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**There's no escaping here. Even heavy parts
are packed precisely and secured safely.
With clamping forces of up to 15 tonnes!**





VICES

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Please note:
 The delivery time specified in the catalogue is valid from 01.01.2012

Operation guide

	NC-Compact vices						
	RKK	RKE	RKE-L	RKG-L	RKE-LV	RKE-M LV	RKE-H L
Clamping system	mechanical-hydraulic ¹⁾ mechanical-machanical	mechanical-mechanical	mechanical-hydraulic ¹⁾ mechanical-machanical	mechanical-mechanical	mechanical-mechanical	mechanical without power transmitter ^{*)}	hydraulic with stroke
Jaw width	92 113 135 160 200	125 160	92 125 160 200	125 160 200	125	92 125	125
Types of jaws	Stepped jaws ¹⁾ ; Standard with normal jaws	Standard- or stepped jaws	Standard- or stepped jaws	Stepped jaws	Stepped- or carrier jaws	Stepped jaws	Standard- or stepped jaws
Clamping capacity	0 - 340	0 - 451	0 - 451	0 - 451	0 - 192	0 - 206	0 - 312
Max. clamping force [kN]	25 - 60	40 - 60	25 - 60	40 - 60	40	25 - 40	40
Possible operation	3-Side Duo-Tower Quattro-Tower	3-Side Duo-Tower Quattro-Tower	Base	Base	Base	Base	Base
Clamping	single clamping	single clamping	single clamping	single clamping	single clamping	single clamping	single clamping
Extra		Basic body extension			Fixed jaws on operators side	Actuation double-sided	hydraulic connection for single-acting cylinders
Page	4010	4016	4022	4028	4032	4036	4040

¹⁾ only size 92

¹⁾ only size 92

^{*)} Constant clamping force at each clamping Sequence and large repeating accuracy only when using a torque wrench

Operation guide

	NC-Compact-twin vices		NC-Compact-self centering vices		NC-self centering vices	NC power vices	
Type	RKD	RKD-M	RKZ	RKZ-M	NCZ	RBA	RBAW
Clamping system	mechanical-mechanical	mechanical without power transmitter ^{*)}	mechanical-mechanical	mechanical without power transmitter ^{*)}	mechanical without power transmitter	mechanical-hydraulic	mechanical-hydraulic
Jaw width	92 125	92 125	125	50 70 92 125	110 160	92 113 135 160	113 135 160
Types of jaws	Centre jaws with stepped jaws	Centre jaws with stepped jaws	Stepped jaws	Stepped jaws	Standard jaws	Normal jaws	Normal jaws
Clamping capacity	0 - 180	0 - 180	32- 298	0 - 269	38 - 222	0 - 310	0 - 310
Max. clamping force [kN]	25 - 40	25 - 40	40	10 - 25	25 - 50	25 - 50	30 - 50
Possible operation	3-Side Duo-Tower Quattro-Towe	3-Side Duo-Tower Quattro-Towe	3-Side Duo-Tower Quattro-Towe	Base	Base	3-Side	3-Side
Clamping	twin clamping	twin / centric/single clamping	centric clamping	centric clamping	twin / centric/single clamping	single clamping	single clamping
Extra			V-jaws	V-jaws	actuation with hydraulic motor or pneumatic motor	Clamping capacity presetting	Integrated angle drive, Clamping capacity presetting
Page	4044	4046	4052	4056	4060	4066	4070

^{*)} Constant clamping force at each clamping Sequence and large repeating accuracy only when using a torque wrench

Operation guide

	Machine vices						
	RB	RH	MSR	RS	SG	Draw-down-vice UH	Self-centering vice UZ
Clamping system	mechanical-hydraulic	hydraulic with stroke	mechanical without power transmitter ^{*)}	mechanical without power transmitter ^{*)}	mechanical without power transmitter ^{*)}	mechanical without power transmitter ^{*)}	mechanical without power transmitter ^{*)}
Jaw width	113 135 160 200 250 315	113 135 160 200	125 150 175	92 113 135 160 200	92 113 135 160 200 250	90 113 135 160 200 250 300	113 135 160 200 250
Types of jaws	Normal jaws	Normal jaws	Draw-down jaws	Normal jaws	Normal jaws	Normal jaws	Normal jaws
Clamping capacity	0 - 420	0 - 350	0 - 400	0 - 185	0 - 345	0 - 400	0 - 400
Max. clamping force [kN]	30 - 150	25 - 100	30 - 60	18 - 55	20 - 60	20 - 70	15 - 28
Possible operation	Base	Base	Base	Base	Base	Base	Base
Clamping	single clamping	single clamping	single clamping	single clamping	single clamping	single clamping	centric clamping
Extra	Rotation plate, Clamping capacity presetting	Rotation plate, for single-acting cylinder, Clamping capacity presetting	Rotation plate, Clamping capacity presetting	Rotation plate	Rotation plate, Clamping capacity presetting	Rotation plate, immobile jaws on operators side	Rotation plate
Page	4076	4078	4083	4084	4084	4088	4088

^{*)} Constant clamping force at each clamping Sequence and large repeating accuracy only when using a torque wrench

Operation guide

	Drilling machine vices					
Typ	BOF	BSS	DPV	DPV 3-W	BSH	
Clamping system	mechanical manually operated	mechanical manually operated	mechanical manually operated	mechanical manually operated	mechanical manually operated	
Jaw width	90 110 135 160	110 135	80 100 120 150	100	65 80 100	80 100 120 140
Types of jaws	SBO-jaws, soft	SBO-jaws, soft	SBO-jaws, soft	SBO-jaws, soft	SBO-jaws, soft	
Clamping capacity	0 - 220	0 - 160	0 - 125	0 - 93	0 - 150	
Max. clamping force [kN]	-	-	-	-	-	
Possible operation	Base	Base	Base	3-Side	Base	
Clamping	single clamping	single clamping	single clamping	single clamping	single clamping	
Extra		quick-acting clamping			D.I.Y. user- design	sturdy craftsman design
Page	4092	4092	4092	4093	4093	

Operation guide

	Precision vices								
	Precision sine vices								
	PL-S	PLF	PL-G	PSK-S	PSK-O	PS-SV	PS-SH	PS-SL	PS-ZD
Clamping system	mechanical manually operated	mechanical manually operated	mechanical manually operated	mechanical manually operated	mechanical manually operated	mechanical manually operated	mechanical manually operated	mechanical manually operated	mechanical
Jaw width	34 45 70 90 120	50 73 100	60 73 88	45 65 100 125	45 65 100 125	70 90	70	75	70 120
Types of jaws	fixed and movable jaws	fixed and movable jaws	fixed and movable jaws	fixed and movable jaws	fixed and movable jaws	fixed and movable jaws	fixed and movable jaws	fixed and movable jaws	fixed and movable jaws
Clamping capacity	0 - 150	0 - 125	0 - 125	0 - 150	0 - 140	0 - 120	0 - 50	0 - 80	0 - 150
Max. clamping force [kN]	-	-	-	-	-	-	-	-	-
Possible operation	3-Side	3-Side	3-Side	3-Side	3-Side	Base	Base	Base	Base
Clamping	single clamping	single clamping	single clamping	single clamping	single clamping	single clamping	single clamping	single clamping	single clamping
Extra	without spindle	without spindle	with spindle	with spindle	without spindle	Sinus-swivelling axis			two-dimensional
						front	rear	longitudinal	
Page	4095	4095	4096	4096	4096	4097	4097	4097	4098

Range of application

Range of application	RKK RKE RKE-L RKD RKZ	RKE-HL	DUO QUATRO	NCZ	RB	RH	RBA RBAW	RS SG UH	UZ	PL PSK PS SW	BOF BSS BSH	DPV DPV 3-W	MS
Machining centers with high working accuracy	●	●	●	●	■	■	●	■	■	▲ 2			■
Universal-milling-machines with high working accuracy	●	●	●	●	■	■	●	■	■	▲ 2			■
Universal-milling-machines standard version	■	■	■	●	■	■	■	■	■	▲			■
Erosion machines								▲ 1	▲ 1	●			▲ 1
Jig boring machine	●	●	●	●	■	■	●	▲	▲	●			▲
Measuring machines with measuring devices										●			
Planing machines	■	■	■	■	■	■	■	■	●				
Drilling machines											●	●	
Grinding machines	■	■	■	■	■	■	■	■	■	●			▲
Series production	■	●	■	■	■	●	■	■	■	■	■	■	■
Application for automatic operation		●		● 3		●							
For machines with pallet-changing-equipment	●	▲	●	●	●	▲	●	●	●		■	■	■
For end and side fastening (only specific types)	●	●					●					●	
For small drilling jobs (DIY work)												■	

- = Particularly suitable
- = Normal application
- ▲ = Possible, with reservations

- 1 = Dirt and wear on the moving parts
- 2 = Low clamping force
- 3 = With hydraulic motor or pneumatic motor

Sectional view toggle lever principle

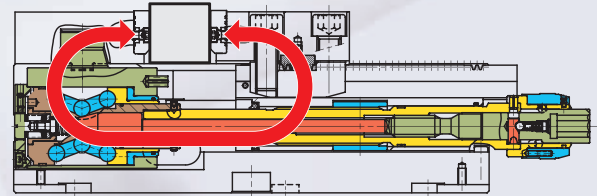
NC-Compact vices

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.

Toggle lever principle

Sectional view RKK Size 2 - 5

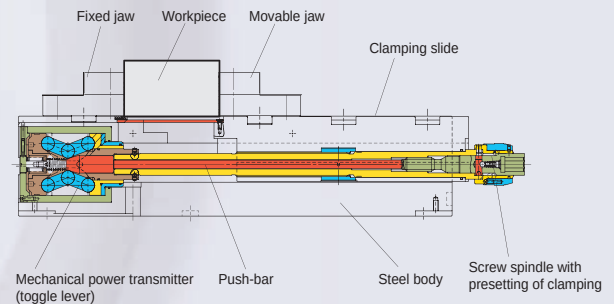


RKE

High-end NC-Compact vice. Mounting of the power transmitter in the steel body. The RKE version is also available with cast body (**RKG**). Both clamping systems are also available in a simplified version (**RKE-L / RKG-L**).

Also offered in this series are an NC-Compact vice for 5-side machining (**RKE-LV**) and a clamping system with hydraulic actuation (**RKE-HL**).

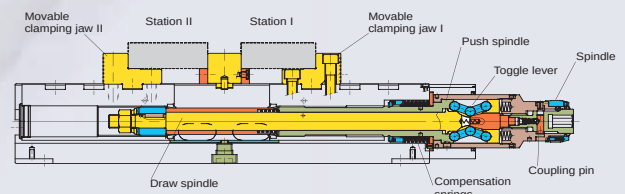
Sectional view RKE



RKD

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

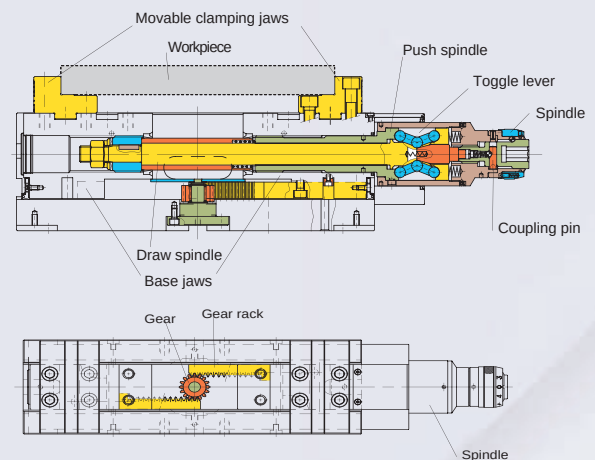
Sectional view RKD



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.

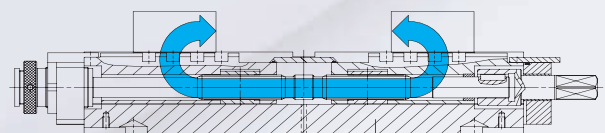
Sectional view RKZ



NCZ

The NC self-centering vice NCZ is universally suited for use in machining centers and conventional machine tools. The NCZ offers various actuation options.

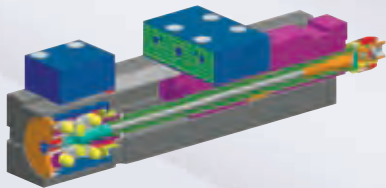
Sectional view NCZ



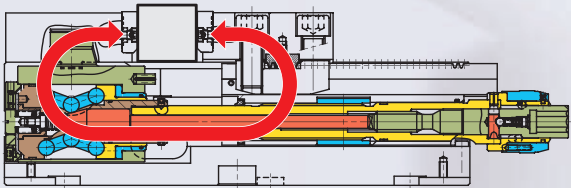
Functional description / Schematic representation

Clamping system mechanical-mechanical with toggle lever

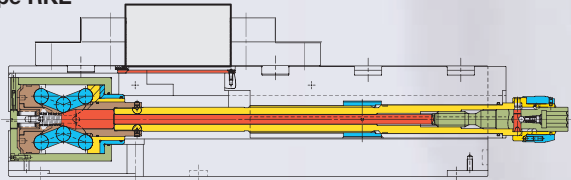
Single clamping



Type RKK



Type RKE



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.

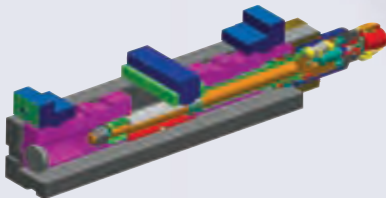
c) Mechanical clamping without power transmission

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.

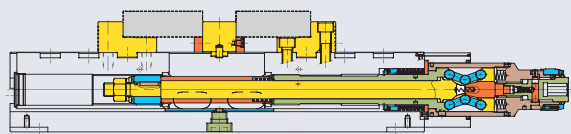
The adjustment collar can then be set to the desired clamping force, and the high clamping force introduced.

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

Twin clamping

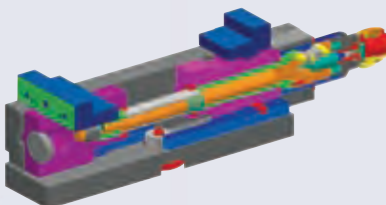


Type RKD

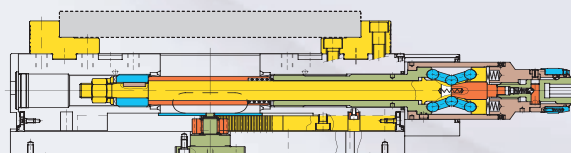


Movable clamping jaw I is brought to the workpiece in Station 1 by clockwise turning of the spindle using the hand-crank, and held there at a clamping force of approx. 100 daN ("third hand function"). Continuing to turn the crank brings movable clamping jaw II to the workpiece in Station II and fixes 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!

Centric clamping



Type RKZ



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 centric motion of the movable clamping jaw over the entire clamping stroke, regardless of clamping force and clamping span.

RKK with SA / SGN jaws



They are primarily used with modern CNC milling machines and machining centers requiring a high degree of accuracy. Clamping possible on 3 sides.

RKK size 1: Clamping system mechanical-hydraulic with power transmitter, manually operated; with stepped jaws
RKK sizes 2 to 5: Clamping system mechanical-mechanical with power transmitter, manually operated; with standard jaws SA and normal jaw SGN

Compact and solid construction makes RÖHM NC-compact vices stand out.

Technical features:

- the solid steel body and all guide surfaces are hardened and ground on all sides
- locking pin with clamping force presetting
- mounting thread for workpiece stop
- clamping surface for clamping claws
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured

Customer advantage:

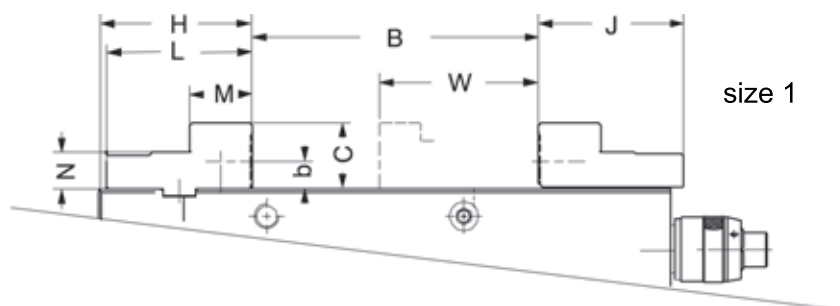
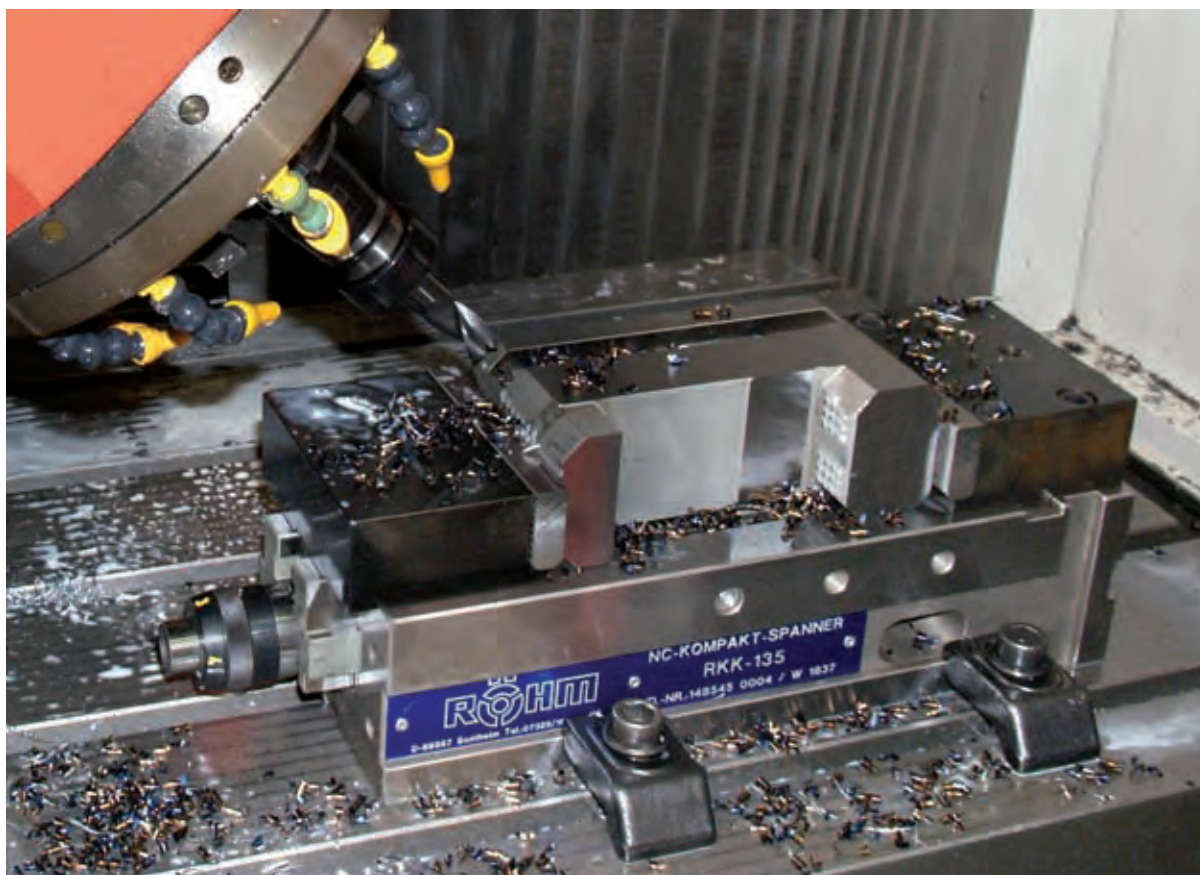
- non-deformable design for very high clamping accuracy
- size 1: long clamping slide with diagonal offset, hardened on all sides, function surfaces ground
- size 2-5: long clamping slide with toothing

Tool group A32
Type 743-10 **RKK**
with standard jaws SA and
SGN normal jaw

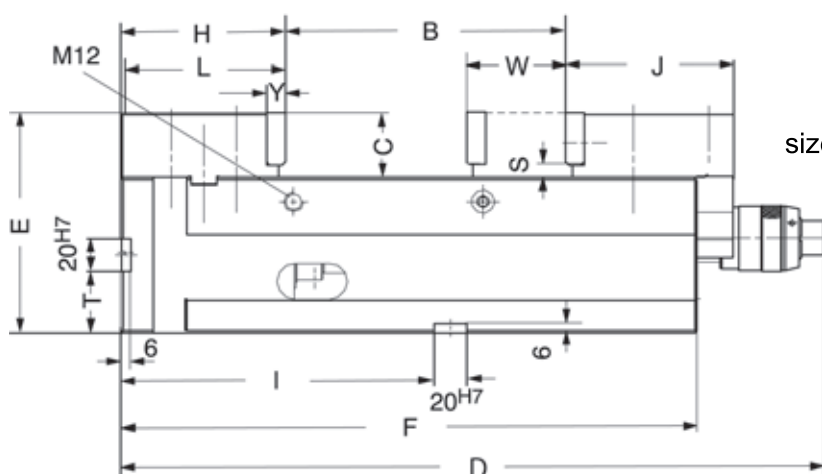
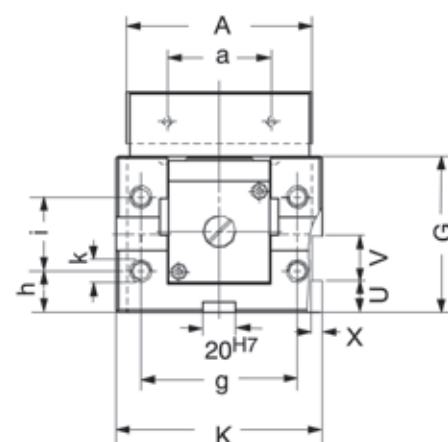
Item no.	162640 ¹⁾	148681	151342	148545	148682	149371
Size	1	2	2a	3	4	5
Jaw width A	92	113	113	135	160	200
Clamping capacity B	0-138	0-170	0-170	0-215	0-340	0-340
C	32	39	39	49	60	70
D	330	424	424	483	618	618
E	112	133	133	148	179	189
F	276	350	350	400	525	525
G _{0,02}	80	95	95	100	120	120
H _{0,05}	73	100	100	110,5	130	130
J	70	102	102	102	110	110
K	94	125	125	150	205	205
L	70	99	99	109	128	128
M	30	-	-	-	-	-
N	18	-	-	-	-	-
S	-	74	74	9,4	10,4	74
T _{0,02}	30	37,5	37,5	40	50	50
U	20	20	20	20	20	20
V	20	40	40	40	40	40
W	68	125	125	168	235	235
X	4,5	6,5	6,5	6,5	6,5	6,5
Y	-	11,6	11,6	15,6	15,6	19,6
Clamping travel	70	50	50	60	108	108
a	63	63	63	80	100	125
b	13,6	13,6	13,6	15,6	19,6	24,6
c	M6x11	M6x12	M6x12	M8x13	M8x13	M10x15
g	70	95	95	110	145	145
h	20	25	25	22,5	20	20
i	40	45	45	55	80	80
k	M10x12	M12x20	M12x20	M12x22	M16x20	M16x20
l _{0,02}	140	190	190	240	365	365
Clamping force kN	25	30	40	40	60	60
Weight kg	15	35	35	50	107	108

1) With stepped jaws

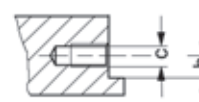
RKK with SA / SGN jaws



size 1



size 2-5



Accessories RKK

Tool group A37
Type 743-51 **Stepped jaws SB**
reversible

Item no.	Contents of delivery	Size	Width	Height
162627	set	1	92	32



Tool group A37
Type 743-50
Standard top jaws SA
reversible, for use in conjunction
with bolt-on jaws, with mounting
screws

Item no.	Contents of delivery	Size	Width	Height
149233	set	2/2a	109	39
149236	set	3	132	49
149373	set	4	157	60
149374	set	5	197	70



Tool group A37
Type 743-70 **Carrier jaws TB**
reversible, for use in conjunction
with pronged inserts or special
jaws, with mounting screws

Item no.	Contents of delivery	Size	Width	Height
148687	set	2/2a	110	25
147748	set	3	135	30
148688	set	4	160	30
149384	set	5	200	30



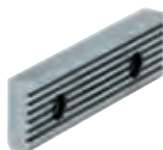
Tool group A37
Type 726-74 **Pronged insert KRE**
for carrier jaws 743-70
with fixing screw

Item no.	Contents of delivery	Size	Width	Height
146070	piece	1/2/3/4/5/2a	30	20



Tool group A37
Type 721 **Normal jaw SGN**
one side smooth, one side
grooved, both sides ground

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



Accessories RKK

Tool group A37
Type 721

Normal jaw fine checkered SGNf
reversible, used to increase the specific surface pressure (higher retention force), one side fine checkered, one side longitudinally checkered



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

Tool group A37

Type 721 **V-jaw SPR**
with vertical and horizontal ground V's, hardened, for use in combination with SGNf; only suitable for twin-clamping



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

Tool group A37

Type 721 **Draw-down jaws SNF**
with spring plate, hardened and ground



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

Tool group A37

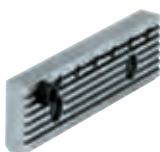
Type 721-00 **V-jaw and standard jawSBO**
soft and gunmetal-finished, with work support; for BOF and BSS



Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
317259 ●	set	2/2a	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

Tool group A37

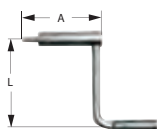
Type 721-52 **Normal jaw SGNA**
with movable workpiece locator, hardened and ground; only suitable for twin-clamping



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

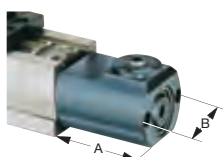
Accessories RKK

Tool group A37
Type 744 **Hand crank**
turnable handle, hexagon socket



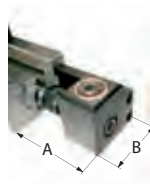
Item no.	Contents of delivery	Size	Hexagon	A	L
134198 ●	piece	1	12	60	90
134600 ●	piece	2/3/4/5/2a	14	104	160

Tool group A37
Type 743-19 **90° Angle drive**
for RKK 92 / RKE-L 92
for fastening to NC-compact vices,
ideal for side-mounted clamping
jaws or for large machine tables



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

Tool group A37
Type 743-19 **90° Angle drive**
for RKK 2-5

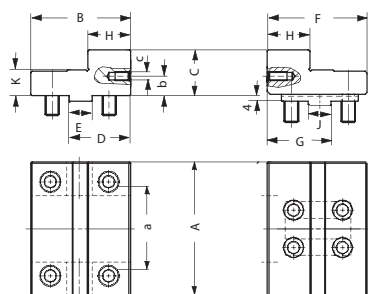


Item no.	Contents of delivery	Size	A	B	C
151650 ■	piece	2/2a	154	93,5	98
151651 ■	piece	3	161	101	98
151652 ■	piece	4/5	174	111	98

Clamping jaw dimensions for RKK

Type 743 - 51 SB

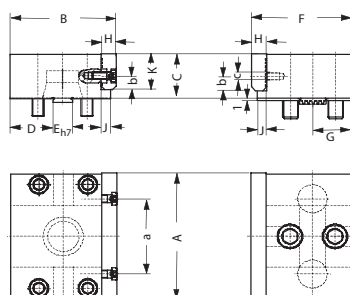
Stepped jaws, reversible



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

Type 743 - 50 SA

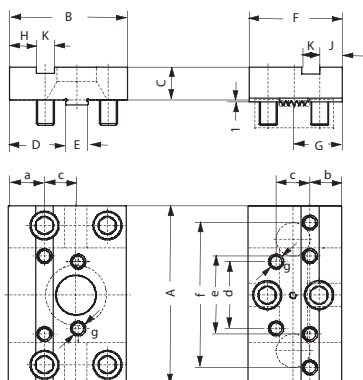
SA standard top jaws, reversible



Size	2	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 _{h7}	16	20	20	20
F	102	102	110	110
G	38	39	42	42
H	11,6	15,6	15,6	19,6
J	76	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

Type 743 - 70 TB

Carrier jaws, reversible



Size	2	3	4	5
A	110	135	160	200
B	90	95	105	105
C	25	30	30	30
D	41	44	50	50
E _{h7}	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 _{H7}	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

	SN with SNS	SN reversed	Carrier jaws with pronged inserts	Carrier jaws with pronged inserts	Stepped jaw Stepped jaw, reversed
Size					
1	-	-	-	-	B9: 0-138 / B10: 84-222
2+2a	0-170	35-206	59-233	89-263	
3	0-215	29-255	30-257	110-337	
4+5	0-340	48-386	59-395	144-481	



Especially used on CNC-machines.
With the DUO clamping tower exists the possibility to clamp two NC compact vices, face mounting back to back.

Clamping system mechanical-mechanical with power transmitter, manually operated
Horizontal, vertical or side mounting.

Technical features:

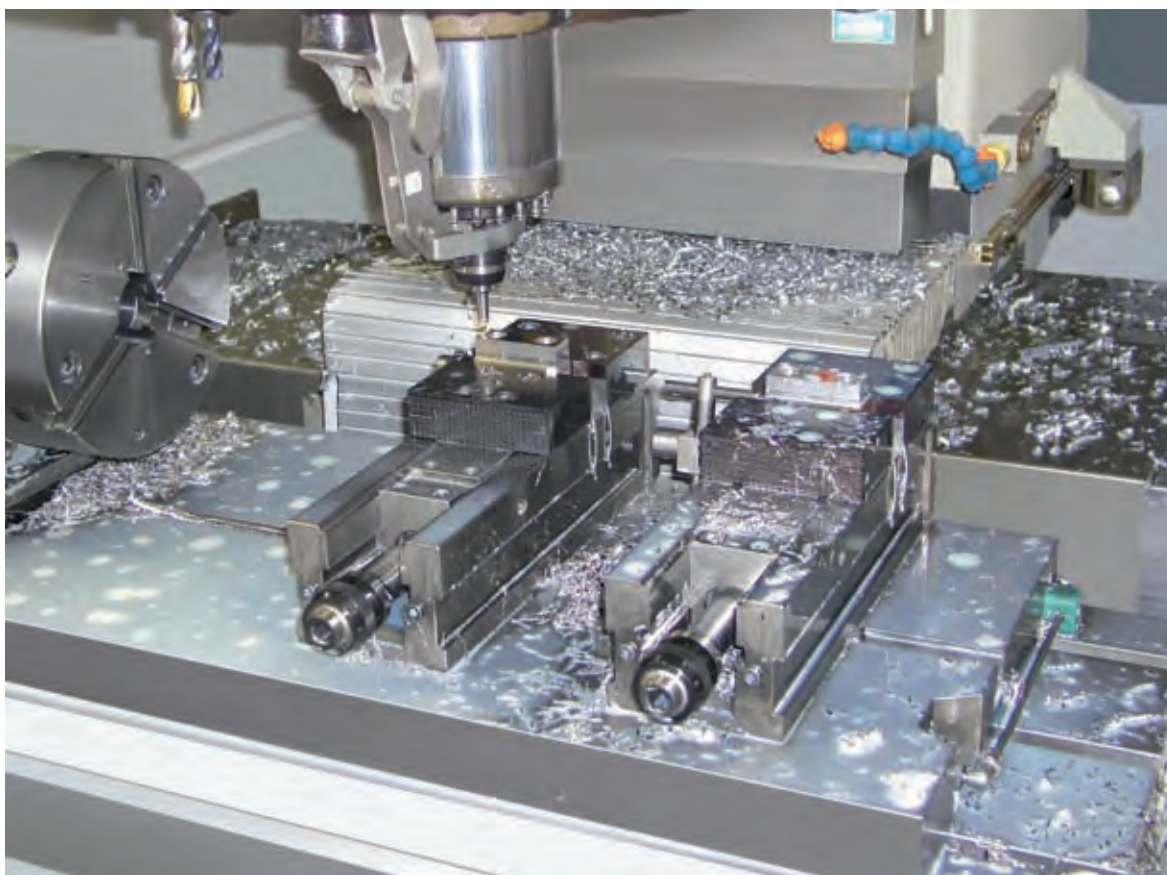
- the solid steel body and all guide surfaces are hardened and ground on all sides
- long clamping slide with clutch, hardened on all sides, function surfaces ground
- locking pin with clamping force presetting
- clamping surface for clamping claws
- solid chip guard prevents chips from penetrating the inside of the body

Customer advantage:

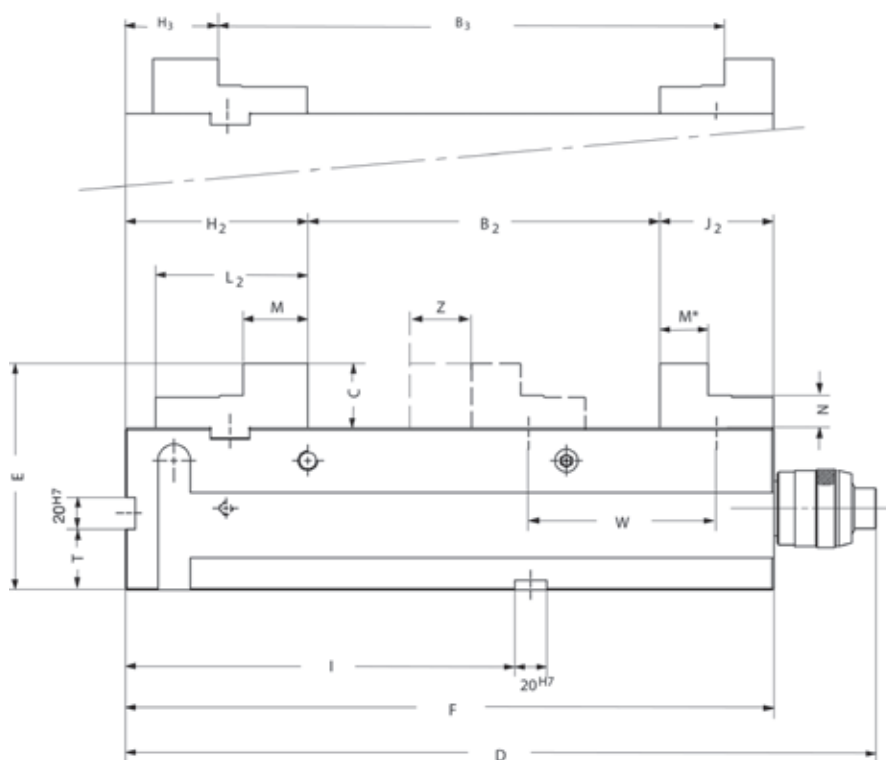
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured
- thread-bore for receiving all ROHM flat-clamping jaws with jaw width 125/160mm
- thread for fastening angle drive

Tool group A32
Type 743-10 RKE
with stepped jaws or standard
clamping jaws

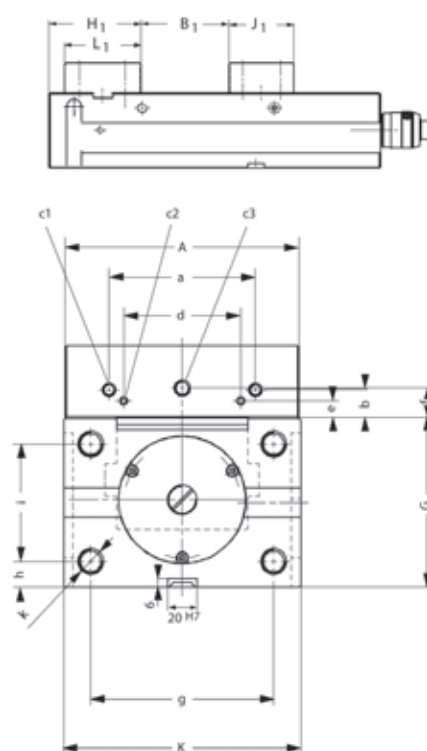
Item no.	160342 ●	162648 ●	162646 ●	162647 ●
Jaw width A	125	160	125	160
Jaw design	stepped jaws	stepped jaws	standard clamping jaws	standard clamping jaws
B1	-	-	0-215	0-320
B2	0 - 216	0 - 320	-	-
B3	97 - 312	131 - 451	-	-
C	40	50	40	50
D	463	618	463	618
F	400	530	400	530
G _{0,02}	100	115	100	115
H1 _{-0,05}	-	-	110,5	130
H2 _{-0,05}	112,5	130	-	-
H3 _{-0,05}	56,5	64	-	-
J1	-	-	78	100
J2	70	97	-	-
K	126	162	126	162
L1	-	-	92	100
L2	94	98	-	-
M	40	34	-	-
M*	30	32,5	30	32,5
N _{0,01}	20	25	-	-
T _{-0,02}	37,5	47,5	37,5	47,5
W	1 x 108	2 x 102,5	1 x 108	2 x 102,5
Z	109	117	109	117
a	80	100	80	100
b	15,6	19,6	15,6	19,6
c1	M8x14	M8x14	M8x14	M8x14
c2	M5x10	M5x10	M5x10	M5x10
c3	M10x18	M10x18	M10x18	M10x18
d	60	80	60	80
e	12	12	12	12
f	18	20	18	20
g	95	125	95	125
h	25	175	25	175
i	45	80	45	80
k	M 12 x 22	M 16 x 25	M 12 x 22	M 16 x 25
l _{-0,02}	240	200	240	200
Clamping force kN	40	60	40	60
Weight kg	41	79	41	79



stepped jaws



standard jaws



Accessories RKE

Tool group A37
Type 743-50
Standard top jaws SA
reversible



Item no.	Contents of delivery	Size	Width	Height
162628 ●	set	125	125	40
162629 ●	set	160	160	50

Tool group A37
Type 743-51 **Stepped jaws SB**
reversible



Item no.	Contents of delivery	Size	Width	Height
160343 ●	set	125	125	40
162630 ●	set	160	160	50

Tool group A37
Type 743-72 **Carrier jaws TB**
without swivelling claw inserts



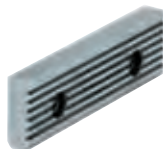
Item no.	Contents of delivery	Size	Width	Height
165856 ●	set	125	125	20
166218 ●	set	160	160	25

Tool group A37
Type 743-74
Swivelling pronged inserts
for carrier jaws 743-72



Item no.	Contents of delivery	Size	Ø	Height
165854 ●	piece	125	28	10
166216 ●	piece	160	30	10

Tool group A37
Type 721 **Normal jaw SGN**
one side smooth, one side
grooved, both sides ground



Item no.	Contents of delivery	Size	Width	Height
158897 ●	set	125	125	39,7
152755 ●	piece	160	160	49,6

Tool group A37
Type 721
Normal jaw fine checkered SGNf
reversible, used to increase the
specific surface pressure (higher
retention force), one side fine
checkered, one side longitudinally
checkered



Item no.	Contents of delivery	Size	Width	Height
163225 ●	set	125	125	39,7
156197 ●	piece	160	160	49,6

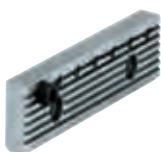
Accessories RKE

Tool group A37
Type 721 **V-jaw SPR**
with vertical and horizontal ground
V's, hardened, for use in
combination with SGN;
only suitable for twin-clamping



Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
082363 ●	piece	125	135	39,6	4-20	6-40
082364 ●	piece	160	160	49,6	5-29	7-48

Tool group A37
Type 721-52 **Normal jaw SGNA**
with movable workpiece locator,
hardened and ground; only suitable
for twin-clamping



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

Tool group A37
Type 721 **Draw-down jaws SNF**
with spring plate, hardened and
ground



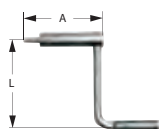
Item no.	Contents of delivery	Size	Width	Height
077105 ●	set	125	135	39,6
077106 ●	set	160	160	49,6

Tool group A37
Type 728-00
V-jaw and standard jawSBO
soft and gunmetal-finished, with
work support; for BOF and BSS



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

Tool group A37
Type 744 **Hand crank**
turnable handle, hexagon socket



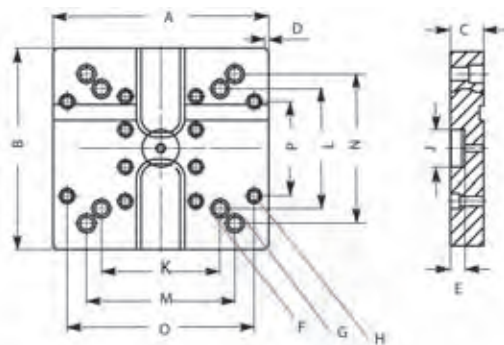
Item no.	Contents of delivery	Size	Hexagon	A	L
134600 ●	piece	125/160	14	104	160

Tool group A37
Type 743-19
90° Angle drive



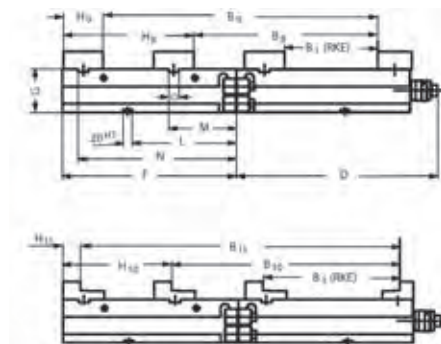
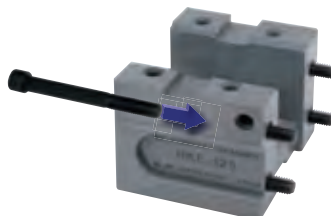
Item no.	Contents of delivery	Size	A	B	C
158339 ●	piece	125	133	106	98
158888 ●	piece	160	166	111	98

Special Accessories RKK / RKE



Tool group A37
Type 743-10
Standard basic plate GP
for DUO-Tower
for NC compact vices

Item no.	For	A	B	C	D	E	F	G	H	J	K	L	M	N	O	P	Weight kg
164016 ▲	RKD 92 / RKD-M 92	250	250	45	5x45°	20	KM 12	KM 16	KM 16	50	126	126	160	160	200	200	24
164018 ▲	RKK 92 / RKE 92	250	250	45	5x45°	20	KM 12	KM 16	KM 16	50	126	126	160	160	200	200	24
164020 ▲	RKK 113 / RKE 125 / RKD 125 / RKZ 125	290	270	45	5x45°	20	KM 16	KM 16	KM 12	50	160	160	200	200	252	126	29
164022 ▲	RKK 135	290	270	45	5x45°	20	KM 16	KM 16	KM 12	50	200	200	240	240	252	126	29
164024 ▲	RKK 160 / RKK 200	350	350	45	5x45°	20	KM 16	KM 12	KM 16	50	240	160	252	252	300	300	45
164026 ▲	RKE 160 / (RKE 200)	350	350	45	5x45°	20	KM 16	KM 12	KM 16	50	240	160	252	252	300	300	45

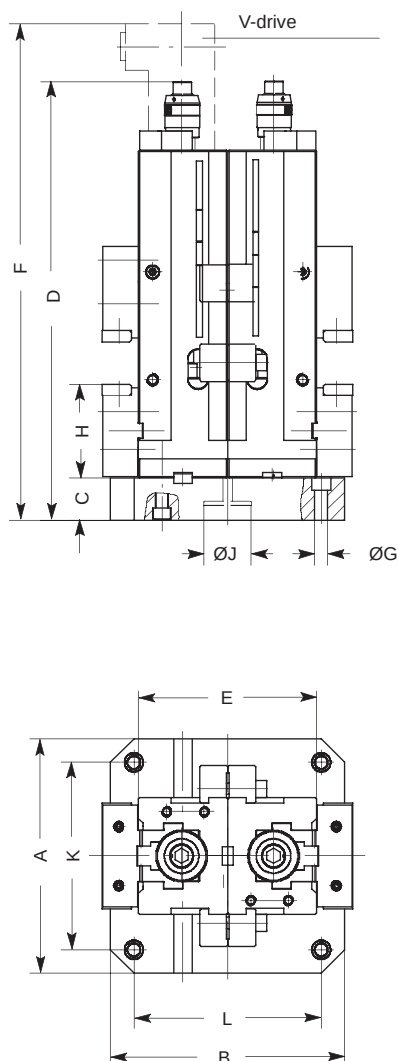


Tool group A37
Type 743-10
Extension GKV for extension of
clamping capacity for extra-long
workpieces (**only RKE**)
fastening with dual clamps
respectively with screws (included)

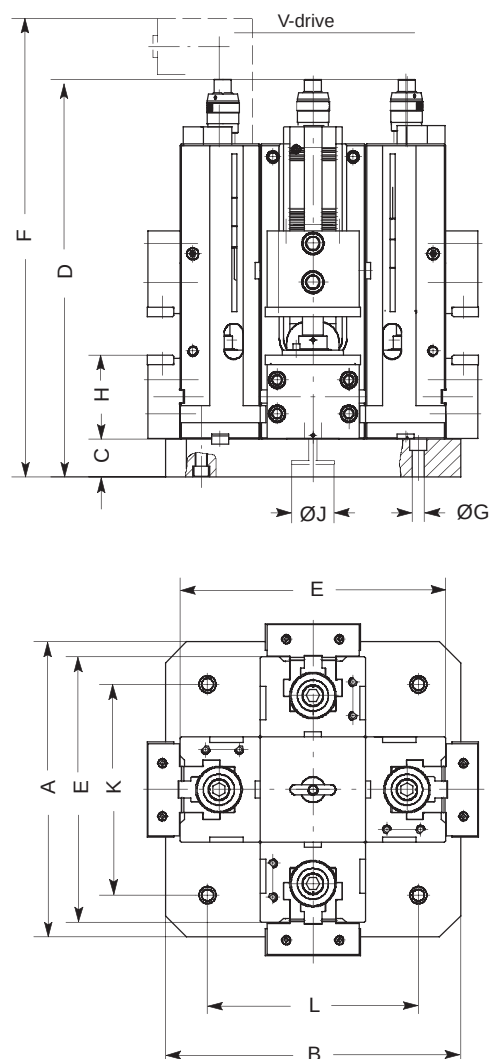
Item no.	For	D	F	G	L	M	N	O	B1	B3	B8	B9	B10	B11	H8	H9	H10	H11	Fixing	Weight kg
164118 ■	RKE 125	463	105	100	-	-	68	24	0-215	97-312	-	121-335	-	218-432	-	95	-	41	Dual clamps	6,5
164120 ■	RKE 125	463	200	100	-	-	160	24	0-215	97-312	-	213-427	-	310-524	-	98	-	44	Dual clamps	13
158436 ■	RKE 125	463	400	100	240	156	364	24	0-215	97-312	208-422	416-630	306-520	514-728	302	94	248	40	•	26
164122 ■	RKE 160	618	190	115	-	-	150	30	0-320	131-451	-	215-535	-	346-666	-	105	-	39	•	18
164124 ■	RKE 160	618	295	115	-	-	253	30	0-320	131-451	-	318-638	-	449-769	-	107	-	41	•	27
158911 ■	RKE 160	618	530	115	200	225	493	30	0-320	131-451	290-605	560-875	421-736	681-1006	370	102	304	36	•	49

Duo and Quatro clamping towers RKK and RKE

Duo clamping towers (on request)



Quatro clamping towers (on request)



Technical data

Size	RKK 92	RKK 113 RKK 113a	RKK 135	RKK 160	RKK 200	RKE 125	RKE 160 RKE 200
Jaw width	92	113	135	160	200	125	160
A	250	250	290	350	350	250	350
B	250	250	270	350	350	250	350
C	45	45	45	45	45	45	45
D	375	469	528	663	663	508	663
E	160	190	200	240	240	200	230
F	435	549	606	744	744	578	741
G*							
H	73	100	110,5	130	130	110,5	130
J*							
K*							
L*							
kg	50	90	125	260	260	105	200

* On inquiry insert dimensions please

Technical data

Size	RKK 92	RKK 113 RKK 113a	RKK 135	RKK 160	RKK 200	RKE 125	RKE 160 RKE 200
Jaw width	92	113	135	160	200	125	160
A	320	350	400	500	500	350	400
B	320	350	400	500	500	350	400
C	45	45	45	45	45	45	45
D	375	469	528	663	663	508	663
E	254	315	350	445	445	325	392
F	435	549	606	744	744	578	741
G*							
H	73	100	110,5	130	130	110,5	130
J*							
K*							
L*							
kg	100	180	250	530	530	210	375

* On inquiry insert dimensions please

RKE-L



Especially used on CNC-machines.
Base mounting.

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.

Technical features:

- solid steel-body
- all guide surfaces are hardened and ground
- long clamping slide with clutch, hardened on all sides, function surfaces ground
- locking pin with clamping force presetting
- clamping surface for clamping claws

Customer advantage:

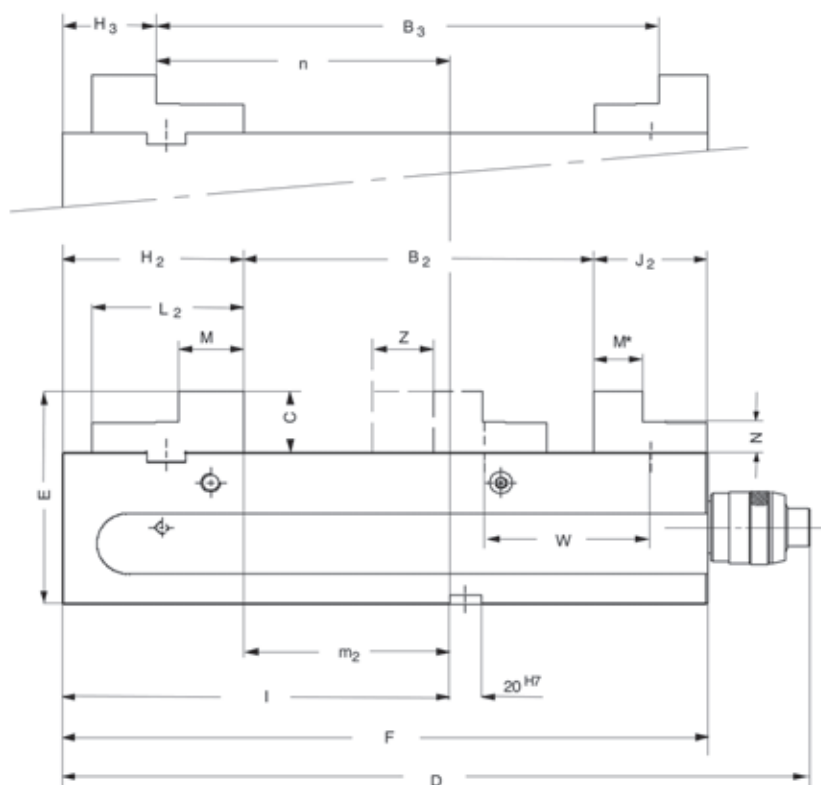
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured
- solid chip guard prevents chips from penetrating the inside of the body

Tool group A32
Type 743-10 **RKE-L**
with stepped jaws or standard
clamping jaws

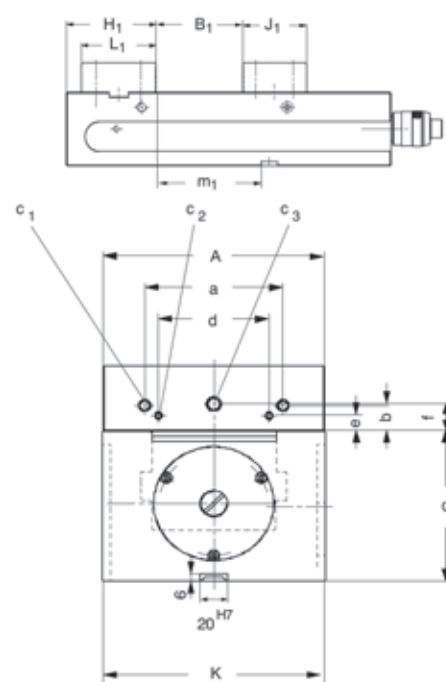
Item no.	162829	160671	162830	163375	162827	162828	163374
Jaw width A	92	125	160	200	125	160	200
Jaw design	stepped jaws	stepped jaws	stepped jaws	stepped jaws	standard clamping jaws 0 - 215	standard clamping jaws 0 - 320	standard clamping jaws 0 - 320
B1	-	-	-	-	-	-	-
B2	0 - 138	0 - 216	0 - 320	0 - 315	-	-	-
B3	71 - 208	97 - 312	131 - 451	131 - 451	-	-	-
C	32	40	50	60	40	50	60
D	330	463	618	618	463	618	618
F	276	400	530	530	400	530	530
G _{±0,02}	80	100	115	115	100	115	115
H1	-	-	-	-	110,5	130	130
H2	80	112,5	130	135	-	-	-
H3	41	56,5	64	64	-	-	-
J1	-	-	-	-	78	100	100
J2	56	70	97	97	-	-	-
K	94	126	162	162	126	162	162
L1	-	-	-	-	92	100	105
L2	64	94	98	103	-	-	-
M	25	40	34	39	-	-	-
M*	25	30	32,5	32,5	-	-	-
N _{±0,01}	16	20	25	25	-	-	-
W	68	1x108	2x102,5	2x102,5	1x108	2x102,5	2x102,5
Z	70	109	117	117	109	117	117
a	63	80	100	125	80	100	125
b	13,6	15,6	19,6	24,6	15,6	19,6	24,6
c1	M 6x14	M 8x14	M 8x14	M 10x15	M 8x14	M 8x14	M 10x15
c2	M 5x9	M 5x10	M 5x9	M 5x10	M 5x10	M 5x9	M 5x10
c3	M 10x16	M 10x18	M 10x18	M 14x20	M 10x18	M 10x18	M 14x20
d	48	60	80	110	60	80	110
e	8	12	12	12	12	12	12
f	14	18	20	25	18	20	25
l	140	240	200	200	240	200	200
m1 _{±0,02}	-	-	-	-	129,5	70	65
m2 _{±0,02}	60	127,5	70	65	-	-	-
n _{±0,02}	99	183,5	136	136	-	-	-
Clamping force kN	25	40	60	60	40	60	60
Weight kg	15	41	79	85	41	79	85



stepped jaws



standard jaws



Accessories RKE-L

Tool group A37
Type 743-50
Standard top jaws SA
reversible



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

Tool group A37
Type 743-51 **Stepped jaws SB**
reversible



Item no.	Contents of delivery	Size	Width	Height
162851 ●	set	92	92	32
160343 ●	set	125	125	40
162630 ●	set	160	160	50
162985 ●	set	200	200	60

Tool group A37
Type 743-72 **Carrier jaws TB**
without swivelling claw inserts



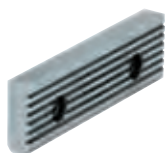
Item no.	Contents of delivery	Size	Width	Height
165856 ●	set	125	125	20
166218 ●	set	160	160	25

Tool group A37
Type 743-74
Swivelling pronged inserts
for carrier jaws 743-72



Item no.	Contents of delivery	Size	Ø	Height
165854 ●	piece	125	28	10
166216 ●	piece	160	30	10

Tool group A37
Type 721 **Normal jaw SGN**
one side smooth, one side
grooved, both sides ground



Item no.	Contents of delivery	Size	Width	Height
152752 ●	piece	92	92	31,6
158897 ●	set	125	125	39,7
152755 ●	piece	160	160	49,6
152759 ●	piece	200	200	62,6

Tool group A37
Type 721
Normal jaw fine checkered SGNf
reversible, used to increase the
specific surface pressure (higher
retention force), one side fine
checkered, one side longitudinally
checkered



Item no.	Contents of delivery	Size	Width	Height
163218 ●	piece	92	92	31,6
163225 ●	set	125	125	39,7
156197 ●	piece	160	160	49,6
156198 ●	piece	200	200	62,6

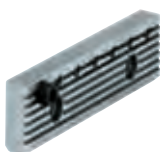
Accessories RKE-L

Tool group A37
Type 721 **V-jaw SPR**
with vertical and horizontal ground
V's, hardened, for use in combina-
tion with SGN; only suitable for
twin-clamping



Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					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

Tool group A37
Type 721-52 **Normal jaw SGNA**
with movable workpiece locator,
hardened and ground; only suitable
for twin-clamping



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

Tool group A37
Type 721 **Draw-down jaws SNF**
with spring plate, hardened and
ground



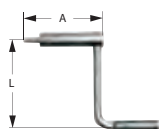
Item no.	Contents of delivery	Size	Width	Height
077105 ●	set	125	135	39,6
077106 ●	set	160	160	49,6
077107 ■	set	200	200	62,6

Tool group A37
Type 728-00
V-jaw and standard jawSBO
soft and gunmetal-finished, with
work support; for BOF and BSS



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

Tool group A37
Type 744 **Hand crank**
turnable handle, hexagon socket



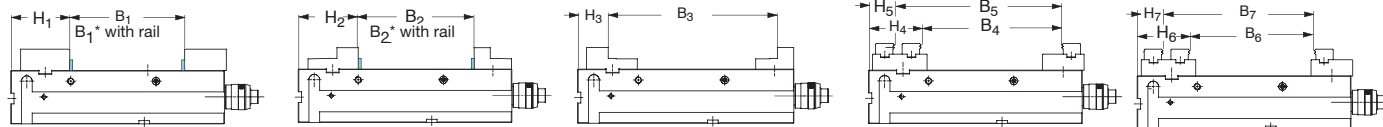
Item no.	Contents of delivery	Size	Hexagon	A	L
134198 ●	piece	92	12	60	90
134600 ●	piece	125/160/200	14	104	160

Tool group A37
Type 743-19
90° Angle drive



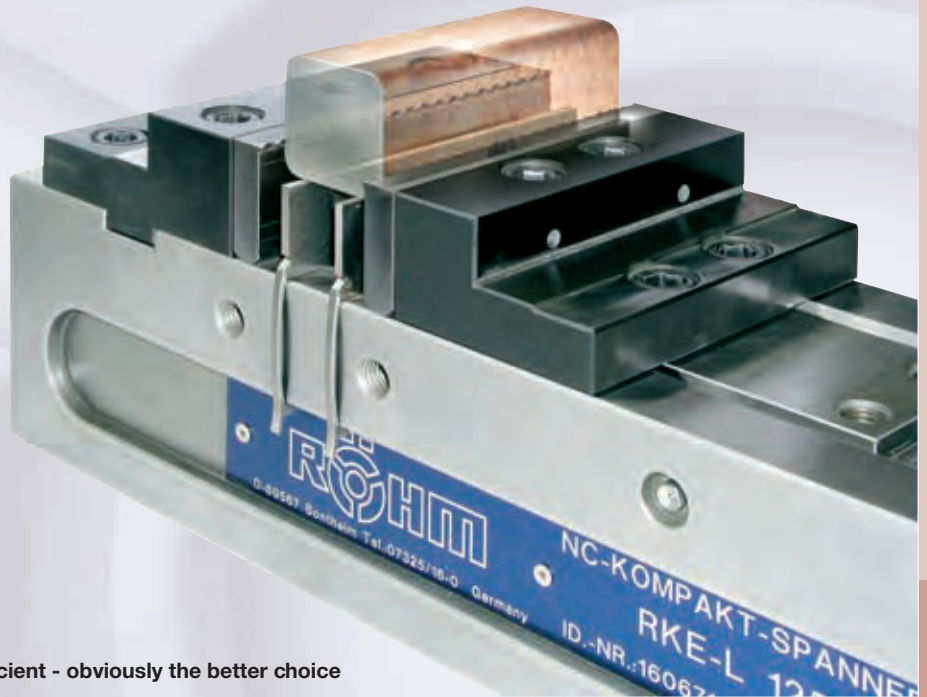
Item no.	Contents of delivery	Size	A	B	C
154185 ■	piece	92	113,5	90	83,5
158339 ●	piece	125	133	106	98
158888 ●	piece	160/200	166	111	98

Clamping ranges RKE / RKE-L



	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-L 92	-	-	80	0-138 *12-138	41	71-208	-	-	-	-
RKE 125 RKE-L 125	110,5	0-215 *12-215	112,5	0-216 *12-216	56,5	97-312	H ₄ : 98 H ₅ : 48	B ₄ : 50-262 B ₅ : 100-321	H ₆ : 98 H ₇ : 48	B ₆ : 20-232 B ₇ : 70-282
RKE 160 RKE-L 160	130	0-320 *12-320	130	0-320 *12-320	64	131-451	H ₄ : 122 H ₅ : 52	B ₄ : 67-383 B ₅ : 137-453	H ₆ : 122 H ₇ : 52	B ₆ : 18-334 B ₇ : 88-404
RKE-L 92	130	0-320 *12-320	135	0-315 *12-315	64	131-451	-	-	-	-

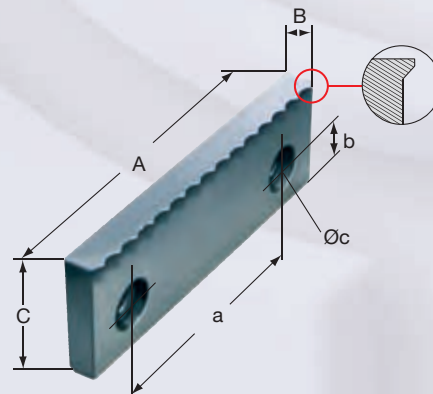
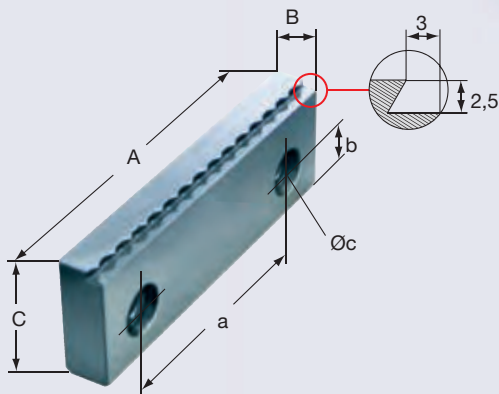
SKB Claw jaws - the clever alternative to embossing technology



Claw jaws SKB
without step, clamping depth > 2,5 mm,
workpiece clamping e.g. with
„Cliparc“ support rails

Claw jaws SKB: stronger, more flexible, more efficient - obviously the better choice

- Positive-fit clamping by the penetration of the hardened claw tips
- High holding forces: enhancement by a factor of 3 to 5 compared to standard jaws
- 5-side machining in one set-up
- Low material loss
- Shorter cycle times
- Reduced production costs and costs per piece
- For use on vices
- Easy to screw onto RÖHM NC-Compact Vices
- Easy, reliable clamping of parallel raw and sawed parts
- Hydraulic or manual clamping
- With fine step for clamping depth up to 2,5 mm
- Without fine step for clamping depth > 2,5 mm



Claw jaws SKB with fine step

2,5 mm clamping depth

Tool group A37

Item no. Set	166514	166520	166522
A	92	125	160
B	14	16	18
C	32	40	50
a	63	80	100
b	13,6	15,6	19,6
Øc	7(M6)	9(M8)	9(M8)

Claw jaws SKB without step

universal for clamping depth > 2,5 mm

Tool group A37

Item no. Set	166661	166667	166669
A	92	125	160
B	14	16	18
C	32	40	50
a	63	80	100
b	13,6	15,6	19,6
Øc	7(M6)	9(M8)	9(M8)

RKG-L



Base mounting.
Made in one casting.

Clamping system mechanical-mechanical with power transmitter, manually operated
With stepped jaws

Technical features:

- function surfaces hardened and ground
- stable basic body made of GGG
- long clamping slide with clutch
- locking pin with clamping force presetting
- clamping surfaces for clamping claws

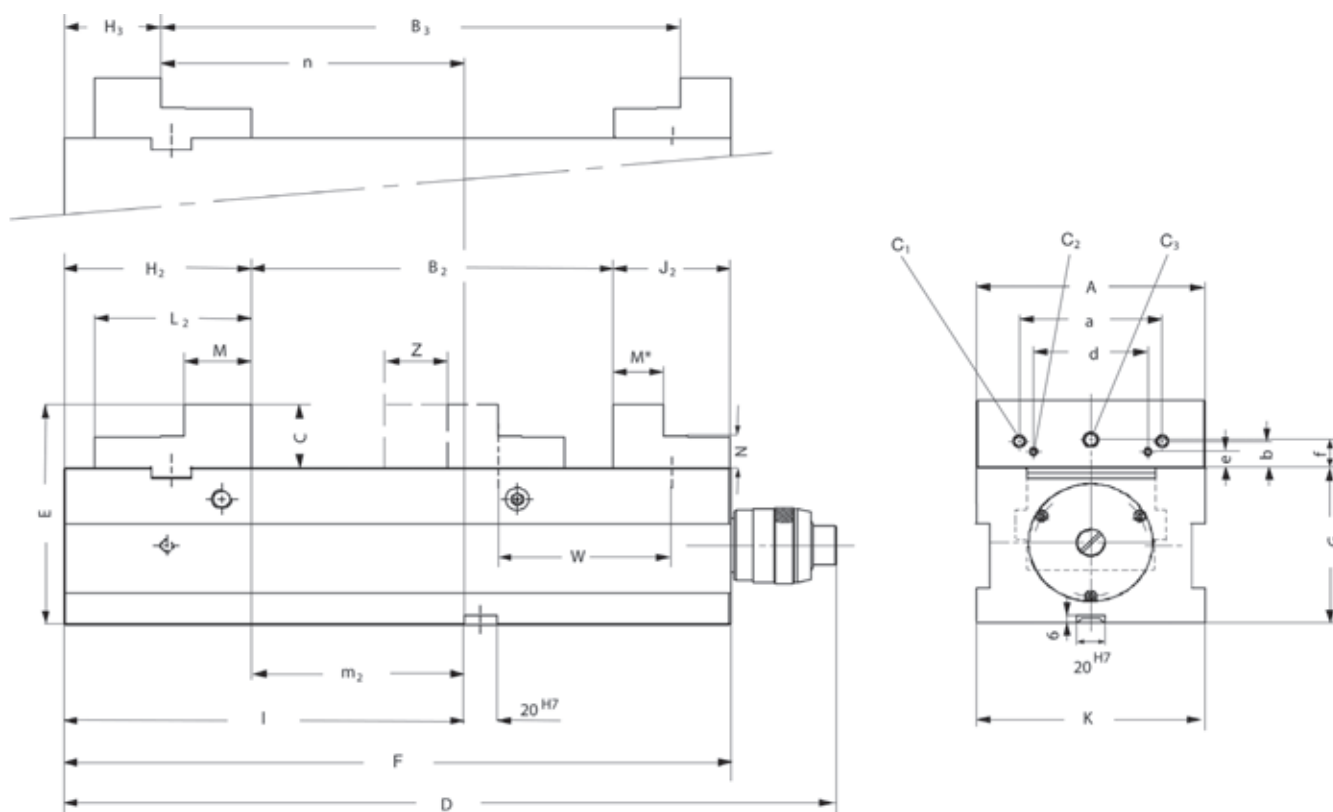
Customer advantage:

- solid chip guard prevents chips from penetrating the inside of the body
- stepped jaws, reversible, hardened and ground
- mounting thread M12 for workpiece stop

Tool group A32
Type 743-10 **RKG-L**
With stepped jaws

Item no.	164691 ●	164692 ●	164693 ●
Jaw width A	125	160	200
Jaw design	stepped jaws	stepped jaws	stepped jaws
B2	0-216	0 - 320	0 - 315
B3	97-312	131 - 451	131 - 451
C	40	50	60
D	463	618	618
E	140	165	175
F	400	530	530
G _{±0,02}	100	115	115
H2	112,5	130	135
H3	56,5	64	64
J2	70	97	97
K	126	162	162
L2	94	98	103
M	40	34	39
M*	30	32,5	32,5
N _{±0,01}	20	25	25
W	1x108	2x102,5	2x102,5
Z	109	117	117
a	80	100	125
b	15,6	19,6	24,6
c1	M8x14	M 8x14	M 10x15
c2	M5x10	M 5x9	M 5x10
c3	M10x18	M 10x18	M 14x20
d	60	80	110
e	12	12	12
f	18	20	25
l	240	200	200
m2 _{±0,02}	127,5	70	65
n _{±0,02}	183,5	136	136
Clamping force kN	40	60	60
Weight kg	41	79	85

RKG-L



Accessories RKG-L

Tool group A37
Type 743-50
Standard top jaws SA
reversible



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

Tool group A37
Type 743-51 **Stepped jaws SB**
reversible



Item no.	Contents of delivery	Size	Width	Height
160343 ●	set	125	125	40
162630 ●	set	160	160	50
162985 ●	set	200	200	60

Tool group A37
Type 743-72 **Carrier jaws TB**
without swivelling claw inserts



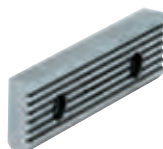
Item no.	Contents of delivery	Size	Width	Height
165856 ●	set	125	125	20
166218 ●	set	160	160	25

Tool group A37
Type 743-74
Swivelling pronged inserts
for carrier jaws 743-72



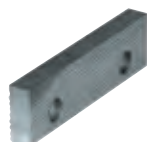
Item no.	Contents of delivery	Size	Ø	Height
165854 ●	piece	125	28	10
166216 ●	piece	160	30	10

Tool group A37
Type 746-50 **Standard jaws SGN**
one side smooth, one side
grooved, hardened and ground



Item no.	Contents of delivery	Size	Width	Height
158897 ●	set	125	125	39,7
152755 ●	piece	160	160	49,6
152759 ●	piece	200	200	62,6

Tool group A37
Type 746-50 **Standard jaws fine
checkered SGNf**
reversible, used to increase the
specific surface pressure (higher
retention force), one side fine
checkered, one side longitudinally
checkered



Item no.	Contents of delivery	Size	Width	Height
163225 ●	set	125	125	39,7
156197 ●	piece	160	160	49,6
156198 ●	piece	200	200	62,6

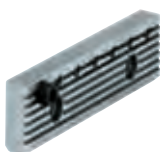
Accessories RKG-L

Tool group A37
Type 721 **V-jaw SPR**
with vertical and horizontal ground
V's, hardened, for use in combina-
tion with SGN; only suitable for
twin-clamping



Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
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

Tool group A37
Type 721-52 **Normal jaw SGNA**
with movable workpiece locator,
hardened and ground; only suitable
for twin-clamping



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

Tool group A37
Type 721 **Draw-down jaws SNF**
with spring plate, hardened and
ground



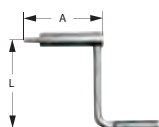
Item no.	Contents of delivery	Size	Width	Height
077105 ●	set	125	135	39,6
077106 ●	set	160	160	49,6
077107 ■	set	200	200	62,6

Tool group A37
Type 728-00
V-jaw and standard jawSBO
soft and gunmetal-finished, with
work support; for BOF and BSS



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

Tool group A37
Type 744 **Hand crank**
turnable handle, hexagon socket



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

Tool group A37
Type 743-19
90° Angle drive



Item no.	Contents of delivery	Size	A	B	C
158339 ●	piece	125	133	106	98
158888 ●	piece	160/200	166	111	98

RKE-LV



Collision free 5-side machining in one operation

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

Technical features:

- with tension clamping, 0-point of workpiece-end on operators side
- large clamping range
- no shifting of the movable top jaw
- steel body and all guidings hardened and ground
- massive chip protection

Customer advantage:

- minimal processing times
- high-precision positioning
- compact design
- carrier jaws incl. swivelling claw inserts; for clamping of circular and rectangular workpieces

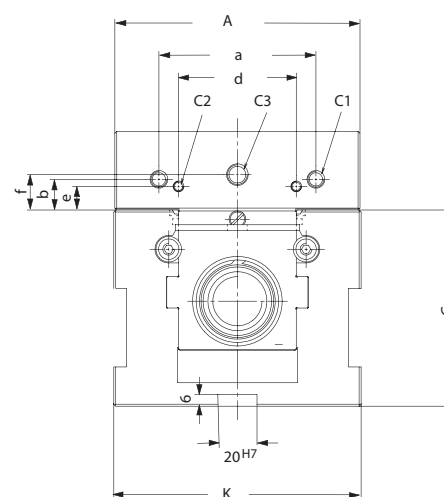
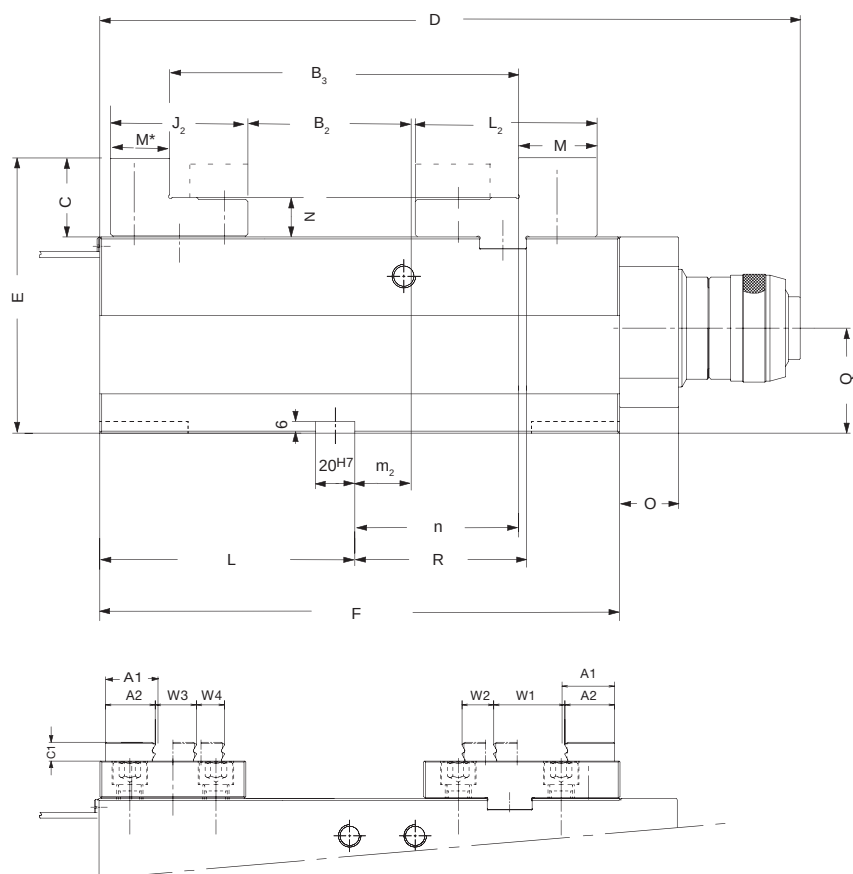
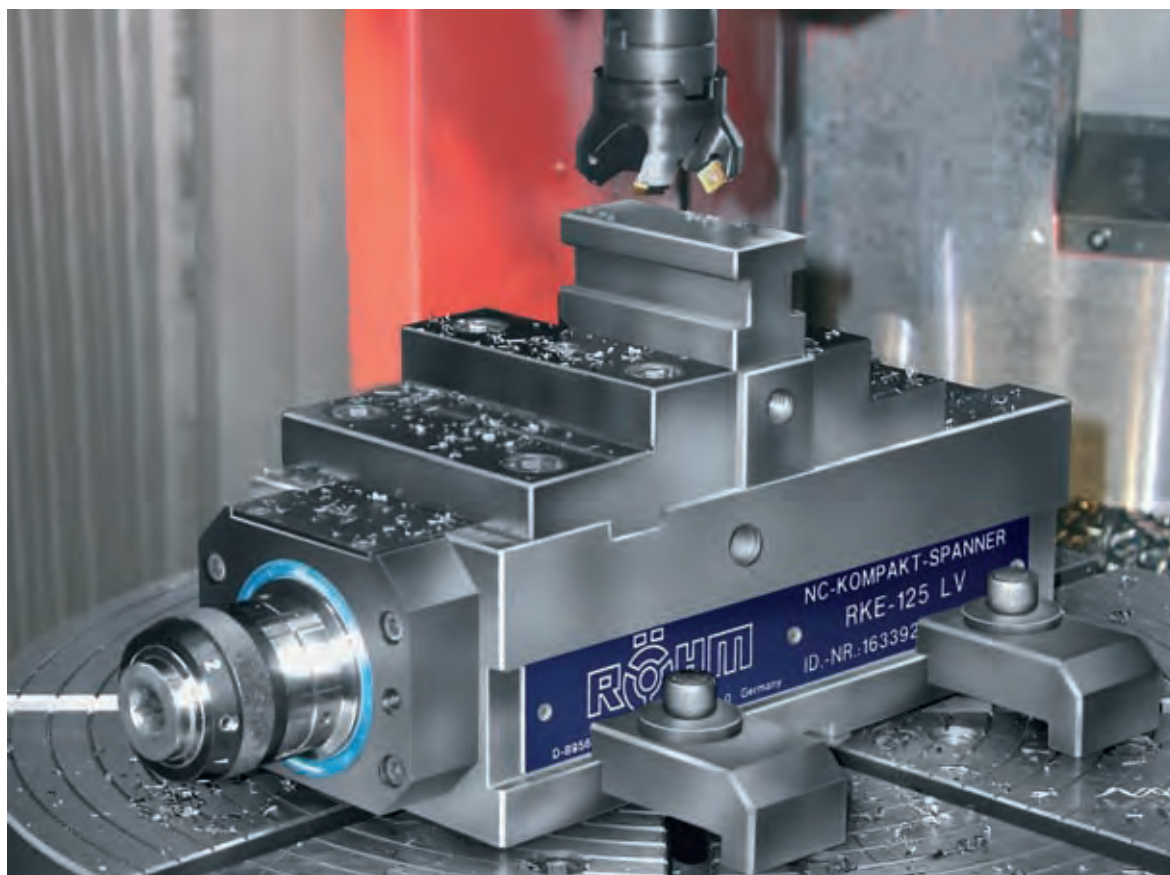
Clamping ranges carrier jaws:

rightangular workpieces: 35 - 215 mm,
circular workpieces: dia. 65 - 225 mm

Tool group A32
Type 743-10 **RKE-LV**
With reversible stepped jaws or carrier jaws

Item no.	163392 ●	165851 ■
Jaw width A	125	125
Jaw design	stepped jaws	carrier jaws
B2	0-96	35-215
B3	96-192	65-225
C	40	20
D	372	372
E	140	130
F	280	280
J2	70	78
K	126	126
L	145	125
L2	94	105
M	40	-
M*	30	-
N _{0,01}	20	20
O	30	30
Q	53,5	53,5
R	87,5	87,5
a	60	-
b	15,6	-
c1	M10	-
c2	M8	-
c3	M5	-
d	80	-
e	12	-
f	18	-
m2 _{±0,02}	27,5	-
n _{±0,02}	83,5	-
Clamping force kN	40	40
A1	-	28
A2	-	26,5
C1	-	10
W1	-	38
W2	-	17
W3	-	22
W4	-	15
Weight kg	29	29

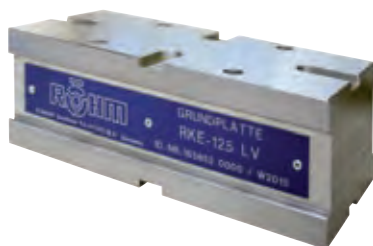
RKE-LV



Accessories RKE-LV

Tool group A37
Type 743-10
Standard basic plate GP

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



Tool group A37
Type 743-50
Standard top jaws SA
reversible

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



Tool group A37
Type 743-51 **Stepped jaws SB**
reversible

Item no.	Contents of delivery	Size	Width	Height
160343 ●	set	125	125	40



Tool group A37
Type 743-72 **Carrier jaws TB**
without swivelling claw inserts

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



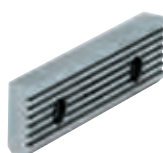
Tool group A37
Type 743-74
Swivelling pronged inserts
for carrier jaws 743-72

Item no.	Contents of delivery	Size	Ø	Height
165854 ●	piece	125	28	10



Tool group A37
Type 746-50 **Standard jaws SGN**
one side smooth, one side
grooved, hardened and ground

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



Accessories RKE-LV

Tool group A37
Type 746-50

Standard jaws fine checkered SGNr

reversible, used to increase the specific surface pressure (higher retention force), one side fine checkered, one side longitudinally checkered



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

Tool group A37

Type 721 **V-jaw SPR**

with vertical and horizontal ground V's, hardened, for use in combination with SGN; only suitable for twin-clamping

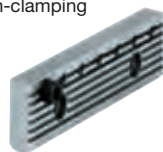


Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
082363 ●	piece	125	135	39,6	4-20	6-40

Tool group A37

Type 721-52 **Normal jaw SGNA**

with movable workpiece locator, hardened and ground; only suitable for twin-clamping



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

Tool group A37

Type 721 **Draw-down jaws SNF**

with spring plate, hardened and ground



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

Tool group A37

Type 728-00

V-jaw and standard jawSBO

soft and gunmetal-finished, with work support; for BOF and BSS

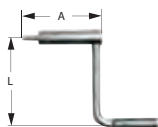


Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
317260 ●	set	125	135	39,8	3-13	6-40

Tool group A37

Type 744 **Hand crank**

turnable handle, hexagon socket



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

Tool group A37

Type 743-19

90° Angle drive



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

RKE-M LV



Because of the short design the RKE-M LV is perfect suitable for operation on 5 sides in one setting.

Clamping system mechanical without power transmitter, manually operated.

The equipment with transferable and reversible stepped jaws enables a high flexibility and wide range.

Adjusted to the workpiece, a large number of different clamping jaws of the RÖHM-assessories-program is available.

Technical features:

- solid steel body
- all guide surfaces are hardened and ground
- long clamping slide with clutch, hardened on all sides, function surfaces ground
- clamping surfaces for clamping claws
- shortend design with few interference sides; low risk of collision
- interchangeable jaw program for all kinds of operation

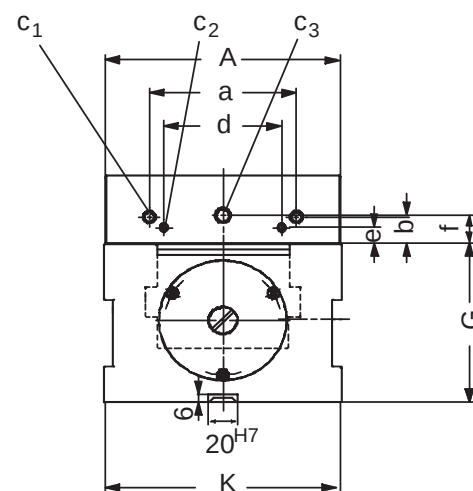
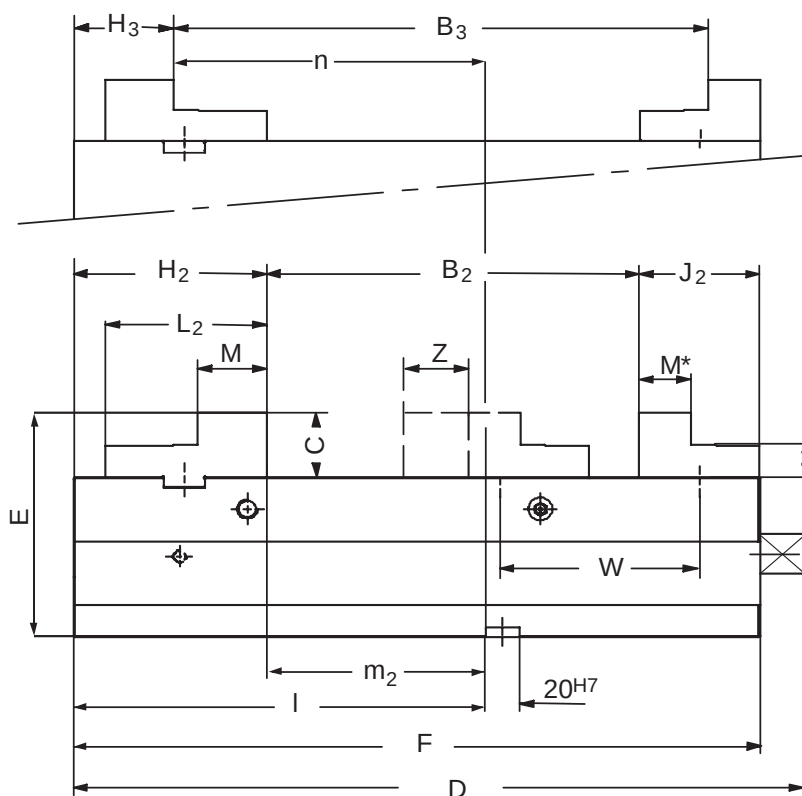
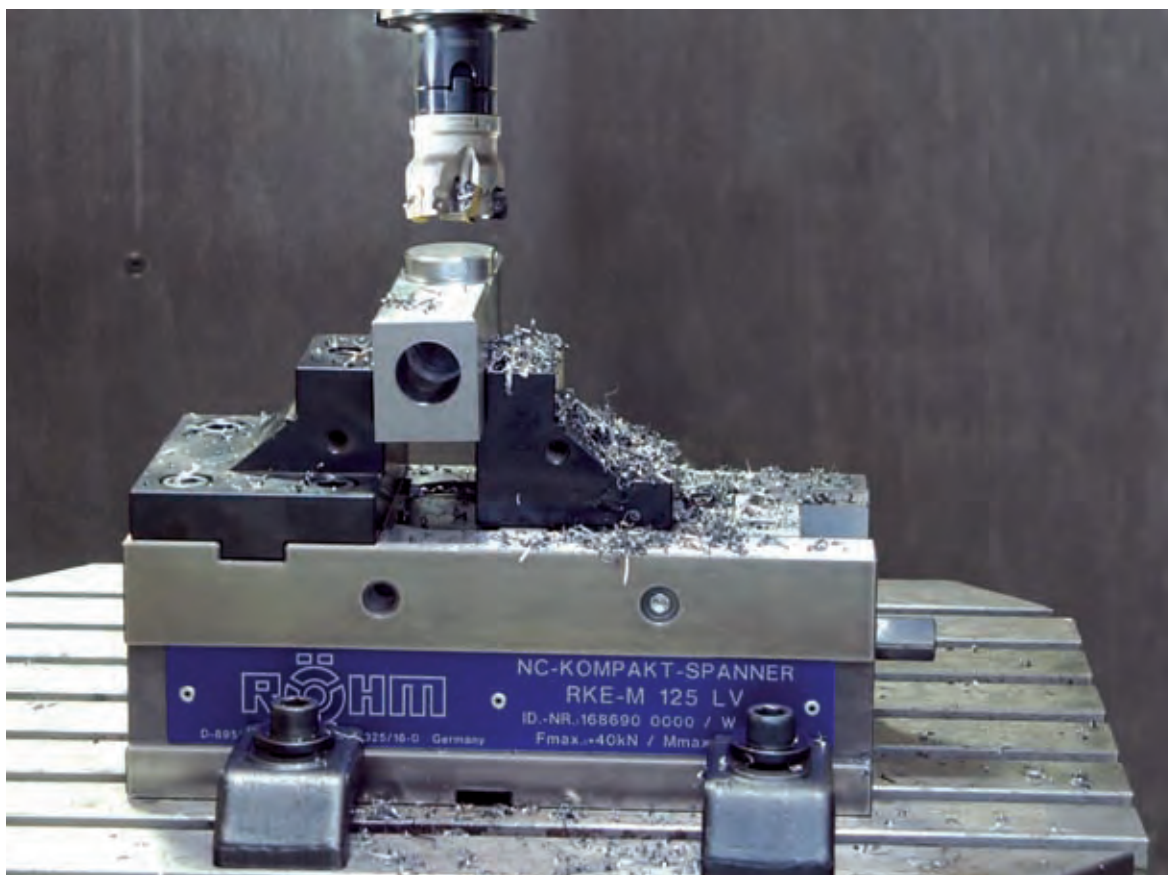
Customer advantage:

- the NC-compact vice can be actuated on both sides

Tool group A32
Type 743-00 **RKE-M LV**
With stepped jaws

Item no.	168689	168690
Jaw width A	92	125
Jaw design	stepped jaws	stepped jaws
B1	-	-
B2	0-98	0-110
B3	71-168	97-206
C	32	40
D	240	305
E	112	140
F	220	280
G _{0,02}	80	100
H ₁	-	-
H2	65	96,5
H3	26	40,5
J1	-	-
J2	56	70
K	94	126
L1	-	-
L2	64	94
M	25	40
M*	25	30
N _{0,01}	16	20
T _{-0,02}	-	-
Shifting range W	1x48	1x46
Clamping travel Z	52	65
a	63	80
b	13,6	15,6
c1	M 6x10	M8x14
c2	M5x8	M5x10
c3	M10x16	M10x18
d	48	60
e	8	12
f	14	18
g	-	-
h	-	-
i	-	-
l	100	125
m2 _{±0,02}	35	28,5
n _{±0,02}	74	84,5
Clamping force kN	25	40
Weight kg	12	27

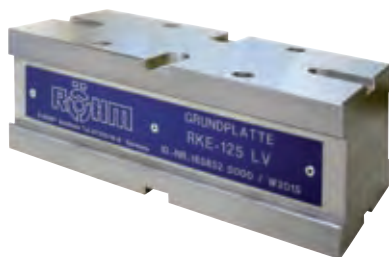
RKE-M LV



Accessories RKE-M LV

Tool group A37
Type 743-10
Standard basic plate GP

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



Tool group A37
Type 743-50
Standard top jaws SA
reversible

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



Tool group A37
Type 743-51 **Stepped jaws SB**
reversible

Item no.	Contents of delivery	Size	Width	Height
162851 ■	set	92	92	32
160343 ●	set	125	125	40



Tool group A37
Type 743-72 **Carrier jaws TB**
without swivelling claw inserts

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



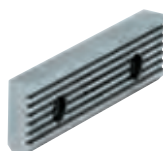
Tool group A37
Type 743-74 **Swivelling pronged inserts** for carrier jaws 743-72

Item no.	Contents of delivery	Size	Ø	Height
165854 ●	piece	125	28	10



Tool group A37
Type 746-50 **Standard jaws SGN**
one side smooth, one side
grooved, hardened and ground

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

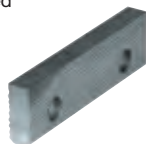


Accessories RKE-M LV

Tool group A37
Type 746-50

Standard jaws fine checkered SGNf

reversible, used to increase the specific surface pressure (higher retention force), one side fine checkered, one side longitudinally checkered



Item no.	Contents of delivery	Size	Width	Height
163218 ●	piece	92	92	31,6
163225 ●	set	125	125	39,7

Tool group A37

Type 721 V-jaw SPR

with vertical and horizontal ground V's, hardened, for use in combination with SGN; only suitable for twin-clamping

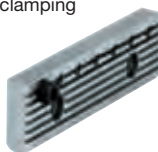


Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
128770 ●	piece	92	92	31,6	3-13	5-32
082363 ●	piece	125	135	39,6	4-20	6-40

Tool group A37

Type 721-52 Normal jaw SGNA

with movable workpiece locator, hardened and ground; only suitable for twin-clamping



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

Tool group A37

Type 721 Draw-down jaws SNF

with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width	Height
077104 ■	set	92	113	31,6
077105 ●	set	125	135	39,6

Tool group A37

Type 728-00

V-jaw and standard jawSBO

soft and gunmetal-finished, with work support; for BOF and BSS



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

Tool group C15

Type 7004-Y Hand crank HKU

with octagon socket



Item no.	Contents of delivery	Size	Octagon	L
009151 ▲	piece	92	12	100
009152 ●	piece	125	14	125

Tool group A37

Type 743-00 Drive adapter ATA



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

RKE-H L



Especially used on CNC-machines.
Base mounting with mechanical power intensification.

Clamping system hydraulic with stroke, hydraulic connection for single-acting cylinders.

Technical features:

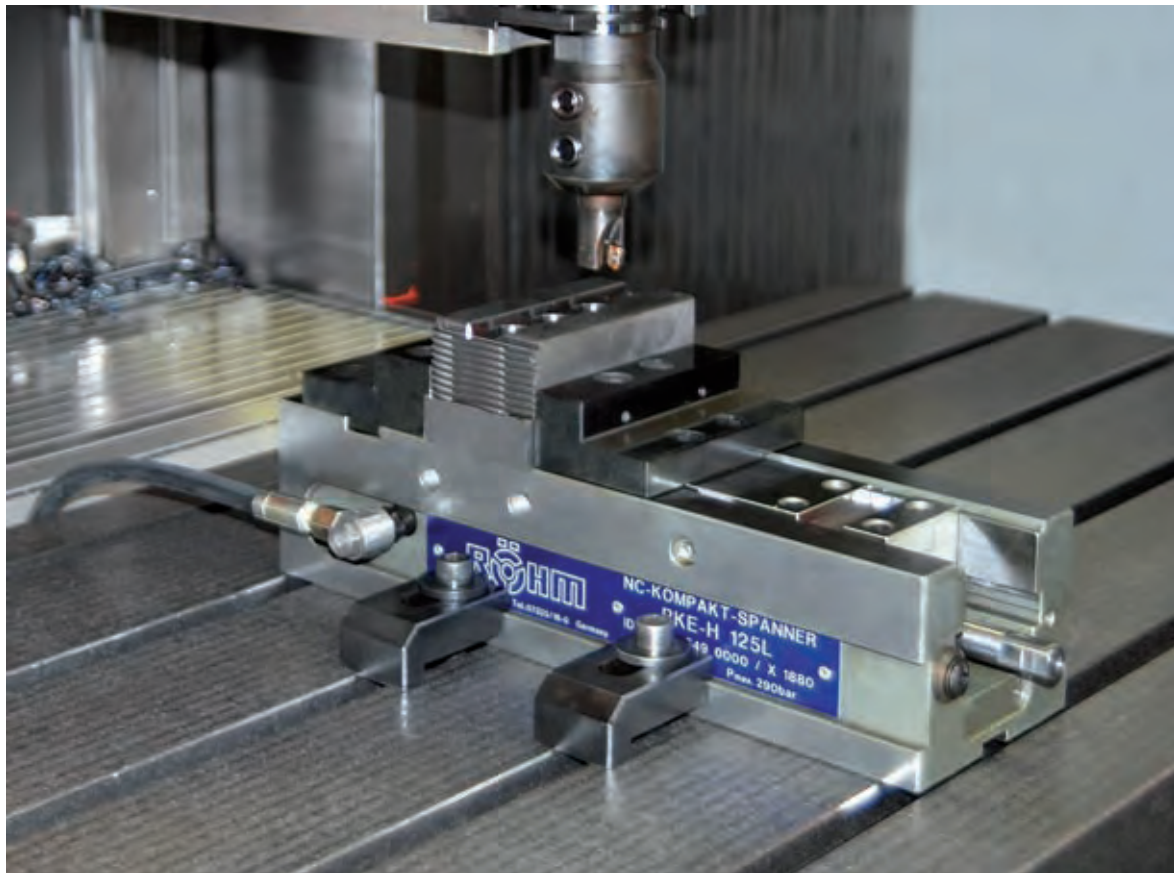
- solid steel-body
- all guide surfaces are hardened and ground
- long clamping slide with clutch, hardened on all sides, function surfaces ground
- clamping surface for clamping claws

Customer advantage:

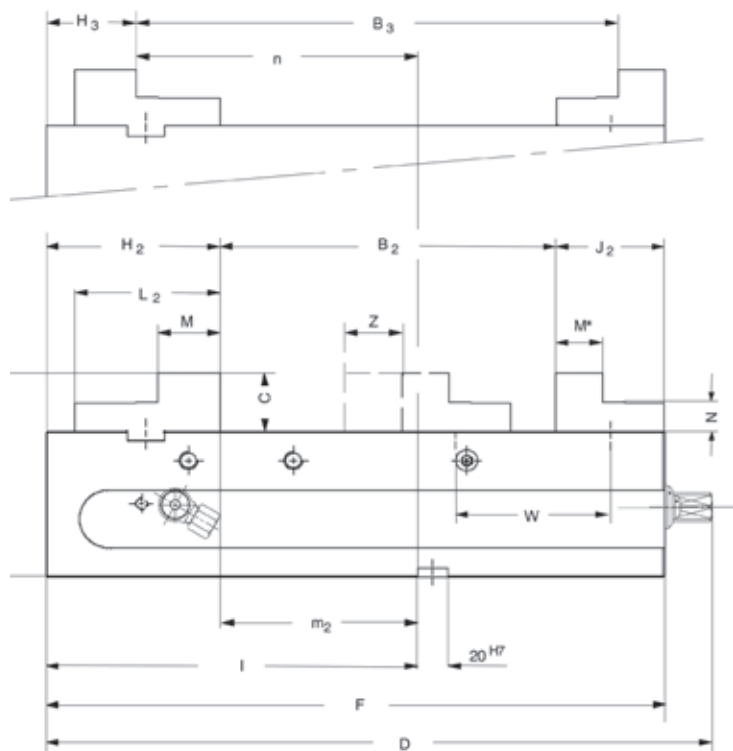
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured
- solid chip guard prevents chips from penetrating the inside of the body

Tool group A32
Type 743-20 **RKE-H L**
with stepped jaws or standard
clamping jaws

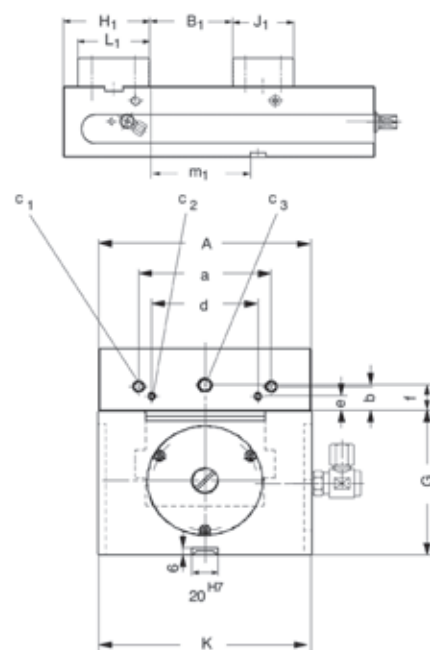
Item no.	165649 ▲	165646 ▲
Jaw width A	125	125
Jaw design	stepped jaws	standard clamping jaws
B1	-	0-215
B2	0 - 216	-
B3	97 - 312	-
C	40	40
D	428	428
E	140	140
F	400	400
G _{±0,02}	100	100
H ₁	-	110,5
H2	112,5	-
H3	56,5	-
J1	-	78
J2	70	-
K	126	126
L1	-	92
L2	94	-
M	40	-
M*	30	-
N _{±0,01}	20	-
Shifting range W	1x108	1x108
Clamping travel Z	109	109
a	80	80
b	15,6	15,6
c1	M 8x14	M 8x14
c2	M 5x10	M 5x10
c3	M10x18	M 10x18
d	60	60
e	12	12
f	18	18
l	240	240
m1 _{±0,02}	-	129,5
m2 _{±0,02}	127,5	
n _{±0,02}	183,5	
Clamping force kN	40	40
Weight kg	41	41



stepped jaws



standard jaws



Accessories RKE-H L

Tool group A37
Type 743-50
Standard top jaws SA
reversible



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

Tool group A37
Type 743-51 **Stepped jaws SB**
reversible



Item no.	Contents of delivery	Size	Width	Height
160343 ●	set	125	125	40

Tool group A37
Type 743-51 **Carrier jaws TB**
without swivelling claw inserts



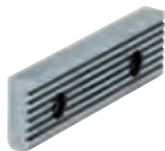
Item no.	Contents of delivery	Size	Width	Height
165856 ■	set	125	125	20

Tool group A37
Type 743-74 **Swivelling pronged inserts** for carrier jaws 743-72



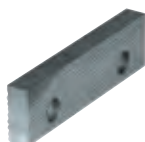
Item no.	Contents of delivery	Size	Ø	Height
165854 ●	piece	125	28	10

Tool group A37
Type 721 **Normal jaw SGN**
one side smooth, one side
grooved, both sides ground



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

Tool group A37
Type 746-50
Standard jaws fine checkered SGNf
reversible, used to increase the
specific surface pressure (higher
retention force), one side fine
checkered, one side longitudinally
checkered



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

Accessories RKE-H L

Tool group A37

Type 721 **V-jaw SPR**

with vertical and horizontal ground V's, hardened, for use in combination with SGN; only suitable for twin-clamping

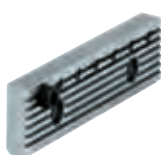


Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
082363 ●	piece	125	135	39,6	4-20	6-40

Tool group A37

Type 721-52 **Normal jaw SGNA**

with movable workpiece locator, hardened and ground; only suitable for twin-clamping



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

Tool group A37

Type 721 **Draw-down jaws SNF**

with spring plate, hardened and ground



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

Tool group A37

Type 728-00

V-jaw and standard jaw SBO

soft and gunmetal-finished, with work support; for BOF and BSS



Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
317260 ●	set	125	135	39,8	3-13	6-40

Tool group C15

Type 7004-Y **Hand crank HKU**

with octagon socket



Item no.	Contents of delivery	Size	Octagon	L
009152 ●	piece	125	14	125



For flexible clamping on machining centres and other production systems.
Three clamping positions: horizontal, vertical and lateral

Clamping system mechanical-mechanical with power transmitter, manually operated

Only approx. 1 1/2 crank rotations at max. clamping force.

Technical features:

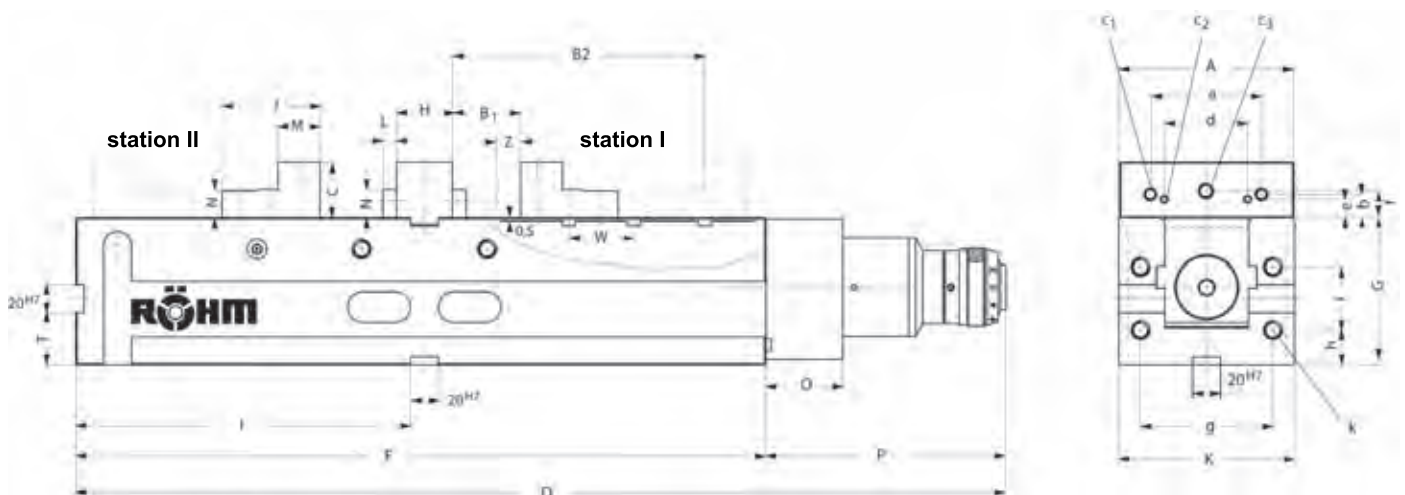
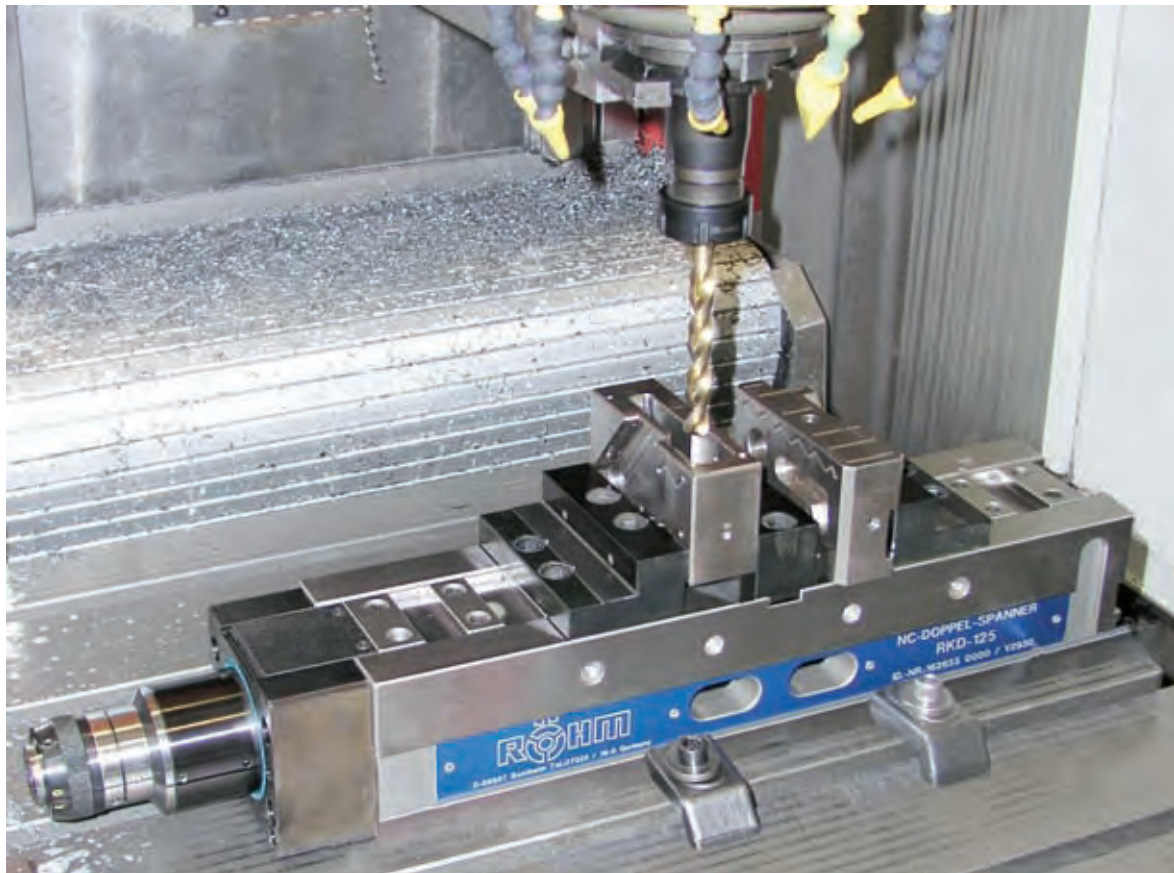
- pre-adjustment of clamping force by means of locking system
- double-clamping via two mobile claws (left-right hand thread) and one immobile centre jaw
- the solid steel body and all guide surfaces are hardened and ground on all sides
- fastening of the vice with clamping claws only
- thread for fastening angle drive

Customer advantage:

- constant clamping force for increased repeating accuracy 0,01
- no overloading of the vice at max. clamping force
- self-locking power transmission
- the clamping thread of the spindle is protected in all positions to prevent the penetration of dirt and chips
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured

Tool group A32
Type 749-10 RKD
With reversible stepped jaws
and centre jaw

Item no.	161830	162655
Jaw width A	92	125
B1 slot 1	0 - 48	0 - 48
B1 slot 2	48 - 96	46 - 94
B1 slot 3	-	92 - 140
B2 slot 1	42 - 79	51 - 88
B2 slot 2	79 - 127	86 - 134
B2 slot 3	-	132 - 180
C	32	40
D	500	667
F	356	495
G _{-0,02}	85	105
H _{0,02}	30	40
J	56	70
K	94	126
L	10	10
M	25	30
N _{-0,01}	16	20
O	55	55
P	144	172
T _{-0,02}	30	37,5
W	1 x 48	2 x 46
Z	50	50
a	63	80
b	13,6	15,6
c1	M6x14	M8 x 14
c2	M5 x 9	M5 x 10
c3	M10 x 16	M10 x 18
d	48	60
e	8	12
f	14	18
g	70	95
h	20	25
i	50	45
k	M10 x 18	M12 x 22
I _{-0,02}	170	240
Clamping force kN	25	40
Weight kg	24	53



RKD-M



For flexible clamping on machining centres and other production systems.
Three clamping functions: Twin clamping - centric clamping - single clamping

Clamping system mechanical without power transmitter, manually operated.

With drive spindle on one side.

Horizontal, vertical or side mounting.

Technical features:

- machine vice with two mobile jaws and one immobile centre jaw
- the solid steel body and all guide surfaces are hardened and ground on all sides
- fastening of the vice with clamping claws only (direct mounting on request)
- constant clamping force during every clamping operation and high repeating accuracy if torque wrenches are used
- large clamp stroke, 50 mm per jaw

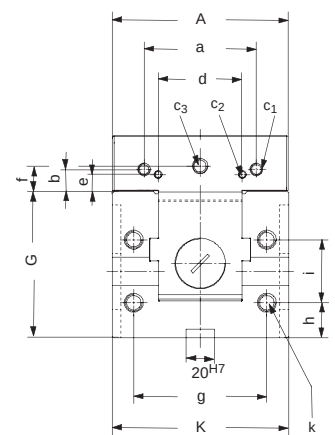
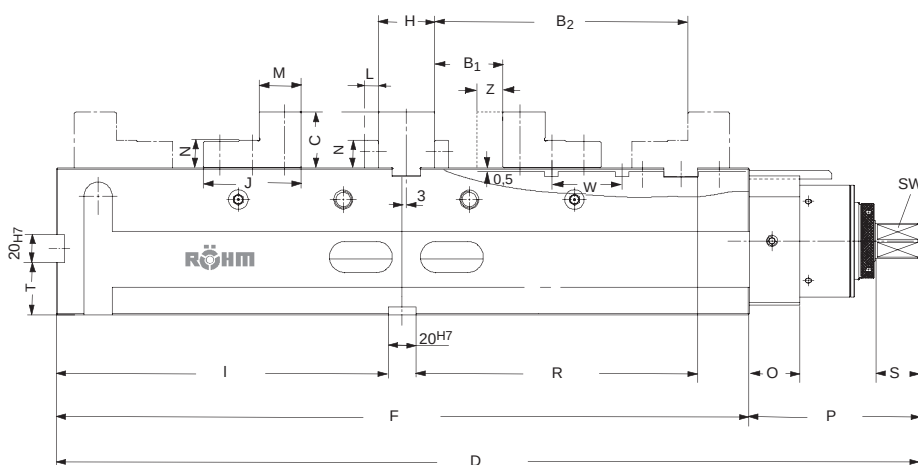
Customer advantage:

- the clamping thread of the spindle is protected in all positions to prevent the penetration of dirt and chips
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured
- the compact vice is on delivery equipped for twin and centric clamping
- operation by means of provided hand crank

Tool group A32
Type 749-00 **RKD-M**
With reversible stepped jaws
and centre jaw

Item no.	162653 ●	162654 ●
Jaw width A	92	125
B1 slot 1	0-48	0-48
B1 slot 2	48-96	46-94
B1 slot 3	-	92-140
B2 slot 1	42-79	51-88
B2 slot 2	79-127	86-134
B2 slot 3	-	132-180
C	32	40
D	480	617
F	366	495
G _{-0,02}	85	105
H _{-0,02}	30	40
J	56	70
K	94	126
L	10	10
M	25	30
N _{-0,01}	16	20
O	36	36
P	114	122
R	143	201
S	31	32
T _{-0,02}	30	37,5
W	1 x 48	2 x 46
Z	50/53	50/53
Key-width SW	17	19
a	63	80
b	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	48	60
e	8	12
f	14	18
g	70	95
h	20	25
i	50	45
k	M10 x 18	M12 x 22
l _{-0,02}	177	237
Clamping force kN	25	40
Weight kg	24	52

RKD-M



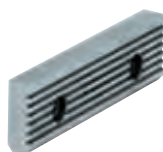
Accessories RKD

Tool group A37
Type 726-60
Stepped jaws SB
reversible, with fixing screws



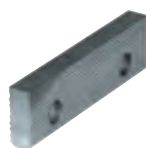
Item no.	Contents of delivery	Size	Width	Height
161831	set	92	92	32
162631	set	125	125	40

Tool group A37
Type 726-50 **Standard jaws SGN**
one side smooth, one side
grooved, hardened and ground



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

Tool group A37
Type 726-50 **Standard jaws fine checked SGNf**
one side fine checked, one side
grooved, hardened and ground



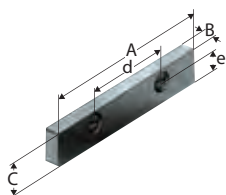
Item no.	Contents of delivery	Size	Width	Height
163223	set	92	92	32
163225	set	125	125	39,7

Tool group A37
Type 749-51 **Center jaws MBA**



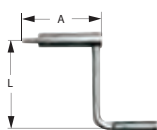
Item no.	Contents of delivery	Size	Width	Height	Thickness
161833	piece	92	92	32	30
162632	piece	125	125	40	40

Tool group A37
Type 749-51 **Work support WAM**
for center jaws



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

Tool group A37
Type 744 **Hand crank**
turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A	L
134600	piece	92/125	14	104	160

Tool group A37
Type 726-19 **Angle drive**



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

Accessories RKD-M

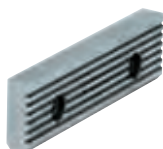
Tool group A37
Type 726-60
Stepped jaws SB
reversible, with fixing screws

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



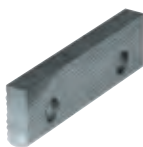
Tool group A37
Type 726-50 **Standard jaws SGN**
one side smooth, one side
grooved, hardened and ground

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



Tool group A37
Type 726-50 **Standard jaws fine checkered SGNf**
one side fine checkered, one side
grooved, hardened and ground

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



Tool group A37
Type 726-52 **V-jaw PB**
horizontal and vertical

Item no.	Contents of delivery	Size	Width	Height	Thickness	Height prism	Clamping range	
							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



Tool group A37
Type 749-00 **Drive adapter ATA**

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



Tool group A37
Type 749-51
Fixed stepped jaw FSB
for single clamping, reversible

Item no.	Contents of delivery	Size	Width	Height
162633	set	92	92	32
160344	set	125	125	40



Accessories RKD-M

Tool group A37
Type 749-51 **Center jaws MBA**



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

Tool group C15
Type 7004-Y **Hand crank HKU**
with octagon socket

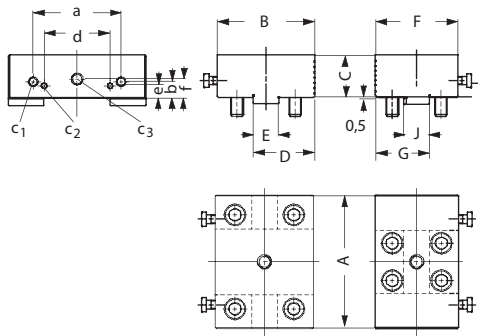


Item no.	Contents of delivery	Size	Octagon	L
009153	piece	92	17	160
009154	piece	125	19	200

Clamping jaw dimensions for NC-Compact vices

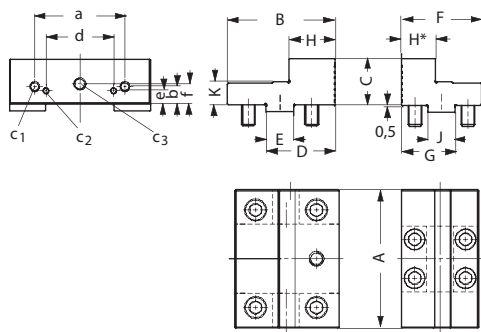
Clamping jaw dimensions for NC-Compact vices RKE, RKE-L, RKG-L, RKE-LV, RKE-M, RKE-H, RKG-M

Type 743 - 50 SA
Standard top jaws - Set



Jaw width	125	160	200
Item no.	162628	162629	162984
B	92	100	105
C	40	50	60
D	58	65	65
E _{h7}	24	30	30
F	78	100	100
G	51	65	65
J _{g6}	24	30	30
a	80	100	125
b	15,6	19,6	24,6
c ₁	M8	M8	M10
c ₂	M5	M5	M5
c ₃	M10	M10	M14
d	60	80	110
e	12	12	12
f	18	20	25

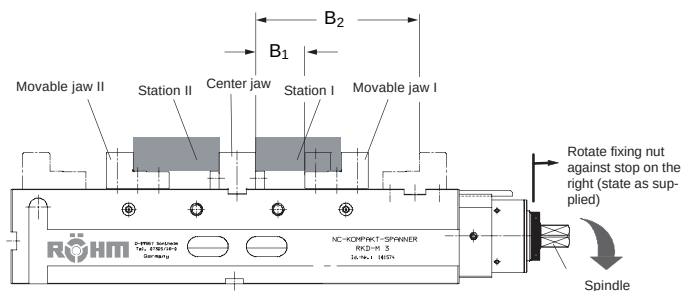
Type 743 - 51 SB
Stepped jaws - Set



Jaw width	92	125	160	200
Item no.	162851	160343	162630	162985
B	64	94	98	103
C	32	40	50	60
D	42	60	65	70
E _{h7}	20	24	30	30
F	56	70	97	97
G	38	47	63,5	63,5
H/H*	25/25	40/30	34/32,5	39/32,5
J _{g6}	20	24	30	30
K	16	20	25	25
a	63	80	100	125
b	13,6	15,6	19,6	24,6
c ₁	M6	M8	M8	M10
c ₂	M5	M5	M5	M5
c ₃	M10	M10	M10	M14
d	48	60	80	110
e	8	12	12	12
f	14	18	20	25

Clamping ranges RKD-M

Clamping ranges: Twin clamping



Function:

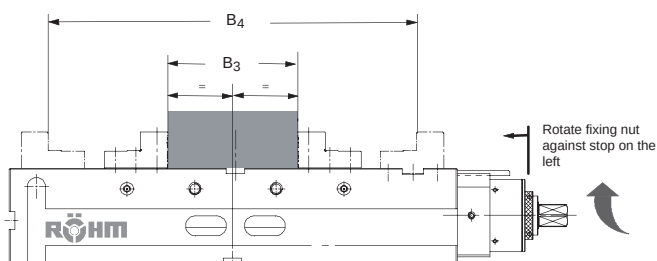
To adjust mobile jaw I with regard to the workpiece of station I turn the spindle to the right by means of the handle (left-right handed thread). About 1 kN are applied to keep the jaw in the adjusted position (third-hand function). By further turning the lever, mobile jaw II is adjusted with regard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

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

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

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

Clamping ranges: Centric clamping

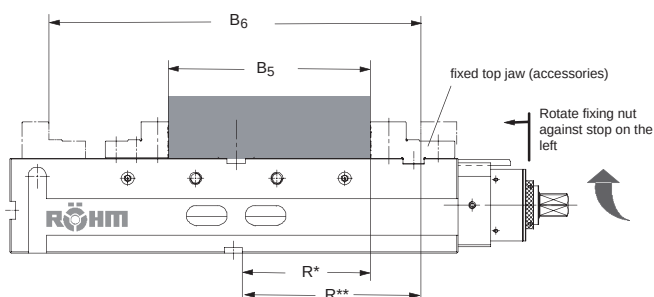


Remove central jaw

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

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

Clamping ranges: Single clamping



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

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



Horizontal, vertical or side mounting.

Clamping system mechanical-mechanical with power transmitter, manually operated
Self-centering with two mobile jaws

Technical features:

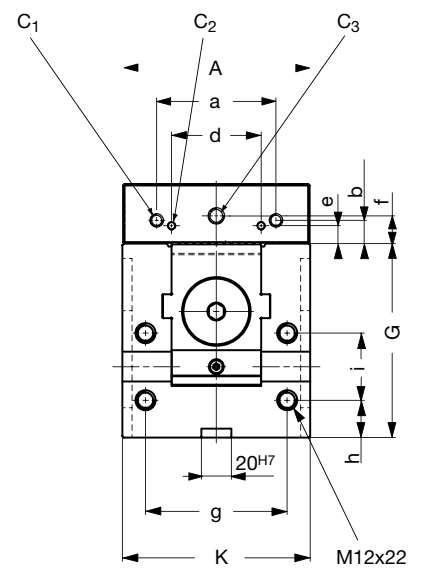
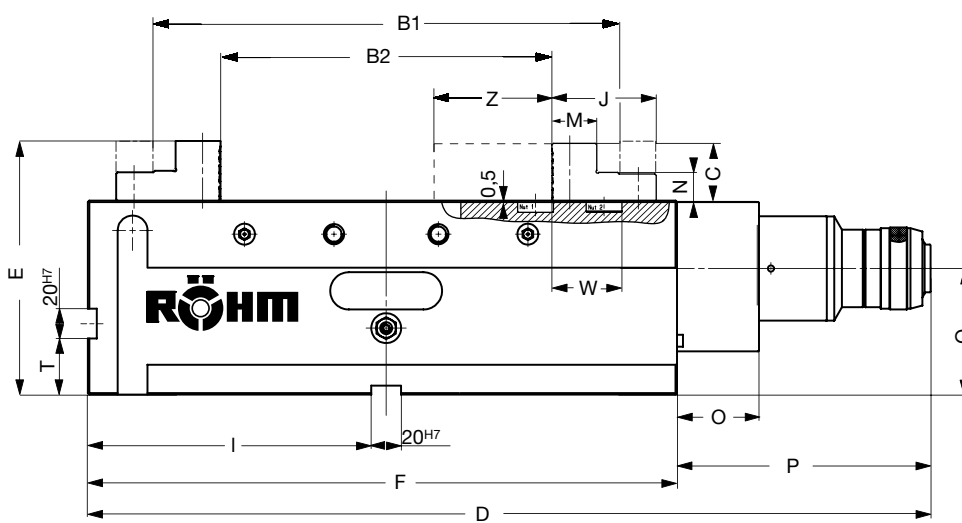
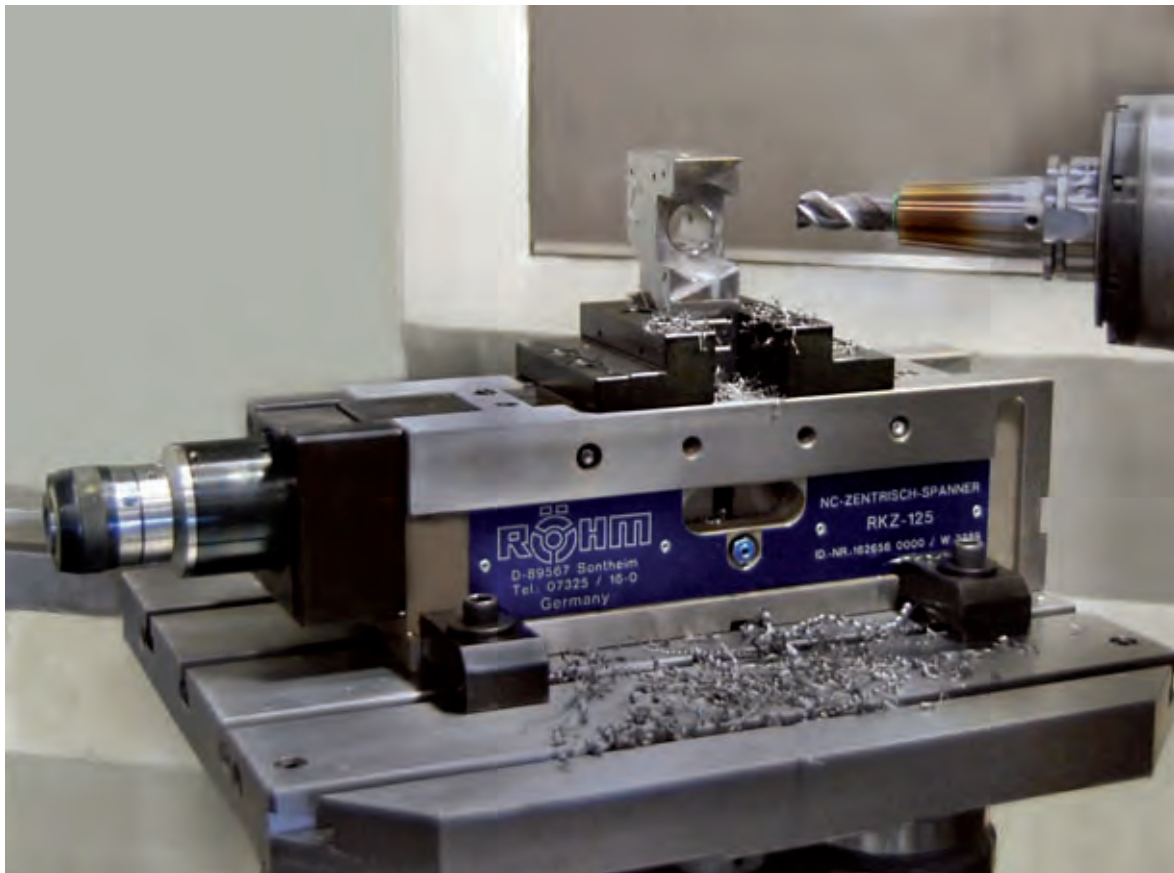
- constant force for each clamping process
- increased repeating accuracy
- the steel body and all guide surfaces are hardened and ground
- fastening of the vice with clamping claws only
- clamping accuracy at the centre: $\pm 0,01$ - Repeating accuracy: 0,01

Customer advantage:

- the clamping thread of the spindle is protected in all positions to prevent the penetration of dirt and chips
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured
- equipped as standard with stepped interchangeable jaws

Tool group A32
Type 726-10 **RKZ**
With stepped jaws

Item no.	162656 ●
Jaw width A	125
B1 slot 1	112-206
B1 slot 2	204-298
B2 slot 1	32-126
B2 slot 2	124-218
C	40
D	565
E	170
F	395
G _{0,02}	130
J	70
K	126
M	30
N _{-0,01}	20
O	55
P	170
Q	84,5
T _{0,02}	37,5
W	46
Z stroke	50
a	80
b	15,6
c1	M8x14
c2	M5x10
c3	M10x18
d	60
e	12
f	18
g	95
h	25
i	45
l _{-0,02}	190
Clamping force kN	40
Weight kg	50,5



Accessories RKZ

Tool group A37
Type 726-60 **Stepped jaws SB**
reversible, with fixing screws

Item no.	Contents of delivery	Size	Width	Height
162631	set	125	125	40



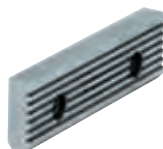
Tool group A37
Type 726-60 **Raised stepped jaws ESB**

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



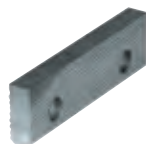
Tool group A37
Type 746-50 **Standard jaws SGN**
one side smooth, one side
grooved, hardened and ground

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



Tool group A37
Type 746-50 **Standard jaws fine
checkered SGNf**
reversible, used to increase the
specific surface pressure (higher
retention force), one side fine
checkered, one side longitudinally
checkered

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



Accessories RKZ

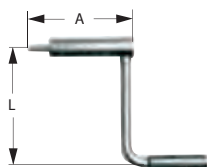
Tool group A37
Type 726-52 **V-jaw PB**
horizontal and vertical

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



Tool group A37
Type 744 **Hand crank**
turnable handle, hexagon socket

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



Tool group A37
Type 726-19 **Angle drive**

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



RKZ-M



Highly suitable for 5-side machining

Clamping system mechanical without power transmitter, manually operated.

Self-centering with two mobile jaws

Technical features:

- Short, compact design
- large stroke
- the steel body and all guide surfaces are hardened and ground
- constant clamping force during every clamping operation and high repeating accuracy if torque wrenches are used
- clamping accuracy at the centre: $\pm 0,02$ - repeating accuracy: 0,01

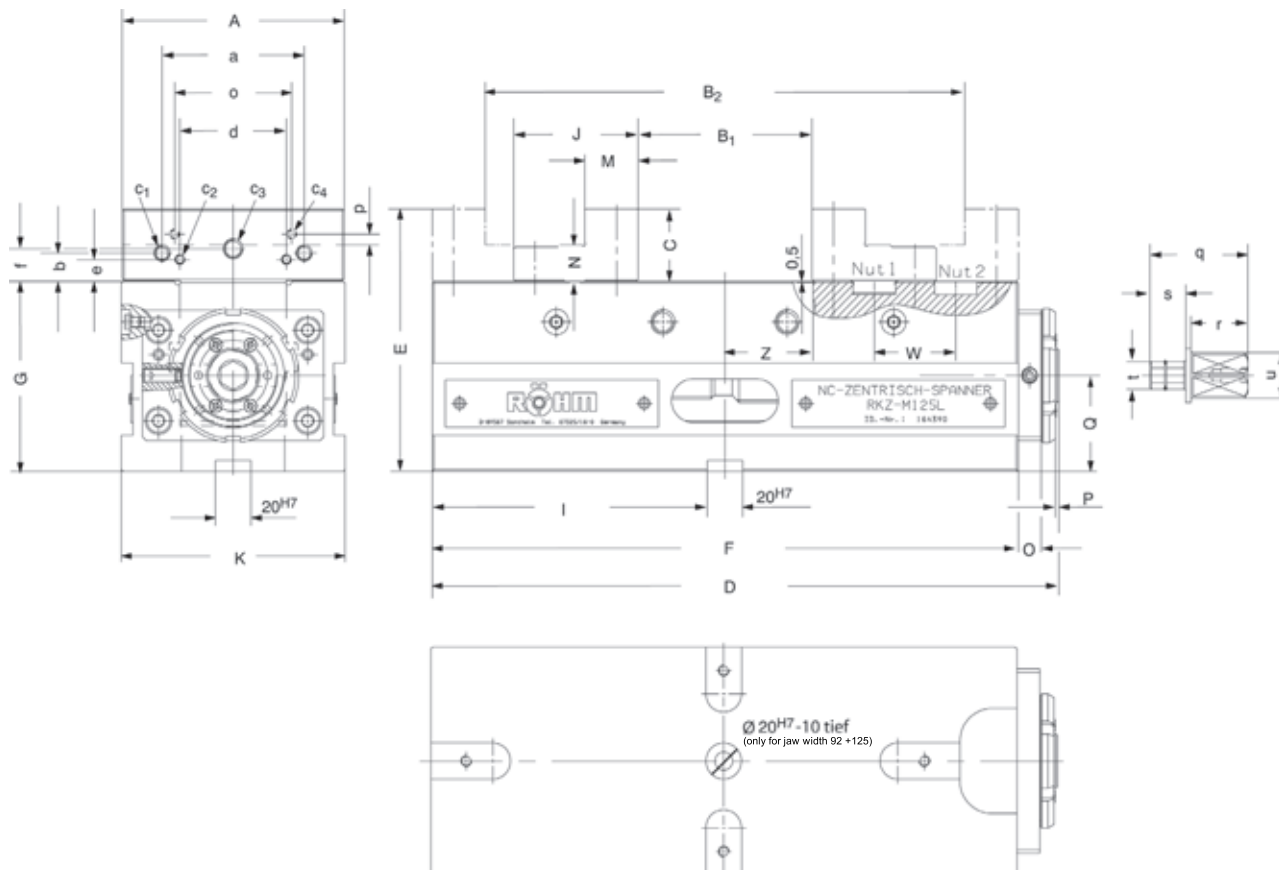
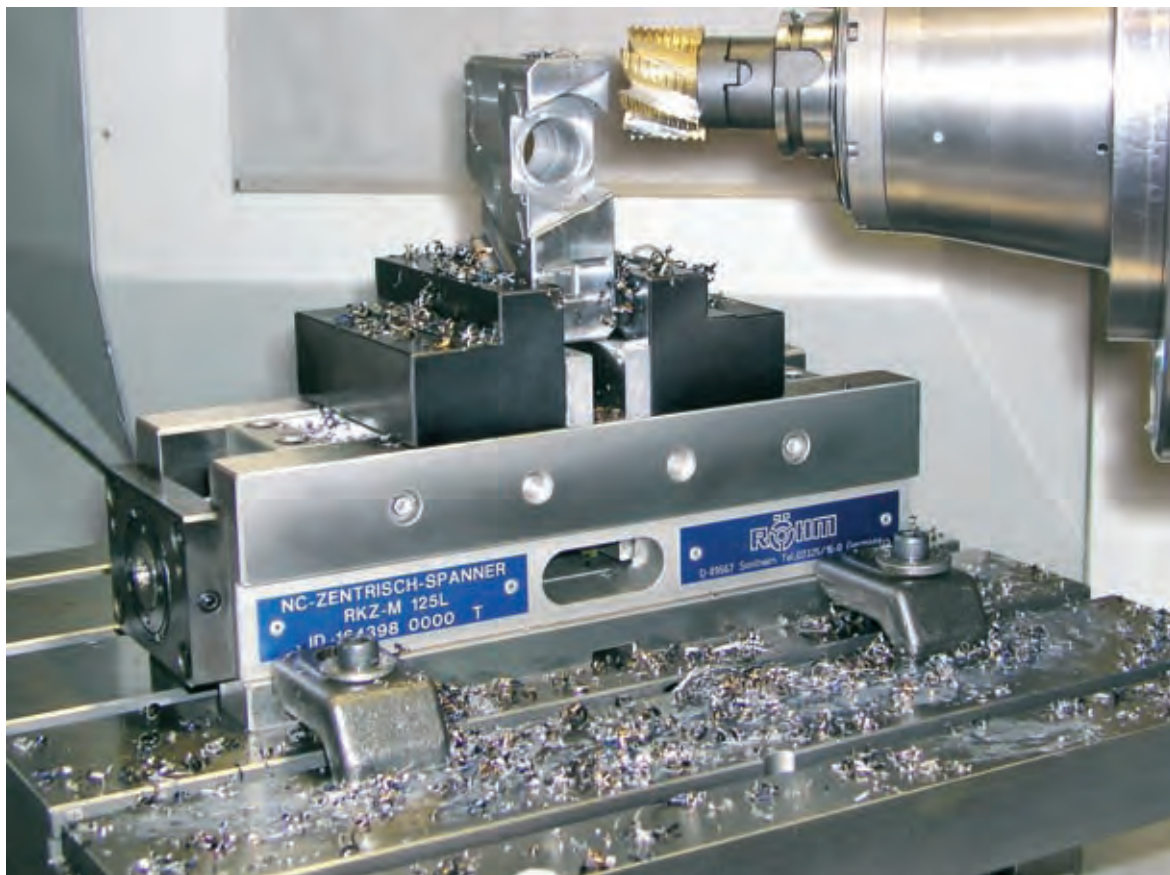
Customer advantage:

- equipped as standard with stepped interchangeable jaws
- special clamping jaws available on request

Tool group A32
Type 726-00 **RKZ-M**
With stepped jaws

Item no.	164813 ●	164814 ●	164815 ●	164390 ●	164398 ¹⁾ ●
Jaw width A	50	70	92	125	125
B1 slot 1	0-39	0 - 58	0 - 76	0 - 97	0 - 97
B1 slot 2	36-75	48-106	70-146	92-189	92-189
B2 slot 1	37-75	48-105	78-138	81-177	81-177
B2 slot 2	72-111	95-153	132-208	172-269	172-269
C	20	25	32	40	60
D _{max}	157	209	283	353	353
E	75	95	117	145	165
F	140	190	260	330	330
G _{-0,02}	55	70	85	105	105
J	32	41	56	70	70
K	52	72	94	126	126
M	14	175	25	30	30
N _{-0,01}	10	12	16	20	40
O	10	10	13	13	13
P	1	1	2	2	2
Q	31	40	41,5	53	53
W	18	24	35	46	46
Z	20,5	30	39	49,5	49,5
a	-	-	63	80	80
b	-	-	13,6	15,6	15,6
c1	-	-	M6x10	M8x14	M8x14
c2	M 4 x 8	M 5 x 8	M5x8	M5x8	M5x8
c3	-	-	M10x16	M10x18	M10x18
c4	M3x6	M4x8	M5x8	M5x8	M5x8
d	26	37	48	60	60
e	5	6	8	12	12
f	-	-	14	18	18
l	60	85	120	155	155
o	32	52	55	55	55
p	3,5	4,5	6	6	6
q	38	52	55	55	55
r	20	30	32	32	32
s	15	19	20	20	20
t	6 kt-SW 8	6 kt-SW 10	6 kt-SW 14	6 kt-SW 14	6 kt-SW 14
u	4 kt-SW 12	4 kt-SW 14	4 kt-SW 19	4 kt-SW 19	4 kt-SW 19
Clamping force kN	10	15	20	25	25
Weight kg	3,5	7	18	32,5	35

¹⁾ with enlarged stepped-jaws



Accessories RKZ-M

Tool group A37
Type 726-60 **Stepped jaws SB**
reversible, with fixing screws



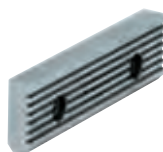
Item no.	Contents of delivery	Size	Width	Height
164864	set	50	50	20
164844	set	70	70	25
161831	set	92	92	32
162631	set	125	125	40

Tool group A37
Type 726-60 **Raised stepped jaws ESB**



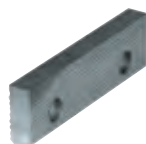
Item no.	Contents of delivery	Size	Width	Height
164399	set	125	125	60

Tool group A37
Type 726-50 **Standard jaws SGN**
one side smooth, one side
grooved, hardened and ground



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

Tool group A37
Type 726-50 **Standard jaws fine checkered SGNf**
one side fine checkered, one side
grooved, hardened and ground



Item no.	Contents of delivery	Size	Width	Height
165165	set	50	50	19,6
165171	set	70	70	24,6
163223	set	92	92	32
163225	set	125	125	39,7

Tool group A37
Type 726-52 **V-jaw PB**
horizontal and vertical



Item no.	Contents of delivery	Size	Width	Height	Thickness	Height prism	Clamping range	
							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

Tool group C15
Type 7004-Y **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

Tool group A37
Type 726-00 **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

General accessories

Tool group A37
Type 743-00

Dual clamp DSP

complete, for connecting two compact vices base-to-base for mutual support



Item no.	Contents of delivery
149125 ●	piece

Tool group A37
Type 743-00

Single clamp SPE

complete, for mounting vices on the end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121 ●	piece	12	M10x55
149122 ●	piece	14	M12x55
149123 ●	piece	16	M12x60
149124 ●	piece	18	M16x60
155722 ●	piece	20	M16x65
151507 ●	piece	22	M16x65

Tool group A37
Type 740-02

Work locator WSA

universally adjustable, to screw on the vice, M12 connecting screw



Item no.	Contents of delivery
320400 ●	piece

Tool group A37
Type 740-02

Work locator WSA

universally adjustable, can be mounted on the machine table (14 mm T-slot) or bolted onto the vice (M12)

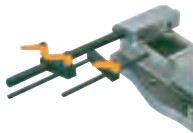


Item no.	Contents of delivery
320401 ●	piece

Tool group A37
Type 740-02

Precision vice locator PSA

universally adjustable, to screw on the vice, M12 connecting screw



Item no.	Contents of delivery
681192 ●	piece

Tool group A37
Type 739

Fixed slot nuts NTS

hardened and ground, with fixing screw



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

NCZ



They are mainly used for highly accurate work on CNC milling machines and machining centers.
Due to their compact and stable design especially large workpieces can be clamped.

Mounting on machine table or pallet, with clamps or directly by means of mounting bores (index measuring 50 mm).

Clamping system mechanical, various operating possibilities.

Technical features:

- with hand crank (without top jaws)
- high clamping force is supplied by ground spindle with left- and right-hand threading and roller born
- clamping accuracy repeatable to within 0,005 mm
- very high clamping and centering accuracy

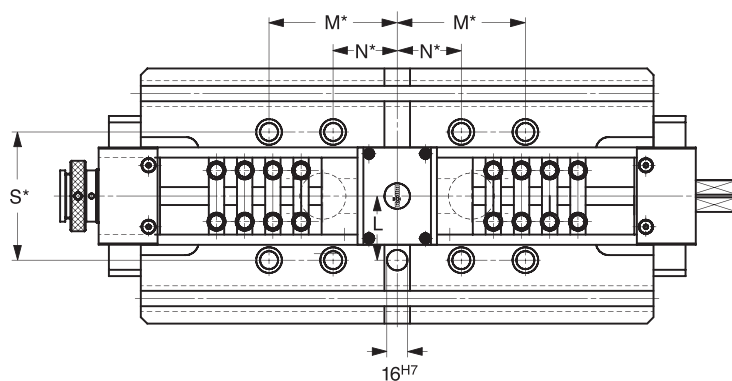
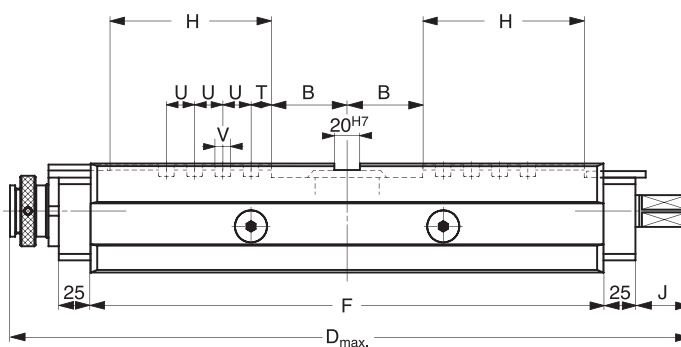
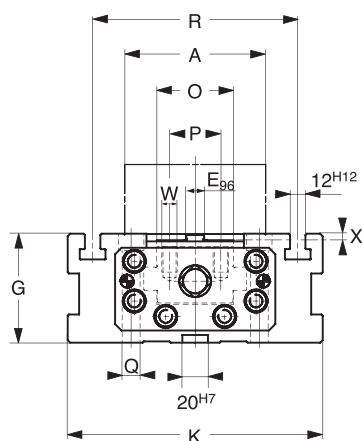
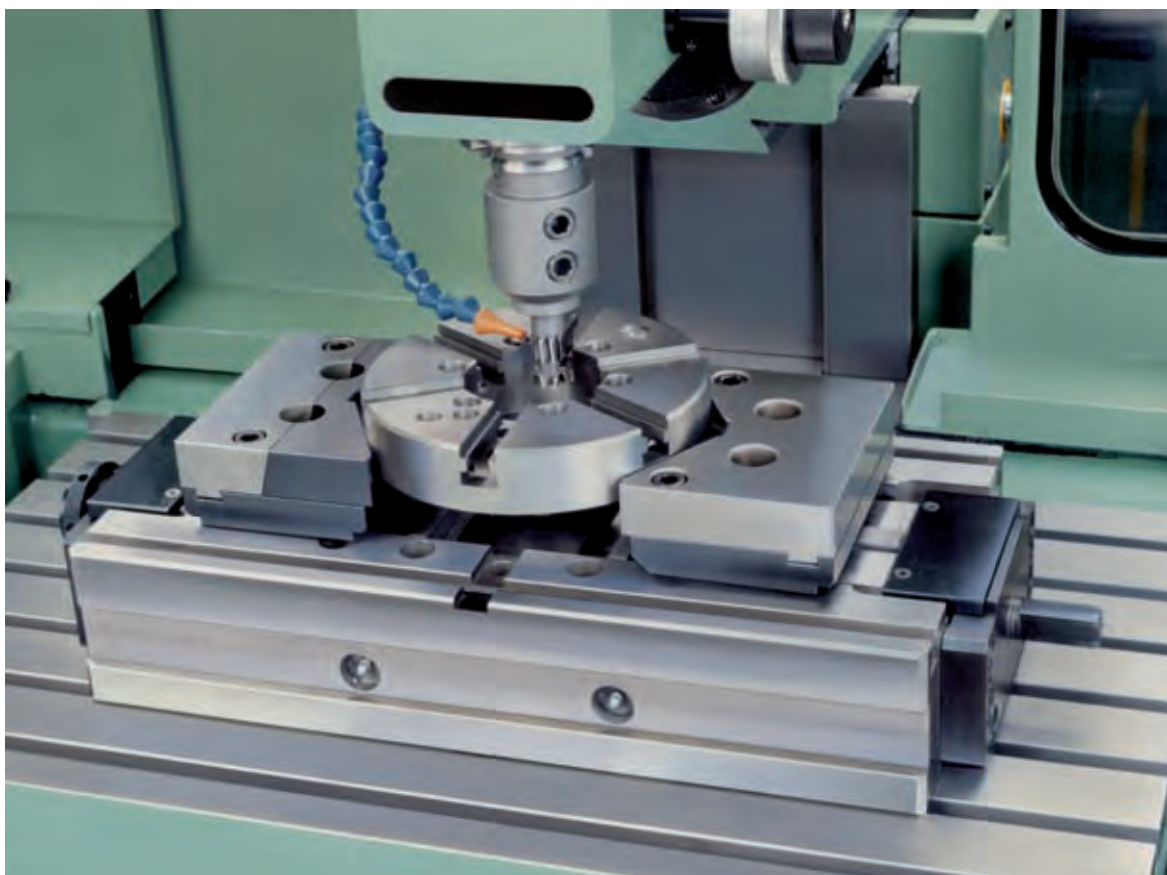
Customer advantage:

- clamps centrally with two movable basic jaws
- either one or two work-pieces can be clamped (one work piece with axially led rigid spindle, two work pieces with compensating spindle)
- suitable for internal and external clamping
- unusually large clamping range in relation to the overall length
- self-locking power transmission
- Easy to service: Four lubricating nipples are sufficient to lubricate all surfaces subject to wear

Tool group A32
Type 726-00 **NCZ**
With standard jaws

Item no.	145661	145660
Size	2	4
Jaw width A	110	160
Bmax	59	77
Bmin	34	43
D	532	638
E	14	20
F	400	500
G _{0,03}	85	100
H	126	158
J	44	48
K	199	249
L±0,05	50	75
M1)	100	100
N1)	50	50
O	60	100
P	40	60
Q	Ø 14	Ø 14
R	160	205
S	100	150
T	16	20
U	22	30
V	12	16
W	M12	M16
X±0,01	5	6
Clamping force kN	25	50
Jaw travel	25	34
Weight kg	50	85

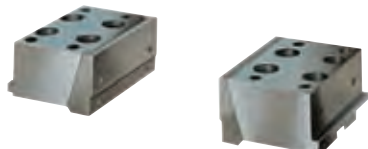
1) different dimensions on request



Accessories NCZ

Tool group A37
Type 726-50
Standard jaws SB complete,
with mounting screws
reversible,
with SNS keep-down inserts
and a bolt-on surface for clamping
jaws or special jaws; the upper
side can also be used for bolting
on special jaws

Item no.	Contents of delivery	Size	Width
150556	set	2	110
150557	set	4	160



Tool group A37
Type 726-73
V-jaw PB, vertical
one side rigid, one side floating
transversal to the clamping
direction, with fixing screws

Item no.	Contents of delivery	Size	Width	Height	Length	Size prism
146225	set	2	110	20	101	99
146065	set	4	160	30	119	145



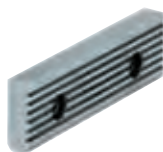
Tool group A37
Type 726-52 **V-jaw PB**, horizontal
for fastening at the standard jaws,
with fixing screws

Item no.	Contents of delivery	Size	Width	Height	Length	Size prism
146221	set	2	110	105	108	80
146057	set	4	160	150	135	109



Tool group A37
Type 721 **Normal jaw SGN**
one side smooth, one side
grooved, both sides ground

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



Tool group A37
Type 721
Normal jaw fine checkered SGNf
reversible, used to increase the
specific surface pressure (higher
retention force), one side fine
checkered, one side longitudinally
checkered

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



Accessories NCZ

Tool group A37
Type 721 **V-jaw SPR**
with vertical and horizontal ground
V's, hardened, for use in
combination with SGN; only
suitable for twin-clamping



Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
082362 ●	piece	2	113	31,6	3-13	5-32
082364 ●	piece	4	160	49,6	5-29	7-48

Tool group A37
Type 721 **Draw-down jaws SNF**
with spring plate, hardened and
ground



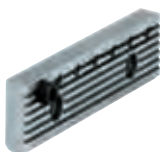
Item no.	Contents of delivery	Size	Width	Height
077104 ■	set	2	113	31,6
077106 ●	set	4	160	49,6

Tool group A37
Type 728-00
V-jaw and standard jawSBO
soft and gunmetal-finished, with
work support; for BOF and BSS



Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
317259 ●	set	2	110	31,8	3-12	5-32
317261 ●	set	4	160	49,8	5-22	7-48

Tool group A37
Type 721-52 **Normal jaw SGNA**
with movable workpiece locator,
hardened and ground; only suitable
for twin-clamping



Item no.	Contents of delivery	Size	Width	Height
150739 ■	piece	2	113	31,6
150741 ■	piece	4	160	49,6

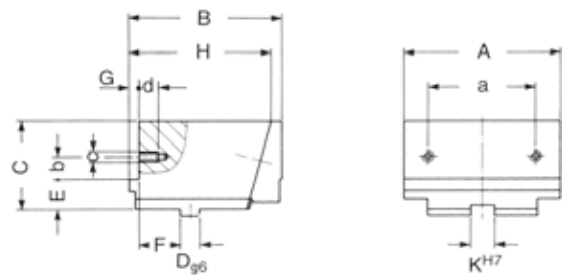
Tool group C15
Type 7004-Y **Hand crank HKU**
with octagon socket



Item no.	Contents of delivery	Size	Octagon	L
382112 ●	piece	2	19	160
009154 ●	piece	4	19	200

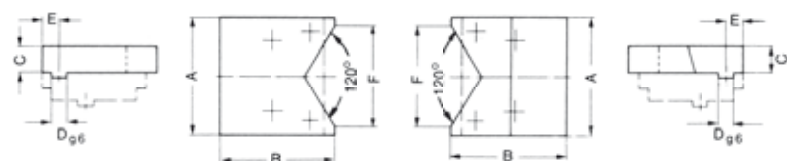
Jaw dimensions NCZ

Type 726-50 **Standard jaw**



Size	2	4
A	110	160
B	98	128
C	54	73
D	12	16
E	22,4	23,4
F	30	37
G	8	9
H	91	118
K	14	20
a	63	100
b	13,6	19,6
c	M6	M8
d	12	13

Type 726-73 **V-jaws (vertical)**



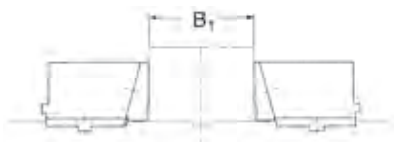
Size	2	4
A	110	160
B	101	119
C	20	30
D	16	16
E	17	17,5
F	99	145

Clamping ranges NCZ

Standard jaws (reversible)

Standard jaws (reversible)

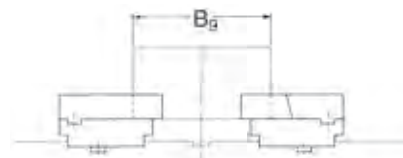
B ₁	38-172	42-222
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V-jaws (vertical) on support plates

V-jaws (vertical) on support plates

B ₉	55-190	07-284
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V-jaws (horizontal) on standard jaws

V-jaws (horizontal) on standard jaws

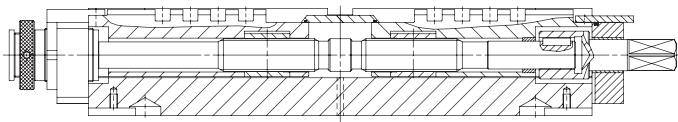
B ₁₀	55-150	80-200
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Clamping range is only possible if the workpieces are leaded sideways



Clamping system / Drive types NCZ

Mechanical NCZ clamping system: Mechanical drive with hand crank



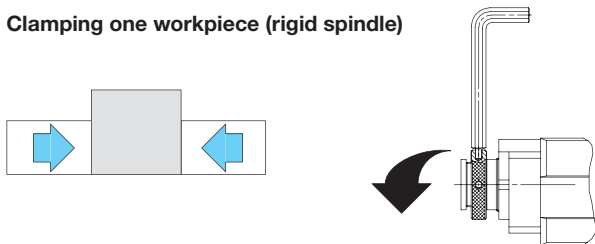
Advantages:

- High and reliable clamping force
- Clamps centrally with two movable basic jaws
- Clamping of one workpiece with axially led rigid spindle or clamping of two workpieces with compensating spindle and center locator
- Self-locking power transmission

Clamping:

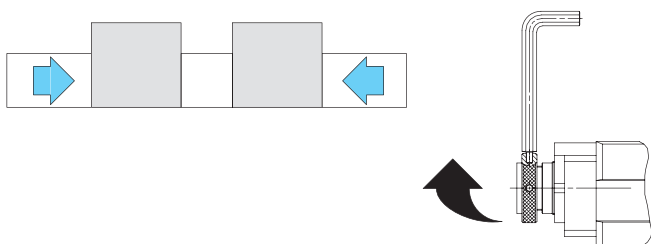
By rotating the spindle (with right-hand and left-hand thread) with the hand crank (or drive variants 2 – 5), the movable basic jaws with the appropriate top jaws centrally approach the workpiece and the clamping force is safely built up.

Clamping one workpiece (rigid spindle)



To clamp a workpiece centrally, the spindle with two opposing threads must be rigidly housed — adjusting nut turned to the right (as when delivered). In the factory, the center of the clamping device is aligned with the fitting groove in the center of the casing and can be corrected, if required.

Clamping 2 workpieces (compensating spindle)



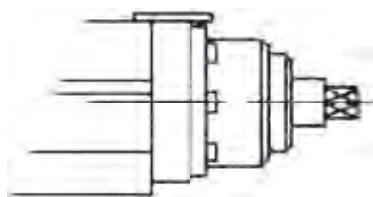
For clamping two workpieces, the center locator matching the clamping jaws used is generally mounted. This is rigidly fixed in the fitting groove. During these clamping operations, therefore, the clamping jaws must compensate the workpiece tolerances, i.e. the spindle must be axially movable. The jaws are thus uniformly brought up to both workpieces and the clamping pressure is built up to the same level for both of them.

Converting the spindle from rigid to compensating

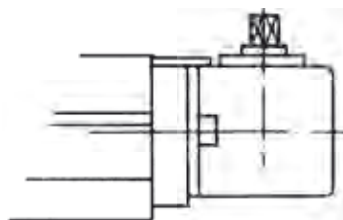
After loosening and turning the setting nuts to the left, the spindle and the basic jaws have an axial movement of 3 mm.

5 different drive variants:

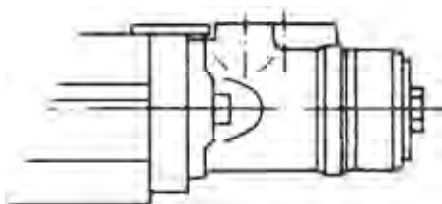
Depending on the application, RÖHM NCZ self-centering vices can, additional to the standard equipment (manual with hand crank, type of drive 1), be equipped with different types of drive:



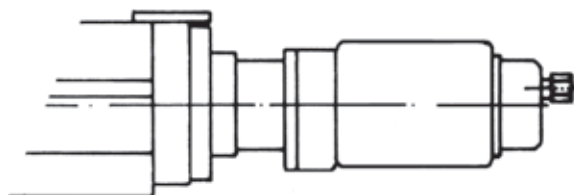
2. Manual with power intensifier and hand crank ($i=1:4$).
The clamping force cannot be preset.



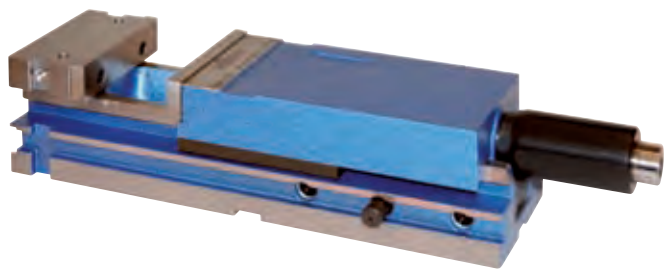
3. Manual with angle drive and hand crank, especially suitable for large machine tables or pallets.



4. Hydraulic motor, especially suitable for rationally clamping series parts in the minimum time.



5. Pneumatic motor, especially suitable for rationally clamping series parts in the minimum time.



For the universal application on milling machines and machining centers.
Horizontal, vertical or side mounting with height adjustment $\pm 0,02$.

Standard version

High reliability, long working life and high precision

Clamping system mechanical without power transmitter, manually operated.

Technical features:

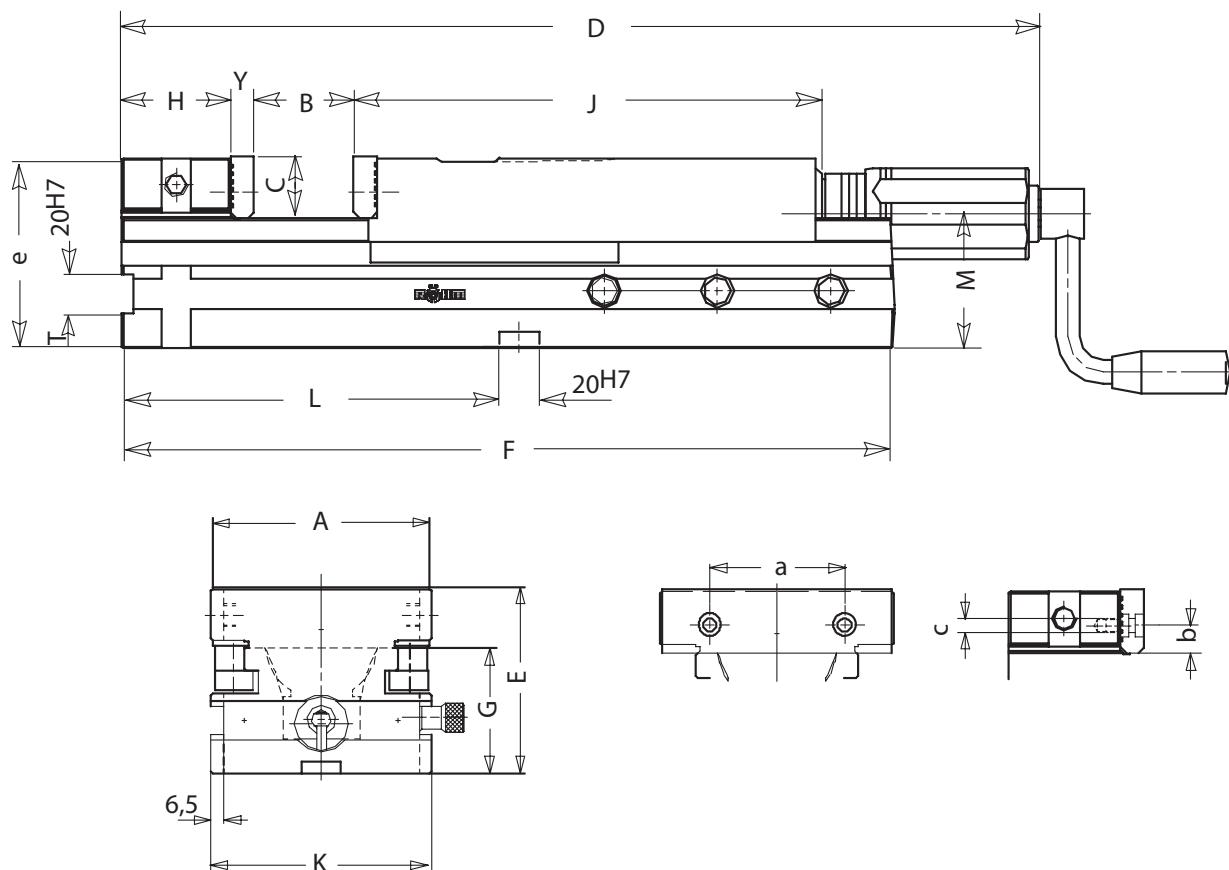
- steel body with stationary jaw, uniformly forged into the die
- locking device for the mechanical pre-clamping of workpieces
- automatic reclamping in the hydraulic unit via the installed belleville spring
- all wear parts, primarily the jaw guides, are hardened and ground
- robust guide surface of the movable jaw

Customer advantage:

- robust and maintenance-free spindle
- rapid-change hydraulic unit
- with normal jaws and hand crank
- locking pin is protected against dirt and chips
- rapid adjustment of the clamping range via locking pin

Tool group A27
Type 746-10 **RBA**
Standard version

Item no.	153394	153395	153396	153397
Size	1	2	3	4
Jaw width A	92	113	135	160
B	0-100	0-170	0-220	0-310
C	31,6	31,6	39,6	49,6
D _{max}	490	583	681	817
E _{$\pm 0,02$}	91,2	97,7	112,7	133,7
F	310	390	468	574
G $\pm 0,02$	59	65,5	72,5	83,5
H $\pm 0,02$	50	55	70	80
J	218	236,5	262	298
K $\pm 0,02$	94	115	137	162
L $\pm 0,02$	130	190	190	240
M	61,5	68	78	93
T $\pm 0,02$	12,5	175	175	22,5
Y _{-0,01}	11,6	11,6	15,6	15,6
a	63	63	80	100
b	13,6	13,6	15,6	19,6
c	M6	M6	M8	M8
d	12	12	13	13
e _{$\pm 0,02$}	89,5	96	111	132
Clamping force kN	25	30	40	50
Weight kg	15,5	24	39	60



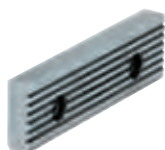
Accessories RBA

Tool group A37
Type 721 **Draw-down jaws SNF**
with spring plate, hardened and ground



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

Tool group A37
Type 721 **Normal jaw SGN**
one side smooth, one side grooved, both sides ground



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

Tool group A37
Type 721
Normal jaw fine checkered SGNF
reversible, used to increase the specific surface pressure (higher retention force), one side fine checkered, one side longitudinally checkered



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

Tool group A37
Type 721 **V-jaw SPR**
with vertical and horizontal ground V's, hardened, for use in combination with SGN; only suitable for twin-clamping



Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					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

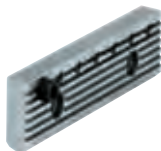
Tool group A37
Type 728-00
V-jaw and standard jawSBO
soft and gunmetal-finished, with work support; for BOF and BSS



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

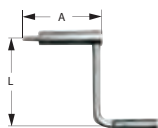
Accessories RBA

Tool group A37
Type 721-52 **Normal jaw SGNA**
with movable workpiece locator,
hardened and ground; only suitable
for twin-clamping



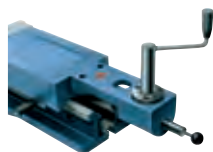
Item no.	Contents of delivery	Size	Width	Height
150739 ■	piece	2	113	31,6
150740 ■	piece	3	135	39,6
150741 ■	piece	4	160	49,6

Tool group A37
Type 744 **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

Tool group A37
Type 744-50 **Angle drive**
for bolting onto the movable jaw
(the movable jaw must be
reworked), for activating the
spindle screw from above (90°)



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

Tool group A37
Type 740 **Hydraulic unit HDE**



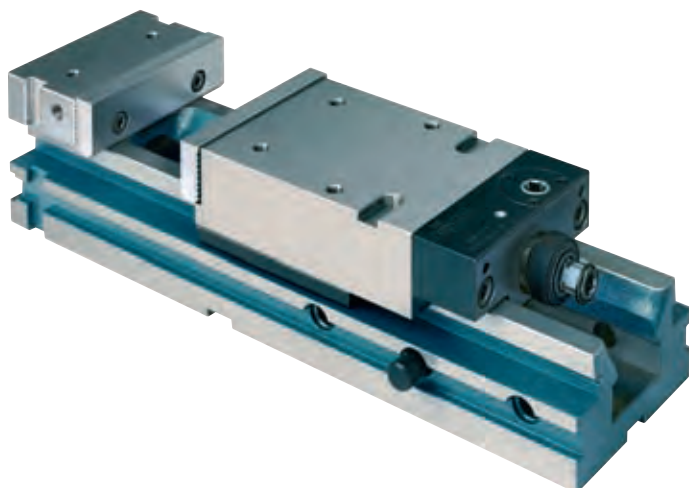
Item no.	Contents of delivery	Size	A	B
094170 ●	piece	1	102	56
226502 ●	piece	2	109	62
226503 ●	piece	3	114	70
226504 ●	piece	4	115	70

Tool group A37
Type 744 **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

RBAW



For the universal application on milling machines and machining centers.
Horizontal, vertical or side mounting with height adjustment $\pm 0,02$.

With angle drive

High reliability, long working life and high precision

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

Technical features:

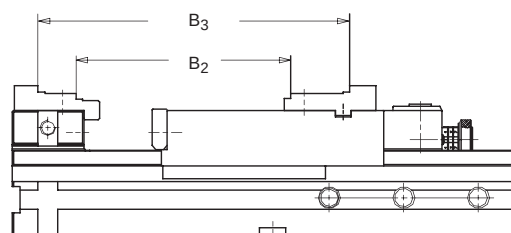
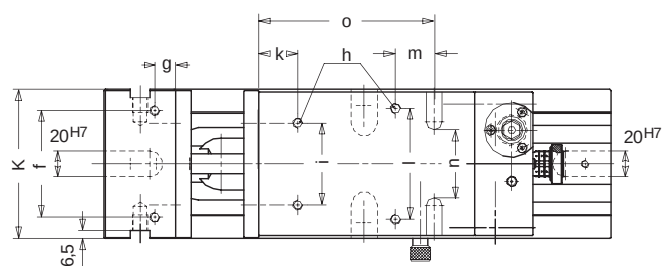
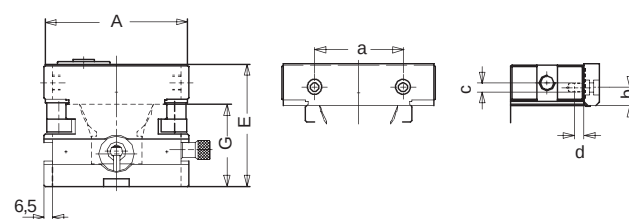
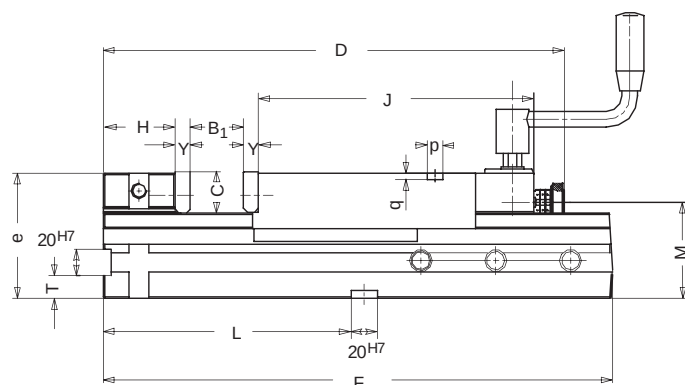
- steel body with stationary jaw, uniformly forged into the die
- automatic reclamping in the hydraulic unit via the installed belleville spring
- all wear parts, primarily the jaw guides, are hardened and ground
- robust guide surface of the movable jaw
- with normal jaws and hand crank

Customer advantage:

- robust and maintenance-free spindle
- the short design of the movable jaw (made of steel) allows a reduced overall length even by max. clamping width
- further stepped or special top jaws can be fixed on the top of the stationary and movable jaws
- locking pin is protected against dirt and chips
- large clamping range

Tool group A27
Type 748-10 **RBAW**
With angle drive

Item no.	154763	154764	154765
Size	2	3	4
Jaw width A	113	135	160
B1	0-175	0-225	0-310
B2	125-300	138-363	146-454
B3	199-374	220-445	248-556
C	31,6	39,6	49,6
D _{max}	500	578	702
E _{$\pm 0,02$}	97,7	112,7	133,7
F	390	468	574
G $\pm 0,02$	65,5	72,5	83,5
H $\pm 0,02$	55	70	80
J	211	213	240
K $\pm 0,02$	115	137	162
L $\pm 0,02$	190	190	240
M	73,5	80,5	96
T $\pm 0,02$	175	175	22,5
Y _{-0,01}	11,6	15,6	15,6
a	63	80	100
b	13,6	15,6	19,6
c	M6	M8	M8
d	12	13	13
e _{$\pm 0,02$}	96	111	132
f	82	80	100
g	16	30	30
h	M 8 x 14	M10x16	M12x20
i	63	80	100
k	30	30	30
l	85	105	120
m	30	35	35
n	52	70	96
o	135	135	142
p ¹⁷	12	14	14
q	5	5	5
Clamping force kN	30	40	50
Weight kg	22	36	62



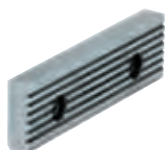
Accessories RBAW

Tool group A37
Type 721 **Draw-down jaws SNF**
with spring plate, hardened and ground



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

Tool group A37
Type 721 **Normal jaw SGN**
one side smooth, one side grooved, both sides ground



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

Tool group A37
Type 721
Normal jaw fine checkered SGNF
reversible, used to increase the specific surface pressure (higher retention force), one side fine checkered, one side longitudinally checkered



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

Tool group A37
Type 721 **V-jaw SPR**
with vertical and horizontal ground V's, hardened, for use in combination with SGN; only suitable for twin-clamping



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

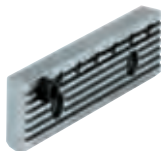
Tool group A37
Type 728-00
V-jaw and standard jawSBO
soft and gunmetal-finished, with work support; for BOF and BSS



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

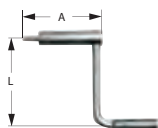
Accessories RBAW

Tool group A37
Type 721-52 **Normal jaw SGNA**
with movable workpiece locator,
hardened and ground; only suitable
for twin-clamping



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

Tool group A37
Type 744 **Hand crank**
turnable handle, hexagon socket



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

General accessories

Tool group A37
Type 743-00
Dual clamp DSP
complete, for connecting two
compact vices base-to-base for
mutual support



Item no.	Contents of delivery
149125 ●	piece

Tool group A37
Type 743-00
Single clamp SPE
complete, for mounting vices on
the end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121 ●	piece	12	M10x55
149122 ●	piece	14	M12x55
149123 ●	piece	16	M12x60
149124 ●	piece	18	M16x60
155722 ●	piece	20	M16x65
151507 ●	piece	22	M16x65

Tool group A37
Type 740-02
Work locator WSA
universally adjustable, to screw on
the vice, M12 connecting screw



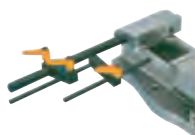
Item no.	Contents of delivery
320400 ●	piece

Tool group A37
Type 740-02
Work locator WSA
universally adjustable, can be
mounted on the machine table
(14 mm T-slot) or bolted onto the
vice (M12)



Item no.	Contents of delivery
320401 ●	piece

Tool group A37
Type 740-02
Precision vice locator PSA
universally adjustable, to screw on
the vice, M12 connecting screw



Item no.	Contents of delivery
681192 ●	piece

Tool group A37
Type 739 **Fixed slot nuts NTS**
hardened and ground, with fixing
screw



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

Machine vices RB and RH

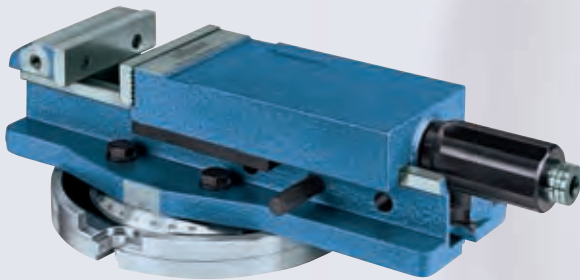
For high clamping accuracy

Special technical features of the RÖHM Machine vices RB and RH:

- Steel body with stationary jaw, drop forged or body made from spherical graphite cast
- Large clamping range
- Long guidance of the movable jaw
- High accuracy

- All wearing parts, above all the jaw guides, are hardened and ground
- Rapid clamping range adjustment
- Can be used on a rotation plate with graduation
- Base equipped with longitudinal grooves for accurate fixing on the machine table
- Height modulation in the special version

RB



RÖHM Machine vices RB:

- Clamping system: mechanical/hydraulic
- Rapid adjustment of the clamping range via 1 protruding bolt.
- After withdrawing the protruding bolt, the movable jaw is moved to the desired position and again locked by protruding bolt.
- Sizes 2, 3 and 4 steel body; sizes 5, 6 and 7 body made out of high-grade spherical graphite cast.

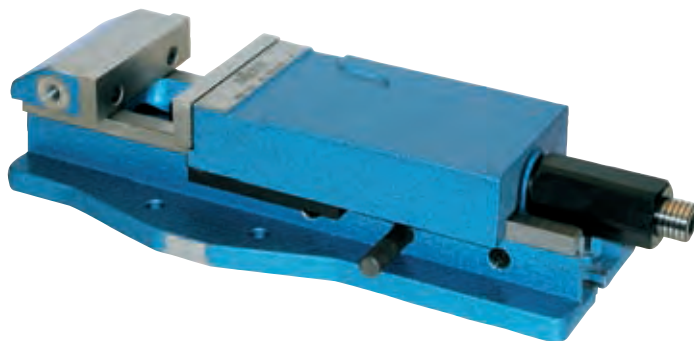
RH



RÖHM Machine vices RH:

These hydraulic high-vices have proved themselves in daily use by problem-free-application and reliable function over a period of years.

- Clamping system: hydraulic with stroke
- Rapid adjustment of the clamping range via 1 protruding bolt.
- After withdrawing the protruding bolt, the movable jaw is moved to the desired position and relocked with the protruding bolt (see RB Machine vices).
- Operating pressure for max. clamping force: 360 bar
- Sizes 2, 3 and 4 steel body; body made out of high-grade spherical graphite cast for size 5



For high clamping accuracy.
Mechanical drive with the hand crank and hydraulic power intensification via the hydraulic unit.

Rapid adjustment of the clamping range via locking pin
Clamping system mechanical-hydraulic with power transmitter, manually operated.

Technical features:

- with SGN normal jaws and hand crank
- steel body with stationary jaw, drop forged at sizes 2, 3 and 4
- sizes 5, 6 and 7 body made out of high-grade spherical graphite cast
- long guidance of the movable jaw
- all wear parts, primarily the jaw guides, are hardened and ground

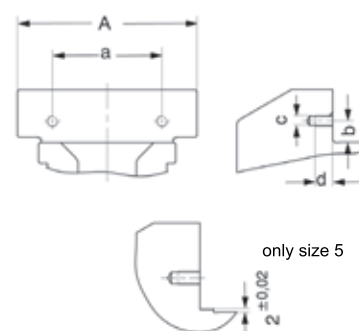
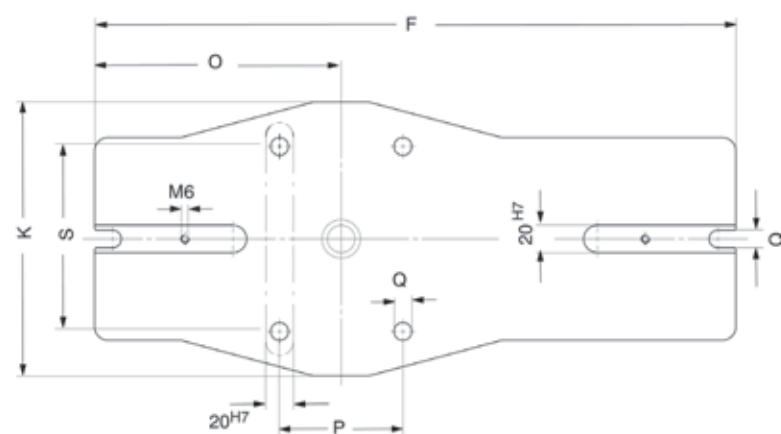
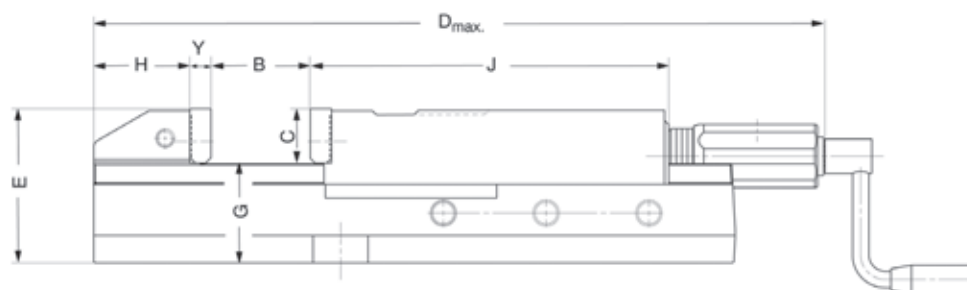
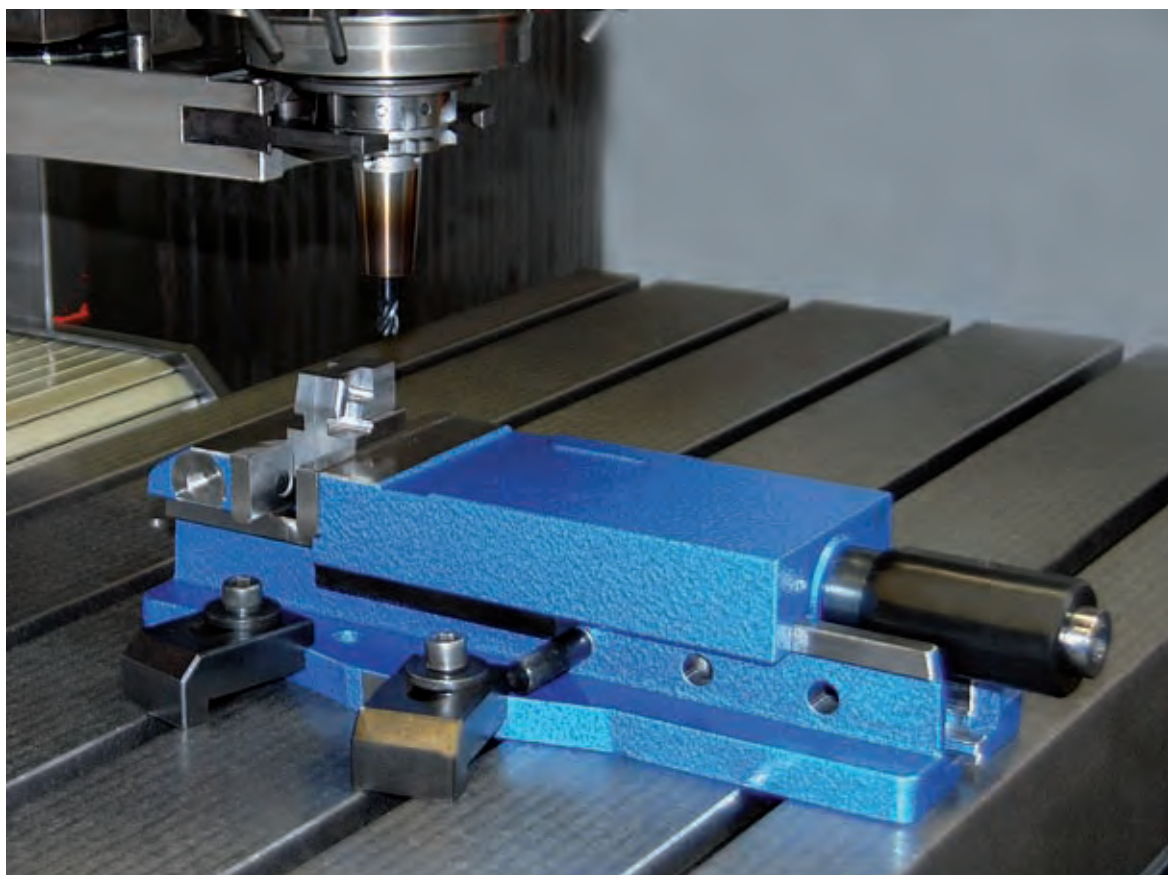
Customer advantage:

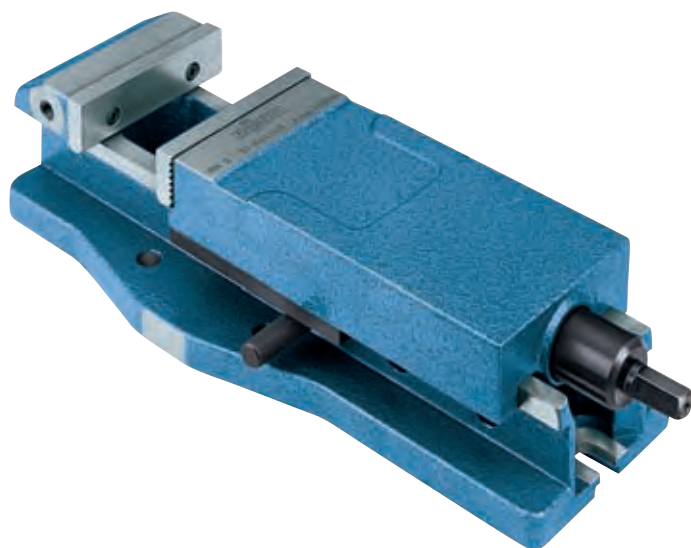
- no overloading of the vice at max. clamping force
- constant clamping force for increased repeating accuracy
- independent tension increase in the rapid-change hydraulic unit via integrated disc springs
- pre-setting of clamping force with blocking device for mechanical pre-clamping of workpiece stacks
- self-locking power transmission

Tool group A10
Type 744 **RB**
With SGN normal jaws
and hand crank

Item no.	158411 ●	158412 ●	158413 ●	129065 ●	137277 ●	137278 ●
Size	2	3	4	5	6	7
Jaw width A	113	135	160	200	250	315
B	170	220	310	350	420	420
C	31,6	39,6	49,6	66,6	79,6	79,6
D	583	681	817	1022	1232	1232
E	97	112	133	171	205	205
F	390	468	574	685	850	850
G±0,02	65,5	72,5	83,5	104,5	125	125
H	55	70	80	90	155	155
J	236,5	262	298	375	445	445
K	160	200	240	280	260	260
O	160	180	220	230	-	-
P	90	90	90	160	-	-
Q	13	13	17	21	-	-
S	100	135	180	180	-	-
Y	12	16	16	20	25	25
a	63	80	100	140	160	200
b	13,6	15,6	19,6	23	24,6	31,6
c	M6	M8	M8	M10	M10	M12
d	12	13	13	16	17	19
Clamping force kN	30	40	50	100	150	150
Weight kg	24	39	60	112	175	183

transversal slot for use in series in special version on request





Particularly suitable for reciprocal milling via electric driven workholding pump unit for double acting cylinders or turbo air hydraulic-pump
Rational clamping of series parts

Rapid adjustment of the clamping range via locking pin
Clamping system hydraulic with stroke, hydraulic connection for single-acting cylinders.

Technical features:

- With SGN normal jaws and hydraulic connection
- jaw travel approx. 7,5 mm
- sizes 2, 3 and 4 steel body
- body made out of high-grade spherical graphite cast for size 5
- operating pressure for max. clamping force: 360 bar

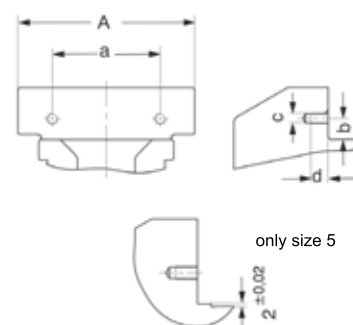
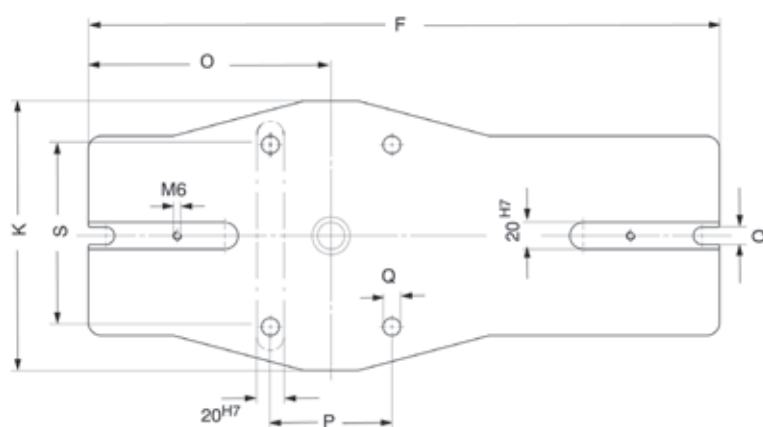
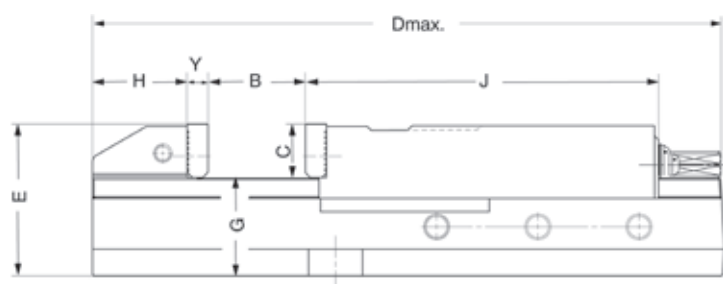
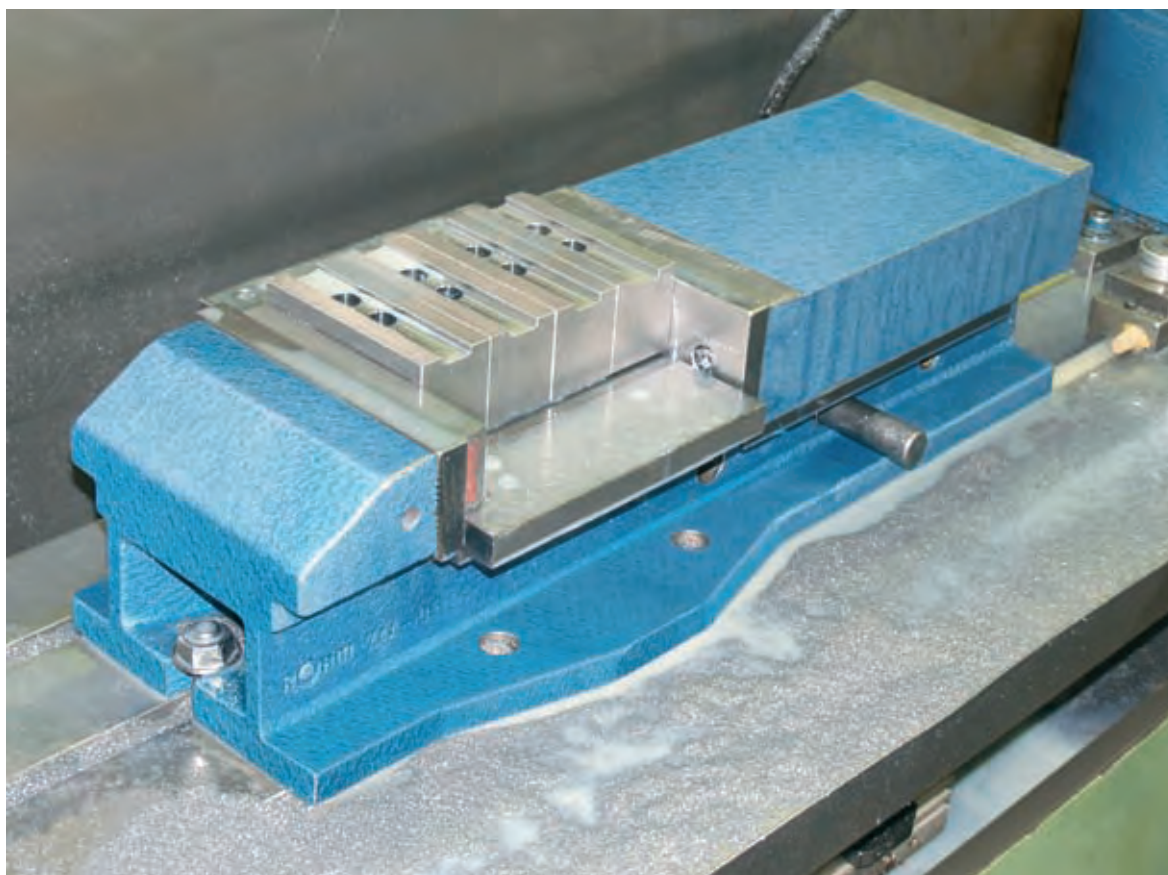
Customer advantage:

- infinitely variable and precise clamping force presetting
- constant clamping force for increased repeating accuracy
- clamping force is maintained even if pressure drops off
- can be used for automatic work cycles
- constant clamping force for the entire jaw travel

Tool group A10
Type 747 RH
With SGN normal jaws and hydraulic connection

Item no.	158511	158512	158513	129725
Size	2	3	4	5
Jaw width A	113	135	160	200
B	170	220	310	350
C	31,6	39,6	49,6	66,6
D	538	645	769	895
E	97	112	133	171
F	390	468	574	685
G±0,02	65,5	72,5	83,5	104,5
H	55	70	80	90
J	236,5	262	298	375
K	160	200	240	280
O	160	180	220	230
P	90	90	90	160
Q	13	13	17	21
S	100	135	180	180
Y	12	16	16	20
a	63	80	100	140
b	13,6	15,6	19,6	23
c	M6	M8	M8	M10
d	12	13	13	16
Clamping force kN	25	40	60	100
Jaw travel	75	75	75	75
Weight kg	24	39	58	102

transversal slot for use in series in special version on request



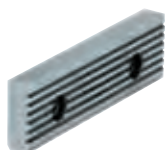
Accessories RB / RH

Tool group A37
Type 721 **Draw-down jaws SNF**
with spring plate, hardened and ground



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

Tool group A37
Type 721 **Normal jaw SGN**
one side smooth, one side grooved, both sides ground



Item no.	Contents of delivery	Size	Width	Height
152753	piece	2	113	31,6
152754	piece	3	135	39,6
152755	piece	4	160	49,6
152756	piece	5	200	64,6
152757	piece	6	250	79,6
152758	piece	7	315	79,6

Tool group A37
Type 721
Normal jaw fine checkered SGNF
reversible, used to increase the specific surface pressure (higher retention force), one side fine checkered, one side longitudinally checkered



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

Tool group A37
Type 721 **V-jaw SPR**
with vertical and horizontal ground V's, hardened, for use in combination with SGN; only suitable for twin-clamping



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

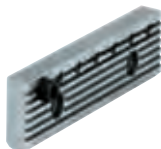
Tool group A37
Type 728-00
V-jaw and standard jawSBO
soft and gunmetal-finished, with work support; for BOF and BSS



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

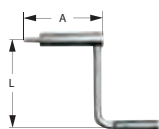
Accessories RB / RH

Tool group A37
Type 721-52 **Normal jaw SGNA**
with movable workpiece locator,
hardened and ground; only suitable
for twin-clamping



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

Tool group A37
Type 744 **Hand crank**
turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A	L
134593	piece	2	12	48	80
134198	piece	3	12	60	90
134499	piece	4	12	117	90
134600	piece	5/6/7	14	104	160

Tool group C15
Type 7004-Y **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

Tool group A37
Type 740 **Hydraulic unit HDE**



Item no.	Contents of delivery	Size	A	B
226502	piece	2	109	62
226503	piece	3	114	70
226504	piece	4	115	70
226505	piece	5	147	98
332827	piece	6-7	165	130

Tool group A37
Type 744 **Spindle** complete



Item no.	Contents of delivery	Size	L
134186	piece	2	99
134187	piece	3	116
134188	piece	4	151
134189	piece	5	182
142323	piece	6-7	224

Tool group A37
Type 740
Standard rotation plate DP
with fixing screws and T-slot nuts
ground contact edge, graduation



Item no.	Size	External Ø	Height	Center Ø	Weight
082441	2	242	30	28	75
082442	3	280	30	28	11
082443	4	340	34	28	18

Tool group A37
Type 744
Universal rotation plate DP
with fixing screws and T-slot nuts
ground contact edge, graduation



Item no.	Size	External Ø	Height	Center Ø	Weight
090854	5	420	40	28	23
137316	6/7	520	50	28	80

General accessories

Tool group A37
Type 740-02
Work locator WSA
universally adjustable, to screw on
the vice, M12 connecting screw



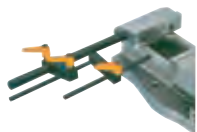
Item no.	Contents of delivery
320400 ●	piece

Tool group A37
Type 740-02
Work locator WSA
universally adjustable, can be
mounted on the machine table
(14 mm T-slot) or bolted onto the
vice (M12)



Item no.	Contents of delivery
320401 ●	piece

Tool group A37
Type 740-02
Precision vice locator PSA
universally adjustable, to screw on
the vice, M12 connecting screw



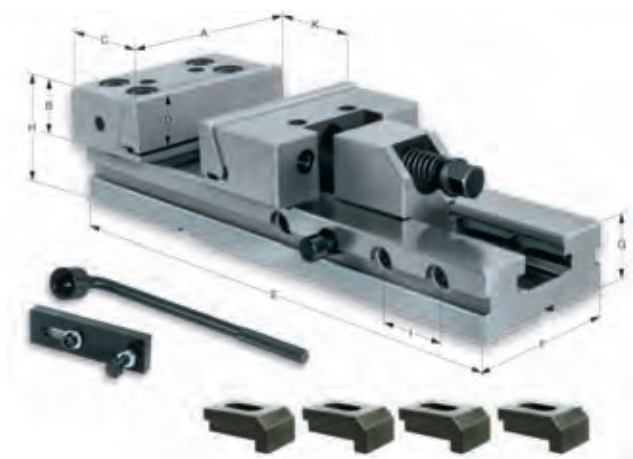
Item no.	Contents of delivery
681192 ●	piece

Tool group A37
Type 739
Fixed slot nuts NTS
hardened and ground, with fixing
screw



Item no.	Contents of delivery	Size	Length
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



For milling machines, machining centres and standard machines.

Clamping system mechanical without power transmitter, manually operated.

Technical features:

- made from alloy steel, hardened and ground
- with draw-down jaws
- hardened steel body (60 HRC)
- repeating accuracy 0,02 mm

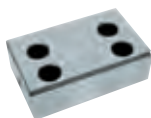
Contents of delivery:

With hand crank,
workpart locator
and four clamps

Tool group A11
Type 706 **MSR**
With draw-down jaws

Item no.	Jaw width A	B	C	D	E	E max	F	G	H	I	K	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	-	655	701	145	58	118	50	400	60	51,2

Tool group A37
Type 706 **Step jaw SB**
for stationary jaw



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

Tool group A37
Type 706 **Step jaw SB**
for movable jaw



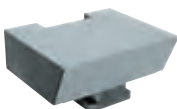
Item no.	Contents of delivery	Size	Width	Height
1043227 ■	piece	125	120	38
1043229 ●	piece	150	146	48
1043231 ■	piece	175	171	58

Tool group A37
Type 706 **V-jaw PB** with jaw steps
for movable jaw



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

Tool group A37
Type 706 **Incline jaw WB**
(for circular parts)
for movable jaw



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

Tool group A37
Type 706-00 **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

Tool group A37
Type 706-10 **Rotation plate DP**



Item no.	Size	External Ø	Height
476867 ●	125	226	47
476868 ●	150	290	58
476870 ●	175	320	58

RS-SG



Made from special cast metal for flexible application
These machine vices are particularly suitable for application on conventional machine tools.

Clamping system mechanical without power transmitter, manually operated.

Technical features:

- with SGN normal jaws and hand crank
- force transmission via spindle thread
- long guidance of movable jaw
- swivel bases in standard and universal design with ground contact edge for supporting the vice

Customer advantage:

- entire clamping range within reach by turning the hand crank
- spindle protective against dirt and chips
- extensive, interchangeable assortment of jaws
- can be used on a rotation plate with graduation

Tool group A11
Type 711 **RS**
With SGN normal jaws
and hand crank

Item no.	Size	Jaw width A	B	C	D	F	G	H	J	K	O	P	Q	R	S	Y	a	b	c	Clamping force kN	Weight kg
128031	1	92	85	31,6	362	260	48	50	174	160	115	60	13	14	120	12	63	13,6	M6	18	12
128032	2	113	105	31,6	423	300	58	55	200	160	125	60	13	14	120	12	63	13,6	M6	25	13,5
128033	3	135	125	39,6	510	365	64	70	242	200	155	70	13	14	146	16	80	15,6	M8	35	25
128034	4	160	145	49,6	575	410	70	80	273	240	175	80	17	18	184,5	16	100	19,6	M8	45	40
111648	5	200	185	62,6	675	460	82	90	322	280	200	118	21	22	210	20	125	24,6	M10	55	65



Made from special cast metal for flexible application
These machine vices are particularly suitable for application on conventional machine tools.

Clamping system mechanical without power transmitter, manually operated.

Technical features:

- with SGN normal jaws and hand crank
- long guidance of movable jaw
- swivel bases in standard and universal design with ground contact edge for supporting the vice
- simple adjustments for the clamping range by moving a pin
- high clamping force due to a heat-treated and bearing-supported spindle

Customer advantage:

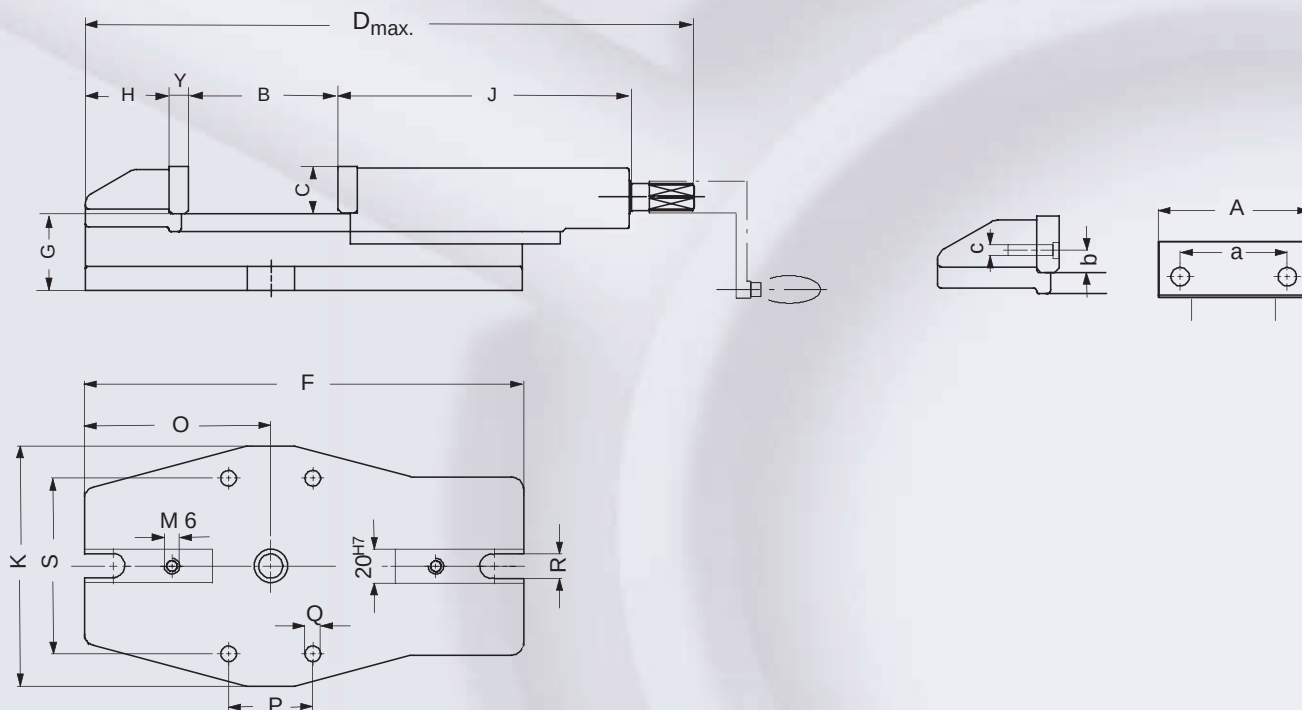
- extensive, interchangeable assortment of jaws
- can be used on a rotation plate with graduation
- disposal of chips and coolant via a groove in the stationary clamping jaw area
- spindle protective against dirt and chips
- wide clamping range

Tool group A11
Type 705 **SG**
With SGN normal jaws
and hand crank

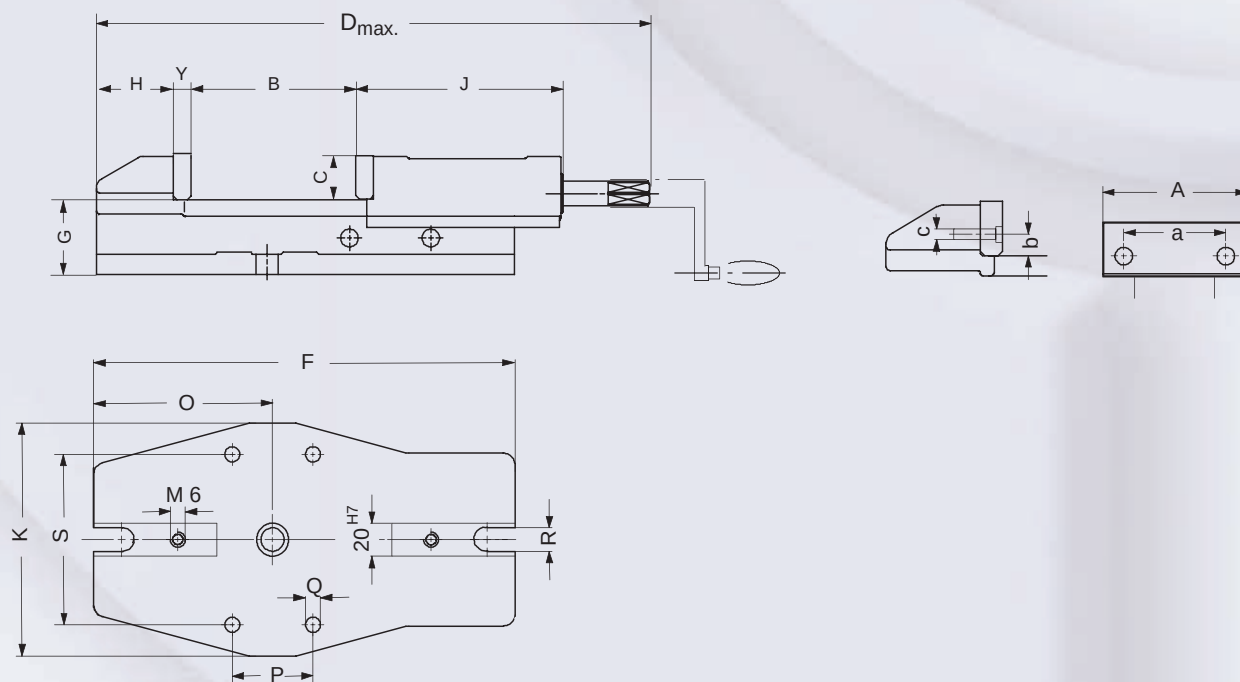
Item no.	Size	Jaw width A	B	C	D	F	G	H	J	K	O	P	Q	R	S	Y	a	b	c	Clamping force kN	Weight kg
125284	1	92	100	31,6	417	310	59	50	158	160	115	90	13	13	100	12	63	13,6	M6	20	13
124521	2	113	125	31,6	458	320	64	55	172	160	125	90	13	13	100	12	63	13,6	M6	25	17
124536	3	135	150	39,6	503	380	67	70	186	200	155	90	13	13	135	16	80	15,6	M8	35	24
124925	4	160	180	49,6	570	430	74	80	214	240	175	90	17	17	180	16	100	19,6	M8	45	35
124941	5	200	215	62,6	660	500	82	90	262	280	200	160	21	21	180	20	125	24,6	M10	55	67
125122	6	250	345	65	853	685	104,5	90	292	280	230	160	21	21	180	50	125	24,6	M10	60	94

RS-SG

Machine vices RS



Machine vices SG



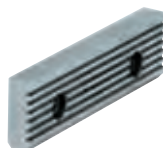
Accessories RS-SG

Tool group A37
Type 721 **Draw-down jaws SNF**
with spring plate, hardened and ground



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

Tool group A37
Type 705 **Standard jaws SGN**
one side smooth, one side grooved, hardened and ground



Item no.	Contents of delivery	Size	Width	Height
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
152761 ¹⁾	piece	6	250	65

¹⁾ both sides ground

Tool group A37
Type 721
Normal jaw fine checkered SGNF
reversible, used to increase the specific surface pressure (higher retention force), one side fine checkered, one side longitudinally checkered



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

Tool group A37
Type 721 **V-jaw SPR**
with vertical and horizontal ground V's, hardened, for use in combination with SGN; only suitable for twin-clamping



Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
128770	piece	1	92	31,6	3-13	5-32
082362	piece	2	113	31,6	3-13	5-32
082363	piece	3	135	39,6	4-20	6-40
082364	piece	4	160	49,6	5-29	7-48
082365	piece	5	200	62,6	6-37	8-56
137838	piece	6	250	65	7-45	9-65

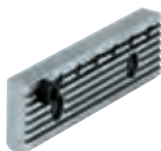
Tool group A37
Type 728-00
V-jaw and standard jawSBO
soft and gunmetal-finished, with work support; for BOF and BSS



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

Accessories RS-SG

Tool group A37
Type 721-52 **Normal jaw SGNA**
with movable workpiece locator,
hardened and ground;
only suitable for twin-clamping



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

Tool group C15
Type 7004-Y
Hand crank HKU for RS
with octagon socket



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

Tool group C15
Type 7004-Y
Hand crank HKU for SG
with octagon socket



Item no.	Contents of delivery	Size	Octagon	L
009150	piece	1	12	80
009152	piece	2	14	125
124550	piece	3	17	160
124937	piece	4/5	19	200
009156	piece	6	24	250

Tool group A37
Type 740
Standard rotation plate DP for RS
with fixing screws and T-slot nuts
ground contact edge, graduation



Item no.	Size	External Ø	Height	Center Ø	Weight
129814	1/2	242	30	28	75
082442	3	280	30	28	11
082443	4	340	34	28	18

Tool group A37
Type 740
Standard rotation plate DP for SG
with fixing screws and T-slot nuts
ground contact edge, graduation



Item no.	Size	External Ø	Height	Center Ø	Weight
082441	2	242	30	28	75
129814	1/2	242	30	28	75
082442	3	280	30	28	11
082443	4	340	34	28	18

Tool group A37
Type 744
**Universal rotation plate DP
for RS and SG**
with fixing screws and T-slot nuts
ground contact edge, graduation



Item no.	Size	External Ø	Height	Center Ø	Weight
090854	5/6	420	40	28	23

UH-UZ



Made from special cast metal for flexible application
These machine vices are particularly suitable for application on conventional machine tools.

Clamping system mechanical without power transmitter, manually operated.

Technical features:

- with SGN normal jaws and hand crank
- high clamping force through roller bearing supported spindle
- low design made of special cast metal
- swivel bases as universal type with ground contact edge for supporting the vice
- vice body and swivel bases are equipped with longitudinal grooves for accurate alignment

Customer advantage:

- entire clamping range within reach by turning the hand crank
- spindle covered in operating range
- adjusting V-jaw guidance
- extensive, interchangeable assortment of jaws
- can be used on a rotation plate with graduation

Tool group A11
Type 721 **UH**
Draw-down-vice

Item no.	Size	Jaw width A	B	C	D	F	G	H	J	K	O	P	Q	R	S	Y	a	b	c	Clamping force kN	Weight kg
014516	1	90	90	24,6	283	263	48	119	13	107	111	40	9	11	82	12	46	11,6	M6	20	6,7
014542	2	113	110	31,6	337	314	55,5	142	14	132	135	50	11	13	101	12	63	13,6	M6	25	10,3
014565	3	135	140	39,6	393	367	61	154	15	152	161,5	60	11	13	118,5	16	80	15,6	M8	35	17,2
014590	4	160	180	49,6	465	436	69,5	180	16	180	193	60	17	17	142	16	100	19,6	M8	40	26,2
014612	5	200	250	62,6	570	539	73,5	202	16	200	244,5	70	17	17	158	20	125	24,6	M10	50	40,2
014635	6	250	300	62,6	676	641	81,5	251	18	220	290	80	17	21	175	20	160	24,6	M10	60	54
014655	7	300	400	79,6	792	754	89,5	251	19	280	346,5	120	17	21	208	25	200	31,6	M12	70	80



Made from special cast metal for flexible application
These machine vices are particularly suitable for application on conventional machine tools.

Centric clamping for milling and planing of forms, slots and grooves of all kinds.

Clamping system mechanical without power transmitter, manually operated.

Technical features:

- with SGN normal jaws and hand crank
- low design made of special cast metal
- the side jaw guides enable simple and exact positioning of the vice
- swivel bases as universal type with ground contact edge for supporting the vice
- centric clamping by right-hand and left-hand threaded spindle

Customer advantage:

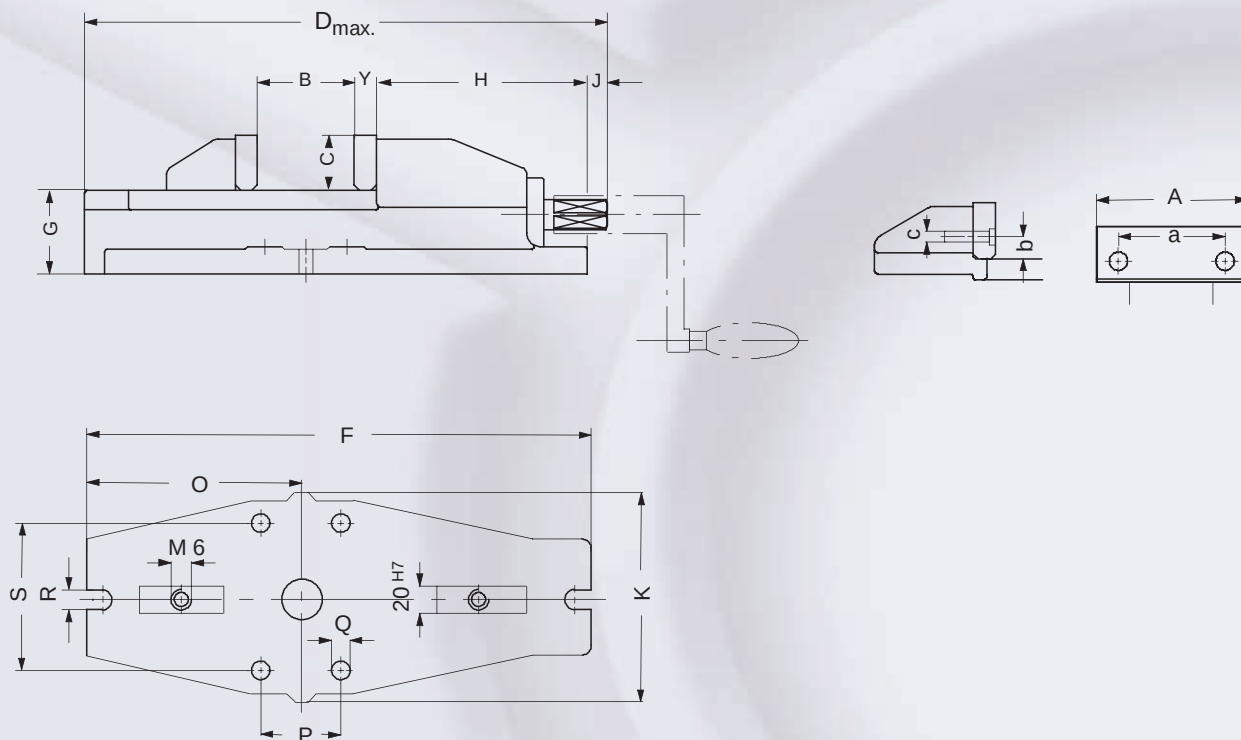
- spindle covered in operating range
- extensive, interchangeable assortment of jaws
- can be used on a rotation plate with graduation

Tool group A11
Type 725 **UZ**
Self-centering vice

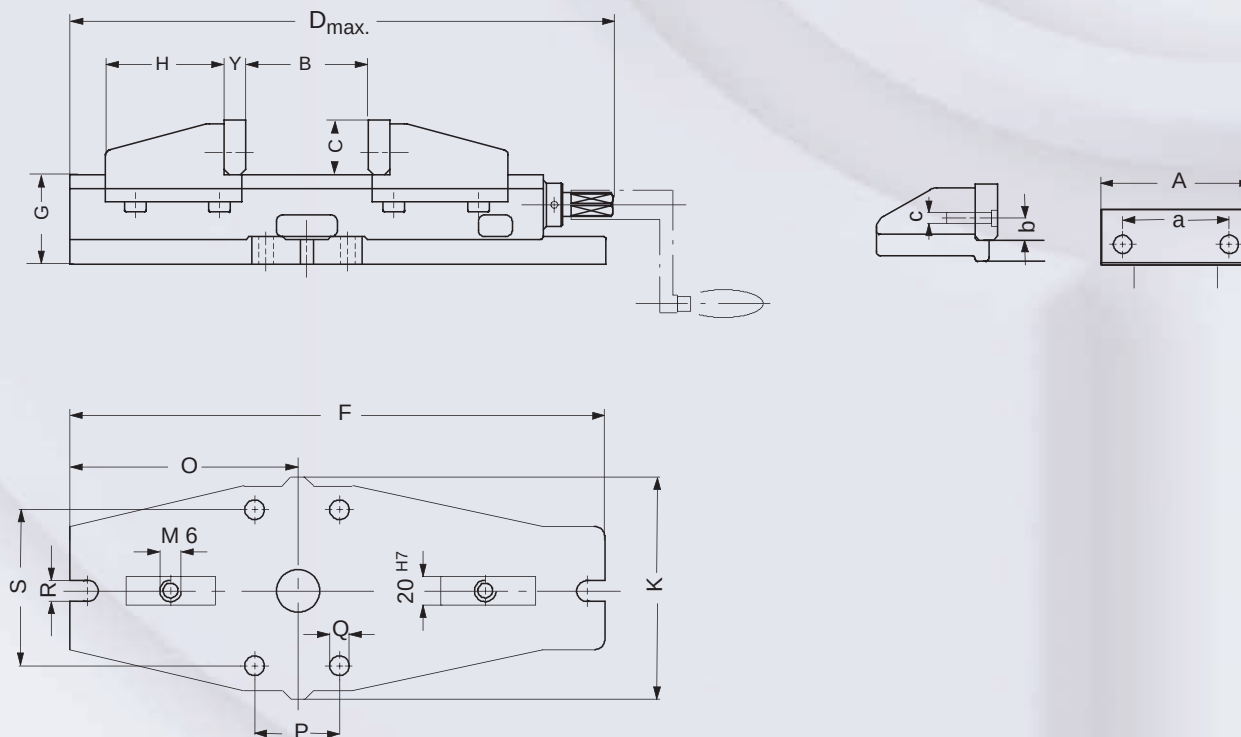
Item no.	Size	Jaw width A	B	C	D	F	G	J	K	O	P	Q	R	S	Y	a	b	c	Clamping force kN	Weight kg
014523	2	113	110	31,6	358	344	61	81	132	149	50	11	13	101	12	63	13,6	M6	15	12,4
014740	3	135	140	39,6	408	394	65,5	87	152	174	60	11	13	118,5	16	80	15,6	M8	22	19
014752	4	160	180	49,6	495	480	74	107	180	214	60	17	17	142	16	100	19,6	M8	24	31
014802	5	200	300	62,6	655	640	79	123	200	294	70	17	17	158	20	125	24,6	M10	25	52
014807	6	250	400	62,6	767	751	85	123	220	344	80	17	21	175	20	160	24,6	M10	28	71

UH-UZ

Machine vices UH



Machine vices UZ



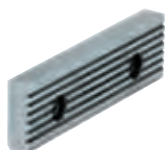
Accessories UH - UZ

Tool group A37
Type 721 **Draw-down jaws SNF**
with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width	Height
077103	set	1	90	24,6
077104	set	2	113	31,6
077105	set	3	135	39,6
077106	set	4	160	49,6
077107	set	5	200	62,6

Tool group A37
Type 721 **Normal jaw SGN**
one side smooth, one side grooved, both sides ground



Item no.	Contents of delivery	Size	Width	Height
152767	piece	1	90	24,6
152753	piece	2	113	31,6
152754	piece	3	135	39,6
152755	piece	4	160	49,6
152759	piece	5	200	62,6
152760	piece	6	250	62,6
152762	piece	7	300	79,6

Tool group A37
Type 721
Normal jaw fine checkered SGNF
reversible, used to increase the specific surface pressure (higher retention force), one side fine checkered, one side longitudinally checkered



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

Tool group A37
Type 721 **V-jaw SPR**
with vertical and horizontal ground V's, hardened, for use in combination with SGN; only suitable for twin-clamping



Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					Horizontal	Vertical
082361	piece	1	90	24,6	3-13	5-32
082362	piece	2	113	31,6	3-13	5-32
082363	piece	3	135	39,6	4-20	6-40
082364	piece	4	160	49,6	5-29	7-48
082365	piece	5	200	62,6	6-37	8-56
082366	piece	6	250	62,6	7-45	9-65

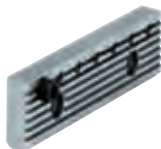
Tool group A37
Type 728-00
V-jaw and standard jawSBO
soft and gunmetal-finished, with work support; for BOF and BSS



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

Accessories UH - UZ

Tool group A37
Type 721-52 **Normal jaw SGNA**
with movable workpiece locator,
hardened and ground; only
suitable for twin-clamping



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

Tool group C15
Type 7004-Y
Hand crank HKU for UH
with octagon socket



Item no.	Contents of delivery	Size	Octagon	L
009150	piece	1	12	80
009152	piece	2/3	14	125
009153	piece	3/4	17	160
009154	piece	4/5/6	19	200
009156	piece	6	24	250
009157	piece	7	24	315

Tool group C15
Type 7004-Y
Hand crank HKU for UZ
with octagon socket



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

Tool group A37
Type 722
Universal rotation plate DP
with T-slot screws and nuts
ground contact edge, graduation



Item no.	Size	External Ø	Height	Center Ø	Weight
014706	1	210	22,5	28	3,5
014709	2	245	25	28	5
014712	3	295	27	38	8
014715	4	345	30	38	11,5
014718	5	450	30	38	16,5
014721	6	450	30	38	173
014723	7	495	34	38	23

General accessories

Tool group A37
Type 740-02 **Work locator WSA**
universally adjustable, can be mounted on the machine table (14 mm T-slot)
or bolted onto the vice (M12)



Item no.	Contents of delivery
320401	piece

Tool group A37
Type 739 **Fixed slot nuts NTS**
hardened and ground, with fixing screw



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



Reliable clamping and mounting of workpieces on drilling and measuring machines.

Standard version

Clamping system mechanical, manually operated

Technical features:

- body made out of special cast metal
- mounting possibilities on the side and frontal
- long guidance for movable jaw also in outer clamping range
- both jaws with contact surface for clamping flat workpieces
- clamping jaws reversible: one size smooth, respectively with longitudinal and transversal prisms, one side grooved, both sides ground

Customer advantage:

- low, stable design with thread spindle
- entire clamping range within reach by turning

Tool group A12
Type 728-00 **BOF**
With V-jaw and normal jaw SBO

Item no.	Size	Jaw width	Clamping capacity	Jaw height	Length	Height	Length body	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



Reliable clamping and mounting of workpieces on drilling and measuring machines.
For rapid clamping and unclamping, especially for series machining of workpieces.

Quick action vice

Clamping system mechanical-mechanical with power transmitter, manually operated

Technical features:

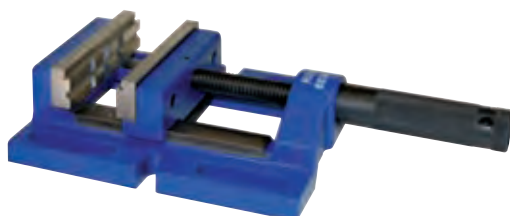
- body made out of special cast metal
- mounting possibilities on the side and frontal
- long guidance for movable jaw also in outer clamping range
- both jaws with contact surface for clamping flat workpieces
- clamping jaws reversible: one size smooth, respectively with longitudinal and transversal prisms, one side grooved, both sides ground

Customer advantage:

- one-hand operation
- positive locking

Tool group A12
Type 728-20 **BSS**
With V-jaw and normal jaw SBO

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



Reliable clamping and mounting of workpieces on drilling and measuring machines.

Standard version

Clamping system mechanical, manually operated

Technical features:

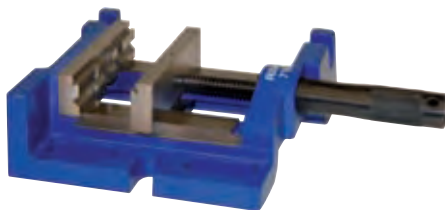
- body made out of cast metal
- movable jaw, mounted on side
- stationary jaw with three vertical and one horizontal prism
- both jaws with contact surface for clamping flat workpieces
- jaws and spindle gunmetal-finished

Customer advantage:

- the thread spindle is covered by a protecting sleeve
- entire clamping range within reach by turning
- constant unit length, spindle moves protected inside the handle
- solid and handy version

Tool group A12
Type 729-60 **DPV**
With V-jaw and normal jaw SBO

Item no.	Size	Jaw width	Clamping capacity	Jaw height	Length	Height	Length body	Width	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



Reliable clamping and mounting of workpieces on drilling and measuring machines.
3 mounting options via two additional contact surfaces machined at right angles: base, right-hand and end-side.

Standard version

Clamping system mechanical, manually operated

Technical features:

- body made out of cast metal
- movable jaw, mounted on side
- stationary jaw with three vertical and one horizontal prism
- both jaws with contact surface for clamping flat workpieces
- jaws and spindle gunmetal-finished

Customer advantage:

- the thread spindle is covered by a protecting sleeve
- entire clamping range within reach by turning
- constant unit length, spindle moves protected inside the handle
- solid and handy version

Tool group A12
Type 729-20 **DPV 3-W**
With V-jaw and normal jaw SBO

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



D. I. Y. design for small drill stands.
Reliable clamping and mounting of workpieces on drilling and measuring machines.

Clamping system mechanical, manually operated

Technical features:

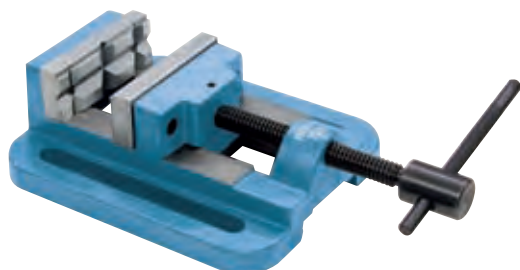
- body made out of cast metal
- long mounting slots
- jaws and spindle gunmetal-finished
- fixed jaw with vertical and horizontal V-jaw

Customer advantage:

- lever movable
- both jaws have a seat for retaining flat workpieces

Tool group A12
Type 729-60 **BSH**
Small, light **D. I. Y. design**

Item no.	Size	Jaw width	Clamping capacity	Length body	Width body	Height	Jaw height	Weight kg
007193 ●	1	63	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



Sturdy craftsman design for drill stands, bench drills and drill presses. Also suitable for milling machines and shapers.

Clamping system mechanical, manually operated

Technical features:

- long mounting slots
- jaws and spindle gunmetal-finished
- fixed jaw with vertical and horizontal V-jaw
- the moveable steel jaw is supported by a cast jaw with internal guidance
- body made out of cast metal

Customer advantage:

- both jaws have a seat for retaining flat workpieces
- long lever for maximal clamping force

Tool group A12
Type 729-60 **BSH**
Sturdy craftsman design

Item no.	Size	Jaw width	Clamping capacity	Length body	Width body	Height	Jaw height	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

Accessories BMS

Tool group A37
Type 728-00

V-jaw and standard jawSBO
soft and gunmetal-finished, with
work support; for BOF and BSS



Item no.	Contents of delivery	Size	Width	Height	Clamping range	
					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

Tool group A37
Type 729-00

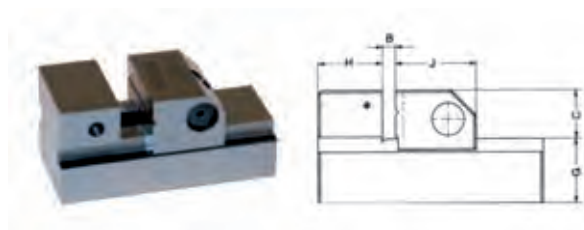
V-jaw and standard jaw SBO
soft and gunmetal-finished, with
work support, for DPV



Item no.	Contents of delivery	Width
1128341 ●	set	85
1128342 ●	set	100
1128344 ¹⁾ ▲	set	100
1128343 ●	set	120
1193108 ▲	set	150

¹⁾ only for DPV 3-W

PZS



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

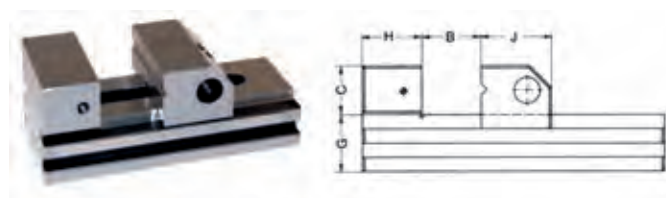
Simple clamping and releasing with the inner hexagon key. Clamping jaws adjustable in steps, lock in automatically.

Technical features:

- with draw-down effect
- made out of alloyed tool steel, hardened and precision ground
- horizontal and vertical ground prism
- no spindle which, for example, could become clogged during erosion

Tool group A29
Type 735-60 **PL-S micro**
with quick adjustment

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



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

Simple clamping and releasing with the inner hexagon key. Clamping jaws adjustable in steps, lock in automatically.

Technical features:

- with draw-down effect
- made out of alloyed tool steel, hardened and precision ground
- horizontal and vertical ground prism
- no spindle which, for example, could become clogged during erosion

Tool group A29
Type 735-65 **PL-S**
with quick adjustment

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



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

Clamping and releasing with locking screws on the top side. Clamping jaws adjustable in steps, lock in automatically.

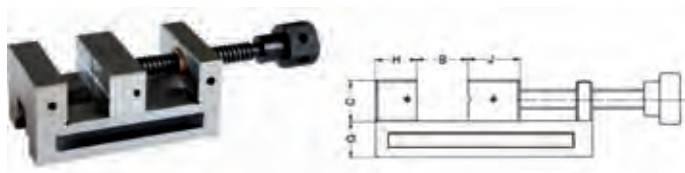
Technical features:

- with draw-down effect
- made out of alloyed tool steel, hardened and precision ground
- horizontal and vertical ground prism
- no spindle which, for example, could become clogged during erosion

Tool group A29
Type 735-70 **PLF**
with quick adjustment in accuracy to gauge

Item no.	Size	Squareness	Parallelism	Jaw width	B	C	Length body	Weight kg
1111185 ●	0	0,005	0,005	50	65	25	140	1,4
1111186 ●	1	0,005	0,005	73	100	35	190	4,1
1111187 ●	2	0,005	0,005	100	125	45	245	7,3

PZS



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

Clamping and releasing with threaded spindle

Technical features:

- horizontal and vertical ground prism
- made out of alloyed tool steel, hardened and precision ground

Tool group A29
Type 735-50 **PL-G**
Precision vices

Item no.	Size	Squareness	Parallelism	Jaw width	B	C	Length body	G	H	J	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	35	210	32	33	45	4
1111184	2	0,005	0,002	88	125	40	250	48	40	50	7,6



For accurate jig operation of workpieces on grinding machines, jig grinding machines and other precision machines.

The angle of this model allows the use of the vice on 4 different faces (on the base, on the face and on both sides).

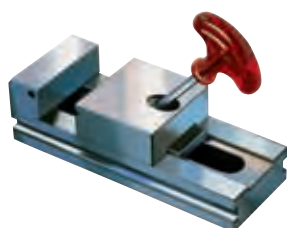
Simple clamping and releasing with hand crank

Technical features:

- made from alloy steel, hardened and ground
- the horizontally ground prism in the movable jaw guarantees the safe clamping even of formed parts
- with spindle

Tool group A29
Type 735-00 **PSK-S**
with 0.005 mm accuracy to gauge
and keep-down effect

Item no.	Size	Jaw width	Clamping capacity	Jaw height	Length	Height	Weight kg
768772	1	45	65	20	150	45	1,4
768773	2	65	100	28	210	65	4
768774	3	100	130	38	270	78	10
768775	4	125	150	40	300	85	15



For accurate jig operation of workpieces on grinding machines, jig grinding machines and other precision machines.

Without spindle for erosion, grinding and inspection work.

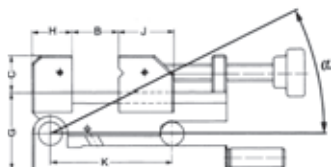
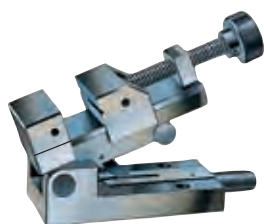
The angle of this model allows the use of the vice on 4 different faces (on the base, on the face and on both sides).

Technical features:

- made from high-grade tool-steel, completely hardened, all sides precision ground
- the horizontally ground prism in the movable jaw guarantees the safe clamping even of formed parts
- without spindle

Tool group A29
Type 735-10 **PSK-O**
precision grinding and control
vice with 0.003 mm accuracy
to gauge

Item no.	Size	Jaw width	Clamping capacity	Jaw height	Length	Height	Weight kg
768777	1	45	60	20	150	45	1,4
768778	2	65	90	28	210	65	4
768779	3	100	120	38	270	78	10
768780	4	125	140	40	300	85	15



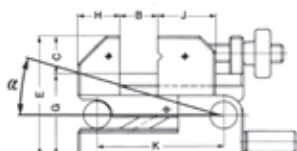
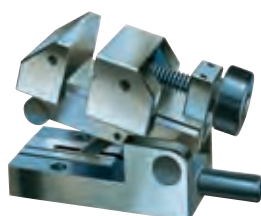
Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

Technical features:

- made out of alloyed tool steel, hardened and precision ground
- bearing pins and headed dowels hardened and ground with accuracy of 0,001 mm
- the clamping device can be positively locked in every angular position

Tool group A29
Type 736-20 **PS-SV**
front swivelling axis

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



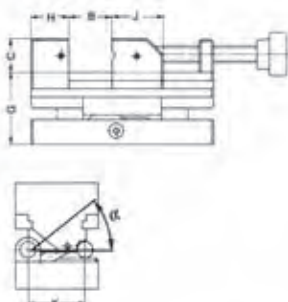
Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

Technical features:

- bearing pins and headed dowels hardened and ground with accuracy of 0,001 mm
- the clamping device can be positively locked in every angular position
- made out of alloyed tool steel, hardened and precision ground

Tool group A29
Type 736-30 **PS-SH**
rear swivelling axis

Item no.	Size	Squareness	Parallelism	Angular accuracy	Jaw width	B	C	Length body	G	H	J	K	α	W	Weight kg
370780	1	0,005	0,002	bei 45° ± 15"	70	50	30	130	63	33	45	100	0° - 46°	2xM5x15	4,5



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

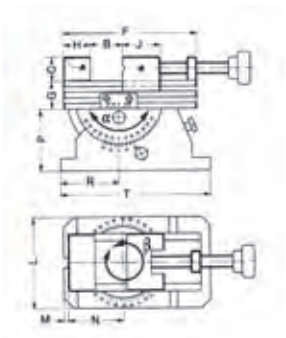
Technical features:

- bearing pins and headed dowels hardened and ground with accuracy of 0,001 mm
- the clamping device can be positively locked in every angular position
- made out of alloyed tool steel, hardened and precision ground

Tool group A29
Type 736-40 **PS-SL**
longitudinal swivelling axis

Item no.	Size	Squareness	Parallelism	Angular accuracy	Jaw width	B	C	Length body	G	H	J	K	α	W	Weight kg
370781	1	0,005	0,002	bei 45° ± 15"	75	80	30	160	63	33	45	50	0° - 46°	2xM5x15	5,9

PZS



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

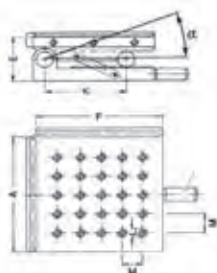
2-dimensional angle adjustment via vernia, for size 1 with 3'-vernia, for size 2 with 5'-vernia.
The fine adjustment screw in the base permits accurate angle setting.
Size 2 for particularly heavy machining work.

Technical features:

- positive locking in every angle position desired via locking screws
- made out of alloyed tool steel, hardened and precision ground
- 360° turnable

Tool group A29
Type 736-50
Precision sine vice PS-ZD
2-dimensional

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



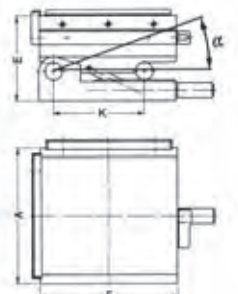
Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

Technical features:

- tapped index holes
- spaced 25 mm apart
- bearing pins and headed dowels hardened and ground with accuracy of 0,001 mm
- the clamping device can be positively locked in every angular position
- made out of alloyed tool steel, hardened and precision ground

Tool group A29
Type 737-50
Precision sine angle plates SW-R

Item no.	Size	Squareness	Parallelism	Angular accuracy	A	E	F	K	L	M	α	Weight kg
370784	1	0,005	0,002	bei 45° ± 15"	150	63	150	100	M6	25	0° - 45°	11,3



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

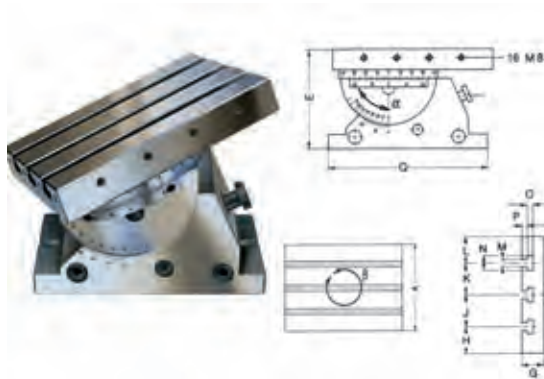
Technical features:

- with magnetic plate
- manually operated by means of a lever
- bearing pins and headed dowels hardened and ground with accuracy of 0,001 mm
- the clamping device can be positively locked in every angular position
- made out of alloyed tool steel, hardened and precision ground

Tool group A29
Type 737-80
Precision sine angle plates SW-M

Item no.	Size	Squareness	Parallelism	Angular accuracy	A	E	F	K	M	α	Weight kg
370785	1	0,005	0,002	bei 45° ± 15"	150	81,5	150	100	-	0° - 45°	12

PZS



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

With angle plate with T-slots arranged side by side, as per DIN 650. The mounting plate can be exactly adjusted in two dimensions by means of a 5"-vernia.

The fine adjustment screw in the base permits accurate angle setting.

Technical features:

- with tilt and rotation axis
- bearing pins hardened and ground to an accuracy of 0,001 mm
- positive locking in every angle position desired via locking screws
- made out of alloyed tool steel, hardened and precision ground

Tool group A29
Type 737-70
Precision angle plates SW-ND
2-dimensional

Item no.	Size	Mounting surface	A	E	F	G	H	J	K	L	M	N	O	P	Q	α	β	Weight kg
370786	1	0,004	220	180	300	40	50	60	60	50	14	28	12	10	270	0° - 45°	360°	47



For accurate setting of any angle between 0° and 90° on production and measuring machines.

Two base surfaces with folding magnets for horizontal and vertical use.

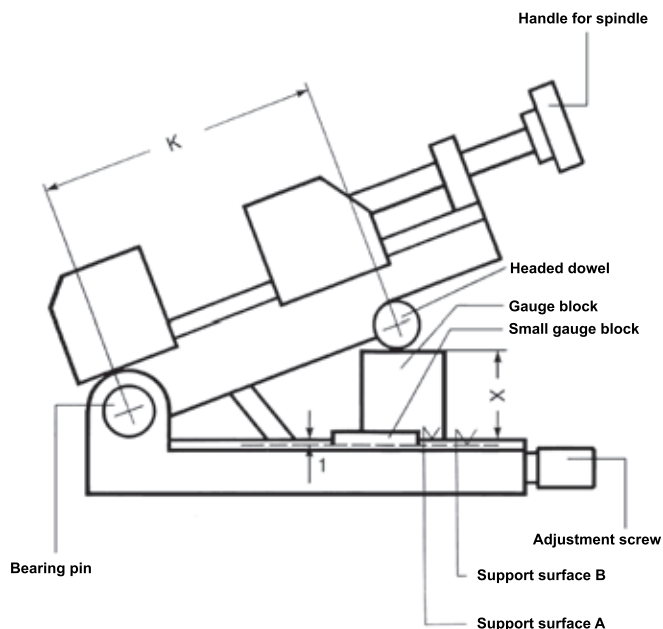
Technical features:

- all parts made out of alloyed steel, hardened and precision ground
- angle setting according to the sine principle with gauge blocks
- 3" angular accuracy

Tool group A37
Type 737-00
Precision sine angle setting device PSE
3" angular accuracy

Item no.	Size	A	B	C	K	α
890706	0	75	34	70	50	0°-90°
220715	1	160	63	131	100	0°-90°

System description precision sine vices



The sine vice can be pivoted upwards by turning the adjustment screw. The gauge block is inserted between surface A and the headed dowel and the adjustment screw is turned back. Thus, the sine vice is pressed against the gauge block and positively locked.

When adjusting small angles, you place the appropriate gauge block on support surface B. Since this surface is 1 mm lower than the support surface A, an additional 1 mm must be taken into account for the tabula value determined.

Formula for calculating the gauge block x

$$x = \sin \alpha \cdot K \quad \text{for locating surface A}$$

$$x = \sin \alpha \cdot K + 1 \quad \text{for locating surface B}$$

Example:

Searched: gauge block for angle setting 24° 15' for precision sine vice PS-SV

Given: $K = 100$; $\sin \alpha = 0,4107$

Calculation: $x = 0,4107 \cdot 100 = 41,07$

The height of the gauge block is 41,07mm



Clamping numerous workpieces on a pallet or a machine table.
Clamping of numerous small and big workpieces on few space.

Delivery includes:

1 x Locating jaw, 4 x Intermediate jaw, 1 x Clamping rail, 2 x T-slot nut for nut 16 mm, 4 x Single clamp, 4 x Work locator

The basic elements are designed for highly versatile use and adaptation to different workpiece sizes.

Optimum utilization of the working range of the machine is achieved by mounting several clamping rails in the longitudinal or transverse direction.

Technical features:

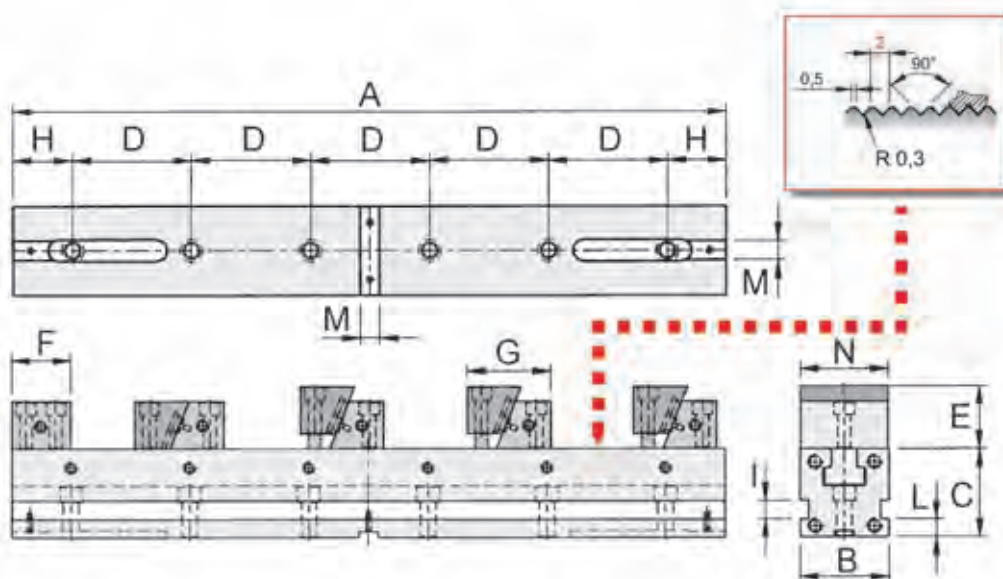
- the scale on the rail allows reading off the exact jaw position and thus repeatability at any time
- constant clamping force during every clamping operation and high repeating accuracy if torque wrenches are used
- serrations on top face for absolutely safe and accurate fastening of jaws

Customer advantage:

- T-slot nuts in size 10mm - 36mm available
- high clamping accuracy
- great machine durability
- reduced tool changing times

Tool group A27
Type 796-90
Multiple clamping system MS
complete
modular system

Item no.	1118789	1118790	1118791	1118792	1118793	1118794	1118795
Size	MS 50 x 400	MS 50 x 500	MS 50 x 600	MS 75 x 400	MS 75 x 500	MS 75 x 600	MS 75 x 700
A	400	500	600	400	500	600	700
B	50	50	50	75	75	75	75
C	50	50	50	75	75	75	75
D	100	100	100	100	100	100	100
E	32/25	32/25	32/25	53/40	53/40	53/40	53/40
F	34	34	34	50	50	50	50
G	55/58	55/58	55/58	70/75	70/75	70/75	70/75
H	50	50	50	50	50	50	50
I	12	12	12	16	16	16	16
L	15	15	15	20	20	20	20
M	16	16	16	16	16	16	16
N	49	49	49	74	74	74	74



Accessories MS

Tool group A27
Type 796-90 **Clamping rail SL**



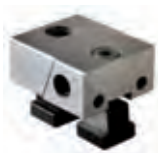
Item no.	Size	A	B	C	D	H	I	L	M
1145245 ▲	MS 50 x 400	400	50	50	100	50	12	15	16
1145246 ▲	MS 50 x 500	500	50	50	100	50	12	15	16
1145247 ▲	MS 50 x 600	600	50	50	100	50	12	15	16
1145250 ▲	MS 75 x 400	400	75	75	100	50	16	20	16
1145251 ▲	MS 75 x 500	500	75	75	100	50	16	20	16
1145252 ▲	MS 75 x 600	600	75	75	100	50	16	20	16
1145253 ▲	MS 75 x 700	700	75	75	100	50	16	20	16

Tool group A37
Type 796-90 **Locating jaw MS**



Item no.	For	Width	Height	Length
1145243 ▲	MS 50	49	25	34
1145248 ▲	MS 75	74	40	50

Tool group A37
Type 796-90 **Intermediate jaw MS**



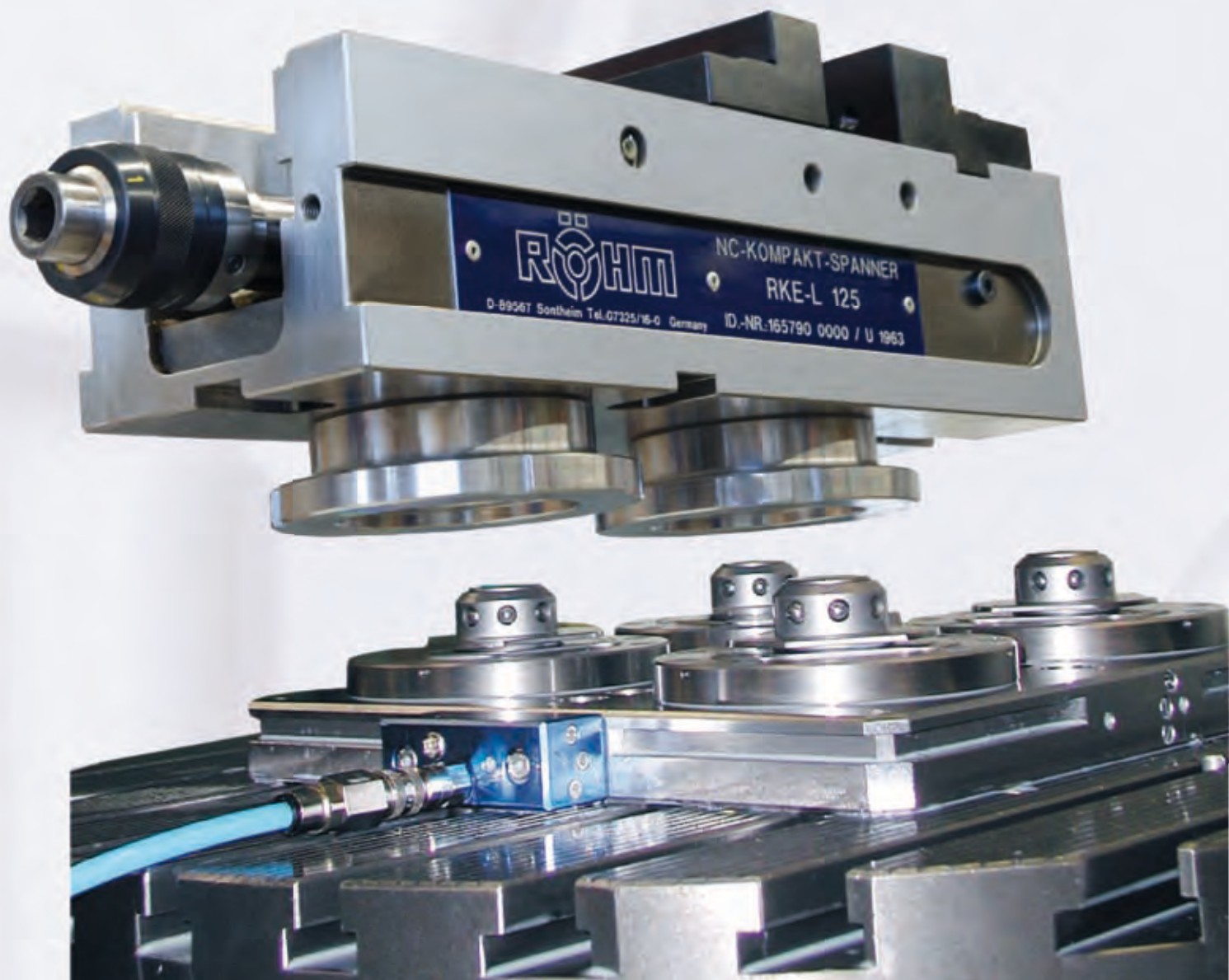
Item no.	For	Width	Height min	Height max	Length min	Length max
1145244 ■	MS 50	49	25	32	55	58
1145249 ■	MS 75	74	40	53	70	75

POWER-GRIP

Userfriendly modular pallet system

- rugged, productivity increasement
- mount and adjust only once
- machine on all machine tables

„Multifunctional machining possibilities in connection with RÖHM clamping tools.“



POWER-GRIP

Your production will be like a walk in the park

Nothing can compare to the POWER-GRIP system. It easily fits into any production process – even automated ones – and is simply different from others and works in a more customer-oriented way:

The dimensions of the palleting system are standardized here via different inside micrometers. A major advantage for you! After the correct design of the inside micrometer, your devices are no longer bound to single machines. Where and on which machine you now machine your workpiece will no longer play any role.

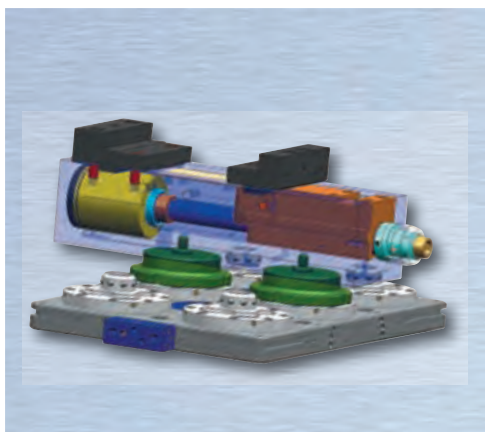
With POWER-GRIP, your device can be used throughout your factory without difficulties – as easily as a walk in the park!

All good things come in threes

1. It doesn't matter whether you measure, mill, turn, wire-cut/cavity sink by EDM, face/circular grind, drill or laser-cut – POWER-GRIP puts an end to the jumble of incompatible systems and clamping tapers. POWER-GRIP: A single interface for your entire production sequence!
2. The POWER-GRIP system clamps gently on material at 17.000 N and up.
On request, there is extra power available up to 30.000 N per spring unit.
3. POWER-GRIP is made of high-quality material. The reference surfaces are thoroughly hardened. The basic support consists of 1.2085 steel, the spring unit is made of M333 (Böhler, Gillette blade steel). The entire system is rust-resistant. The material fatigue is negligibly low, the lifetime of the components almost unlimited!



POWER-GRIP application areas



Milling

The modular structure allows all machine tables to be loaded individually. Machining of cylindrical and square workpieces by changing the workpiece pallets super-fast.



Turning

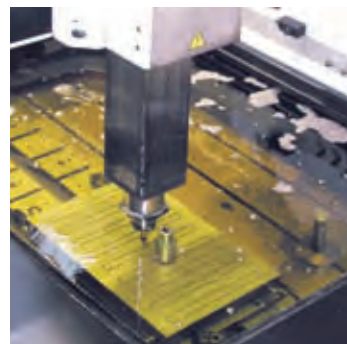
Simple coupling of the workpiece from milling to turning machining.



Eroding

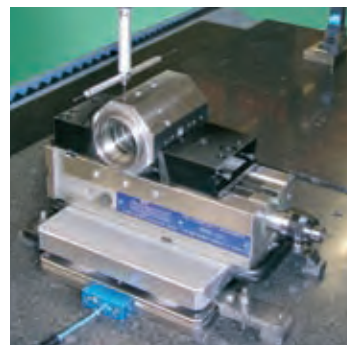
Taking the workpiece from turning and milling to eroding.

Checking the machining progress is always possible on the measuring machine.



Measuring

In order to check after every machining operation, the machined workpiece can be quickly taken up at any time without reference loss.



POWER-GRIP structure

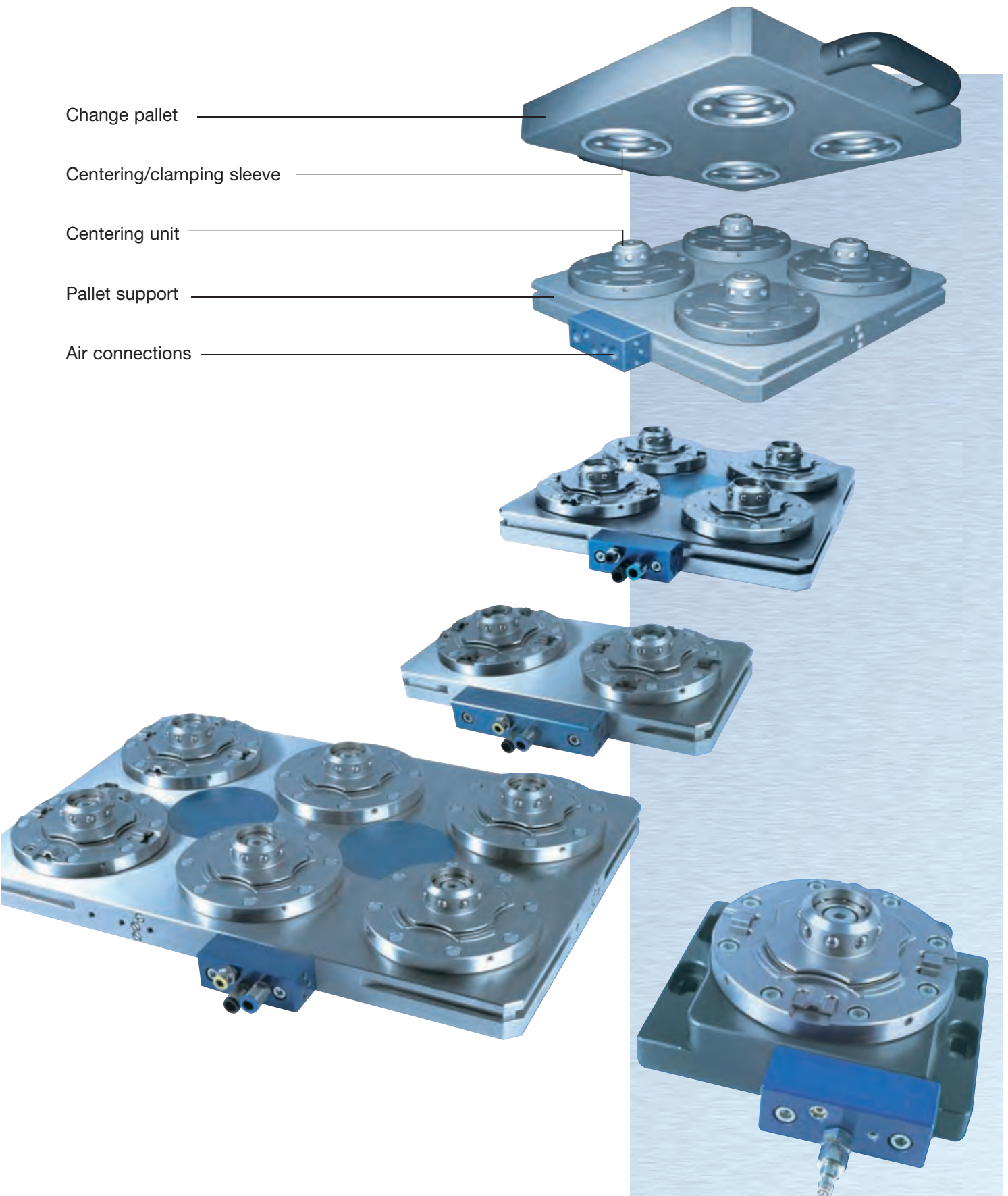
Change pallet

Centering/clamping sleeve

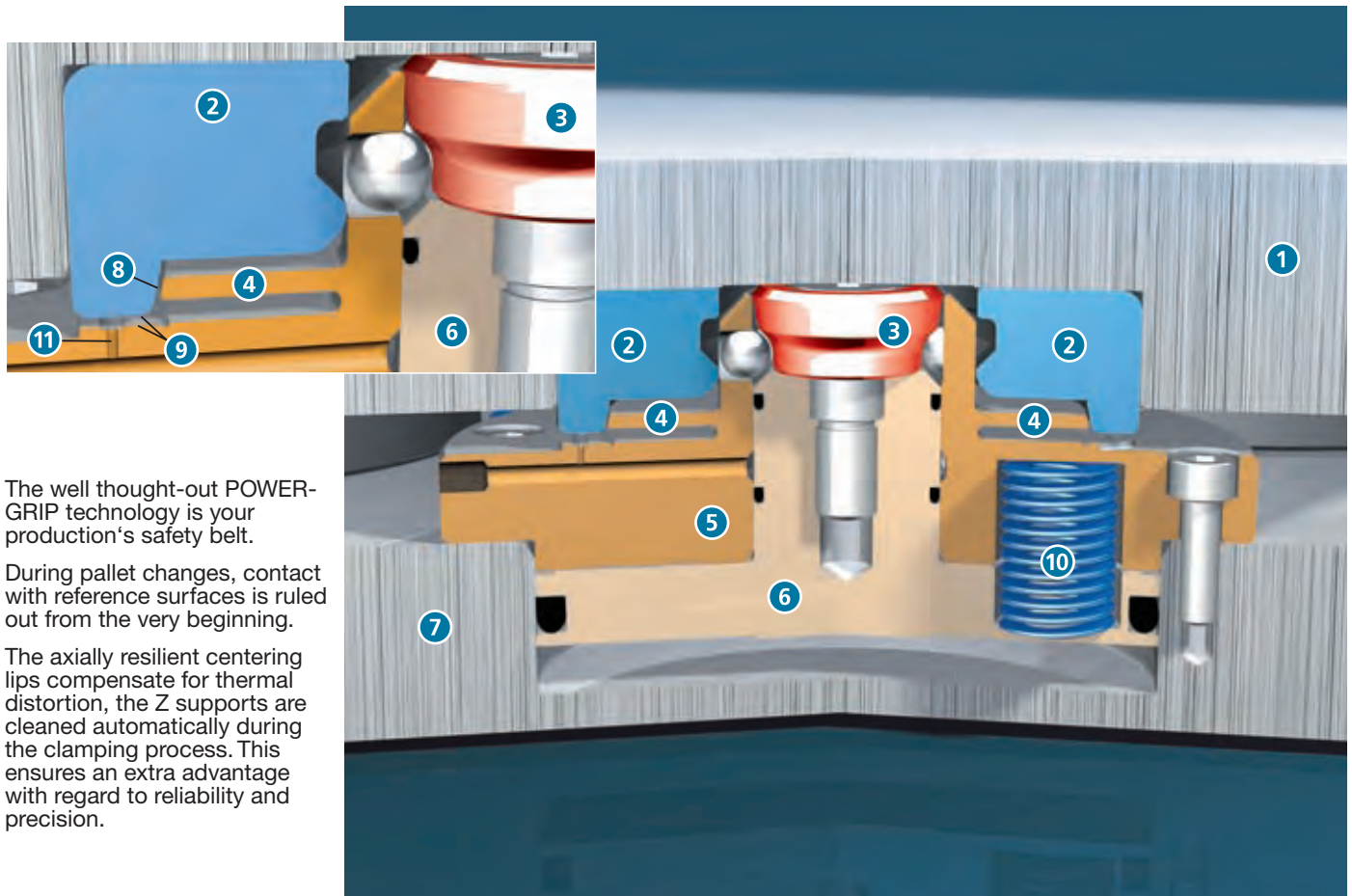
Centering unit

Pallet support

Air connections



Sectional view of the POWER-GRIP-System



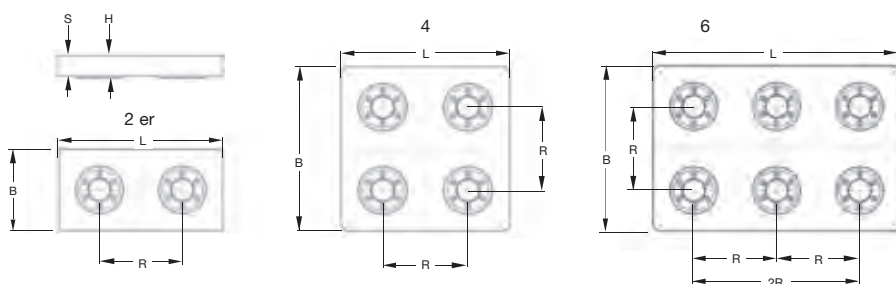
The well thought-out POWER-GRIP technology is your production's safety belt.

During pallet changes, contact with reference surfaces is ruled out from the very beginning.

The axially resilient centering lips compensate for thermal distortion, the Z supports are cleaned automatically during the clamping process. This ensures an extra advantage with regard to reliability and precision.

1. Change pallet
2. Centering / clamping collets
3. Clamping cone
4. Axially resilient centering lip
5. Centering unit
6. Piston
7. Pallet carrier
8. XY-reference surfaces
9. Z-reference surfaces
10. Spring
11. Bore for Z-support cleaning

Dimensions

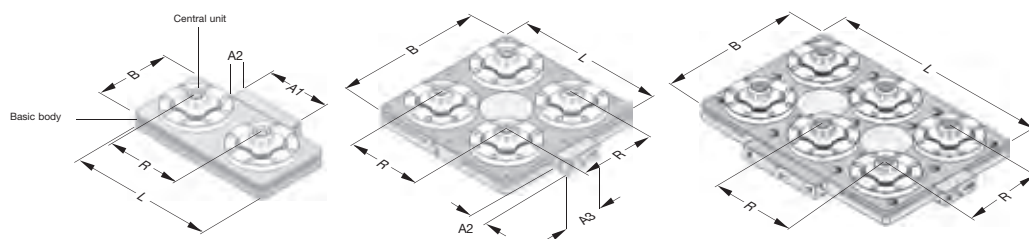


Pallets

Tool group A22

milled	Item no. 488743	488747	488764
grounded	Item no. 488744	488748	488765
L ±0,2	318	318	478
B ±0,2	158	318	318
R ±0,01	160		
S Thickness of pallet	38,1±0,02 / 38 ±0,01 milled		
H Height of pallet	42,1/42 ±0,01 grounded		

The involved centering and clamping sleeves are also available in single pieces to fit into any pallets.

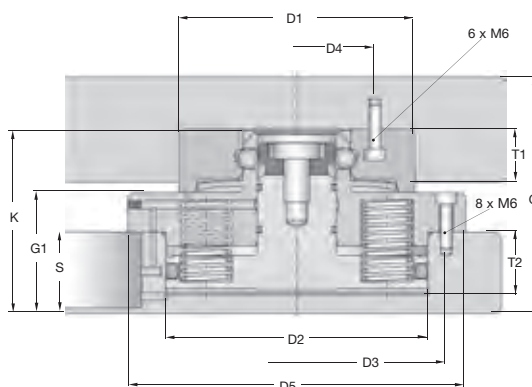


Pallet carrier

Tool group A22

Item no.	1011207	488716	488724
L ±0,2	316	316	476
B ±0,2	156	316	316
R ±0,01		160	
A1 connection block long		140 ±0,1	
A2 connection block		30 ±0,1	
A3 connection block short		80 ±0,1	

Mounting holes in 50, 63, 100 and 125 mm grid as well as customized available. Basic body and centering unit also available in single pieces for fitting.



Complete system clamped

D1	D2	D3	D4	D5	T1	T2	G	G1	K	S
92 +0,012 +0,004	100 +0,02 +0,005	112 ±0,1	62 ±0,1	Ø129 +0 -0,02	19 ±0,01	25 ±0,1	88	46 +0,01 0	69 ±0,01	31 ±0,01

Dimensions in mm



Centering unit index 90° prevents twisting when using the centering sleeve index 90° for 1 x change pallets.



Centering unit Standard

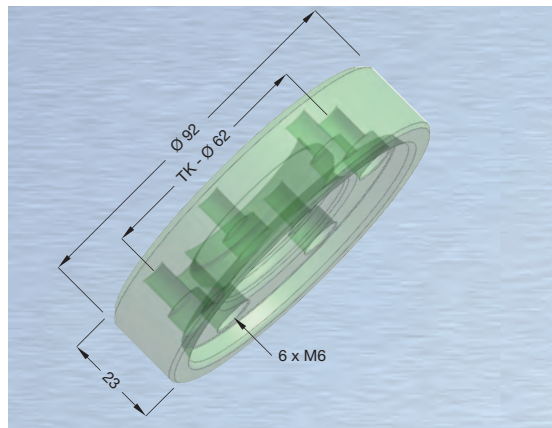


Centering and clamping sleeves

Take advantage of the pallet savings potential by means of direct device fastening with different centering and clamping sleeves



Standard
for installation in pallets
and devices
Item no. 488742



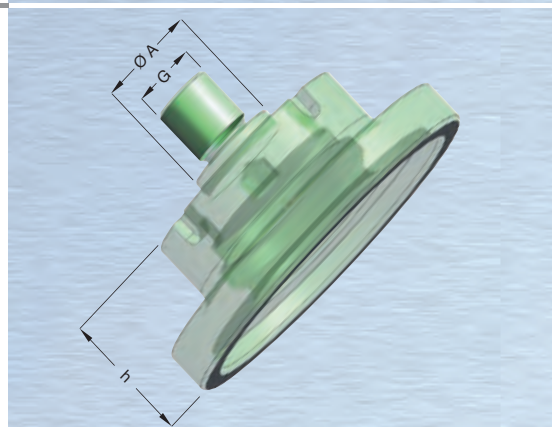
With threaded bolt

Flat design for directly fastening in the clamping device and fixtures

Tool group A22

G	A	h	Item no.
M12	25	32	1081407 ¹⁾
M16	25	32	1084431
	32	32	1084432

¹⁾ Ø A32 on request



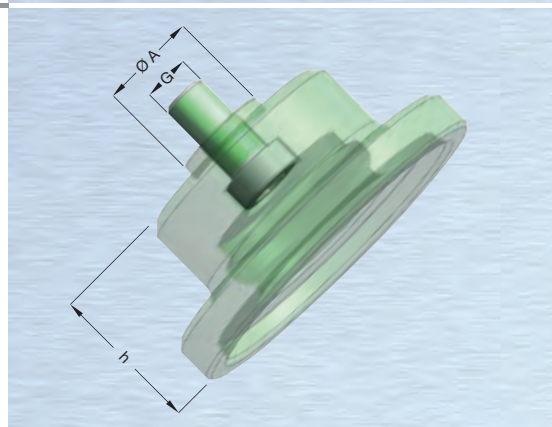
With standard screw

Simple design for direct installation in fixtures and clamping device

Tool group A22

G	A	h	Item no.
M12	25	38	1081405 ¹⁾
M16	25	40	1084434
	32	40	1084437

¹⁾ Ø A32 on request



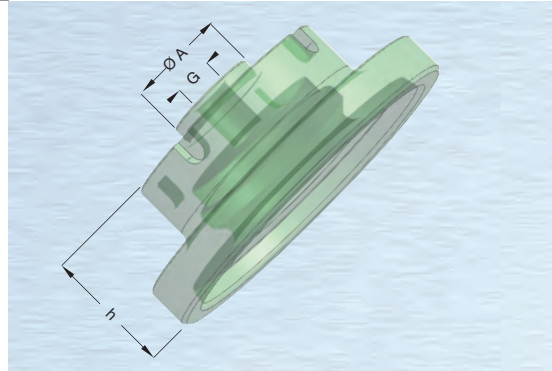
With inner thread

for fastening from above through clamping device or fixture

Tool group A22

G	A	h	Item no.
M12	25	32	1084439 ¹⁾
M16	25	42	1084440
	32	42	1084441

¹⁾ Ø A32 on request



Accessories



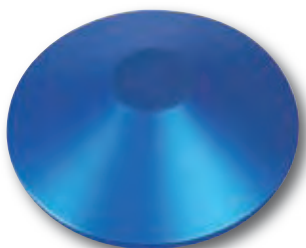
Pneumatic operating unit

For up to 3 air connections. Allows pallets to be released, Z-support cleaning, pneumatic reclamping and air purge supply.



Gasket

For protecting from contamination during machining and to seal during erosion.



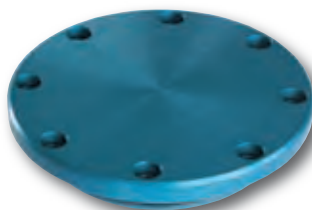
Protection caps

Optimum protection for non-active centering units.



Support

For gentle depositing and fixing of pallets on rotary tables.

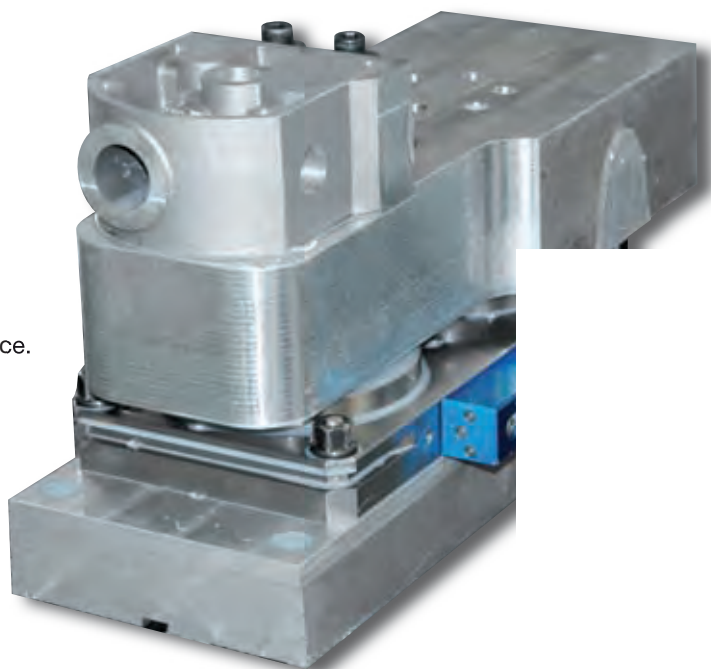


Basic body cover

For covering the pallet support instead of a centering unit. As an inexpensive option for later retrofitting of the pallet support with a centering unit.

Special solutions

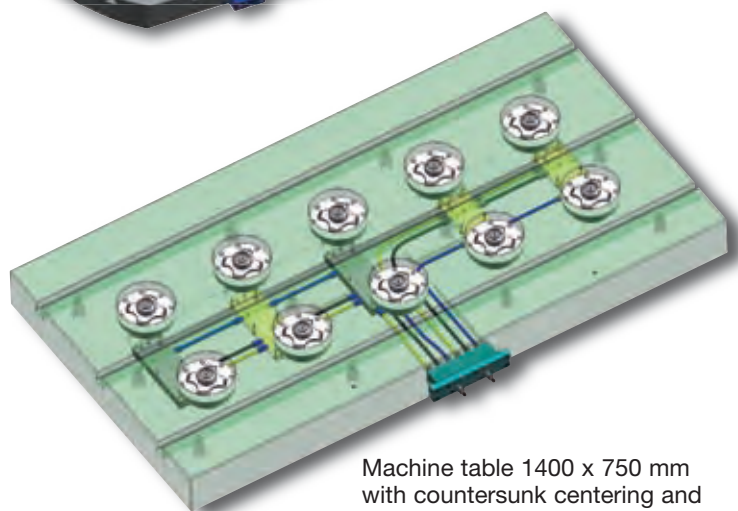
2x pallet support for direct mounting of a special clamping device.



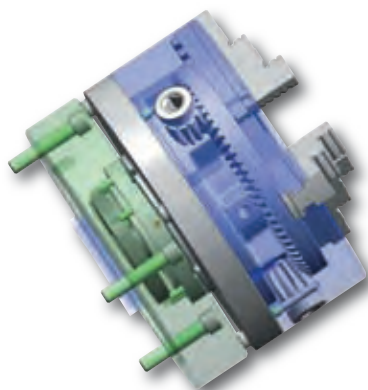
Machine rotary table 860 mm for machine Hedelius with countersunk centering and clamping sleeves.



Machine table 1400 x 750 mm with countersunk centering and clamping sleeves.



Lathe chuck Ø 200 mm with integrated POWER-GRIP flange.

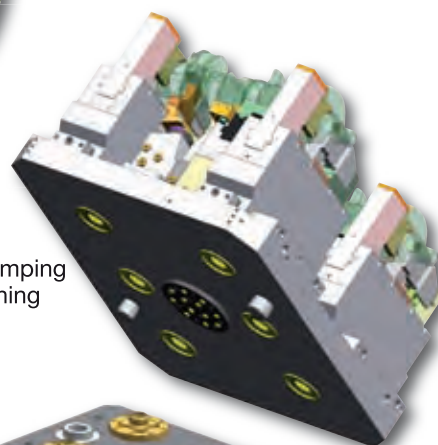


Special solutions



Machine table of a profile-grinding machine with 8 centering and clamping sleeves integrated into the machine table, with special pallet.

POWER-GRIP 6x clamping device for the machining of crankshafts.



Ø 510 mm face plate with POWER-GRIP centering and clamping sleeves for machining of turbine blades in the aircraft industry.

