222	298	111	153	208	269	269
Length (opened) mm	500	667	480	617	298	218	565	157	209	283	353	353
Width mm	94	126	94	126	125	125	126	52	72	94	126	126
Height mm	117	145	117	145	196,5	196,5	170	75	95	117	145	165
Clamping force (max.) kN	25	40	25	40	25	25	40	10	15	20	25	25
Weight kg	24	53	24	52	17,4	20,3	50,5	3,5	7	18	32,5	35
<b>Page</b>	4040		4046		4056		4060		4066			

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

# Operation guide



ORANGE LINE



ORANGE LINE



Operation guide

TYPE	RB-K Orange Line					RB-M Orange Line					RBA				RBAW							
	Machine vices										NC power vices											
<b>Features</b>	- Great accuracy due to precise jaw guidance - Fast clamping range adjustment using the pin system					- Great accuracy due to precise jaw guidance - Fast clamping range adjustment using the pin system					- Clamping force presetting - Steel body with hardened guide				- Integrated angular drive - Clamping width presetting							
<b>Clamping system</b>	mechanical-hydraulic					mechanical					mechanical-hydraulic				mechanical-hydraulic							
<b>Force amplification</b>	<input checked="" type="checkbox"/>					*					<input checked="" type="checkbox"/>				<input checked="" type="checkbox"/>							
<b>Set-up options</b>	Base					Base					3-Side				3-Side							
Machining centers with high working accuracy	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/>					<input checked="" type="checkbox"/>					<input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/>							
Universal milling machines with high working accuracy	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/>					<input checked="" type="checkbox"/>					<input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/>							
Universal milling machines standard version	<input checked="" type="checkbox"/>					<input checked="" type="checkbox"/>					<input checked="" type="checkbox"/>				<input checked="" type="checkbox"/>							
Jig boring machines	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/>					<input checked="" type="checkbox"/>					<input checked="" type="checkbox"/> <input checked="" type="checkbox"/>				<input checked="" type="checkbox"/> <input checked="" type="checkbox"/>							
5-axis machining																						
Grinding machines	<input checked="" type="checkbox"/>					<input checked="" type="checkbox"/>					<input checked="" type="checkbox"/>				<input checked="" type="checkbox"/>							
Series production	<input checked="" type="checkbox"/>					<input checked="" type="checkbox"/>					<input checked="" type="checkbox"/>				<input checked="" type="checkbox"/>							
For limited space	<input checked="" type="checkbox"/>					<input checked="" type="checkbox"/>					<input checked="" type="checkbox"/>				<input checked="" type="checkbox"/>							
<b>Jaw width mm</b>	<b>92</b>	<b>113</b>	<b>135</b>	<b>160</b>	<b>200</b>	<b>92</b>	<b>113</b>	<b>135</b>	<b>160</b>	<b>200</b>	<b>92</b>	<b>113</b>	<b>135</b>	<b>160</b>	<b>113</b>	<b>135</b>	<b>160</b>					
Clamping range (max.)	100	170	220	310	350	100	185	240	330	370	100	170	220	310	175	225	310					
Length (opened) mm	490	583	679	817	1022	420	586	686	860	1015	490	583	681	817	500	578	702					
Width mm	160	160	200	240	280	160	160	200	240	280	94	115	137	162	115	137	162					
Height mm	91	97	112	133	171	91	97	112	133	171	89,5	96	111	132	96	111	132					
Clamping force (max.) kN	25	30	40	50	100	20	25	35	45	55	25	30	40	50	30	40	50					
Weight kg	15,5	24	39	60	112	15,5	24	39	60	112	15,5	24	39	60	22	36	62					
<b>Page</b>	4076					4082					4088				4094							



yes



suitable



very suitable

# Operation guide



TYPE	MSR					RS					UZ				
	Machine vices														
<b>Features</b>	- 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				
<b>Clamping system</b>	mechanical					mechanical					mechanical				
<b>Force amplification</b>	*					*					*				
<b>Set-up options</b>	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	✓					✓					✓				
<b>Jaw width mm</b>	<b>125</b>	<b>150</b>	<b>150</b>	<b>175</b>	<b>92</b>	<b>113</b>	<b>135</b>	<b>160</b>	<b>200</b>	<b>113</b>	<b>135</b>	<b>160</b>	<b>200</b>	<b>250</b>	
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	
<b>Page</b>	4100					4102					4106				

Operation guide

\*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																			
<b>Features</b>	- 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						
<b>Clamping system</b>	mechanical manually operated		mechanical manually operated				mechanical manually operated						mechanical manually operated						
<b>Force amplification</b>																			
<b>Set-up options</b>	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																			
<b>Jaw width mm</b>	<b>110</b>	<b>135</b>	<b>90</b>	<b>110</b>	<b>135</b>	<b>160</b>	<b>65</b>	<b>80</b>	<b>100</b>	<b>80</b>	<b>100</b>	<b>120</b>	<b>140</b>	<b>80</b>	<b>100</b>	<b>120</b>	<b>150</b>	<b>100</b>	
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	
<b>Page</b>	4112		4112				4113						4114				4114		



yes



suitable



very suitable

# Operation guide



TYPE	Grinding and inspection vice																
	PL-S micro				PL-S			PLF			PL-G			PS-SV		PS-ZD	
<b>Features</b>	<ul style="list-style-type: none"> <li>- Draw-down effect</li> <li>- Simple clamping and releasing with allen key</li> <li>- Clamping jaw adjustable in steps; engages automatically</li> <li>- No spindle</li> </ul>				<ul style="list-style-type: none"> <li>- Draw-down effect</li> <li>- Made of alloyed tool steel, hardened and finely ground</li> <li>- Horizontal and vertical ground prism</li> <li>- No spindle which could, become dirty during erosion</li> </ul>			<ul style="list-style-type: none"> <li>- Clamping and releasing with threaded spindle</li> <li>- Made of alloyed tool steel, hardened and finely ground</li> </ul>			<ul style="list-style-type: none"> <li>- Made of alloyed tool steel, hardened and finely ground</li> <li>- Bearing and location pins hardened and ground with a precision of 0.001 mm</li> <li>- The clamping device can be positively locked in any angular position</li> </ul>		<ul style="list-style-type: none"> <li>- Positive locking in any desired angular position by locking screws</li> <li>- Made of alloyed tool steel, hardened and finely ground</li> <li>- Can be rotated 360°</li> </ul>				
<b>Clamping system</b>	mechanical, manually operated				mechanical, manually operated			mechanical, manually operated			mechanical, manually operated		mechanical, manually operated				
<b>Force amplification</b>																	
<b>Set-up options</b>	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																	
<b>Jaw width mm</b>	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		
<b>Page</b>	4118				4119			4119			4120		4120				

Operation guide

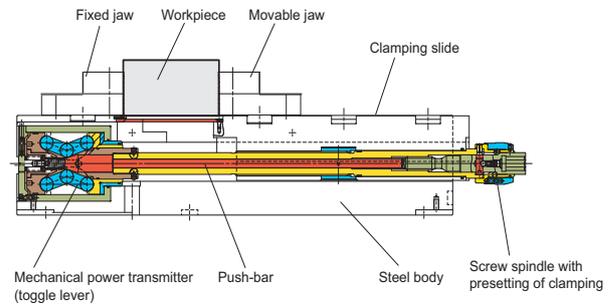
\* Constant clamping force for each clamping process and high repeatability in combination with a torque wrench

# 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.

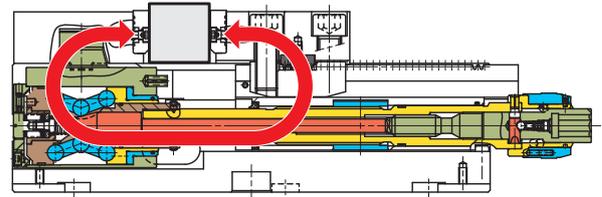
## SECTIONAL VIEW RKE



## RKK SIZE 2-5

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

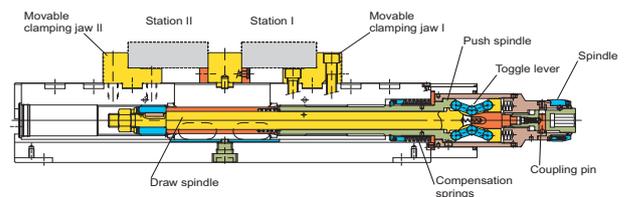
## SECTIONAL VIEW RKK SIZE 2 - 5



## RKD

NC-Compact twin vice with two movable clamping jaws (left-hand/right-hand thread) and a fixed center jaw.

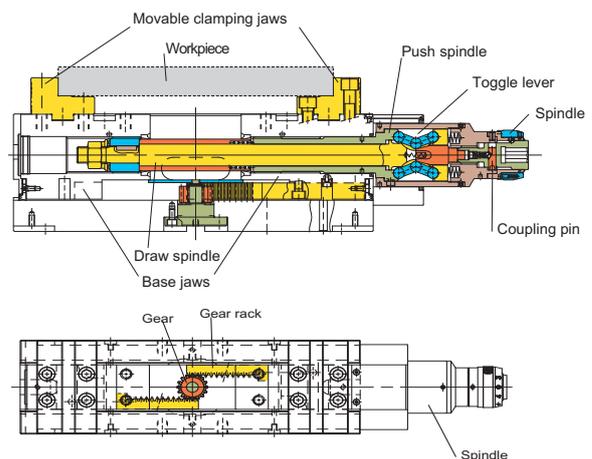
## SECTIONAL VIEW RKD



## RKZ

NC-Compact vice with two movable clamping jaws and large clamping stroke. The force acts equally on both jaws via push spindle and draw spindle. Form-fitted racks in the lower area of the main jaw mesh towards the center into a centrally mounted pinion.

## SECTIONAL VIEW RKZ



# 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.

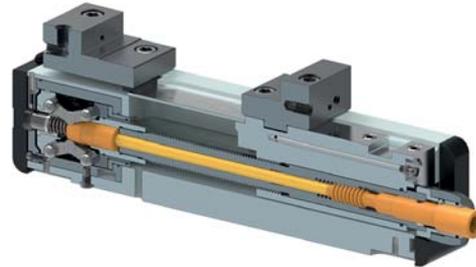
#### b) Presetting of different clamping forces

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.

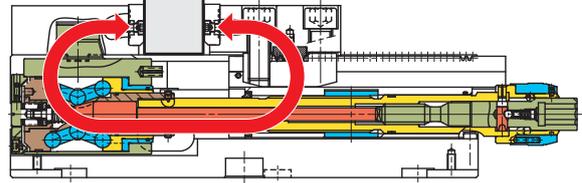
#### c) Mechanical clamping without power transmission

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.

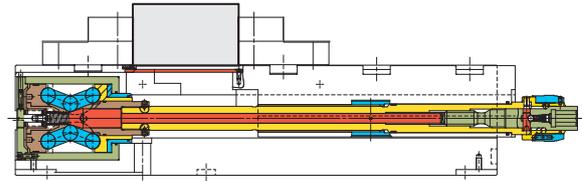
**RKK:** The power transmission guarantees that the body remains free from deformation; a very high clamping accuracy is achieved.



Type RKK

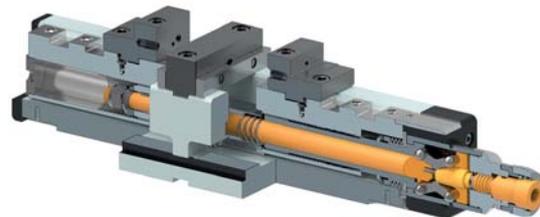


Type RKE

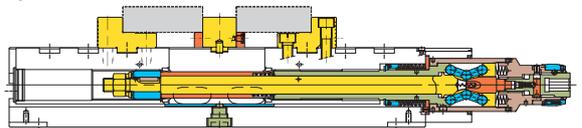


### TWIN CLAMPING

Movable clamping jaw I is brought to the workpiece in Station 1 by clockwise turning of the spindle using the hand-crank, and held there at a clamping force of approx. 100 daN ("third hand function"). Continuing to turn the crank brings movable clamping jaw II to the workpiece in Station II and fixes it there. Turning the hand-crank further in clockwise direction all the way exceeds the release torque of the coupling pin and initiates mechanical power transmission of the toggle lever. The accumulating pressure is distributed evenly over the push-and-draw spindle on the clamping jaws. Compensating springs compensate for dimensional variations up to  $\pm 3\text{mm}$  between workpiece I and workpiece II. During tensioning, both clamping stations must be occupied by identical workpieces!

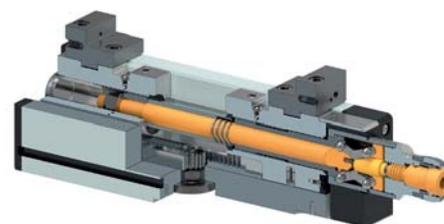


Type RKD

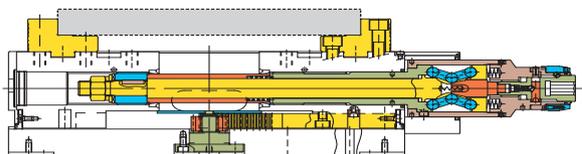


### CENTRIC CLAMPING

The two movable clamping jaws are brought to the workpiece by clockwise turning of the spindle with the hand-crank (left-hand/right-hand thread). Turning the hand-crank further in clockwise direction all the way exceeds the release torque of the coupling pin and initiates mechanical power transmission of the toggle lever. The accumulating pressure is distributed evenly over the push-and-draw spindle on the clamping jaws. Form-fitted racks in the lower area of the main jaw mesh towards the center into a centrally mounted gear. This connection effects the synchronous, respectively simultaneous central motion of the movable clamping jaw over the entire clamping stroke, regardless of clamping force and clamping span.



Type RKZ





## 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.



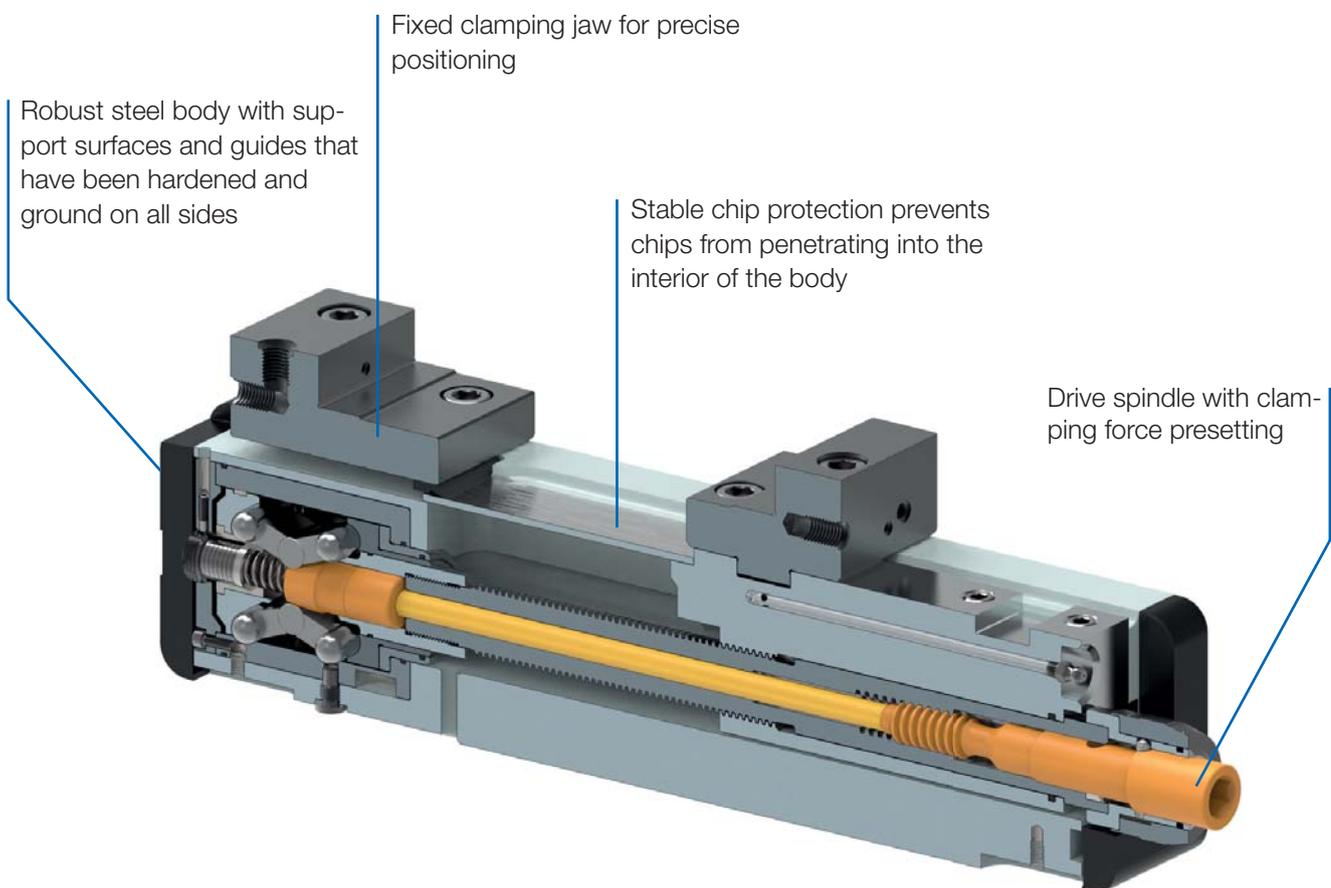
Video RKE

# 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





### 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

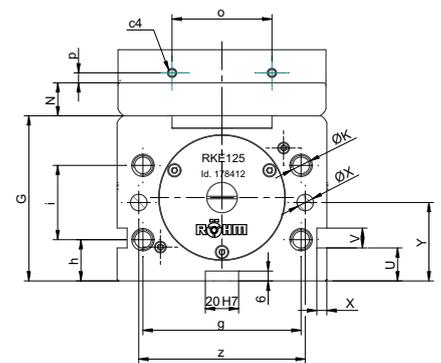
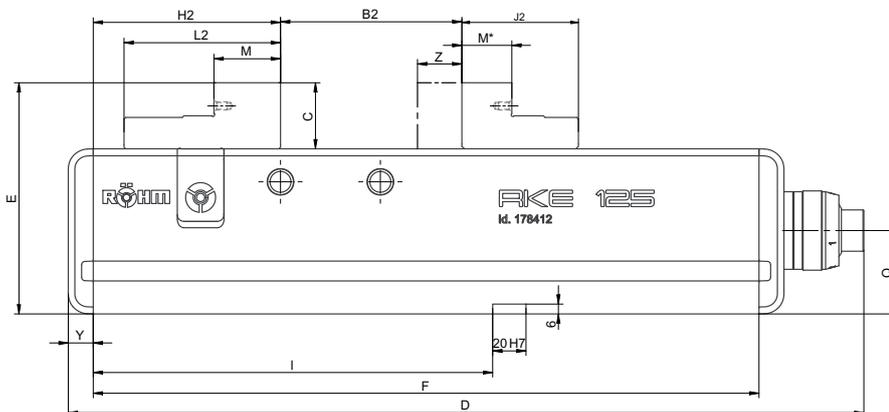
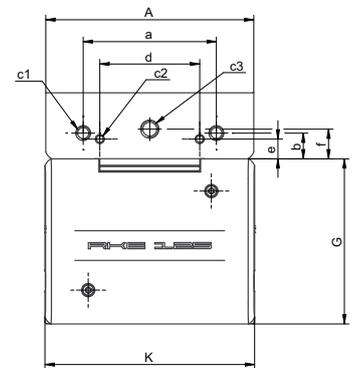
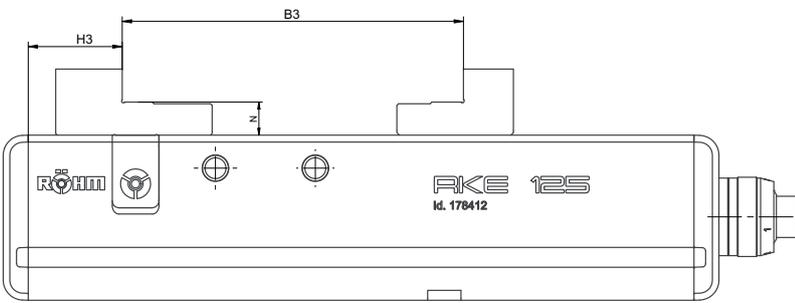
- ④ Horizontal, side or in connection with a base plate vertical mounting, for example as DUO clamping tower (back to back)
- ④ Sturdy chip protection prevents chips from penetrating
- ④ Drive spindle with clamping force presetting
- ④ Clamping surface for clamping claws
- ④ Central lubrication of guides and spindle thread
- ④ 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

A32  
RKE with stepped jaws

Item no.	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	330	463	618	618
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
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



# 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
168693	set	125	62	60
175387	set	160	95	75



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

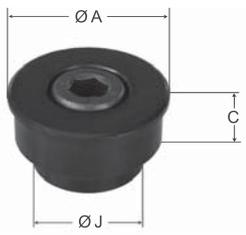
**Swivelling claw inserts for carrier jaws 743-72**


Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	C 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	C 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

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

A37

**Claw jaws 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

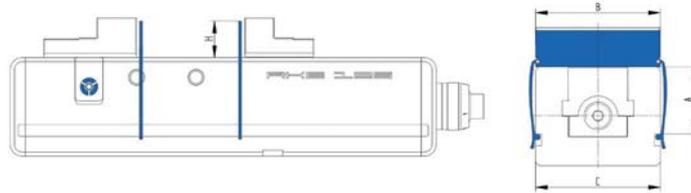
# Accessories RKE

A37

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


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661	set	125	92	32	14
166667	set	160	125	40	16
166669	set	200	160	50	18

A37

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


Item no.	Web height A mm	Jaw width B mm	Rail height H mm	Guiding width C mm	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	160/200	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, only suitable for double clamping


Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking 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

A37

**Normal jaw SGNA**, with movable workpiece stop, hardened and ground, only suitable for double clamping


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

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

A37

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


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

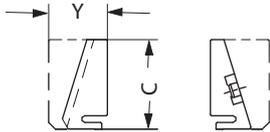
# Accessories RKE

A37

**Draw-down jaws RNG**, with two permanent magnets

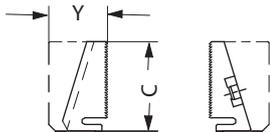
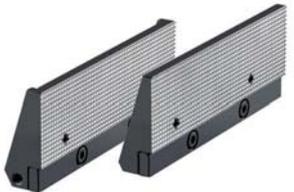

Item no.	Contents of delivery	Size	Width mm	Height mm
155237	set	92	92	32
159227	set	125	125	39,5
155240	set	160	160	50
163782	set	200	200	60

A37

**Standard insert RNS**, held by two permanent magnets


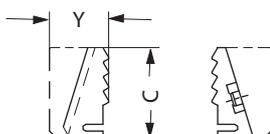
Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242	set	92	92	32	21
159232	set	125	125	40	26
155245	set	160	160	50	30
163783	set	200	200	60	34

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

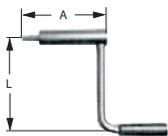
**Floating jaw horizontal PEB** for clamping non-parallel workpieces



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 mm	L mm
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 mm	B mm	C mm
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

# Accessories RKE / RKK



### APPLICATION

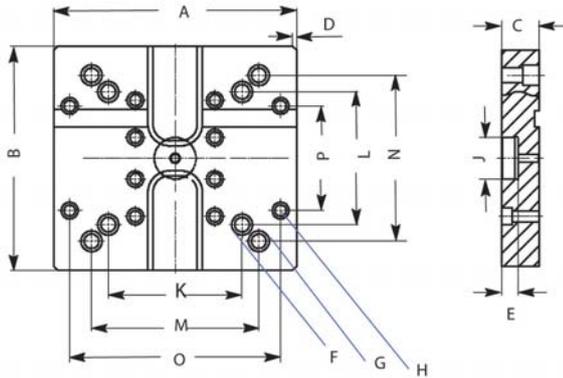
Suitable for the complete setup of two NC-compact vices, back-to-back.

### TYPE

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

### TECHNICAL FEATURES

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

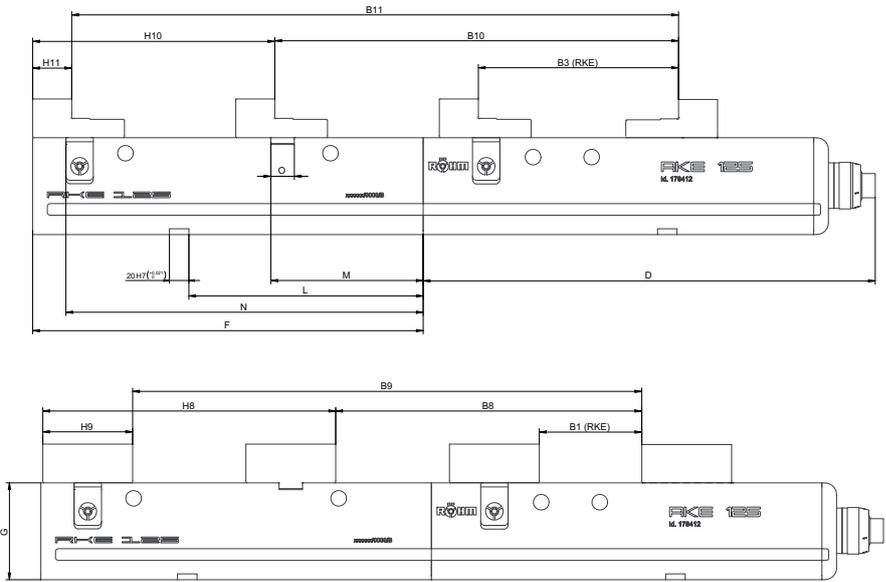


A37

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

Item no.	164016 ▲	164018 ▲	164020 ▲	164022 ▲	164024 ▲	164026 ▲
For	RKD 92 / RKD-M 92	RKK 92 / RKE 92	RKK 113 / RKE 125 / RKD 125 / RKZ 125	RKK 135	RKK 160 / RKK 200	RKE 160 / (RKE 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



A37  
**Extension GKV** for extension of clamping capacity, for extra-long workpieces (**only RKE**),  
 Fastening with screws (included in the scope of delivery)

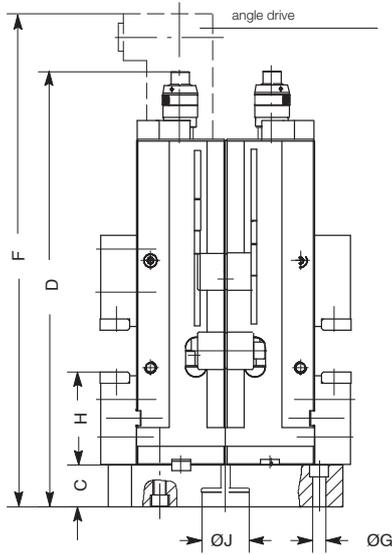
Item no.	178418	178419	178420	178421	178422	178423
For	RKE 125	RKE 125	RKE 125	RKE 160	RKE 160	RKE 160
D	463	463	463	618	618	618
F	105	200	400	190	295	530
G	100	100	100	115	115	115
L	-	-	240	-	-	200
M	-	-	156	-	-	225
N	68	160	364	150	253	493
O	24	24	24	30	30	30
B1	0-215	0-215	0-215	0-320	0-320	0-320
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



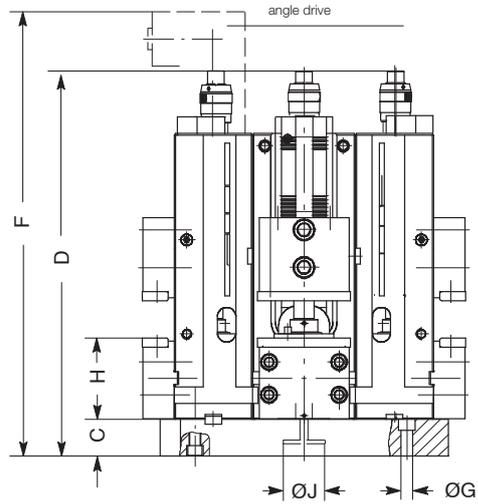
# Notes

# Duo and Quattro clamping towers RKE

Duo-clamping towers (on request)



Quattro-clamping towers (on request)



DUO- / QUATTRO clamping towers

**Technical data**

Size	RKE 125	RKE 160 RKE 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

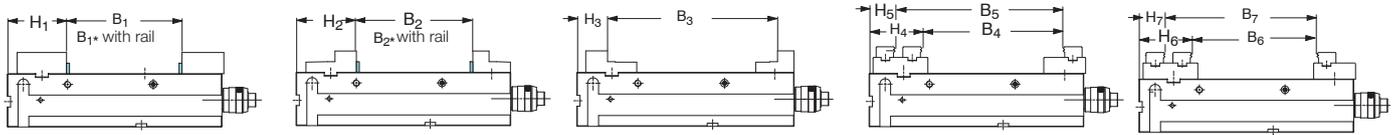
\* On inquiry insert dimensions please

**Technical data**

Size	RKE 125	RKE 160 RKE 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

# Clamping range RKE

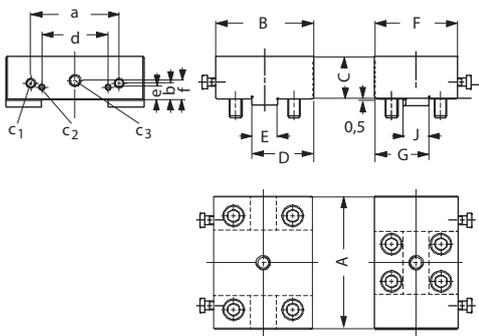


	Standard jaws		Stepped jaws		Carrier jaws with pronged inserts					
	H1	B1 B1* with rail	H2	B2 B2* with rail	H3	B3	H4/H5	B4/B5	H6/H7	B6/B7
RKE 125	110,5	0-215	112,5	0-216	56,5	97-312	H4: 98 H5: 48	B4: 50-262 B5: 100-321	H6: 98 H7: 48	B6: 20-232 B7: 70-282
RKE 160	130	0-320	130	0-320	64	131-451	H4: 122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

# Clamping jaw dimensions for NC-Compact vices

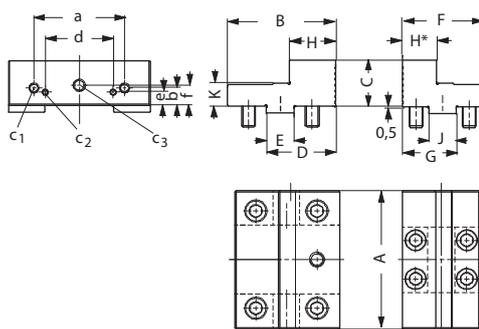
Clamping range RKE

### Standard top jaws - set



Jaw width	125	160	200
<b>Id.-Nr.</b>	<b>162628</b>	<b>162629</b>	<b>162984</b>
B	92	100	105
C	40	50	60
D	58	65	65
E <sub>h7</sub>	24	30	30
F	78	100	100
G	51	65	65
J <sub>g6</sub>	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
<b>Id.-Nr.</b>	<b>162851</b>	<b>160343</b>	<b>162630</b>	<b>162985</b>
B	64	94	98	103
C	32	40	50	60
D	42	60	65	70
E <sub>h7</sub>	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 <sub>g6</sub>	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



## 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

- ④ With tension clamping, zero point of the workpiece on the operator side
- ④ Large clamping range
- ④ High-precision positioning
- ④ Stable chip guard for longer life

## TECHNICAL FEATURES

- Sturdy steel basic body and all guides are hardened and ground on all sides
- Compact design
- 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

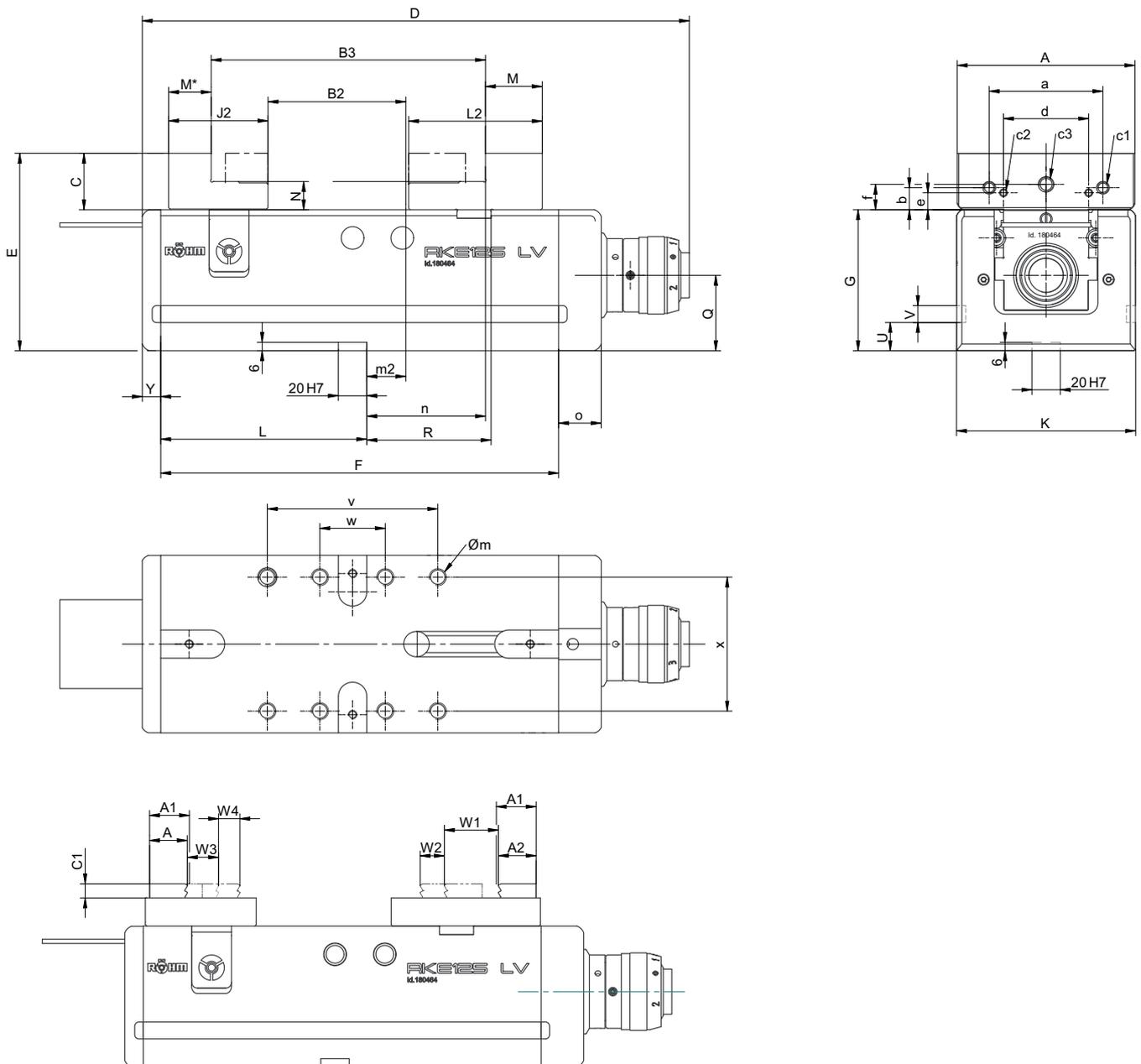
A32

**RKE-LV**, with reversible stepped jaws or carrier jaws

NC-Compact vices  
RKE-LV

Item no.	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	M10	-
c2	M8	-
c3	M5	-
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



NC-Compact vices  
RKE-LV

# Accessories RKE-LV

A37

**Standard base plate GP**

Item no.	Contents of delivery	Size	Length mm	Width mm	Height mm	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



# Accessories RKE-LV

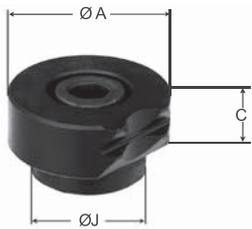
A37

**Carrier jaws, without claw inserts**

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

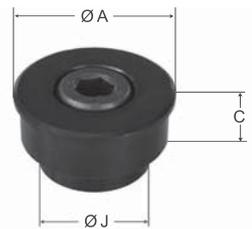


A37

**Swivelling claw inserts, for carrier jaws 743-72**


Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	C mm
165854	piece	92/125	28	20	10

A37

**Tensioner for carrier jaws 743-72**


Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	C mm
169389	piece	92/125	28	20	10

A37

**Claw jaws with fine step, 2.5 mm clamping depth**


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166520	set	160	125	40	16

A37

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

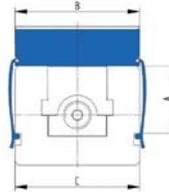
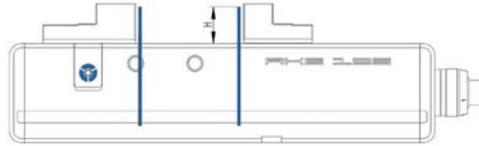

Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166667	set	160	125	40	16

# Accessories RKE-LV

A37

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


Item no.	Web height A mm	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



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	Chuck capacity mm	
					Horizontal	Vertical
082363	piece	125	135	39,6	4-20	6-40



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



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



# Accessories RKE-LV

A37

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



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

A37

**Hand crank**, turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A mm	L mm
134600	piece	125/160/200	14	104	160

A37

**90° Angle drive**



Item no.	Contents of delivery	Size	A mm	B mm	C mm
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



### 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 subject to wear and the spindle thread can be lubricated quickly and easily

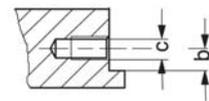
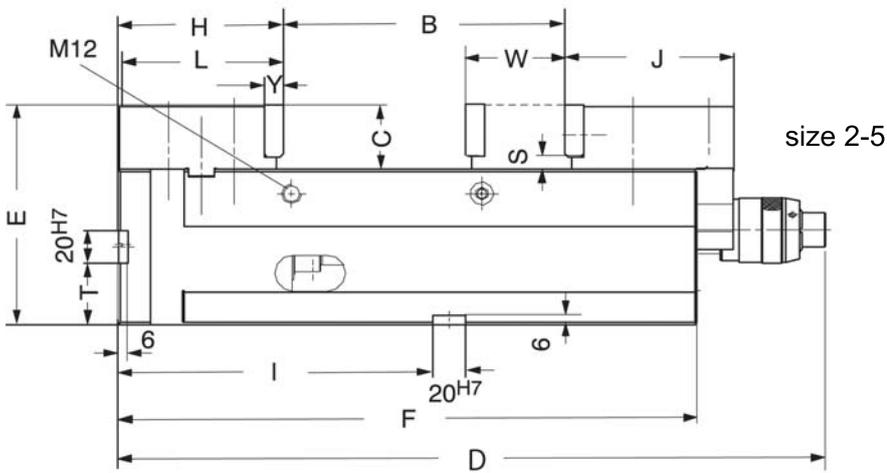
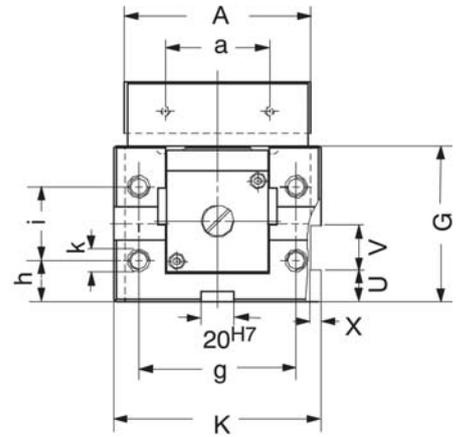
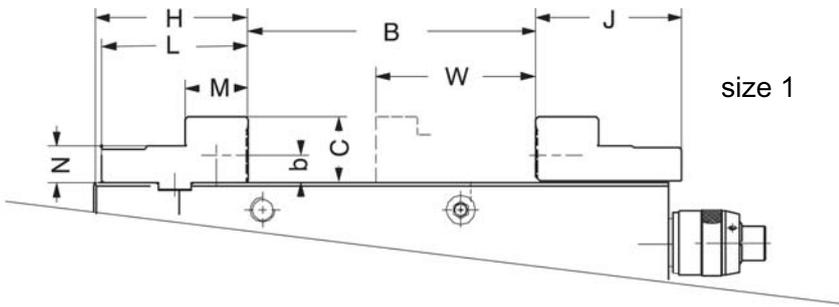
### TECHNICAL FEATURES

- 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 tothing

A32  
RKK, with standard jaws SA and SGN normal jaw

Item no.	162640 <sup>1)</sup>	151342	148545	148682	149371
Size	1	2a	3	4	5
Jaw width A mm	92	113	135	160	200
Clamping capacity B mm	0-138	0-170	0-215	0-340	0-340
C mm	32	39	49	60	70
D mm	330	424	483	618	618
E mm	112	133	148	179	189
F mm	276	350	400	525	525
G-0,02 mm	80	95	100	120	120
H-0,05 mm	73	100	110,5	130	130
J mm	70	102	102	110	110
K mm	94	125	150	205	205
L mm	70	99	109	128	128
M mm	30	-	-	-	-
N mm	18	-	-	-	-
S mm	-	7,4	9,4	10,4	7,4
T-0,02 mm	30	37,5	40	50	50
U mm	20	20	20	20	20
V mm	20	40	40	40	40
W mm	68	125	168	235	235
X mm	4,5	6,5	6,5	6,5	6,5
Y mm	-	11,6	15,6	15,6	19,6
Clamping travel mm	70	50	60	108	108
a mm	63	63	80	100	125
b mm	13,6	13,6	15,6	19,6	24,6
c mm	M6x11	M6x12	M8x13	M8x13	M10x15
g mm	70	95	110	145	145
h mm	20	25	22,5	20	20
i mm	40	45	55	80	80
k x depth	M10x12	M12x20	M12x22	M16x20	M16x20
l-0,02 mm	140	190	240	365	365
Clamping force kN	25	40	40	60	60
Weight kg	15	35	50	107	108

<sup>1)</sup> With stepped jaws



# 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
149233	set	2a	109	39
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
149239	set	2a	108	49
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
148687	set	2a	110	25
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	Ø J mm	C mm
146070	piece	3/4/5/2a	30	20



A37

**Claw jaws 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



# Accessories RKK

A37

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



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661	set	125	92	32	14
166667	set	160	125	40	16
166669	set	200	160	50	18

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
152753	piece	2a	113	31,6
152754	piece	3	135	39,6
152755	piece	160	160	49,6
152759	piece	200	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	92	92	31,6
156195	piece	2a	113	31,6
156196	piece	3	135	39,6
156197	piece	160	160	49,6
156198	piece	200	200	62,6

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
082362	piece	2a	113	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

A37

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



Item no.	Contents of delivery	Size	Width mm	Height mm
077104	set	2a	113	31,6
077105	set	125	135	39,6
077106	set	160	160	49,6
077107	set	200	200	62,6

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	2a	110	31,8	3-12	5-32
317260	set	125	135	39,8	3-13	6-40
317261	set	4	160	49,8	5-22	7-48

Accessories NC-Compact vices RKK

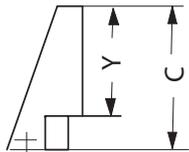
# Accessories RKK

A37  
Normal jaw SGNA, with movable workpiece stop, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
150739	piece	2a	113	31,6
150740	piece	125	135	39,6
150741	piece	4	160	49,6

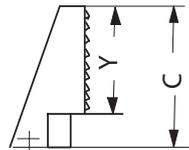
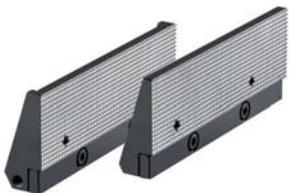
A37  
Standard inserts NCS, hardened and ground for machined workpieces without angular error



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
147953	set	2a	110	49	36
147954	set	3	135	53	40
147955	set	4	160	67	50
158823	set	5	200	67	50

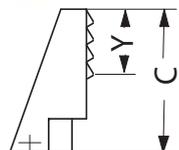
Accessories NC-Compact vices RKK

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
163227	set	2a	110	49	36
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

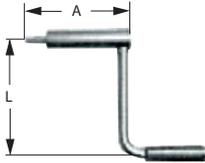


Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
148916	set	2a	110	49	24
148917	set	3	135	53	24
148918	set	4	160	67	45
159447	set	5	200	67	45

# Accessories RKK

A37

**Hand crank, turnable handle, hexagon socket**



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

A37

**90° Angle drive, for RKK 92 / RKE-L 92, for fastening NC-compact vices, advantageous for front-sided set-up or for large machine tables**



Item no.	Contents of delivery	Size	A	B	C
154185	piece	92	113,5	90	83,5

A37

**90° Angle drive, for RKK 2-5**



Item no.	Contents of delivery	Size	A	B	C
151650	piece	2/2a	154	93,5	98
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

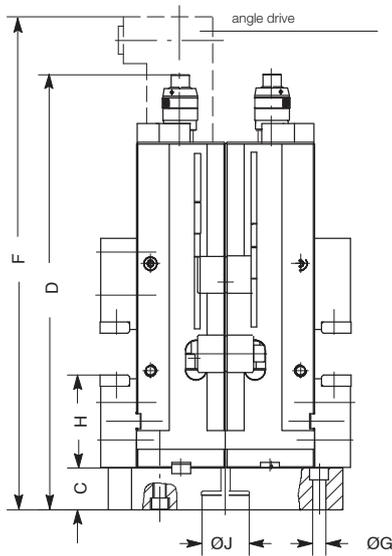
**Fixed slot nuts NTS, hardened and ground, with fixing screw**



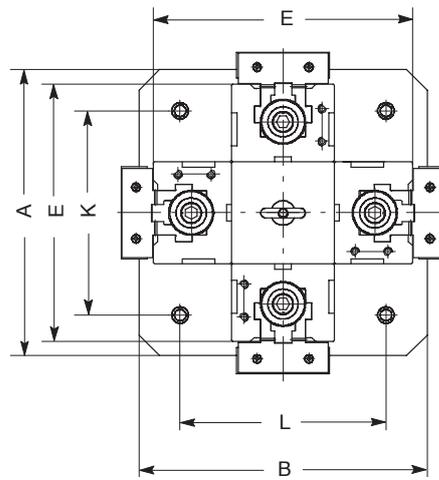
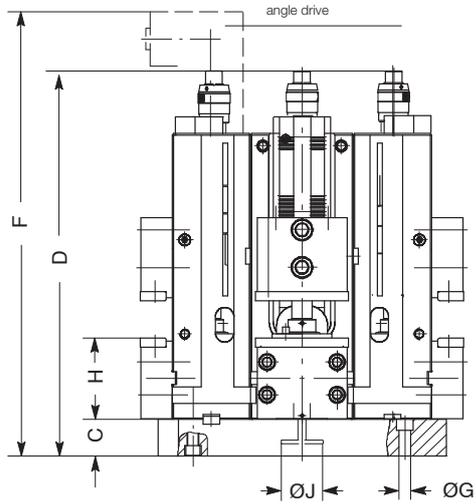
Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

# Duo and Quattro clamping towers RKK

Duo-clamping towers (on request)



Quattro-clamping towers (on request)



DUO- / QUATTRO clamping tower

Technical data

Size	RKK 92	RKK 113 RKK 113a	RKK 135	RKK 160	RKK 200
Jaw width	92	113	135	160	200
A	250	250	290	350	350
B	250	250	270	350	350
C	45	45	45	45	45
D	375	469	528	663	663
E	160	190	200	240	240
F	435	549	606	744	744
G*					
H	73	100	110,5	130	130
J*					
K*					
L*					
kg	50	90	125	260	260

\* On inquiry insert dimensions please

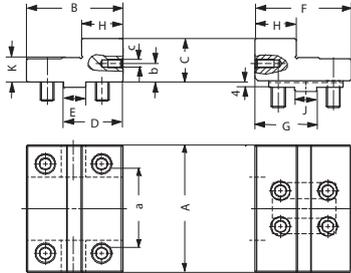
Technical data

Size	RKK 92	RKK 113 RKK 113a	RKK 135	RKK 160	RKK 200
Jaw width	92	113	135	160	200
A	320	350	400	500	500
B	320	350	400	500	500
C	45	45	45	45	45
D	375	469	528	663	663
E	254	315	350	445	445
F	435	549	606	744	744
G*					
H	73	100	110,5	130	130
J*					
K*					
L*					
kg	100	180	250	530	530

\* On inquiry insert dimensions please

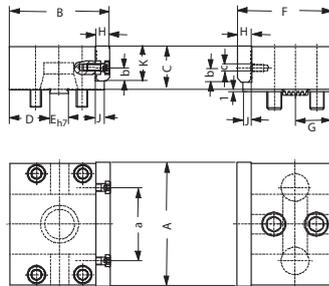
# Jaw dimensions and clamping range RKK

## With stepped jaws, reversible



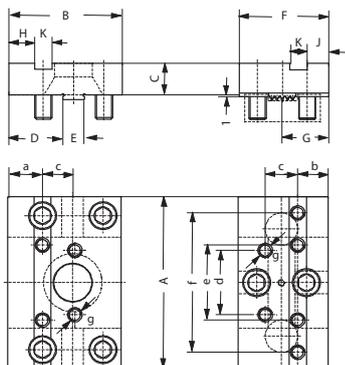
Size	1
A	92
B	70
C	32
D	43
E <sub>h7</sub>	16
F	70
G	45
H	30
J <sub>g6</sub>	16
K	18
a	63
b	13,6
c	M6

## Standard top jaws SA, reversible



Size	2/2a	3	4	5
A	113	135	160	200
B	99	109	128	128
C	39	49	60	70
D	41,5	44	50	50
E <sub>h7</sub>	16	20	20	20
F	102	102	110	110
G	38	39	42	42
H	11,6	15,6	15,6	19,6
J	7,6	9,6	9,6	13,6
K	31,6	39,6	49,6	62,6
a	63	80	100	125
b	13,6	15,6	19,6	24,6
c	M6	M8	M8	M10

## Carrier jaws, reversible



Size	2/2a	3	4	5
A	110	135	160	200
B	90	95	105	105
C	25	30	30	30
D	41	44	50	50
E <sub>h7</sub>	16	20	20	20
F	83	83	83	83
G	43	43	43	43
H	41	21	24	24
J	20	20	20	20
K <sub>H7</sub>	16	16	16	16
a	49	29	32	32
b	28	28	28	28
c	25	25	30	30
d	50	60	70	70
e	80	60	70	110
f	-	110	130	160
g	M12	M12	M12	M12

## Clamping ranges: External clamping RKK

Size	Carrier jaws with pronged inserts	Carrier jaws with pronged inserts	Stepped jaw / Stepped jaw, reversed
1	-	-	B9: 0-138 / B10: 84-222
2+2a	59-233	89-263	
3	30-257	110-337	
4+5	59-395	144-481	

Jaw dimensions / clamping range RKE



## 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.

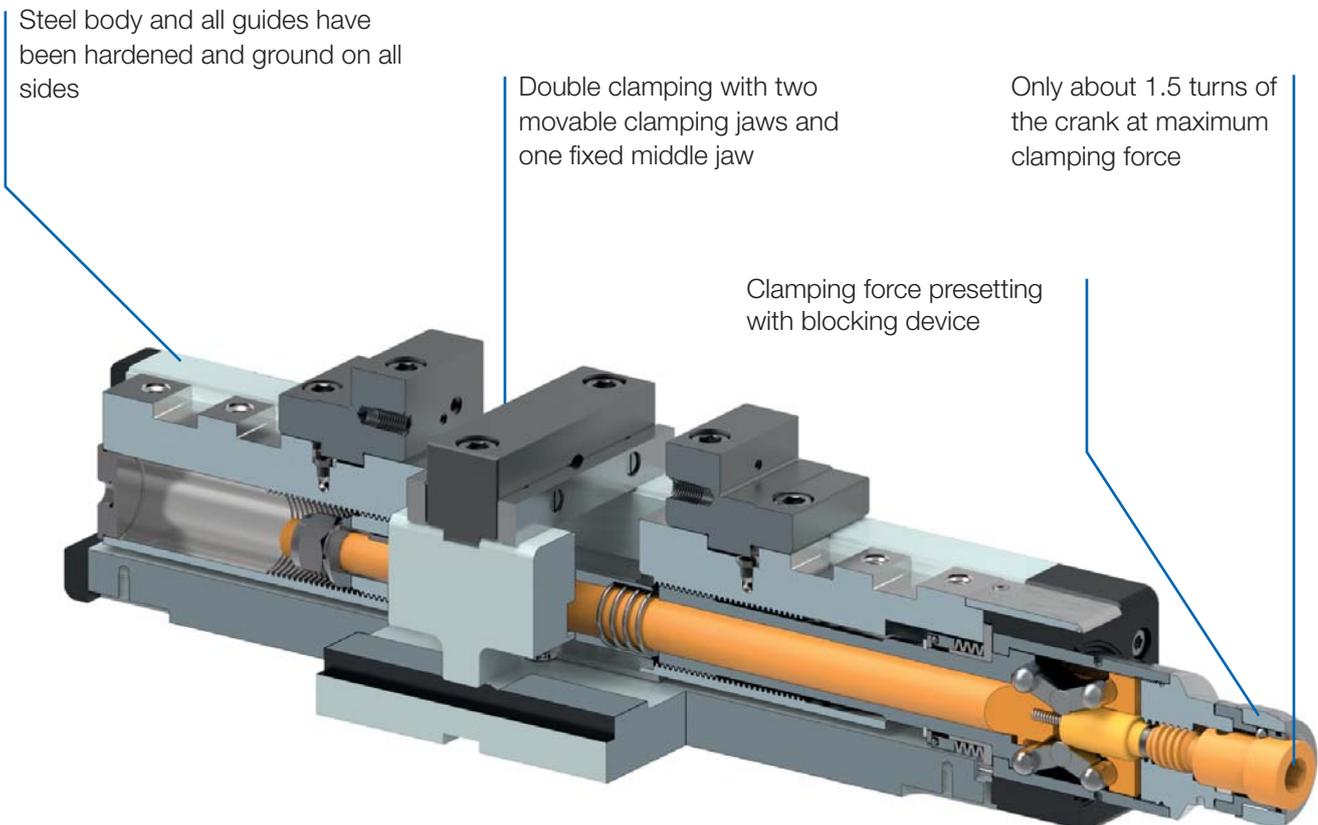
Balance springs compensate dimensional discrepancies from up to  $\pm 3$  mm between workpiece I and workpiece II.

# 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





### APPLICATION

Optimized for flexible clamping tasks on machining centers and other production systems.  
3-sided set-up: bottom side, front side, lateral side.

### TYPE

Size 92 - clamping system mechanical-hydraulic with power transmitter, manually operated.  
Only approx. 1 1/2 crank turns at max. clamping force.

### CUSTOMER BENEFITS

- ④ High repeatability of 0.01 as well as a constant clamping force for every clamping operation
- ④ No overload of the vice at max. clamping force
- ④ Self-locking force transfer
- ④ The clamping thread of the spindle is protected from dirt and chips in every basic jaw position
- ④ With grease nipples installed on both sides, that all guides and the spindle thread can be lubricated quickly and easily

### TECHNICAL FEATURES

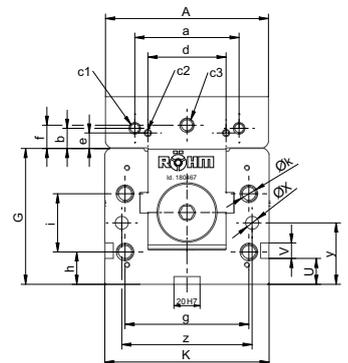
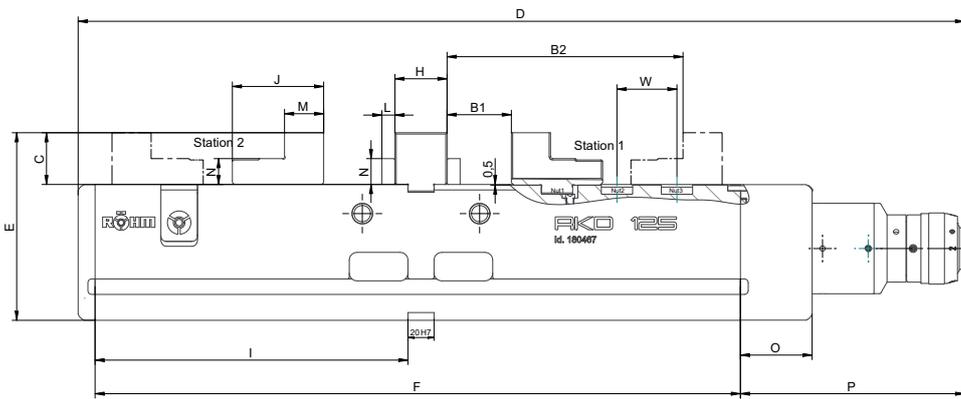
- Clamping force pre-setting with blocking mechanism
- Double clamping with two moving clamping jaws (left/right thread) and a stationary center jaw
- Steel basic body as well as all guides hardened and ground on all sides.
- Fastening only possible with clamping claws
- Thread for fastening angle drive

A32  
RKD, with reversible stepped jaws and centre jaw

Item no.	180466	180467
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	512	680
E mm	117	145
F mm	356	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	55	55
P mm	144	172
T-0,02 mm	30	37,5
U mm	20	20
V mm	12	12
W mm	1 x 48	2 x 46
X x depth	10H7x 12	10H7 x 12
Y mm	12	13
Z mm	50	50
a mm	63	80
b mm	13,6	15,6
c1	M6x14	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	170	240
y±0,01 mm	40	47,5
z mm	72	100
Clamping force kN	25	40
Weight kg	24	53



NC-Compact twin vices RKD



# Accessories RKD

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

**Claw jaws 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

A37

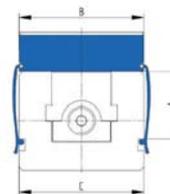
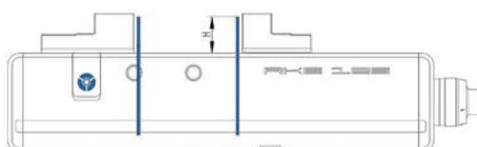
**Claw jaws without step**, universal for clamping depth >2.5 mm


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

A37

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


Item no.	Web height A mm	Jaw width B mm	Rail height H mm	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



# Accessories RKD

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

A37

## Work support WAM, for center jaws



Item no.	Contents of delivery	Size	A mm	B mm	C mm	d mm	e mm
159613	set	92	92	10	16	48	8
158599	set	125	125	10	20	60	12

A37

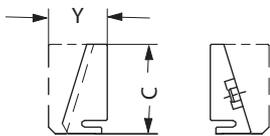
## Draw-down jaws RNG, with two permanent magnets



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

A37

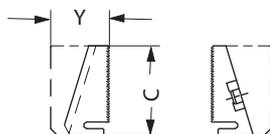
## Standard insert RNS, held by two permanent magnets



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

A37

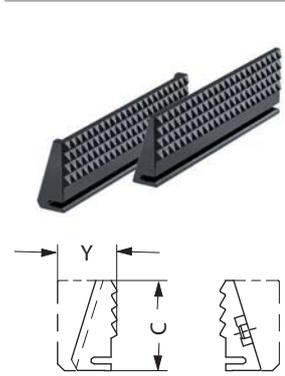
## Standard insert finely checkered RNSf, held by two permanent magnets



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

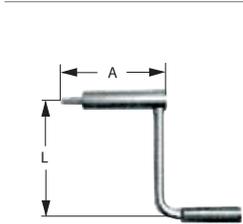
# Accessories RKD

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

A37

**Hand crank**, turnable handle, hexagon socket


Item no.	Contents of delivery	Size	Hexagon	A mm	L mm
134600	piece	125/160/200	14	104	160

A37

**Angle drive**


Item no.	Contents of delivery	Size	A mm	B mm	C mm
159647	piece	92	162	92	98
159015	piece	125	190	110	98

A37

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


Item no.	Contents of delivery	Size	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



# Notes

# RKD-M



## 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

- ③ Large clamp stroke, 50 mm per jaw
- ③ The clamping thread of the spindle is protected from dirt and chips in every basic jaw position
- ③ With grease nipples installed on both sides, that all guides and the spindle thread can be lubricated quickly and easily
- ③ 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

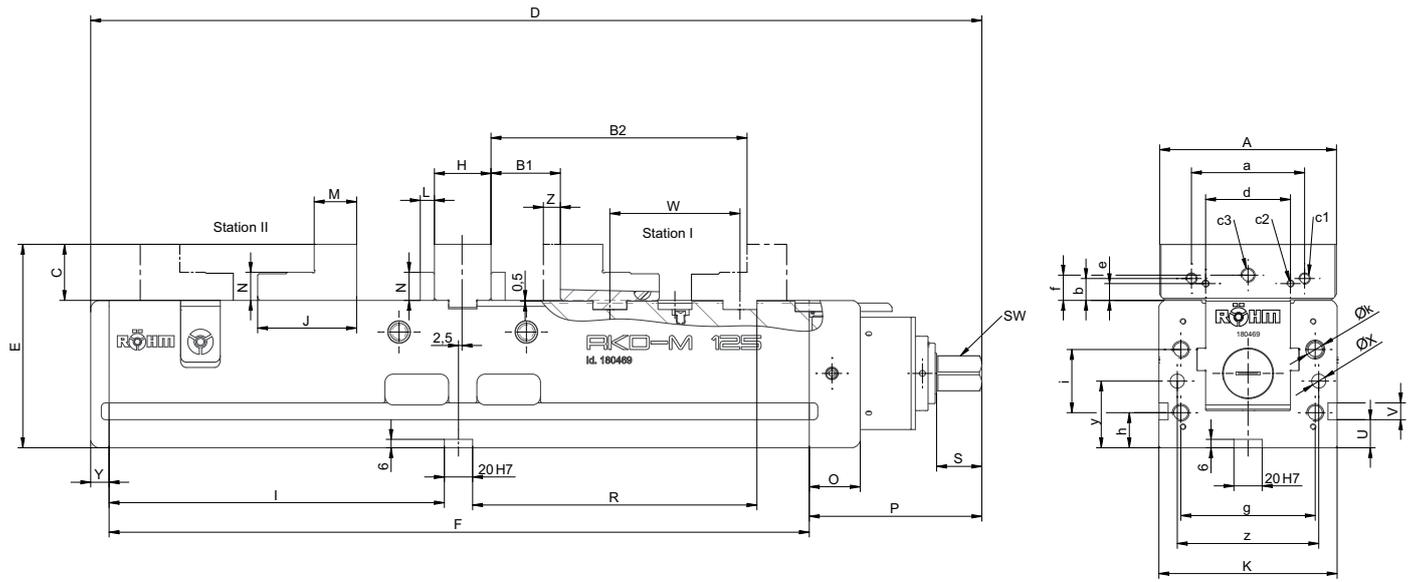
A32  
RKD-M, with reversible stepped jaws and centre jaw

Item no.	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	512	680
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



NC-Compact twin vices RKD-M



# 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	Chuck 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 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

# Accessories RKD-M

A37

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



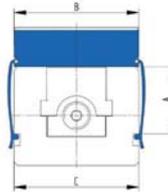
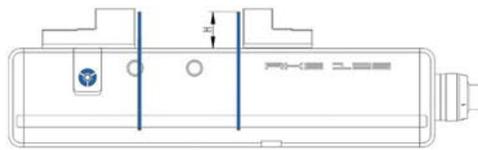
Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661	set	92	92	32	14
166667	set	125	125	40	16

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



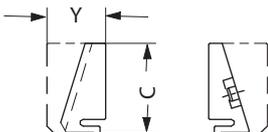
Item no.	Contents of delivery	Size	Width mm	Height mm
155237	set	92	92	32
159227	set	125	125	39,5

A37

**Standard insert RNS**, held by two permanent magnets



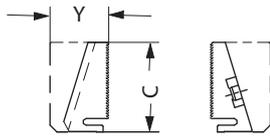
Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242	set	92	92	32	21
159232	set	125	125	40	26



# Accessories RKD-M

A37

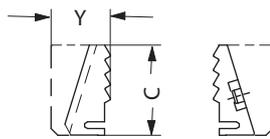
**Standard insert finely checkered RNSf**, held by two permanent magnets



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

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

Accessories NC-Compact vices RKD-M

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	Height mm
162633	set	92	92	32
160344	set	125	125	40

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

# Accessories RKD-M

C15

**Hand crank HKU**, with octagon socket



Item no.	Contents of delivery	Size	Octagon	L
009153	piece	92	17	160
009154	piece	125	19	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

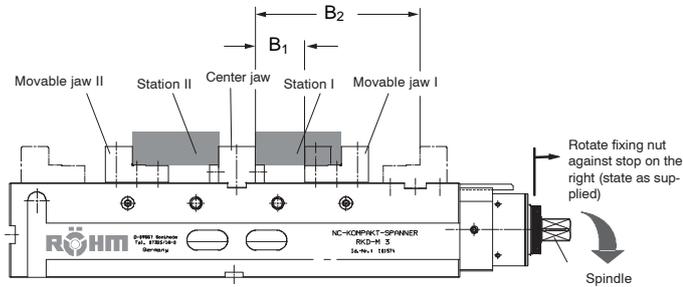
**Fixed slot nuts NTS**, hardened and ground, with fixing screw



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

# Clamping range RKD-M

## Clamping ranges: Twin clamping



**Function:**

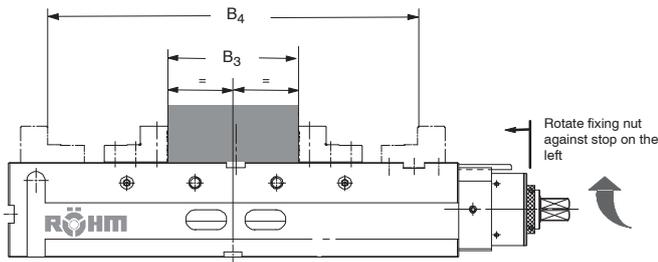
To adjust mobile jaw I with regard to the workpiece of station I turn the spindle to the right by means of the handle (left-right handed thread). About 1 kN are applied to keep the jaw in the adjusted position (third-hand function). By further turning the lever, mobile jaw II is adjusted with regard 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  $\pm 3$  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: 50mm  
Station II: 56mm

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

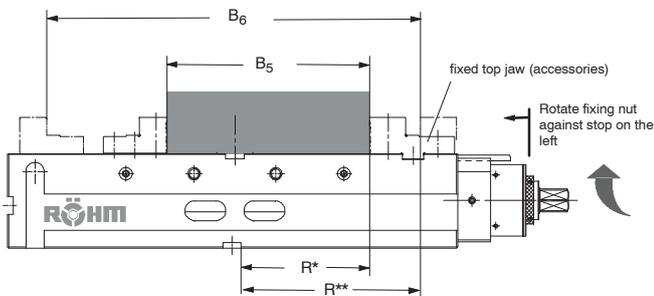
## Clamping ranges: Centric clamping



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

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

## Clamping ranges: Single clamping

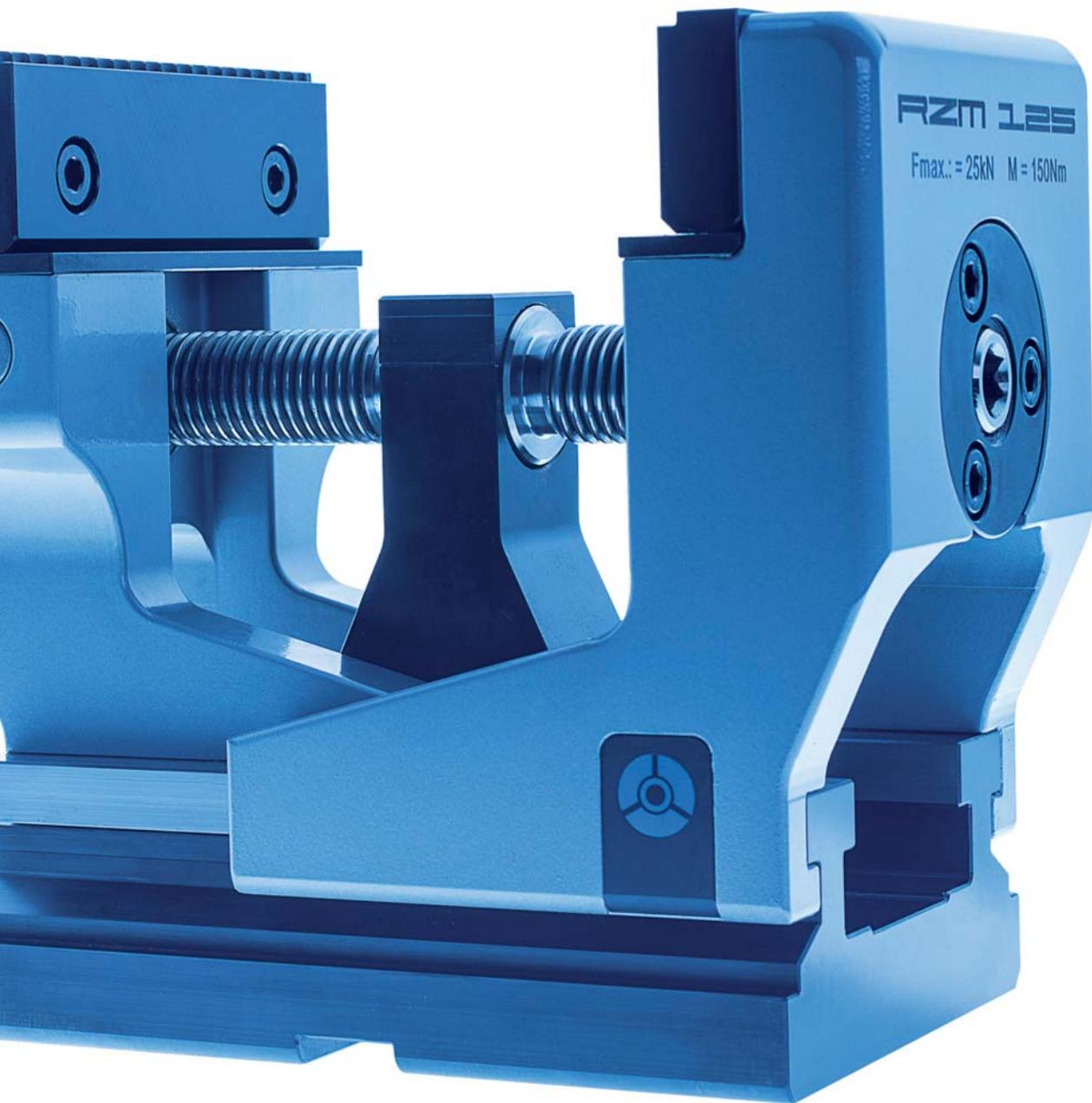


Remove central jaw and movable mounting jaw I.  
Install fixed mounting jaw (accessory - not in scope of delivery).  
Fixing nut - stop on the left (spindle rigid)  
Stroke of moving jaw: "Z" 53mm

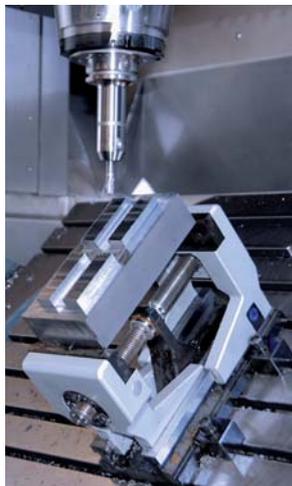
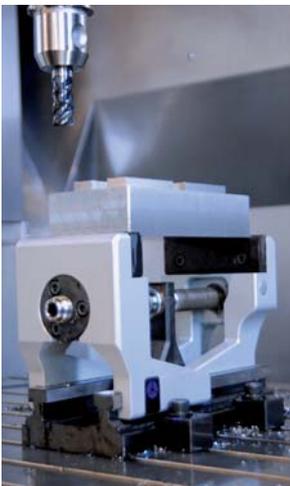
Size		92	125
B <sub>5</sub>	Groove 1	126 - 177	171 - 222
	Groove 2	174 - 225	217 - 268
	Groove 3	-	263 - 314
B <sub>6</sub>	Groove 1	196 - 247	267 - 318
	Groove 2	244 - 295	313 - 364
	Groove 3	-	360 - 410
	R*	101	141
	R**	140	197



# Notes



## 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.



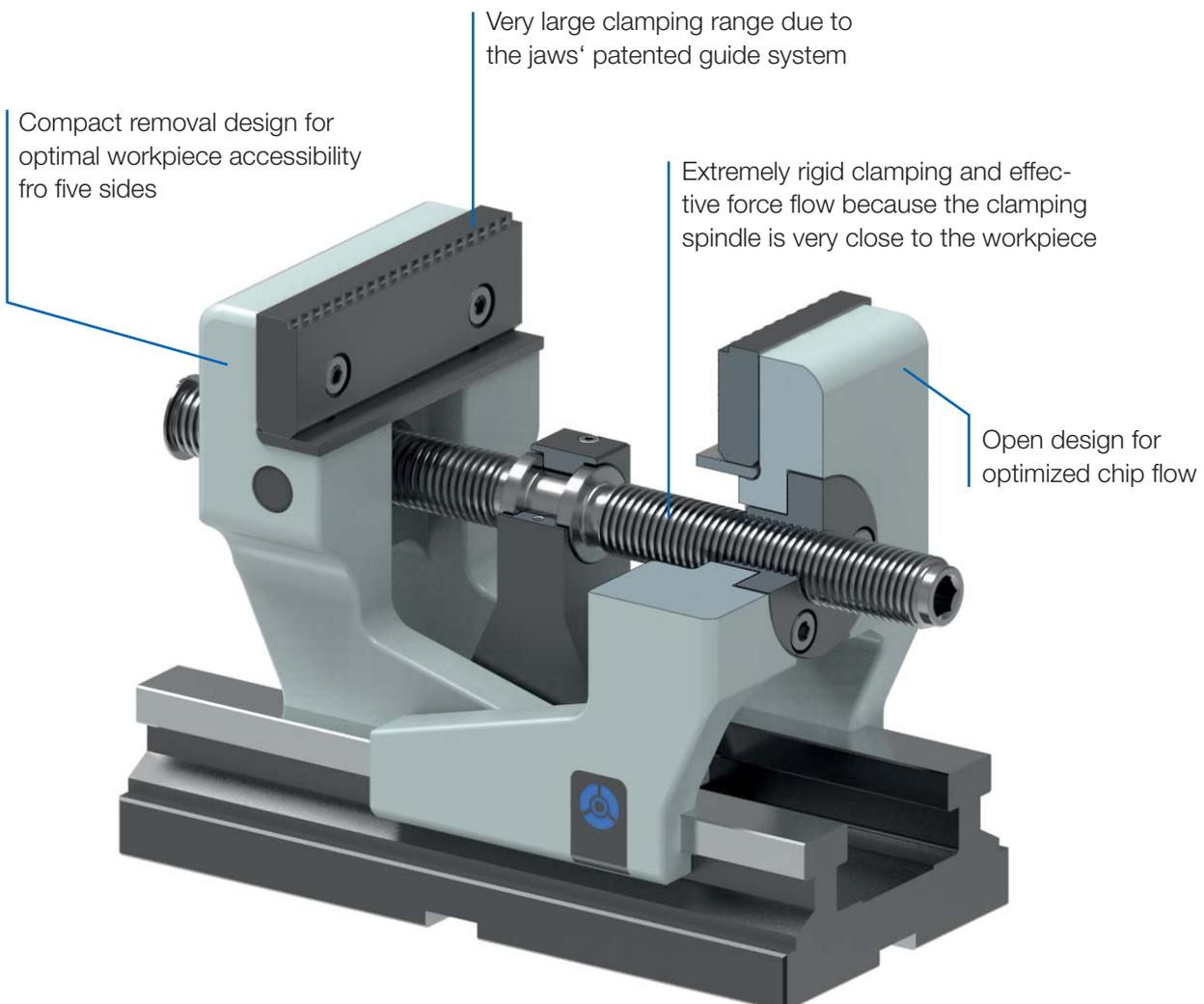
Video RZM

# 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





**APPLICATION**

Optimized for 5-axis machining.

**TYPE**

Clamping system mechanical without power transmitter, manually operated. Centric clamping with two moving jaws.

**CUSTOMER BENEFITS**

- ③ Ideal guidance characteristics of the jaws thanks to patented guidance system
- ③ Very large clamping stroke
- ③ Open design for optimized chip flow, which permits easy cleaning, after heavy duty machining
- ③ Constant clamping force for every clamping operation and high clamping repeatability when a torque wrench is used
- ③ 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/mm<sup>2</sup> to a cutting depth of 2.5 mm

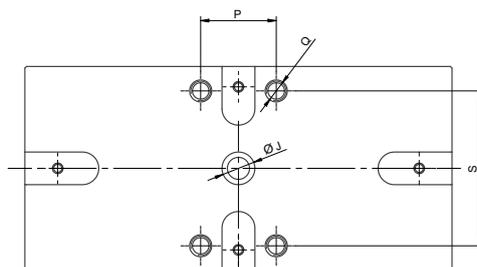
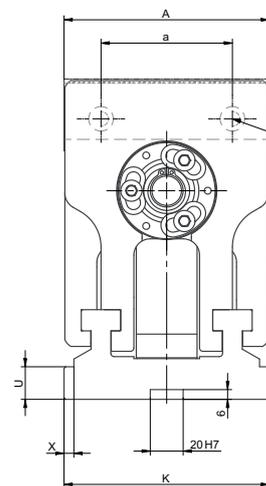
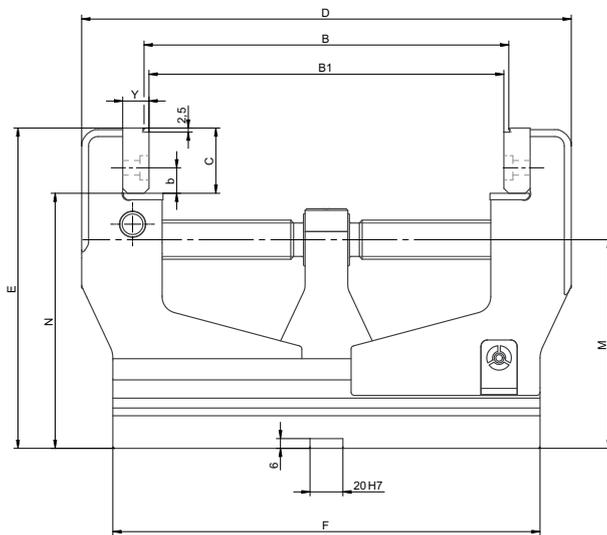
**TECHNICAL FEATURES**

- Steel 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

NC-Compact self centering vice RZM

A32  
RZM

Item no.	178910	178911
Jaw width A mm	125	125
Design	long design	short design
B min.	23	23
B max.	222	142
B1 mm	17-216	17-136
C mm	128	128
D mm	298	218
E mm	196,5	196,5
F mm	260	180
N mm	156,5	156,5
U mm	20	20
X mm	6	6
Clamping force kN	25	25
Tightening torque Nm	150	150
Weight kg	20,3	17,4



# Accessories RZM

A37

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



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166667	set	160	125	40	16

A37

**Claw jaws with fine step**, 2.5 mm clamping depth



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166520	set	160	125	40	16

A37

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



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

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
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	Chuck capacity mm	
							horizontal	vertical
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
150740	piece	125	135	39,6

A37

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



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

A37

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



Item no.	Contents of delivery	Length mm	Diameter mm
178958	piece	218	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



### APPLICATION

Optimized for 5-axis machining.

### TYPE

Clamping system mechanical-mechanical with power transmitter, manually operated.  
Centric clamping with two moving jaws.

### CUSTOMER BENEFITS

- ⊕ Horizontal, vertical or side mounting
- ⊕ High repeatability and constant clamping force
- ⊕ Clamping accuracy at the centre:  $\pm 0.01$  - clamping repeatability: 0.01
- ⊕ 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

### TECHNICAL FEATURES

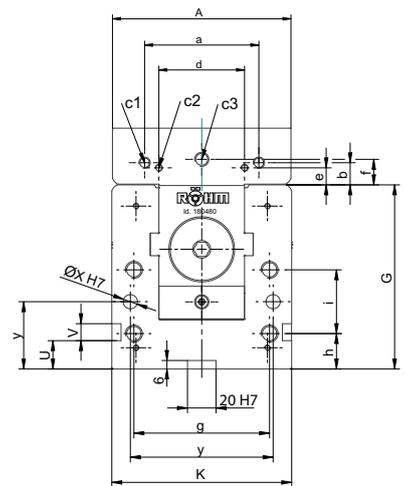
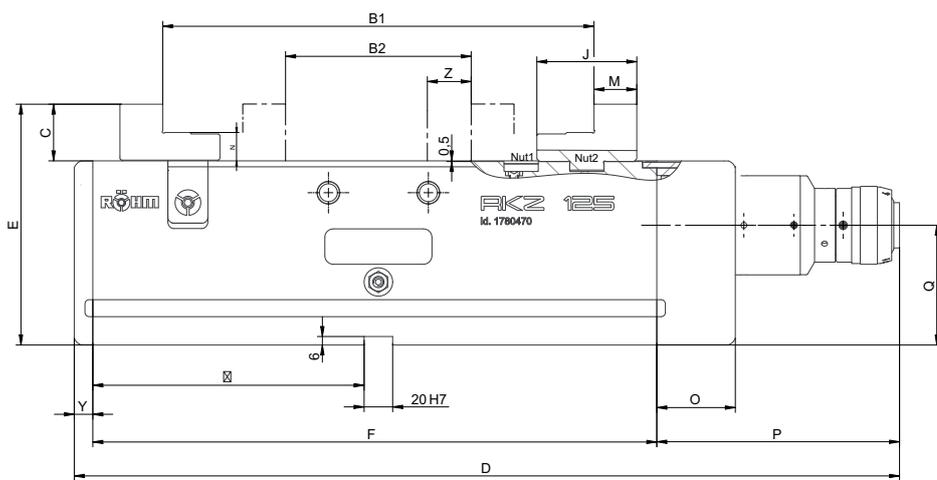
- Steel body as well as all guides hardened and ground on all sides
- Standard-equipped with stepped top jaws
- Vice fastening only possible with clamping claws

A32  
RKZ, with stepped jaws

Item no.	180470
Jaw width A mm	125
B1 slot 1 mm	112-206
B1 slot 2 mm	204-298
B2 slot 1 mm	32-126
B2 slot 2 mm	124-218
C mm	40
D mm	578
E mm	170
F mm	395
G-0,02 mm	130
J mm	70
K mm	126
M mm	30
N-0,01 mm	20
O mm	55
P mm	170
Q mm	84,5
T-0,02 mm	37,5
U mm	20
V mm	12
W mm	46
X x depth	10 H7 x 12
Y mm	12
Stroke Z mm	50
a mm	80
b mm	15,6
c1	M8x14
c2	M5x10
c3	M10x18
d mm	60
e mm	12
f mm	18
g mm	95
h mm	25
i mm	45
I-0,02 mm	190
y $\pm$ 0,01 mm	47,5
z mm	100
Clamping force kN	40
Weight kg	50,5



NC-Compact self centering vice RKZ



# Accessories RKZ

A37

**Stepped jaws SB**, reversible, with fixing screws

Item no.	Contents of delivery	Width mm	Height mm
162631	set	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 4065!

Item no.	Contents of delivery	Size	Width mm	Height mm	Length mm	Size prism mm	Clamping dia. D1 mm		Clamping dia. D2 mm	
							slot 1	slot 2	slot 1	slot 2
169756	set	125	125	84,5	86	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
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



# Accessories RKZ

A37

**V-jaw PB**, horizontal and vertical



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm	Height prism mm	Chucking capacity mm	
							horizontal	vertical
158641	set	125	125	40	20	24	15-40	18-60

A37

**Claw jaws with fine step**, 2.5 mm clamping depth



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

A37

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



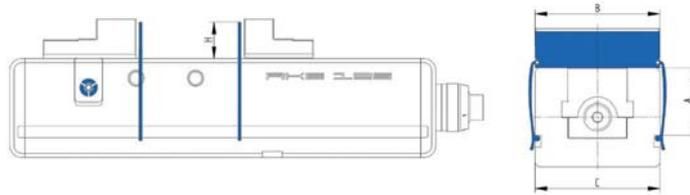
Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166667	set	125	125	40	16

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	Spare clamp (Set = 4 pieces)
1295915	98	125	10/15/20/25/28/30/33/35/36/37	1295918



A37

**Draw-down jaws RNG**, with two permanent magnets

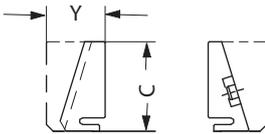


Item no.	Contents of delivery	Size	Width mm	Height mm
159227	set	125	125	39,5

# Accessories RKZ

A37

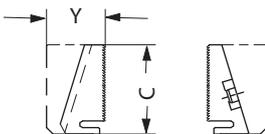
**Standard insert RNS**, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
159232	set	125	125	40	26

A37

**Standard insert finely checkered RNSf**, held by two permanent magnets

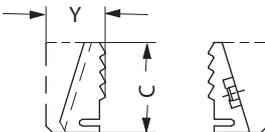


Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163267	set	125	125	40	26

Accessories NC-Compact vices RKZ

A37

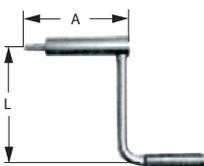
**Claw insert RNK**, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
159235	set	125	125	40	26

A37

**Hand crank**, turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A mm	L mm
134600	piece	125/160/200	14	104	160

# Accessories RKZ

A37  
Angle drive



Item no.	Contents of delivery	Size	A mm	B mm	C mm
159015	piece	125	190	110	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

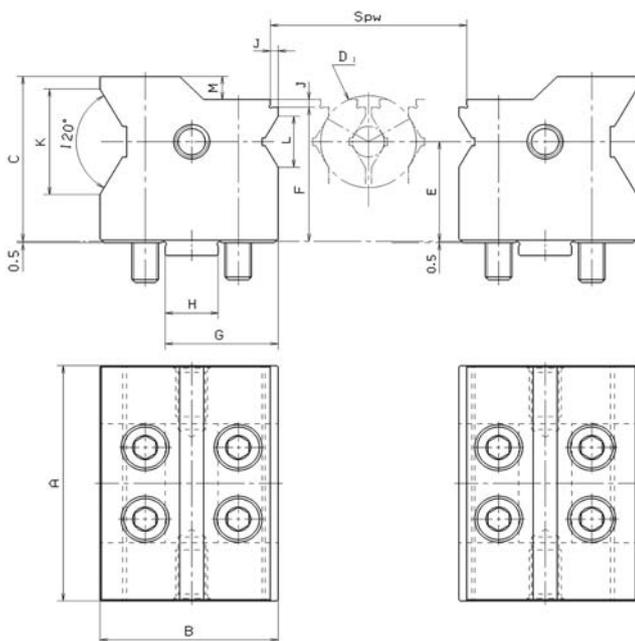
A37  
Fixed slot nuts NTS, hardened and ground, with fixing screw



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

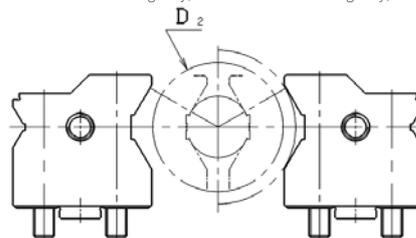
# Jaw dimensions

Double V-jaw, reversible, with fine step



Item no.	169756
Contents of delivers	set
Size A	125
B	86
C	84,5
D1	Groove 1 15-40
	Groove 2 -
D2	Groove 1 30-92**
	Groove 2 89-105
E	54
F	69,5
G	51,5
H	24
J	3
K	56
L	22,6
M	12
Clamping capacity <sup>1)</sup>	7-186

\* Ø 63-75 side loading only; \*\* Ø 72-92 side loading only; <sup>1)</sup> Clamping range example RKZ-M



# RKZ-M



## APPLICATION

Optimized for 5-axis machining.

## TYPE

Clamping system mechanical without power transmitter, manually operated. Centric clamping with two moving clamping jaws.

## CUSTOMER BENEFITS

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

## TECHNICAL FEATURES

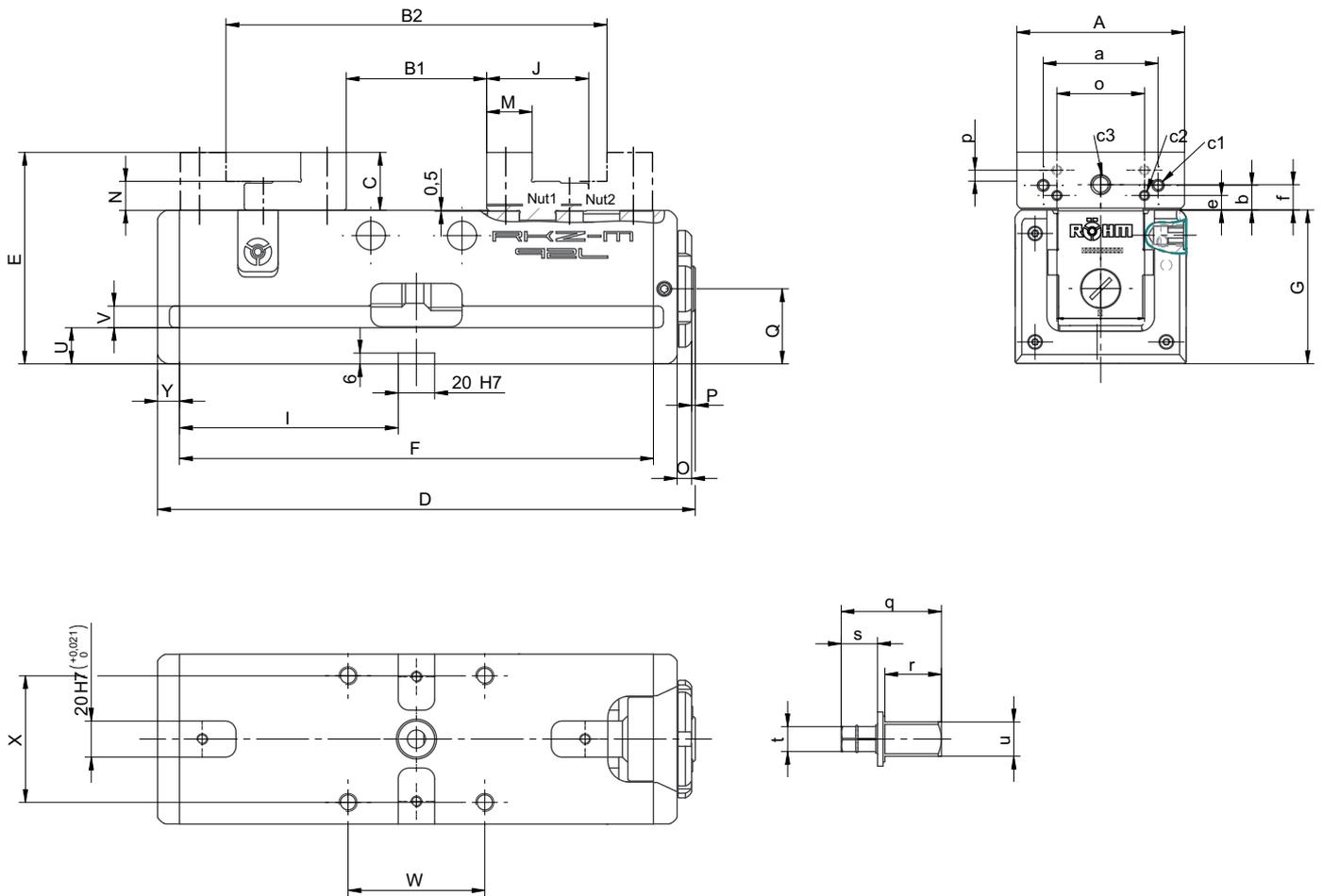
- Steel body as well as all guides hardened and ground on all sides
- Standard-equipped with stepped top jaws

A32  
RKZ-M, with stepped jaws

NC-Compact self centering vices RKZ-M

Item no.	180190	180191	180192	180193
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
Clamping force kN	10	15	20	25
Weight kg	3,5	7	18	32,5

# RKZ-M



# 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 4070!

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



A37

**V-jaw PB**, horizontal and vertical

Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm	Height prism mm	Chuck 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



# Accessories RKZ-M

A37

**Claw jaws 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

A37

**Claw jaws 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

C15

**Hand crank HKU**, with octagon socket


Item no.	Contents of delivery	Size	Octagon	L
009150	piece	50	12	80
009152	piece	70	14	125
382112	piece	92	19	160
009154	piece	125	19	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

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 - 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:**

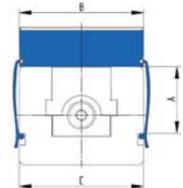
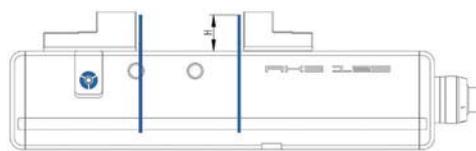
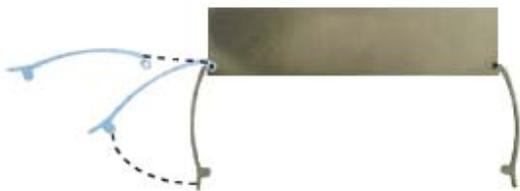
- Different height steppings
- Width only 3 mm
- Rim near through holes can be machined without step jaws or problems due the slim precision support rails.
- Precision and quality parallelism better than 0.005 mm
- Quick cleaning

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

**Support rails Cliparc**

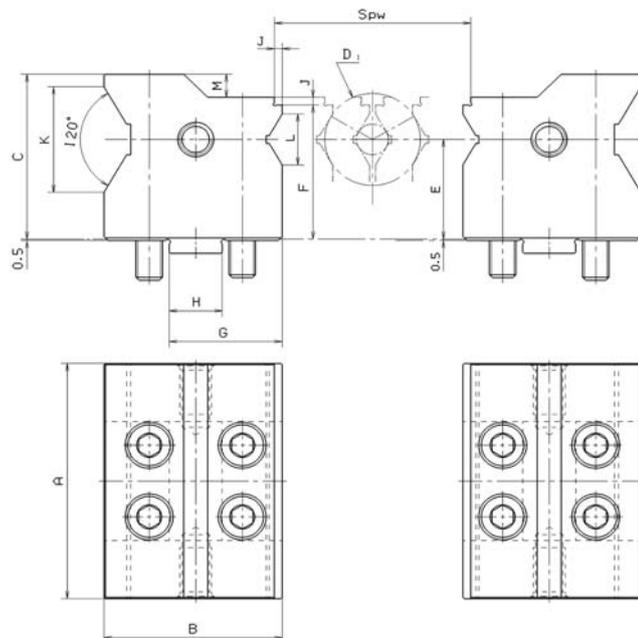


Item no.	1269621	1269622	1269623	1295913	1295914	1295915
For	RKE 92	RKE, RKE-LV 125	RKE 160 / 200	RKD, RKD-M, RKZ-M 92	RKD, RKD-M, RKZ-M 125	RKZ 125
Web height	A 48	68	83	53	73	98
Jaw width	B 92	125	160	92	125	125
Rail height	H 10/16/18/20/23/25/26/27/28/29	10/15/20/25/28/30/33/35/36/37	10/15/20/25/30/35/40/43/45/47	10/16/18/20/23/25/26/27/28/29	10/15/20/25/28/30/33/35/36/37	10/15/20/25/28/30/33/35/36/37
Guidance width	C 94	126	162	94	126	126
Spare clamp (Set = 4 pieces)	1269624	1269625	1269626	1295916	1295917	1295918



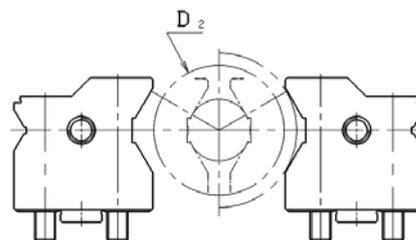
## Jaw dimensions

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 <sup>1)</sup>	7-143	7-186

\* Ø 63-75 side loading only; \*\* Ø 72-92 side loading only; <sup>1)</sup> 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

**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

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

# 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 jaws<sup>1)</sup>



Standard top jaws<sup>1)</sup>

**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**

<sup>1)</sup> not suitable for RZM

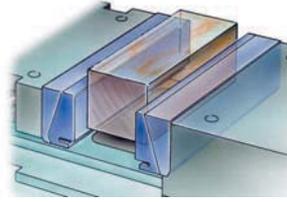
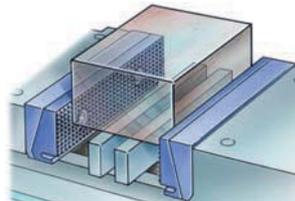
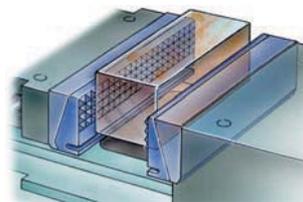
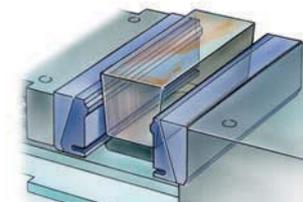
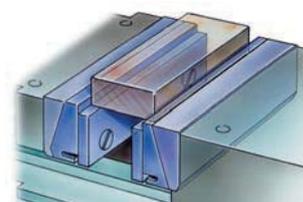
# Quick change clamping inserts

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

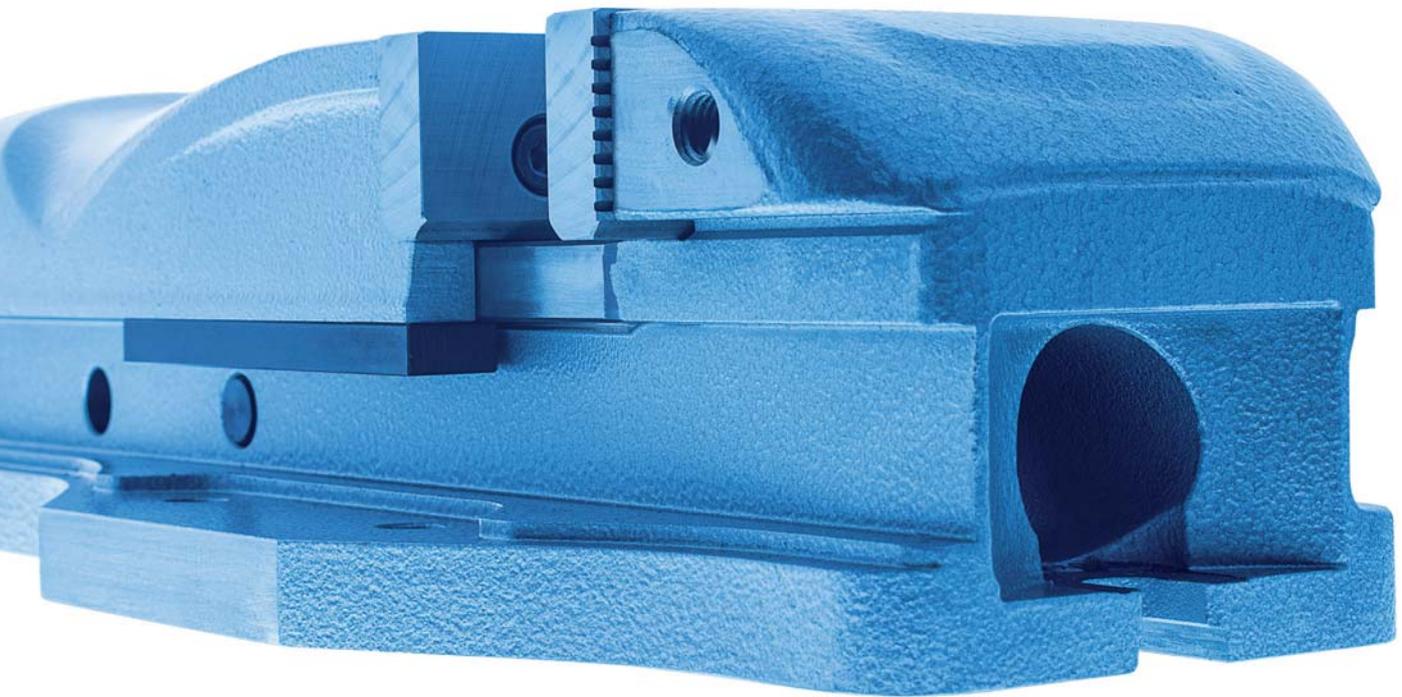
Clamping jaw comparable to the NC-compact vice and machine vices with the same jaw width.



**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.

<p><b>RNS standard insert</b> For machined workpieces without angle error.</p> 	
<p><b>RNS standard insert, finely checked</b> To increase the specific surface pressure (higher holding force).</p> 	
<p><b>RNK claw insert</b> To increase the specific surface pressure (higher holding force).</p> 	
<p><b>Insert with round RNR clamping base – line-shaped clamping base</b> For machined workpieces with and without angle error.</p> 	
<p><b>RWA workpiece support</b> For fastening to the standard inserts. For raising the height of the workpieces during the clamping process.</p> 	

Other sizes and versions available upon request.



UNIVERSALLY USABLE AND PROVEN MANY TIMES OVER



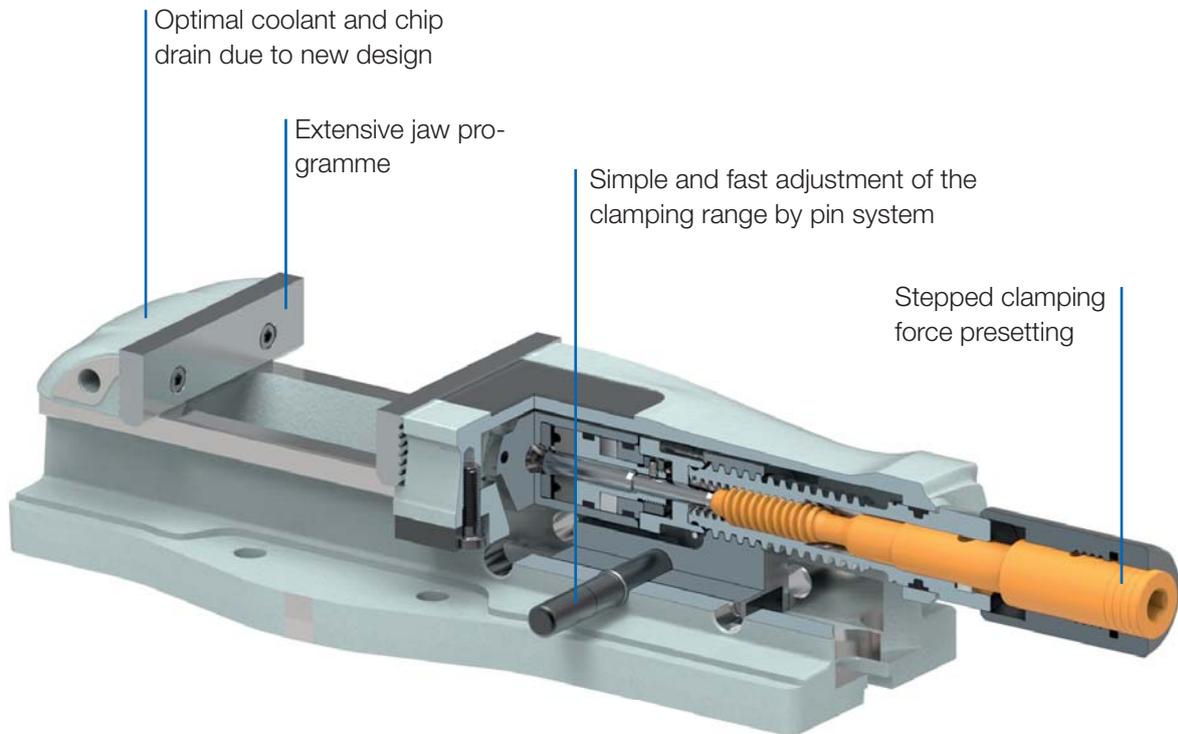
The RÖHM machine vice is suitable for universal application on milling machines and machining centers. The base is equipped with grooves to ensure a precise fastening on the machine table.

# 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



### APPLICATION

For universal use on milling machines and machining centers.

### TYPE

Manual clamping system with power amplifier.

### CUSTOMER BENEFITS

- ② Stepped clamping force presetting
- ② High precision thanks to precise jaw guides
- ② Fast clamping range adjustment via bolt system
- ② Optimal coolant and chip drain
- ② High wear-resistance thanks to hardened jaw guides
- ② Use without force amplification possible for sensitive clamping

### TECHNICAL FEATURES

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

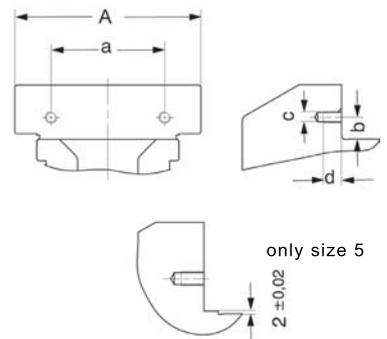
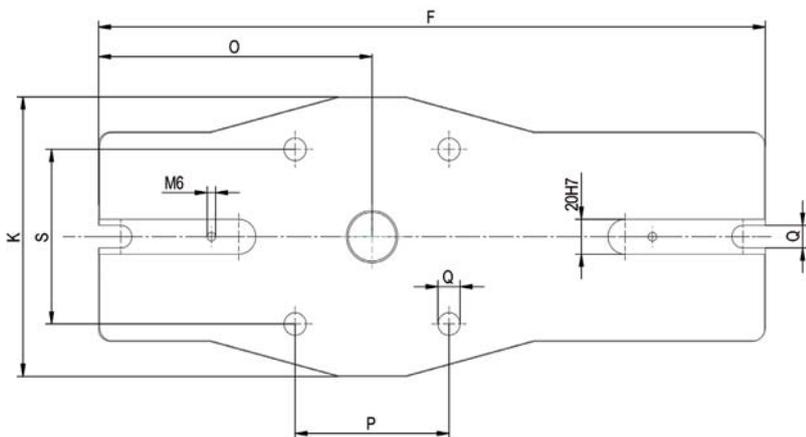
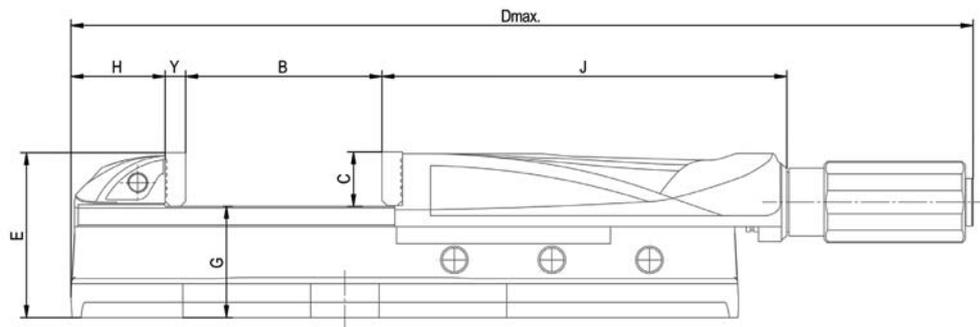
A10  
**RB-K**, with SGN normal jaws and hand crank

Item no.	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	490	583	679	817	1022
E mm	91	97	112	133	171
F mm	310	390	468	574	685
G±0,02 mm	59	65,5	72,5	83,5	104,5
H mm	50	55	70	80	90
J mm	218	236,5	262	298	375
K mm	160	160	200	240	280
O mm	115	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	23
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



Machine vices  
Orange Line



# Accessories RB-K

A37

**Draw-down jaws RNG**, with two permanent magnets



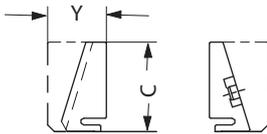
Item no.	Contents of delivery	Size	Width mm	Height mm
155237	set	1	92	32
155238	set	2	110	32
155239	set	3	135	40
155240	set	4	160	50
155241	set	5	200	67

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

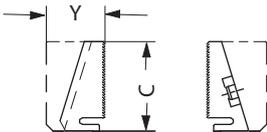


A37

**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

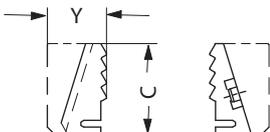


A37

**Claw insert RNK**, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155247	set	1	92	32	21
155248	set	2	110	32	21
155249	set	3	135	40	26
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

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

# 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

A37

**V-jaw SPR**, with vertically and horizontally ground-in prisms, hardened, for combination with SGN, only suitable for double clamping



Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking 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

A37

**Normal jaw SGNA**, with movable workpiece stop, hardened and ground, only suitable for double clamping



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

A37

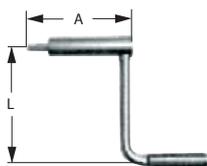
**Floating jaw horizontal PEB**, for clamping non-parallel workpieces



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

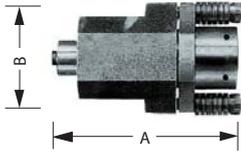
**Hand crank**, turnable handle, hexagon socket



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	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

# RB-M



## APPLICATION

For universal use on milling machines and machining centers.

## TYPE

Clamping system mechanical without power transmitter, manually operated.

## CUSTOMER BENEFITS

- ⊕ 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

## TECHNICAL FEATURES

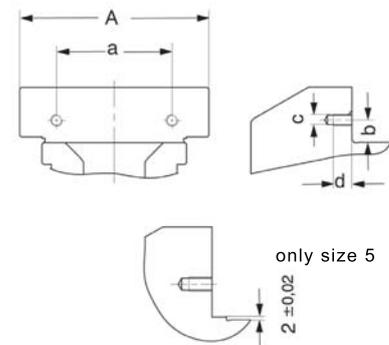
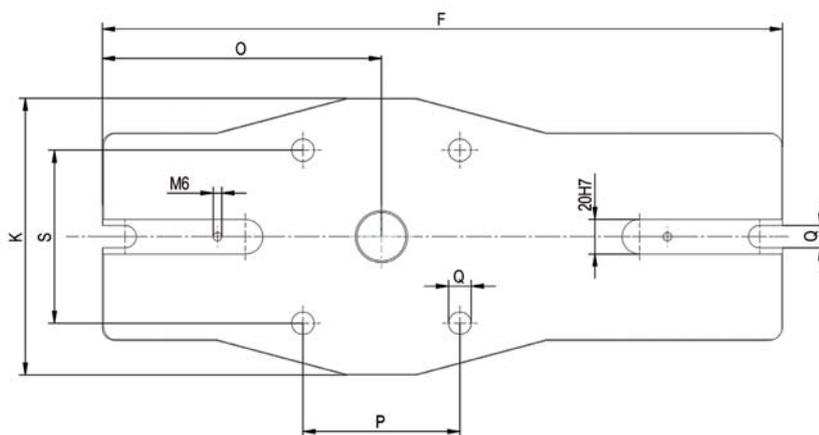
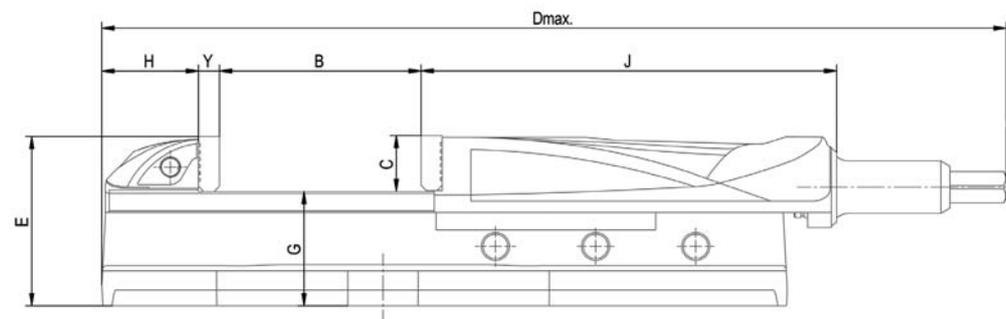
- Base with grooves for exact fixation on the machine table
- Use on rotary plate with graduation
- Set-up option with clamping claws
- Encapsulated spindle

A10

RB-M, with SGN normal jaws and hand crank

Item no.	179080	179081	179082	179083	179084
Size	1	2	3	4	5
Jaw width A mm	92	113	135	160	200
Clamping capacity B mm	100	185	240	330	370
C mm	31,6	31,6	39,6	49,6	66,6
D mm	420	586	686	860	1015
E mm	91	97	112	133	171
F mm	310	390	468	574	685
G±0,02 mm	59	65,5	72,5	83,5	104,5
H mm	50	55	70	80	90
J mm	218	236,5	262	298	375
K mm	160	160	200	240	280
O mm	115	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	13,5	15,6	19,6	23
c	M6	M6	M8	M8	M10
d mm	23	12	13	13	16
Clamping force kN	20	25	35	45	55
Weight kg	15,5	24	39	60	112

# RB-M



Machine vices  
Orange Line

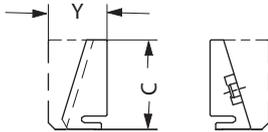
# Accessories RB-M

A37

**Draw-down jaws RNG, with two permanent magnets**

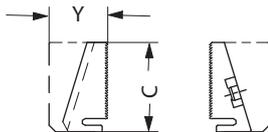

Item no.	Contents of delivery	Size	Width mm	Height mm
155237	set	1	92	32
155238	set	2	110	32
155239	set	3	135	40
155240	set	4	160	50
155241	set	5	200	67

A37

**Standard insert RNS, held by two permanent magnets**


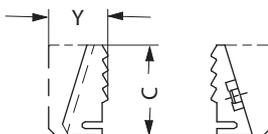
Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242	set	1	92	32	21
155243	set	2	110	32	21
155244	set	3	135	40	26
155245	set	4	160	50	30
155246	set	5	200	67	36

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
155247	set	1	92	32	21
155248	set	2	110	32	21
155249	set	3	135	40	26
155250	set	4	160	50	30
155251	set	5	200	67	36

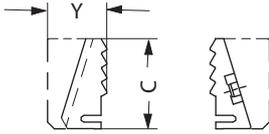
# Accessories RB-M

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

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

Machine vices  
Orange Line

# Accessories RB-M

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

A37

**V-jaw SPR**, with vertically and horizontally ground-in prisms, hardened, for combination with SGN, only suitable for double clamping



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuck 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

A37

**Normal jaw SGNA**, with movable workpiece stop, hardened and ground, only suitable for double clamping



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

C15

**Hand crank HKU**, with octagon socket



Item no.	Contents of delivery	Size	Octagon	L
129658	piece	2/3	12	90
009150	piece	4/5	12	80

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	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



# Notes



### APPLICATION

For universal use on milling machines and machining centers.

### TYPE

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

### CUSTOMER BENEFITS

- ③ Horizontal, vertical and laterally clampable with height adjustment  $\pm 0.02$
- ③ For high reliability, long service life and high precision
- ③ Fast clamping range adjustment via locking pins

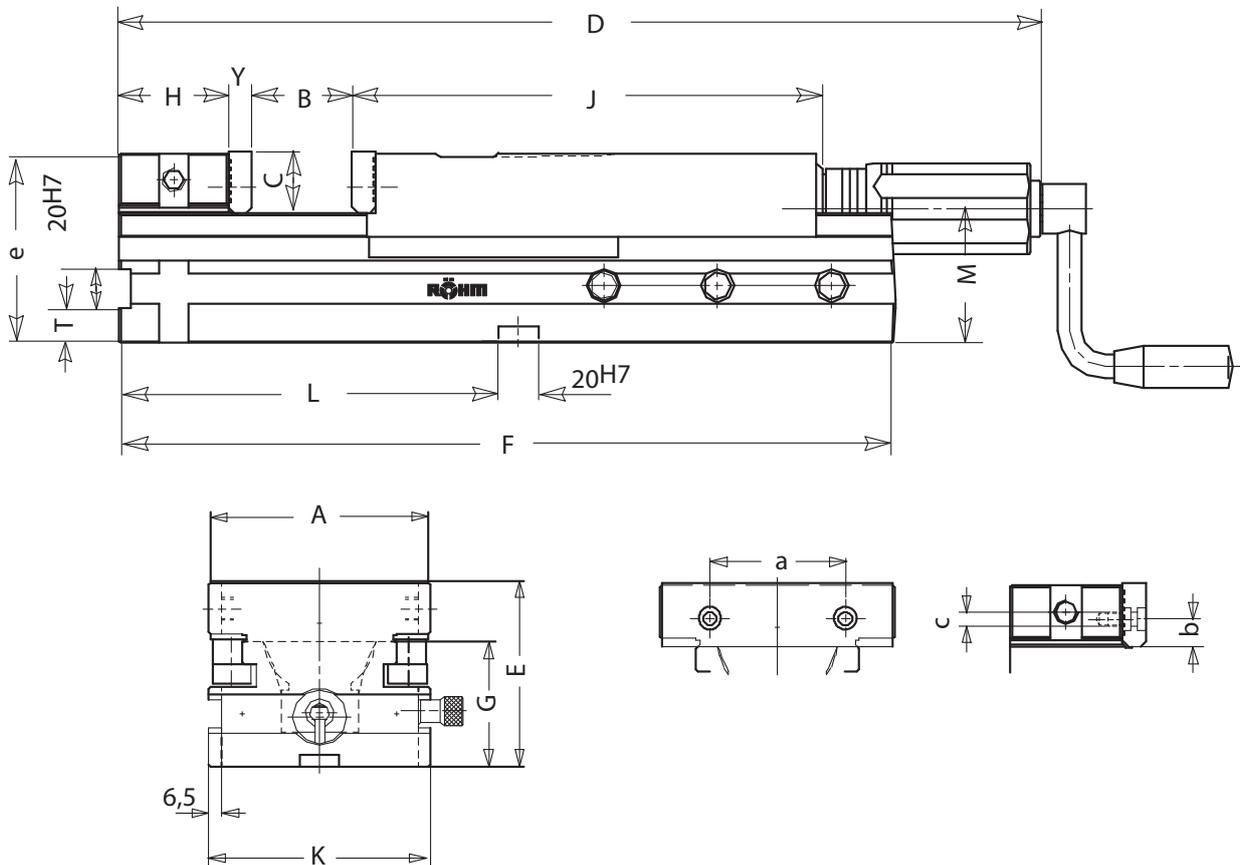
### TECHNICAL FEATURES

- Sturdy, maintenance-free spindle
- Quickly exchangeable hydraulic unit
- With normal jaws and hand crank
- Locking pin is protected against dirt and chips
- Steel body with stationary clamping jaw
- Blocking mechanism for pre-clamping workpieces
- 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

A27

**RBA, standard version**, with normal jaws SGN and hand crank

Item no.	153394	153395	153396	153397
Size	1	2	3	4
Jaw width A mm	92	113	135	160
B mm	0-100	0-170	0-220	0-310
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	31,6	39,6	49,6
Dmax mm	490	583	681	817
E $\pm 0,02$ mm	91,2	97,7	112,7	133,7
F mm	310	390	468	574
G $\pm 0,02$ mm	59	65,5	72,5	83,5
H $\pm 0,02$ mm	50	55	70	80
J mm	218	236,5	262	298
K $\pm 0,02$ mm	94	115	137	162
L $\pm 0,02$ mm	130	190	190	240
M mm	61,5	68	78	93
T $\pm 0,02$ mm	12,5	17,5	17,5	22,5
Y-0,01 mm	11,6	11,6	15,6	15,6
a mm	63	63	80	100
b mm	13,6	13,6	15,6	19,6
c mm	M6	M6	M8	M8
d mm	12	12	13	13
e $\pm 0,02$ mm	89,5	96	111	132
Clamping force kN	25	30	40	50
Weight kg	15,5	24	39	60



# Accessories RBA

A37

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



Item no.	Contents of delivery	Size	Width mm	Height mm
077104	set	2a	113	31,6
077105	set	125	135	39,6
077106	set	160	160	49,6

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
152753	piece	2a	113	31,6
152754	piece	3	135	39,6
152755	piece	160	160	49,6

A37

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



Item no.	Contents of delivery	Size	Width mm	Height mm
163218	piece	92	92	31,6
156195	piece	2a	113	31,6
156196	piece	3	135	39,6
156197	piece	160	160	49,6

A37

**V-jaw SPR**, with vertically and horizontally ground-in prisms, hardened, for combination with SGN, only suitable for double clamping



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuck capacity mm	
					Horizontal	Vertical
128770	piece	92	92	31,6	3-13	5-32
082362	piece	2a	113	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

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	2a	110	31,8	3-12	5-32
317260	set	125	135	39,8	3-13	6-40
317261	set	4	160	49,8	5-22	7-48

# Accessories RBA

A37

**Normal jaw SGNA**, with movable workpiece stop, hardened and ground, only suitable for double clamping



Item no.	Contents of delivery	Size	Width mm	Height mm
150739	piece	2a	113	31,6
150740	piece	125	135	39,6
150741	piece	4	160	49,6

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

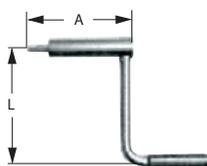
**Stepped top jaw ASB**, for movable jaw



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

**Hand crank**, turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A mm	L mm
134593	piece	1/2	12	48	80
134198	piece	92	12	60	90
134499	piece	4	12	117	90

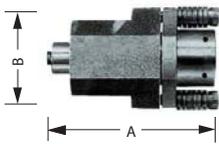
# Accessories RBA

A37

**Angle drive**, for screwing on the moving jaw (the moving jaw must be reworked), for actuating the vice spindle from above (90°)


Item no.	Contents of delivery	Size
142351	piece	1-4

A37

**Hydraulic unit HDE**


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

A37

**Spindle, complete**


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

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



# Notes



### APPLICATION

For universal use on milling machines and machining centers.

### TYPE

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

### CUSTOMER BENEFITS

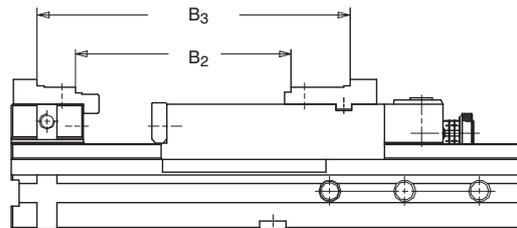
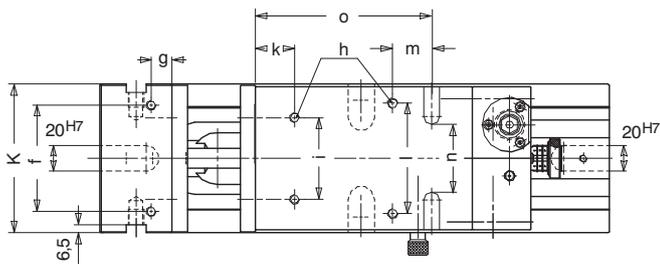
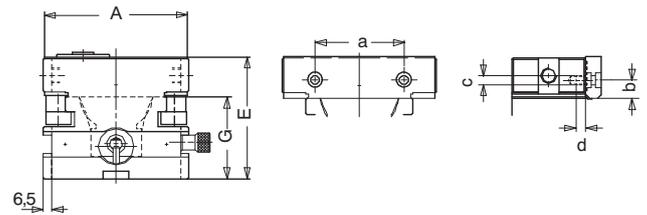
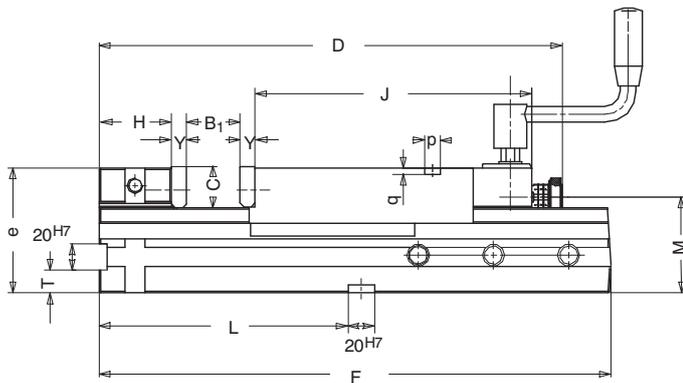
- ② Horizontal, vertical and laterally clampable with height adjustment  $\pm 0.02$
- ② Sturdy, maintenance-free spindle
- ② Additional stepped jaws or special form jaws can be fastened to the surface of the stationary and moving jaw
- ② Drive spindle is protected against dirt and chips
- ② Large clamping range
- ② Short version of moving jaw (made of steel) results in short design length, even for max. clamping width
- ② With angle drive

### TECHNICAL FEATURES

- Steel body with stationary clamping jaw, uniformly forged into the die
- 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

Item no.	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
Y-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



# 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	2a	113	31,6
077105	set	125	135	39,6
077106	set	160	160	49,6

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	2a	113	31,6
152754	piece	3	135	39,6
152755	piece	160	160	49,6

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
156195	piece	2a	113	31,6
156196	piece	3	135	39,6
156197	piece	160	160	49,6

A37

**V-jaw SPR**, with vertically and horizontally ground-in prisms, hardened, for combination with SGN, only suitable for double clamping



Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking capacity mm	
					Horizontal	Vertical
082362	piece	2a	113	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

A37

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



Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking capacity mm	
					Horizontal	Vertical
317259	set	2a	110	31,8	3-12	5-32
317260	set	125	135	39,8	3-13	6-40
317261	set	4	160	49,8	5-22	7-48

# Accessories RBAW

A37

**Normal jaw SGNA**, with movable workpiece stop, hardened and ground, only suitable for double clamping



Item no.	Contents of delivery	Size	Width mm	Height mm
150739	piece	2a	113	31,6
150740	piece	125	135	39,6
150741	piece	4	160	49,6

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

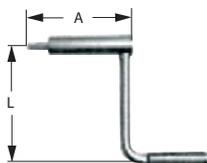
**Floating jaw horizontal PEB**, for clamping non-parallel workpieces



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

# Accessories RBAW

A37

**Hand crank**, turnable handle, hexagon socket


Item no.	Contents of delivery	Size	Hexagon	A mm	L mm
134499	piece	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

**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

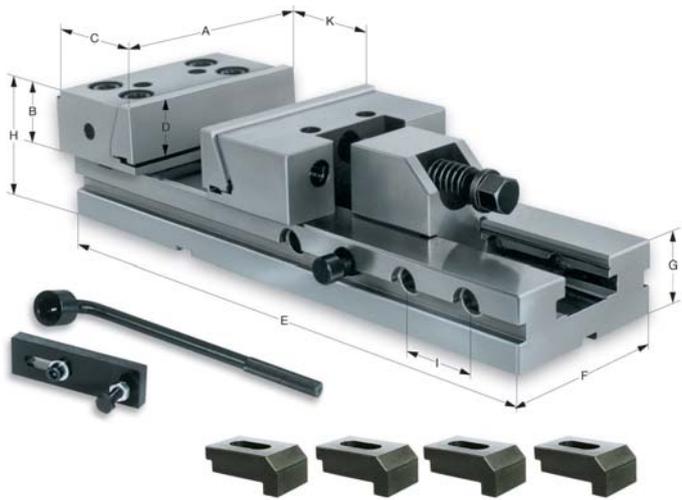
A37

**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

# MSR



### APPLICATION

For universal use on milling machines and machining centers.

### TYPE

Clamping system mechanical without power transmitter, manually operated.

### CUSTOMER BENEFITS

- ⊕ Optimal price/performance ratio
- ⊕ 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

# Accessories MSR

A37  
Step jaw SB, for stationary jaw



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



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

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	47
476868	150	290	58
476870	175	320	58

Accessories machine vices MSR



### APPLICATION

For conventional machine tools.

### TYPE

Clamping system mechanical without power transmitter, manually operated.

### CUSTOMER BENEFITS

- ② Optimal price/performance ratio
- ② Entire clamping range can be bridged over by turning the handcrank
- ② Spindle is protected from dirt and chips
- ② 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

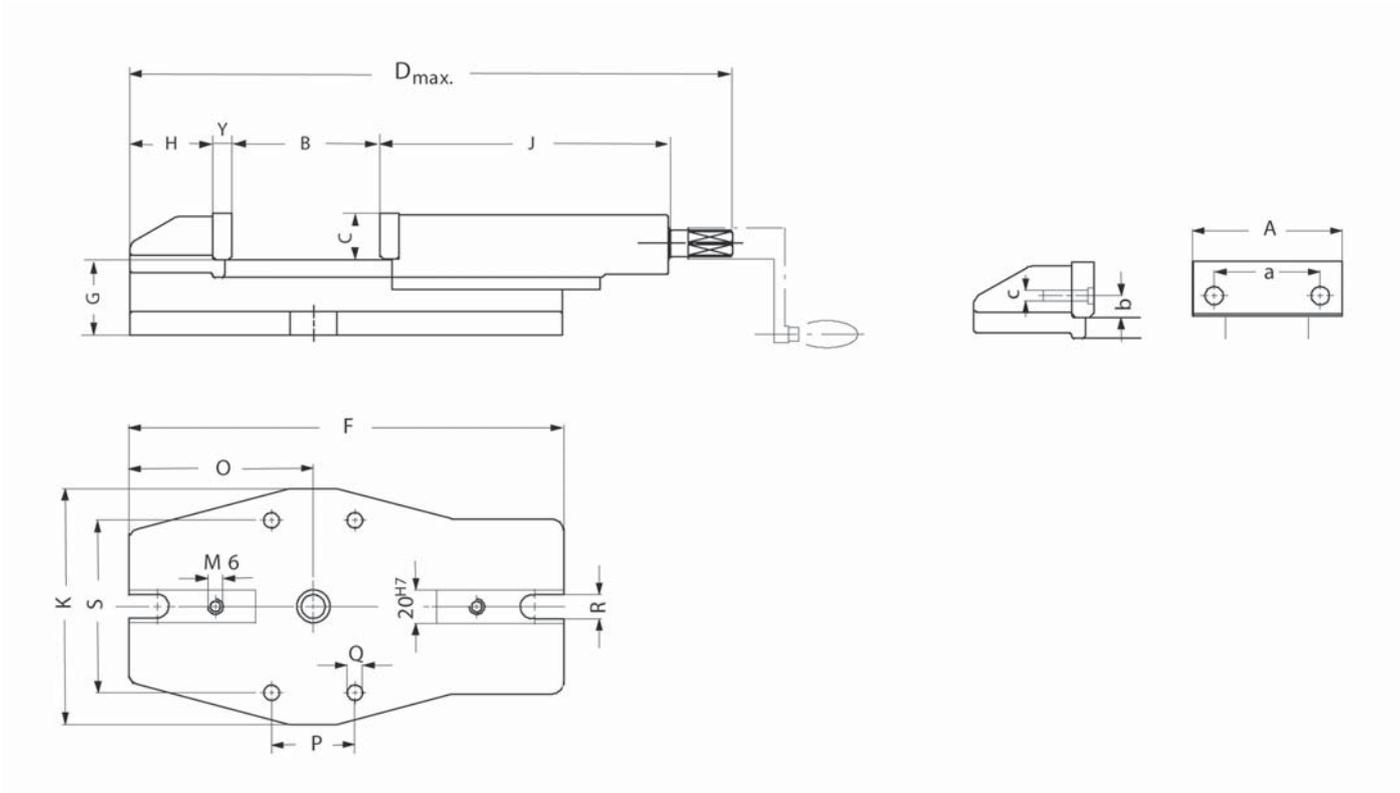
A11

RS, with SGN normal jaws and hand crank

Item no.	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 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	2a	113	31,6
077105	set	125	135	39,6
077106	set	160	160	49,6
077107	set	200	200	62,6

A37

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

<sup>1)</sup> both sides ground

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
156195	piece	2a	113	31,6
156196	piece	3	135	39,6
156197	piece	160	160	49,6
156198	piece	200	200	62,6

A37

**V-jaw SPR**, with vertically and horizontally ground-in prisms, hardened, for combination with SGN, only suitable for double clamping



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuck capacity mm	
					Horizontal	Vertical
128770	piece	92	92	31,6	3-13	5-32
082362	piece	2a	113	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

A37

**Normal jaw SGNA**, with movable workpiece stop, hardened and ground, only suitable for double clamping



Item no.	Contents of delivery	Size	Width mm	Height mm
150739	piece	2a	113	31,6
150740	piece	125	135	39,6
150741	piece	4	160	49,6

# Accessories RS

C15

**Hand crank HKU**, with octagon socket



Item no.	Contents of delivery	Size	Octagon	L mm
009150	piece	50	12	80
009152	piece	70	14	125
009153	piece	92	17	160
009154	piece	125	19	200

A37

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



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



**APPLICATION**

For conventional machine tools.

**TYPE**

Centric clamping system mechanical without power transmitter, manually operated.

**CUSTOMER BENEFITS**

- ③ Optimal price/performance ratio
- ③ Spindle covered in the work area
- ③ Extensive assortment of jaws
- ③ Low design
- ③ 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

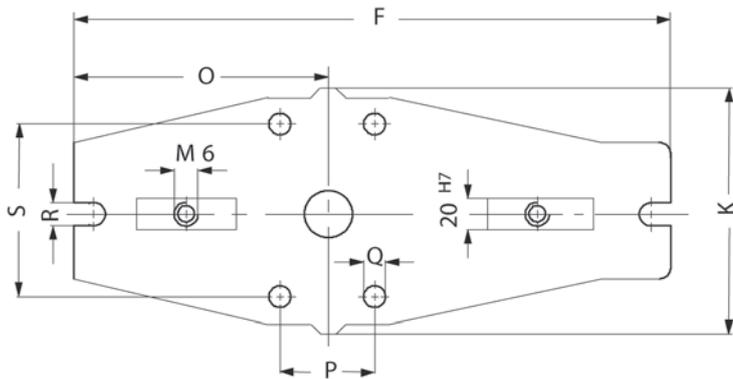
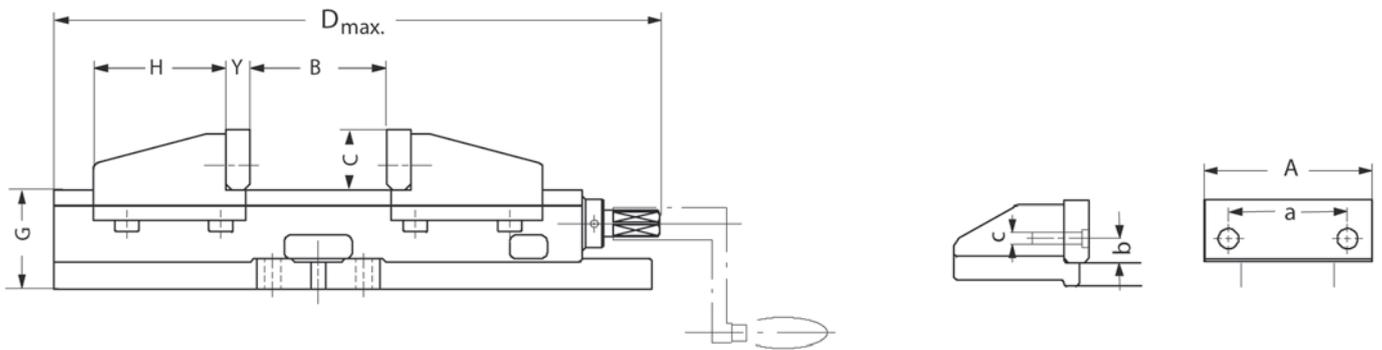
A11  
UZ, self-centering vice

UZ machine vice

Item no.	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 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	2a	113	31,6
077105	set	125	135	39,6
077106	set	160	160	49,6
077107	set	200	200	62,6

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	2a	113	31,6
152754	piece	3	135	39,6
152755	piece	160	160	49,6
152759	piece	200	200	62,6
152760	piece	6	250	62,6
152762	piece		300	79,6

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
156195	piece	2a	113	31,6
156196	piece	3	135	39,6
156197	piece	160	160	49,6
156198	piece	200	200	62,6

A37

**V-jaw SPR**, with vertically and horizontally ground-in prisms, hardened, for combination with SGN, only suitable for double clamping



Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking capacity mm	
					Horizontal	Vertical
082361	piece	2	90	24,6	3-13	5-32
082362	piece	2a	113	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
082366	piece	6	250	62,6	7-45	9-65

A37

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



Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking capacity mm	
					Horizontal	Vertical
317259	set	2a	110	31,8	3-12	5-32
317260	set	125	135	39,8	3-13	6-40
317261	set	4	160	49,8	5-22	7-48

A37

**Normal jaw SGNA**, with movable workpiece stop, hardened and ground, only suitable for double clamping



Item no.	Contents of delivery	Size	Width mm	Height mm
150739	piece	2a	113	31,6
150740	piece	125	135	39,6
150741	piece	4	160	49,6

# Accessories UZ

C15

**Hand crank HKU**, with octagon socket



Item no.	Contents of delivery	Size	Octagon	L
009152	piece	70	14	125
009153	piece	92	17	160
009154	piece	125	19	200

# 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)



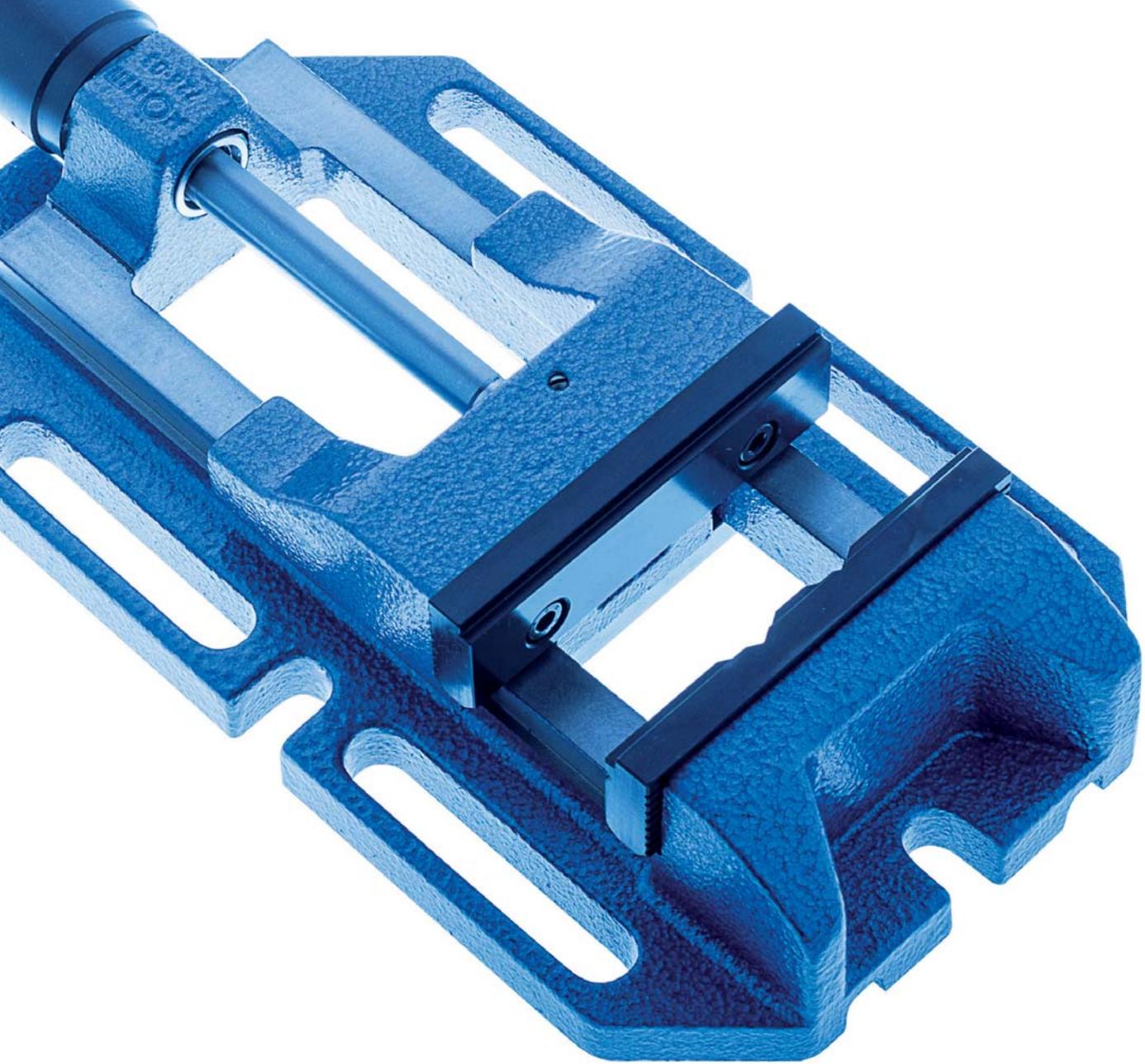
Item no.	Contents of delivery
320401	piece

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



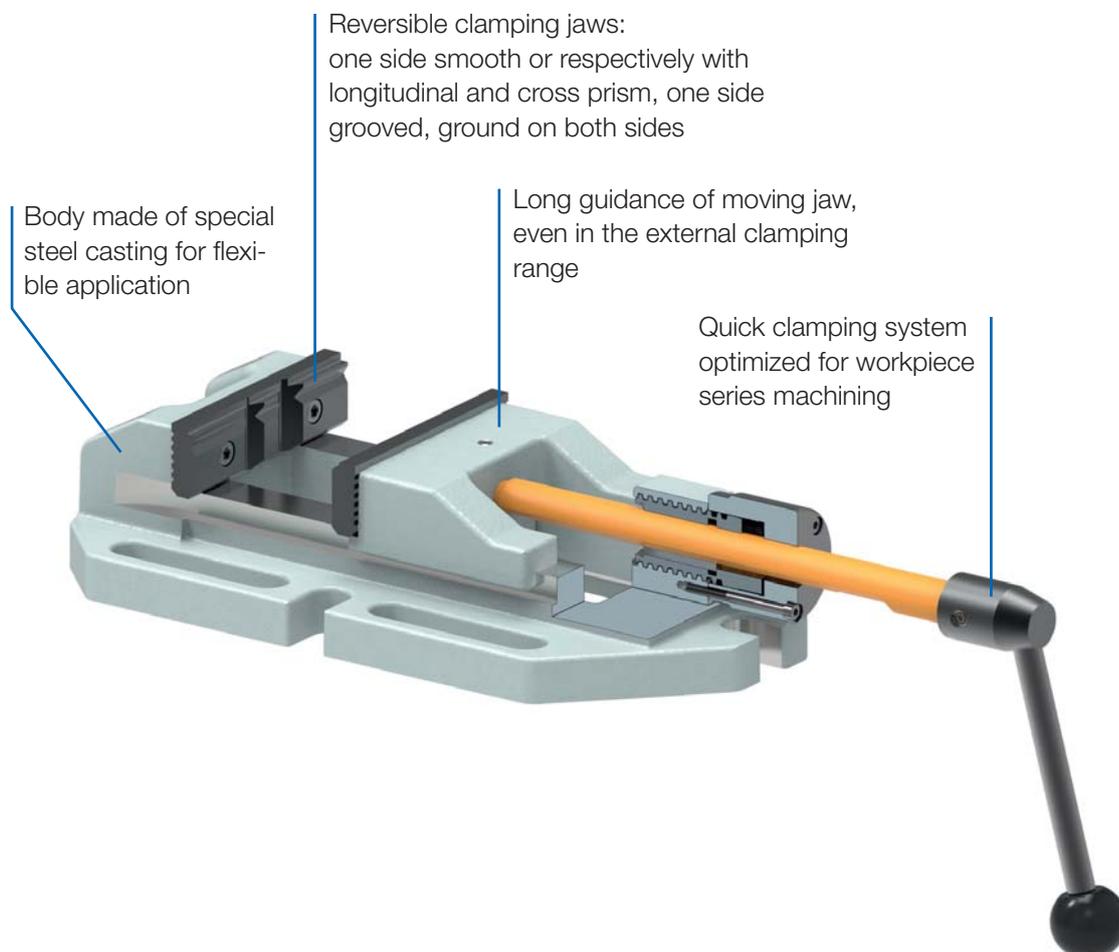
For decades, RÖHM drilling machine vices have been enabling reliable and quick clamping of workpieces on drilling and measuring machines. The entire clamping range can be set by one-handed turning.

# 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





**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 work-piece machining
- ⌚ Optimal price/performance ratio
- ⌚ One-hand operation
- ⌚ Long guidance of moving jaw, even in the external clamping range
- ⌚ Clamping jaws are hardened and 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
- 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	Weight kg
134158	2	110	130	32	510	72,5	315	9,5
134159	3	135	160	40	587	80,5	365	13,5

Drilling machine vices  
BMS

**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 hardened and 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	Weight kg
142835	1	90	90	25	356	60	195	5,5
111595	2	110	130	32	470	72,5	315	9,5
111596	3	135	160	40	550	80,5	365	13,5
111597	4	160	220	50	692	95,5	445	25



**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
- ⊕ Both jaws with support surface for clamping 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	Weight kg
007193	1	65	65	125	105	43	25	1,2
007194	2	80	85	150	130	46	25	1,7
007196	3	100	80	170	175	57	25	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 with support surface for clamping 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	Weight kg
007197	4	80	80	200	140	70	40	5
007201	5	100	95	215	175	75	40	7
007202	6	120	110	260	215	85	40	11
007207	7	140	150	300	220	85	40	12,5



**APPLICATION**

For securely clamping workpieces on drills and measuring machines.

**TYPE**

Clamping system mechanical, manually operated.  
Standard version.

**CUSTOMER BENEFITS**

- ④ Entire clamping range within reach by turning
- ④ Constant design length, spindle moves protected in the handle
- ④ 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	Weight kg
863421	1	80	70	30	234	58	154	142	3,6
863422	2	100	92	30	272	63,5	175	152	4,3
863423	3	120	110	30	345	63,5	225	180	6,3
1132597	4	150	125	30	378	65	238	198	8,1

Drilling machine vices BMS

**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**

- ④ Entire clamping range within reach by turning
- ④ Constant design length, spindle moves protected in the handle
- ④ 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 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	Weight kg
007182	2	100	93	30	279	65	189	159	5,1

# Accessories BMS

A37

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



Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking 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

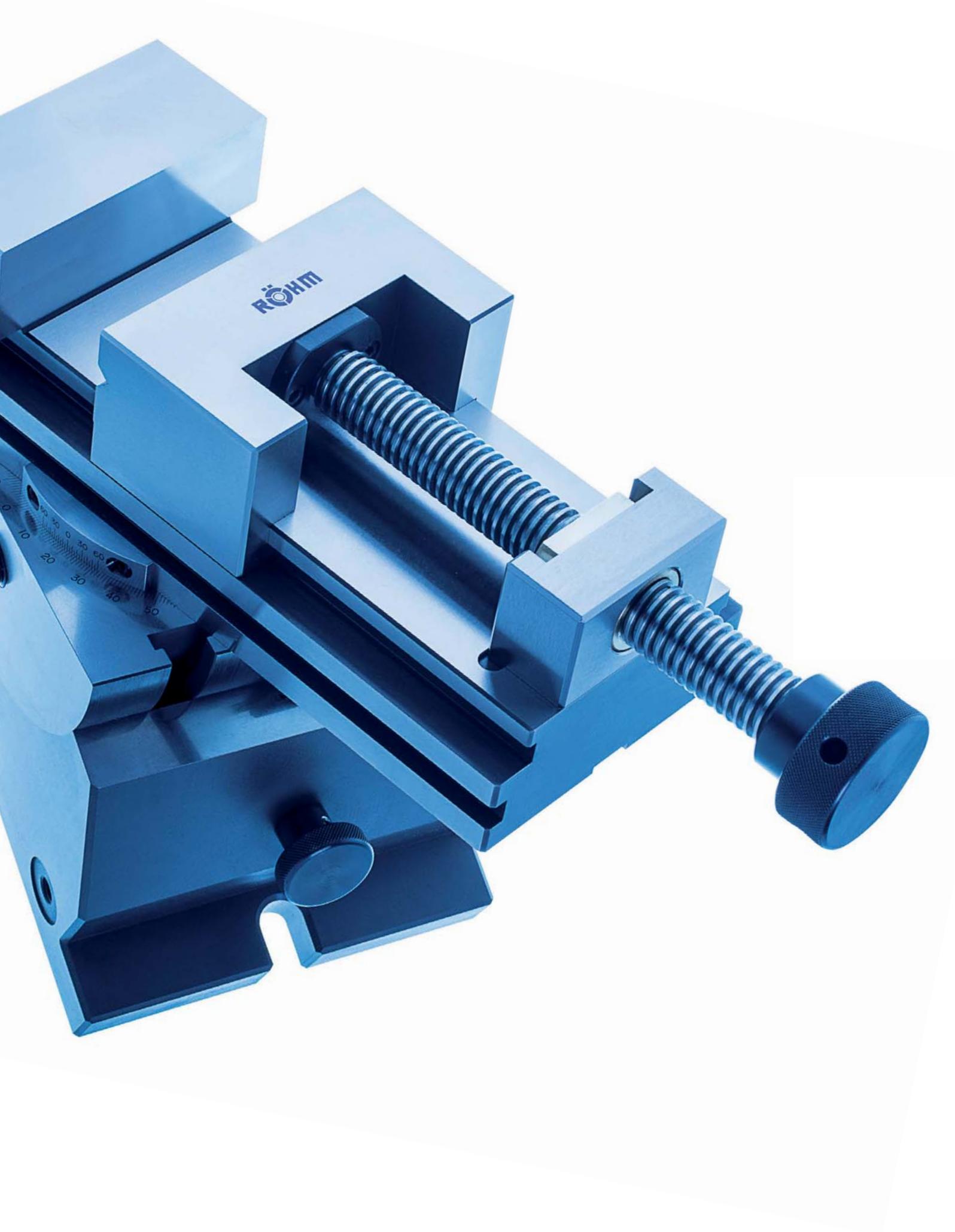
A37

**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 <sup>1)</sup> ▲	set	2	100
1128343	set	3	120
1193108 ▲	set	4	150

<sup>1)</sup> only for DPV 3-W

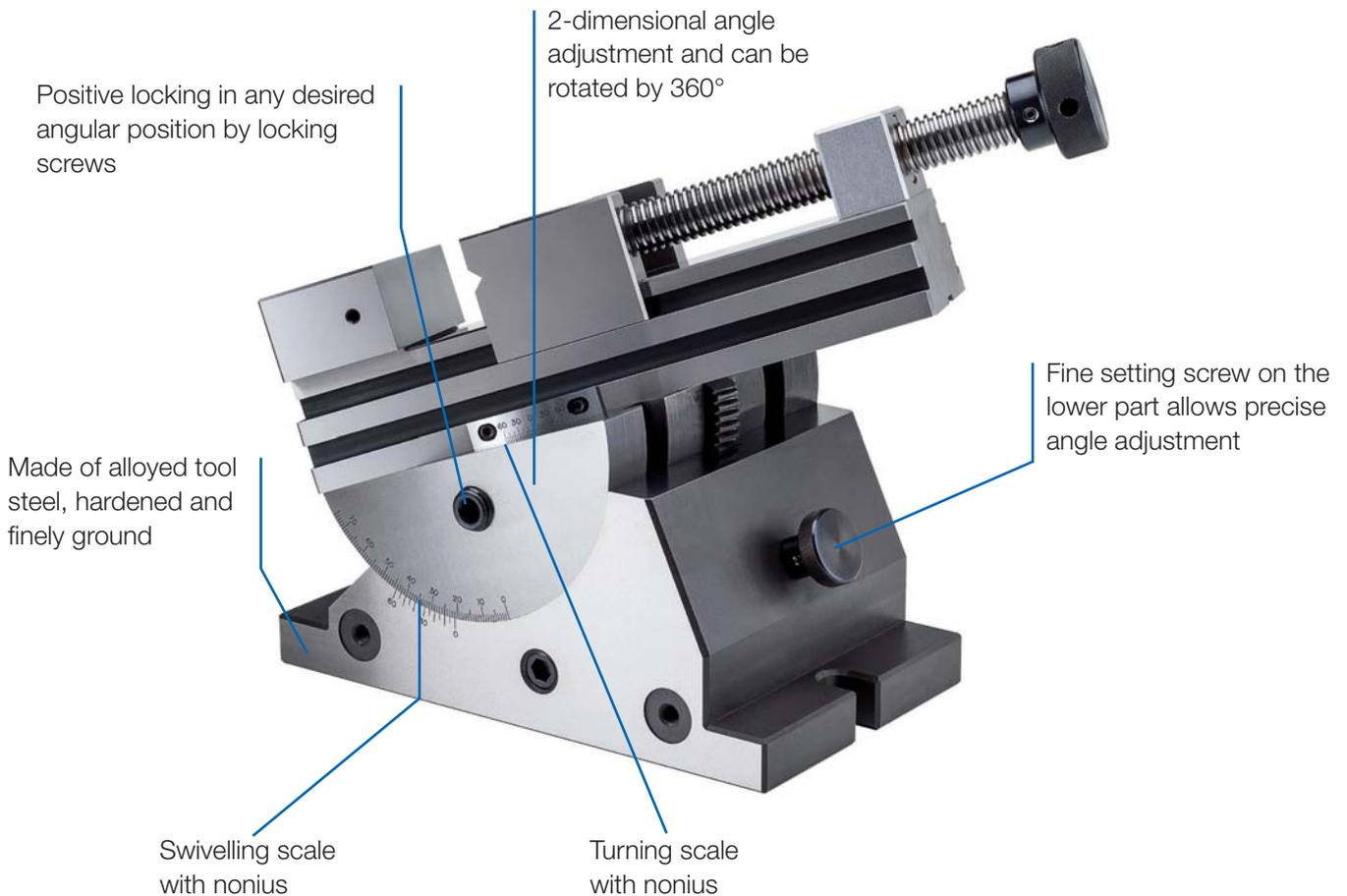


# GRINDING AND INSPECTION VICES

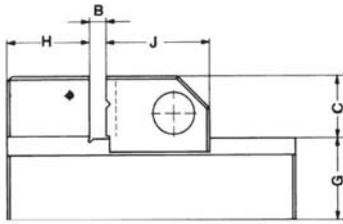
RÖHM grinding and inspection vices are primarily used in grinding, milling and engraving machines, at jig boring machines, for measurement and inspection work and for manufacturing processes which require the highest standards of clamping precision.

## 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 vice



A29  
PL-S micro, with quick adjustment

Item no.	Size	Squareness <sup>1)</sup> / 100 mm	Parallelism <sup>2)</sup> / 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

<sup>1)</sup> Base to stationary jaw clamping surface  
<sup>2)</sup> Base to upper guide edge

## APPLICATION

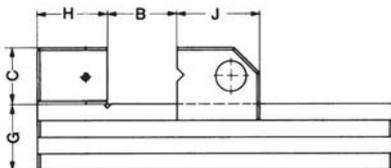
Mainly in tool construction on grinding, milling and engraving machines, on jig boring machines, for measuring and control work and for production operations requiring high clamping precision.

## 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 <sup>1)</sup> / 100 mm	Parallelism <sup>2)</sup> / 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

<sup>1)</sup> Base to stationary jaw clamping surface  
<sup>2)</sup> 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.

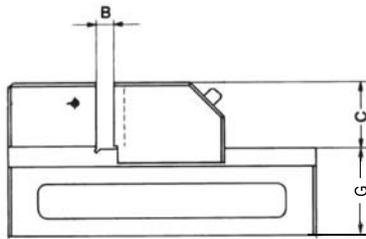
## CUSTOMER BENEFITS

- ⊕ 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 vice



A29  
PLF, with quick adjustment in gauge accuracy

Item no.	Size	Squareness <sup>1)</sup> / 100 mm	Parallelism <sup>2)</sup> / 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

<sup>1)</sup> Base to stationary jaw clamping surface  
<sup>2)</sup> Base to upper guide edge

## APPLICATION

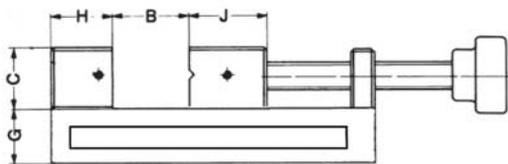
Mainly in tool construction on grinding, milling and engraving machines, on jig boring machines, for measuring and control work and for production operations requiring high clamping precision.

## 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 <sup>1)</sup> / 100 mm	Parallelism <sup>2)</sup> / 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

<sup>1)</sup> Base for stationary jaw clamping surface  
<sup>2)</sup> Base for 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.

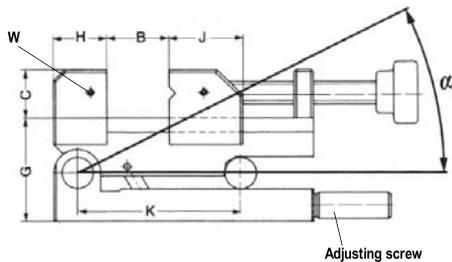
## CUSTOMER BENEFITS

- ⊕ 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 vice



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	$\alpha$	W	Weight kg
370778	1	0,005	0,002	bei $45^\circ \pm 15''$	70	80	93	30	160	63	33	45	100	$0^\circ - 46^\circ$	2xM5x15	5,3
370779	2	0,005	0,002	bei $45^\circ \pm 15''$	90	120	113	40	210	73	40	50	150	$0^\circ - 46^\circ$	2xM5x15	11

Grinding and inspection vice

## APPLICATION

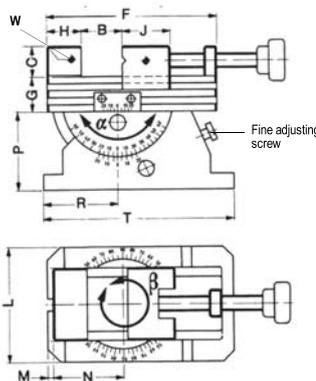
Mainly in tool construction on grinding, milling and engraving machines, on jig boring machines, for measuring and control work and for production operations requiring high clamping precision.

## 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	$\beta$	$\alpha$	W	Weight kg
370782	1	0,005	0,002	70	80	137	30	160	32	33	45	110	5	65	75	70	180	360°	$0^\circ - 120^\circ$	2xM5x15	11,1
370783	2	0,005	0,002	120	150	210	40	270	50	55	70	160	10	105	120	105	270	360°	$0^\circ - 70^\circ$	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

# 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.

Power-Grip

## 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



### With Power-Grip zero point clamping system



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