

DRILL CHUCKS

2015/2016

RÖHM

driven by technology

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

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

Dynamism
Variety
Security
Partnership
Globality
Innovation





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DRILL CHUCKS

Quick-action drill chucks industry

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Quick-action drill chucks

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Errors and corrections are reserved!

Operation guide







TYPE	SPIRO-I	SUPRA-I	SUPRA-S	SUPRA-SK	SUPRA-SK E
Features	Self clamping, flat jaws				
Clamping capacity	0 - 16 mm	0 - 16 mm	0.5 - 16 mm	0.5 - 13 mm	1.5 - 13 mm
Mount	B 10/12/ 16/18 J 6	B 10/12/ 16/18 J 0/1/2/6/33 1/2“-20 3/8“-24	B 12/16/18 1/2“-20 3/8“-24 5/8“-16	B 12/16 1/2“-20 3/8“-24	1/2“-20
For					
Concentricity	■■■■■	■■■■□	■■■□□	■■■□□	■■□□□
Clockwise rotation				✓	✓
For machines without spindle stop	✓	✓	✓	✓	✓
Radial locking				✓	✓
Impact resistant				✓	✓
Socket	M	M	M	M	M
Automatic retightening	✓	✓	✓	✓	✓
Jaw	✓	✓	✓	✓	✓
Page	1006	1007	1008	1009	1010

✓ yes

O optional

M metal

F plastic

machining centers

stationary drilling machines

corded drills

cordless screw drivers

Operation guide





TYPE	EXTRA-RV 80	EXTRA-RV 60	ORANGE LINE EXTRA-RV 40	PRIMA-I	PRIMA-S / -M	ORANGE LINE PRIMA-L
Features	Keyless, radial locking			Key-type		
Clamping capacity	1 - 13 mm	1.5 - 13 mm	1 - 13 mm	0.5 - 26 mm	0.5 - 16 mm	1 - 13 mm
Mount	1/2“-20 3/8“-24 SDS plus Hex	1/2“-20	1/2“-20 3/8“-24	B 12/16/ 18/22/24 J 1/2/3/6/33 5/8“-16	B 10/12/16/18 1/2“-20 3/8“-24 5/8“-16 SDS plus Hex	1/2“-20 3/8“-24
For						
Concentricity						
Clockwise rotation						
For machines without spindle stop						
Radial locking						
Impact resistant	SDS plus, 1/4“ Hex				SDS plus	
Socket	F, M	F, M	F, M	M	M	M
Automatic retightening						
Jaw	HM					
Page	1014	1016	1017	1020	1021	1023

hammer drilling

impact drilling 1/4“ hexagonal mount

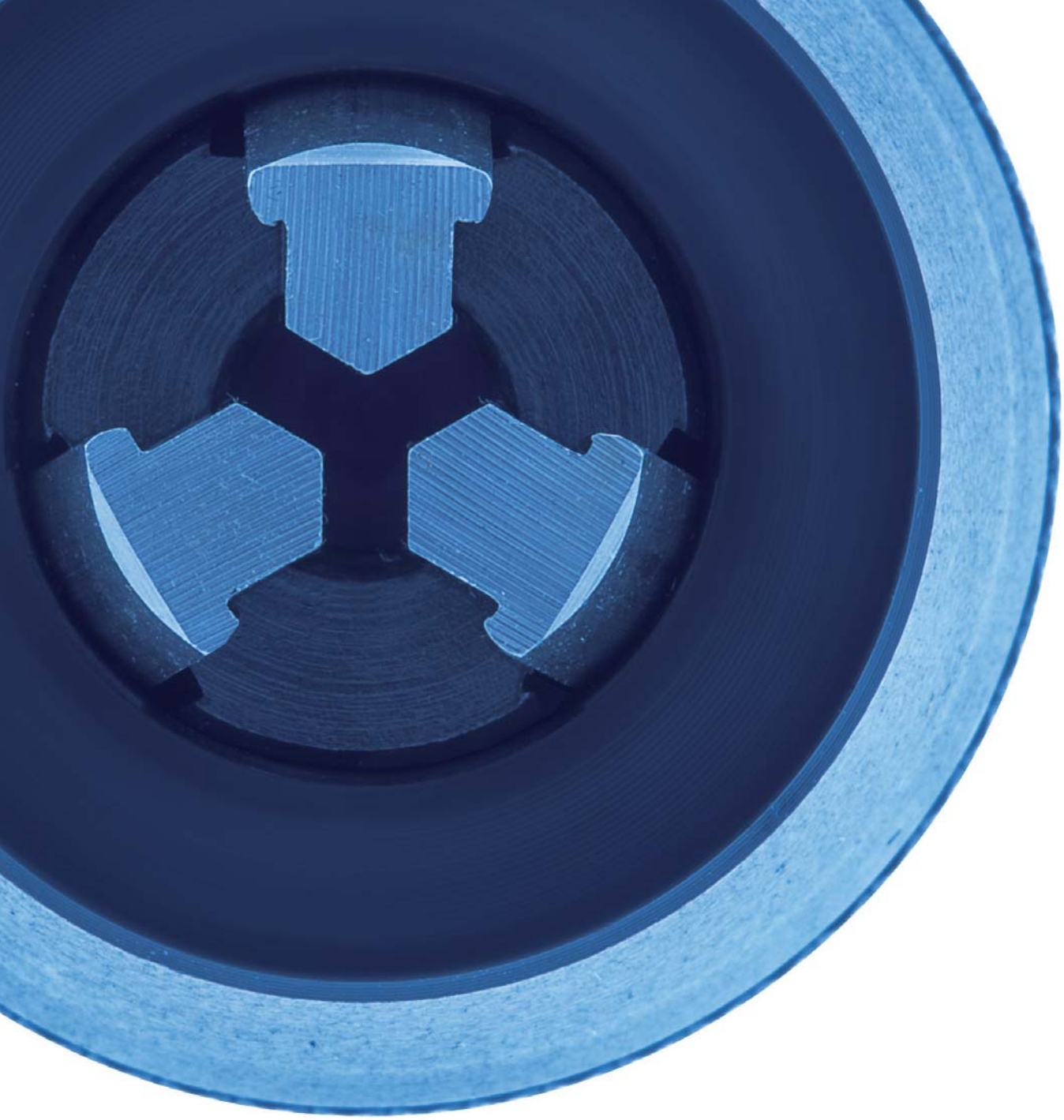
roundend jaws

jaws with carbide inserts

clockwise / counter-clockwise rotation

hammer drilling

flat jaws



SELF-CLAMPING FLAT JAW QUICK-ACTION DRILL CHUCK

The absolute highlight of the SPIRO and SUPRA drill chucks is the self-automatic reclamping. This function, in combination with the hardened flat jaws, increases the clamping force proportional to the cutting force during drilling operation. This prevents the drill from slipping, even at extreme loads.

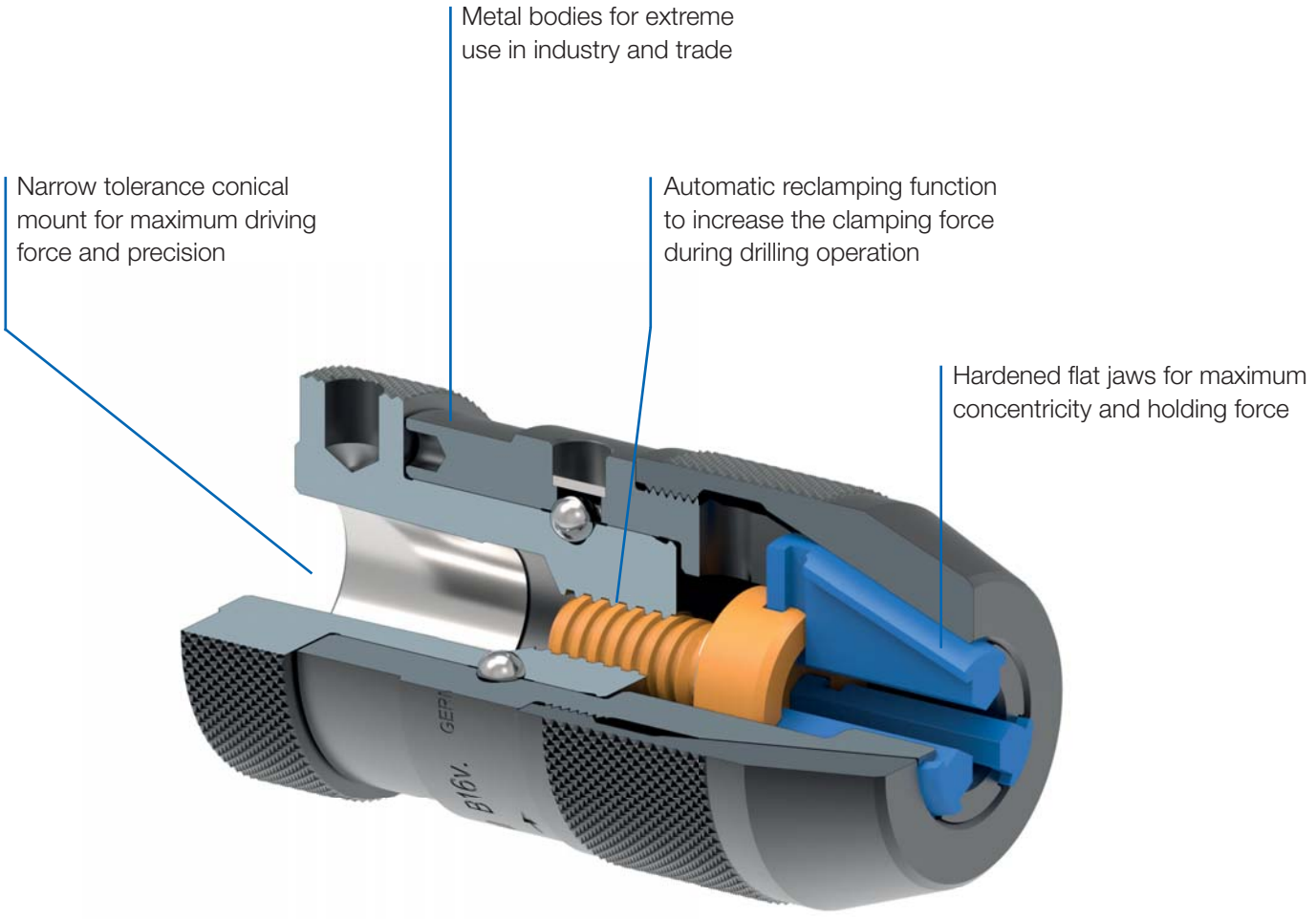
Video drill chuck

QUICK-ACTION DRILL CHUCKS INDUSTRY

The high concentricity and the hardened flat jaws are the decisive factor for these drill chucks. Without these product features, the drill is not centrically clamped, with the result that the borehole will become too large. RÖHM drill chucks guarantee precise concentricity of up to 0.05 mm.

ADVANTAGES AT A GLANCE

- Increase in the clamping force proportional to the cutting force by the automatic reclamping function
- Precise concentricity of up to 0.05 mm due to the proven flat jaw principle
- Long lifetime due to large-area clamping chamfer



SPIRO-I



APPLICATION

Especially suitable on machine tools, box column drills and drilling machines.

TYPE

Self-clamping flat jaw drill chuck with metal sleeve.
Industrial design with maximum precision.

CUSTOMER BENEFITS

- Highest concentricity of up to 0.05 mm
- Increase in the clamping force proportional to the cutting force by the automatic reclamping function
- Conical mount for maximum driving force and precision

TECHNICAL FEATURES

- Strong retaining ring
- Functional components made from steel
- Hardened and ground



A03
SPIRO-I for machine tools, box column drills and drilling machines



Item no.	Size	Type	Clamping capacity mm	Mount	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Weight g
871003	6	I	0-6,5	B 10	0,05	35	62,5	68,6	315
871004	6	I	0-6,5	B 12	0,05	35	62,5	68,6	310
871008	10	I	0-10	B 12	0,05	43	82,5	90,1	665
871009	10	I	0-10	B 16	0,05	43	82,5	90,1	650
871015	13	I	1-13	J 6	0,05	50	94	102,5	980
871012	13	I	1-13	B 16	0,05	50	94	102,5	995
871018	16	I	3-16	J 6	0,05	55	96,5	106,8	1255
871016	16	I	3-16	B 16	0,05	55	96,5	106,8	1260
871017	16	I	3-16	B 18	0,05	55	96,5	106,8	1250

SUPRA-I



APPLICATION

Especially suitable on drilling machines and hand-operated drills.
Rapid clamping and releasing of the drilling tools without key.

TYPE

Self-clamping flat jaw drill chuck with metal sleeve.
Industrial design with maximum precision.

CUSTOMER BENEFITS

- Highest concentricity of up to 0.12 mm
- Increase in the clamping force proportional to the cutting force by by the automatic reclamping function
- Light and quick clamping of tools for maximum user-friendliness

TECHNICAL FEATURES

- Strong retaining ring
- Functional components made from steel
- All wear parts are hardened and ground

A02
SUPRA-I heavy industrial version for drilling machines and hand-operated drills



Item no.	Size	Type	Clamping capacity mm	Mount	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Weight g
871020	4	I	0-4	J0	0,12	26	46,5	51,5	130
871019	4	I	0-4	B10	0,12	26	45,5	50,8	137
871025	6	I	0-6,5	3/8"-24	0,2	32	59,5	65,6	301
871024	6	I	0-6,5	J1	0,12	32	59,5	65,6	275
871022	6	I	0-6,5	B10	0,12	32	59,5	65,6	280
871023	6	I	0-6,5	B12	0,12	32	59,5	65,6	250
871033	8	I	0-8	J1	0,12	35,8	67	73,4	390
871034	8	I	0-8	3/8"-24	0,2	35,8	67	73,4	390
871031	8	I	0-8	B10	0,12	35	67	73,5	380
871032	8	I	0-8	B12	0,12	35,8	67	73,4	345
871042	10	I	0-10	J2	0,12	40,2	80,5	87,1	636
871043	10	I	0-10	J33	0,12	40,2	84	90,6	560
871045	10	I	0-10	1/2"-20	0,2	40,2	79,5	86,1	618
871044	10	I	0-10	3/8"-24	0,2	40,2	79,5	86,1	625
871040	10	I	0-10	B12	0,12	40,2	79,5	86,1	578
871041	10	I	0-10	B16	0,12	40,2	82,5	89,1	624
871055	13	I	1-13	1/2"-20	0,2	46	93	101,5	932
871052	13	I	1-13	J2	0,12	46	91	99,5	900
871054	13	I	1-13	J6	0,12	46	94	102,5	870
871051	13	I	1-13	B16	0,12	46	93	101,5	915
871053	13	I	1-13	J33	0,12	46	94	102,5	948
871066	16	I	3-16	J6	0,12	51	96,5	106,8	1120
871064	16	I	3-16	B16	0,12	51	96,5	106,8	1161
871065[1)]	16	I	3-16	B18	0,12	51	96,5	106,8	1115

[1)] shortened: B18 by 7 mm

SUPRA-S



APPLICATION

Suitable for box column drills and hand-operated drills.

TYPE

Self-clamping flat jaw drill chuck with metal sleeve.

CUSTOMER BENEFITS

- Concentricity of up to 0.17 mm
- Increase in the clamping force proportional to the cutting force by by the automatic reclamping function
- Easy and quick clamping of tools for maximum user-friendliness

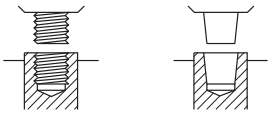
TECHNICAL FEATURES

- Strong retaining ring
- Functional components made from steel

A02

SUPRA-S light version mainly for box column drills and hand-operated drills





Item no.	Size	Type	Clamping capacity mm	Mount	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Weight g
871038	10	S	0,5-10	3/8“-24	0,25	35,8	66	73,7	370
871039	10	S	0,5-10	1/2“-20	0,25	35,8	66	73,7	377
871049	13	S	1-13	3/8“-24	0,25	40,2	76,3	83,6	610
871050	13	S	1-13	1/2“-20	0,25	40,2	76,3	83,6	548
871046	13	S	1-13	B12	0,17	40,2	78,8	86,1	593
871047	13	S	1-13	B16	0,17	40,2	82,3	89,6	581
871062	16	S	3-16	1/2“-20	0,25	46	87,5	97,5	880
871063	16	S	3-16	5/8“-16	0,25	46	87,5	97,5	865
871057	16	S	3-16	B16	0,17	46	88,5	98,5	858
871058	16	S	3-16	B18	0,17	46	92	102	875

SUPRA-SK



APPLICATION

For hand-operated percussion drills and drills up to 1300 watt with mounting thread and taper mount.

TYPE

Impact-resistant and self-clamping flat jaw drill chucks with metal sleeve. Clockwise and counterclockwise rotation with locking mechanism.

CUSTOMER BENEFITS

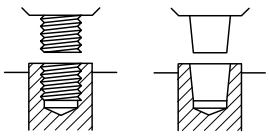
- Concentricity of up to 0.25 mm
- No re-clamping in clockwise and counterclockwise rotation by locking mechanism
- Impact-resistant for universal use

TECHNICAL FEATURES

- Strong retaining ring
- Functional components made from steel
- Hardened and ground

A02
SUPRA-SK for hand-operated percussion drills and drills up to 1300 watt





Item no.	Size	Type	Clamping capacity mm	Mount	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Weight g
249910	10	S	0,5-10	3/8"-24	0,3	40	66	73,7	428
249925	10	S	0,5-10	1/2"-20	0,3	40	66	73,7	399
305188	10	S	0,5-10	B 12	0,25	40	68	75,7	416
249804	13	S	1-13	1/2"-20	0,3	42,8	74,2	83,3	537
1261218[1)]	13	S	1-13	1/2"-20	0,3	42,8	76	83,3	537
305221	13	S	1-13	B 12	0,25	42,8	77	86,1	575
305203	13	S	1-13	B 16	0,25	42,8	80,2	89,3	585

[1)] blister packaging

SUPRA-SK E



APPLICATION

For hand-operated percussion drills and drills up to 1000 watt and cordless drills with up to 70 Nm of torque.

TYPE

Impact-resistant and self-clamping flat jaw drill chuck with metal sleeve.
Clockwise and counterclockwise rotation with locking mechanism.
For machines with and without spindle stop.

CUSTOMER BENEFITS

- Concentricity of up to 0.35 mm
- No re-clamping in clockwise and counterclockwise rotation due to locking mechanism
- Impact-resistant for universal use

TECHNICAL FEATURES

- Functional components made from steel
- Hardened and ground

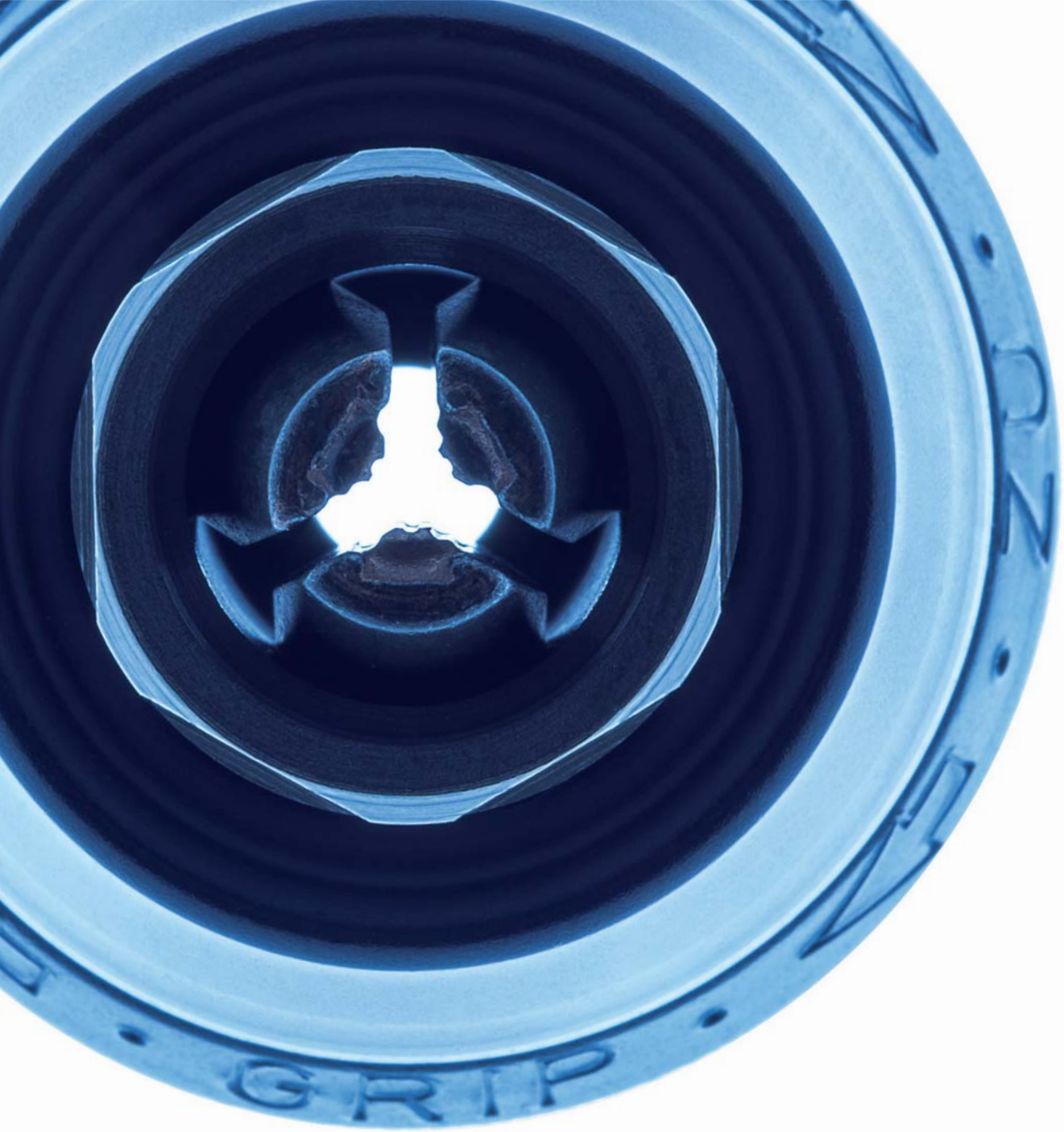
A02
SUPRA-SK E for hand-operated percussion drills and drills up to 1000 watt and cordless drills up to 70 Nm of torque



Item no.	Size	Type	Clamping capacity mm	Mount	Retaining ring	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Weight g
1193004	13	E	1,5-13	1/2"-20		0,35	42,9	72,0	79,3	375
1193005	13	E	1,5-13	1/2"-20	•	0,35	42,5	72,0	79,3	375
1261219[1)]	13	E	1,5-13	1/2"-20		0,35	42,9	72	79,3	402
1261220[1)]	13	E	1,5-13	1/2"-20	•	0,35	42,5	72	79,3	390

[1)] blister packaging

Notes



MAXIMUM USER-FRIENDLINESS

The EXTRA-RV drill chucks impress with their user-friendliness. The drill chuck is clamped and locked with a single manual operation. The radial locking device prevents the unintentional release of the drill bit during clockwise and counterclockwise rotation and makes percussion drilling possible. Thus, these quick-action drill chucks are predestined for use on hand-operated drills.

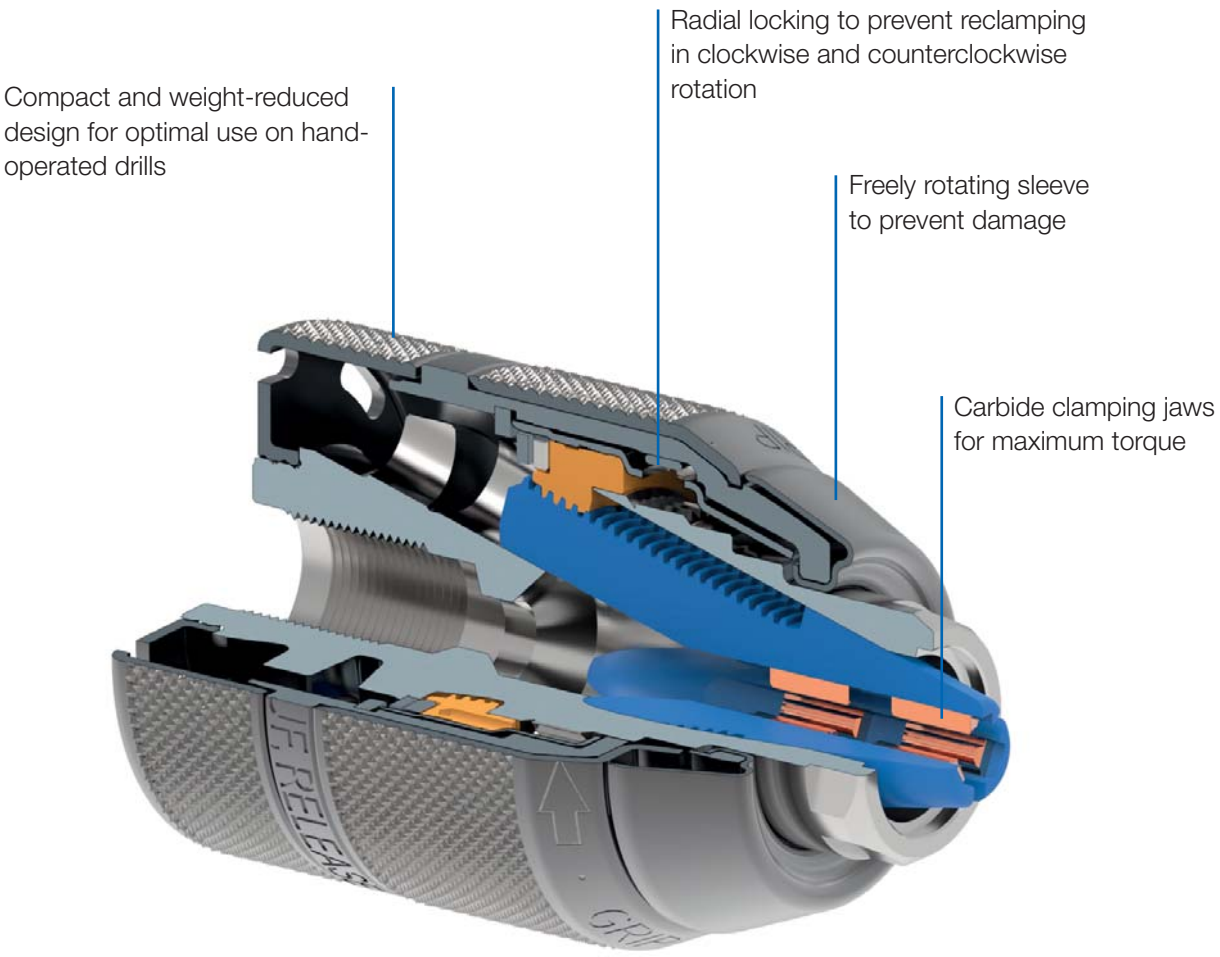
Video drill chuck

QUICK-ACTION DRILL CHUCKS

Due to the weight-reduced design as well as the easy handling, the RÖHM EXTRA-RV drill chucks are optimally suited for use on hand-operated drills. In addition, the drill chucks are impact-resistant and can therefore be used universally.

ADVANTAGES AT A GLANCE

- Easy clamping and locking with one manual operation for maximum user-friendliness
- No reclamping in clockwise or counterclockwise rotation due to radial locking
- Impact-resistant for universal use



EXTRA-RV 80



APPLICATION

For corded and cordless drills with and without spindle stop up to a maximum torque of 100 Nm and up to 1500 watt.

TYPE

Impact-resistant quick-action drill chuck with radial locking and plastic or metal sleeve.
Available in two and single sleeve design for machines with and without spindle stop.
With through-hole for clockwise and counterclockwise rotation.

CUSTOMER BENEFITS

- Easy clamping and locking with one manual operation for maximum user-friendliness
- No re-clamping in clockwise and counterclockwise rotation due to radial locking
- Impact-resistant for universal use

TECHNICAL FEATURES

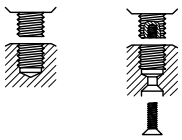
- With carbide inserts in the clamping jaws (size 13)



A01
EXTRA-RV 80 with radial locking, metal design



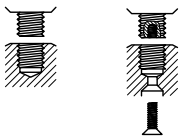
Item no.	Size	Clamping capacity mm	Mount	Retaining ring	Design	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Max. mach. capacity	Through-hole
893351	10	1-10	3/8"-24		**metal**	0,35	42,7	55	60,9	550	●
893350	10	1-10	1/2"-20		**metal**	0,35	42,7	55	60,9	550	●
1033053	10	1-10	1/2"-20	●	**metal**	0,35	42,7	55	60,9	550	●
1033051	13	1,5-13	3/8"-24	●	**metal**	0,4	42,7	64,5	72,4	1100	●
893352	13	1,5-13	1/2"-20		**metal**	0,4	42,7	64,5	72,4	1100	●
802490	13	1,5-13	1/2"-20	●	**metal**	0,4	42,7	64,5	72,4	1100	●



A01
EXTRA-RV 80 with radial locking, plastic design



Item no.	Size	Clamping capacity mm	Mount	Retaining ring	Design	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Max. mach. capacity	Through-hole
767573	10	1-10	3/8"-24		**plastic**	0,35	42,7	55	60,9	550	●
664467	10	1-10	3/8"-24	●	**plastic**	0,35	42,7	55	60,9	550	●
767651	10	1-10	1/2"-20		**plastic**	0,35	42,7	55	60,9	550	●
767639	10	1-10	1/2"-20	●	**plastic**	0,35	42,7	55	60,9	550	●
767641	13	1,5-13	3/8"-24		**plastic**	0,4	42,7	64,5	72,4	1000	●
767657	13	1,5-13	3/8"-24	●	**plastic**	0,4	42,7	64,5	72,4	1000	●
767580	13	1,5-13	1/2"-20		**plastic**	0,4	42,7	64,5	72,4	1000	●
767692	13	1,5-13	1/2"-20	●	**plastic**	0,4	42,7	64,5	72,4	1000	●



EXTRA-RV 80

A01
EXTRA-RV 80 with SDS plus mounting shank and radial locking, metal design



Item no.	Size	Clamping capacity mm	Mount	Retaining ring	Design	External Ø mm	Length opened mm	Length closed mm	Through-hole
1288566	13	1,5-13	1/2"-20 / SDS plus	●	**metal**	42,5	64,5	72,4	●

Use exclusively with hammer function deactivated



A01
EXTRA-RV 80 for impact screwdriver mounting 1/4" Hex, plastic design, specially suited for impact screwdrivers (eccentricity)



Item no.	Size	Clamping capacity mm	Mount	Retaining ring	Design	External Ø mm	Length opened mm	Length closed mm	Through-hole
1178269	10	1-10	1/4"-Hex		**plastic**	42,5	55	63,1	



EXTRA-RV 60



APPLICATION

For corded and cordless drills with spindle stop up to a maximum torque of 80 Nm and up to 1000 watt.

TYPE

Impact-resistant quick-action drill chuck with radial locking and plastic or metal sleeve.
With through-hole for clockwise and counterclockwise rotation.

CUSTOMER BENEFITS

- Easy clamping and locking with one manual operation for maximum user-friendliness
- No re-clamping in clockwise and counterclockwise rotation due to radial locking
- Impact-resistant for universal use

TECHNICAL FEATURES

- Equipped with collision protector

A01
EXTRA-RV 60 with radial locking, very compact metal design



Item no.	Size	Clamping capacity mm	Mount	Retaining ring	Design	External Ø mm	Length opened mm	Length closed mm	Through-hole
1261209[1)]	13	1,5-13	1/2“-20		**metal**	42,7	55,8	69,2	●

[1)] blister packaging

A01
EXTRA-RV 60 with radial locking, very compact plastic design



Item no.	Size	Clamping capacity mm	Mount	Retaining ring	Design	External Ø mm	Length opened mm	Length closed mm	Through-hole
1261210[1)]	13	1,5-13	1/2“-20		**plastic**	42,7	55,8	69,2	●

[1)] blister packaging

EXTRA-RV 40 - Orange Line

ORANGE LINE



APPLICATION

For corded and cordless drills with spindle stop up to a maximum torque of 60 Nm and up to 650 watt.

TYPE

Impact-resistant quick-action drill chuck with radial locking and plastic or metal sleeve.
Available in two and single sleeve design for machines with and without spindle stop.
With through-hole for clockwise and counterclockwise rotation.

CUSTOMER BENEFITS

- Easy clamping and locking with one manual operation for maximum user-friendliness
- No re-clamping in clockwise and counterclockwise rotation due to radial locking
- Impact-resistant for universal use

TECHNICAL FEATURES

- Equipped with collision protector

A01
EXTRA-RV 40 - Orange Line, **metal design,** with radial locking



Item no.	Size	Clamping capacity mm	Mount	Retaining ring	Design	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Through-hole
1261211[1)]	13	1,5-13	1/2"-20		**metal**	0,35	42,7	57	67,5	●
1261212[1)]	13	1,5-13	1/2"-20	●	**metal**	0,35	42,7	57	67,5	●

[1)] blister packaging

A01
EXTRA-RV 40 - Orange Line, **plastic design,** with radial locking



Item no.	Size	Clamping capacity mm	Mount	Retaining ring	Design	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Through-hole
1261217[1)]	10	1-10	3/8"-24	●	**plastic**	0,35	42,7	50,2	60	●
1261215[1)]	10	1-10	1/2"-20		**plastic**	0,35	42,7	50,2	60	●
1261216[1)]	10	1-10	1/2"-20	●	**plastic**	0,35	42,7	50,2	60	●
1261213[1)]	13	1,5-13	1/2"-20		**plastic**	0,35	42,7	57	67,5	●
1261214[1)]	13	1,5-13	1/2"-20	●	**plastic**	0,35	42,7	57	67,5	●

[1)] blister packaging

UNIVERSALLY APPLICABLE

Key-type drill chucks are the all-round talents among drill chucks. In stationary box column drills, hand-operated corded and cordless drills, the drill chucks perform in every way.





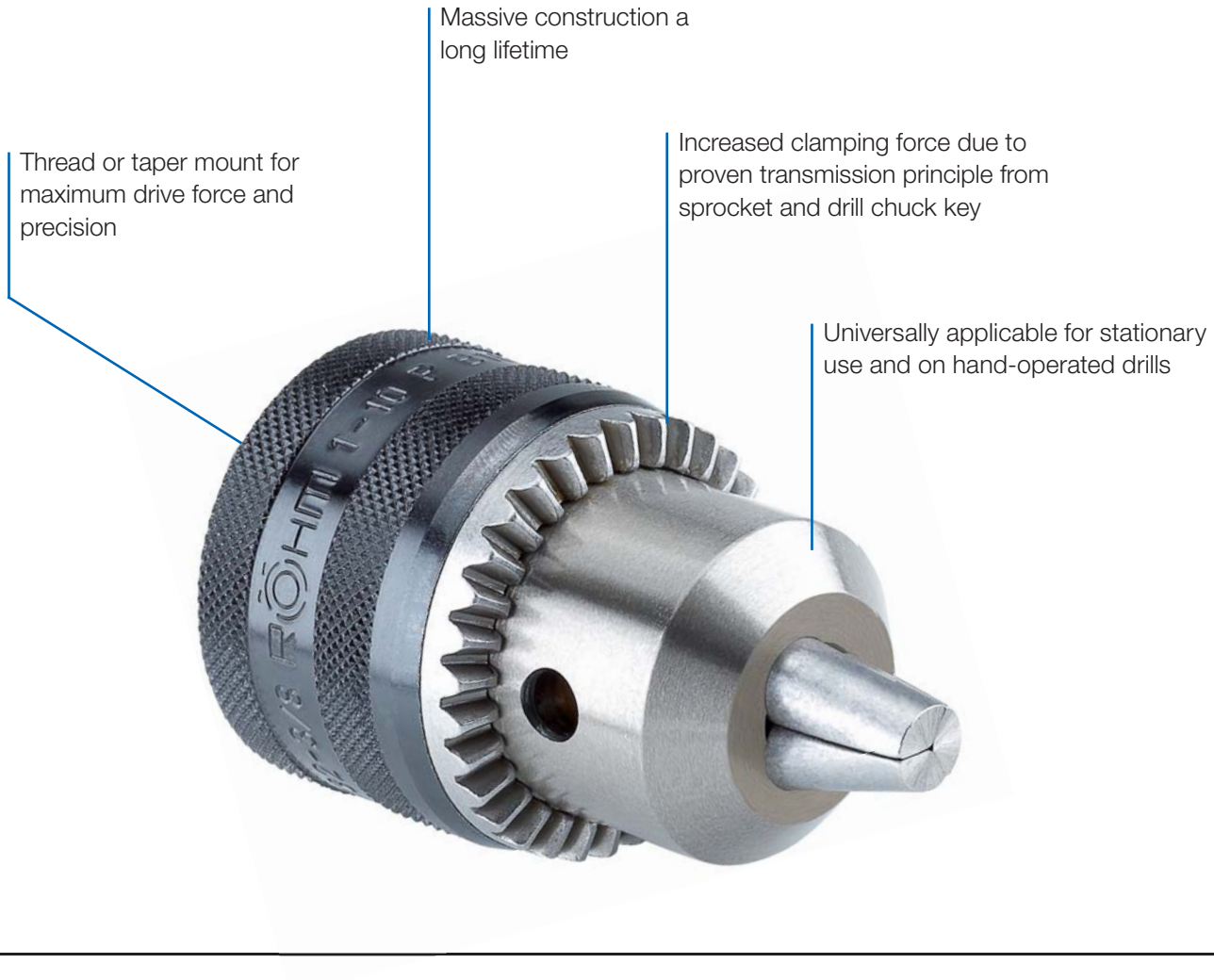
Video drill chuck

KEY-TYPE DRILL CHUCKS

Key-type drill chucks from RÖHM convince with their universal applicability. These drill chucks have proven themselves over decades on stationary box column drills, machine tools, as well as on hand-operated corded and cordless drills.

ADVANTAGES AT A GLANCE

- Universally applicable for stationary use and on hand-operated drills
- High concentricity of up to 0.15 mm due to massive construction
- Increased clamping force due to proven transmission principle by means of drill chuck key



Key-type drill chucks

PRIMA-I



APPLICATION

For universal use on stationary box column drills as well as machine tools.

TYPE

Impact-resistant key-type drill chuck with key. Conical/threaded mount in acc. with DIN ISO 10887 (toothing in acc. with DIN 6349).
With through-hole for clockwise and counterclockwise rotation.
Industrial design with maximum precision.

CUSTOMER BENEFITS

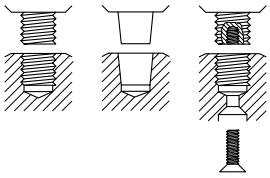
- High concentricity of up to 0.15 mm
- Increased clamping force due to proven transmission principle by means of drill chuck key

TECHNICAL FEATURES

- Hardened keyholes and clamping prisms

A01
PRIMA-I heavy industrial version used on stationary box column drills as well as machine tools





Item no.	Size	Type	Clamping capacity mm	Mount	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Key size
072810	6	I	0,5-6,5	J1	0,15	29,5	42,5	52,5	S1
245548	6	I	0,5-6,5	B12	0,15	29,5	47,5	57,5	S1
072687	10	I	1-10	B16	0,2	42,8	63	77	S2 A
072693	10	I	1-10	J2	0,2	42,8	59	75,5	S2 A
072818	13	I	1-13	J6	0,2	52	67,5	86	S3
072819	13	I	1-13	J33	0,2	52	67,5	86	S3
072820	13	I	1-13	5/8"-16	0,25	52	68,5	87,5	S3
072825	16	I	1-16	B18	0,2	56,5	79	98	S3
072827	16	I	1-16	J3	0,2	56,5	79	98	S3
072828	16	I	1-16	J6	0,2	56,5	79	98	S3
072829	16	I	1-16	5/8"-16	0,2	56,5	80	100,5	S3
072831	20	I	5-20	B22	0,25	65	92,5	113,5	S4
072833	20	I	5-20	J3	0,25	65	82,5	103,5	S4
072834[1)]	26	I	5-26	B24	0,25	80	120	147	S4

[1)] with driver

PRIMA-S / -M



APPLICATION

For universal use on stationary box column drills as well as hand-operated corded and cordless drills.

TYPE

Impact-resistant key-type drill chuck with key. Conical/threaded mount in acc. with DIN ISO 10887 (toothing in acc. with DIN 6349).
With through-hole for clockwise and counterclockwise rotation.
Medium-heavy design with metal sleeve.

CUSTOMER BENEFITS

- High concentricity of up to 0.2 mm
- Increased clamping force due to proven transmission principle by means of drill chuck key

TECHNICAL FEATURES

- Hardened keyholes and clamping prisms



A01
PRIMA-S / -M slight intermediate sizes, primarily for hand-operated percussion drilling machines



Item no.	Size	Type	Clamping capacity mm	Mount	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Key size
072811	6	M	0,5-6,5	3/8"-24	0,2	29,5	42,5	53	S1
245586	6	M	0,5-6,5	B10	0,2	29,5	43	53	S1
245485	8	M	0,5-8	B10	0,23	29,5	43	53	S1
245550	8	M	0,5-8	B12	0,23	29,5	47,5	57,5	S1
245552	8	M	0,5-8	3/8"-24	0,28	29,5	42,5	53	S1
245553	8	M	0,5-8	1/2"-20	0,28	29,5	45	55,5	S1
072653	10	S	0,8-10	B12	0,23	34,5	50	60,5	S2 A
317255[1]	10	S	0,8-10	3/8"-24	0,28	34,5	49,5	61	S2 A
317256[1]	10	S	0,8-10	1/2"-20	0,28	34,5	49,5	61	S2 A
1261221[2]	10	S	1-10	3/8"-24	0,005	34	50	60	S2
1261222[2]	10	S	1-10	1/2"-20	0,005	34,5	49,5	61	S2 A
1261223[2]	13	S	1,5-13	1/2"-20	0,005	42,4	59	74	S2 A
064527	13	S	1,5-13	3/8"-24	0,28	42,8	59	74	S2 A
072800	13	S	1,5-13	B16	0,25	42,8	63	77	S2 A
072897	13	S	1,5-13	B12	0,25	42,8	58	72	S2 A
317257[1]	13	S	1,5-13	1/2"-20	0,28	42,8	59	74	S2 A
1261224[2]	16	M	3-16	1/2"-20	0,03	50	68,5	87,5	S3
1154662	16	S	3-16	1/2"-20	0,35	50	68,5	87,5	S3
1154663	16	S	3-16	5/8"-16	0,35	50	87,5	68,5	S3
1154664	16	S	3-16	B 16	0,35	50	86,5	67,5	S3
1154665	16	S	3-16	B 18	0,35	50	75,5	94,7	S3

[1] drilled-through for clockwise and counterclockwise rotating drilling and percussion drilling machines M5 or M6
[2] blister packaging

A01
PRIMA 6L for impact drivers mounting 1/4" Hex



Item no.	Size	Type	Clamping capacity mm	Mount	External Ø mm	Length opened mm	Length closed mm	Key size
368292	6	L	0,5-6,5	1/4" Hex	29,3	42,5	53	S14

For clockwise and counterclockwise rotation
Only with switched-off impact function



PRIMA

A01
HBF hammer drill chuck with SDS plus adapter



Item no.	Size	Type	Clamping capacity mm	Mount	External Ø mm	Length opened mm	Length closed mm	Key size
600581	13	HBF	2,5-13	SDS plus	42,9	68	81,5	S2A

With carbide inserts in the clamping jaws
Chuck end play for transmitting the entire impact onto the drill
For clockwise and counterclockwise rotation.

SDS plus HM

A01
PRIMA with SDS plus adapter



Item no.	Clamping capacity mm	Mount	External Ø mm	Length opened mm	Length closed mm	Key size
1288568	1,5-13	1/2"-20 / SDS plus	42,9	74	59	S2A

Only with switched-off impact function

SDS plus

PRIMA-L - Orange Line

ORANGE LINE



APPLICATION

For universal use on do-it-yourself drills.

TYPE

Impact-resistant drill chuck with key and threaded mount in acc. with DIN ISO 10887 (toothin in acc. with DIN 6349).
With through-hole for clockwise and counterclockwise rotation.
Lightweight version with metal sleeve.

CUSTOMER BENEFITS

- High concentricity of up to 0.35 mm
- Increased clamping force due to proven transmission principle by means of drill chuck key

TECHNICAL FEATURES

- Hardened clamping prisms



A01
PRIMA-L - Orange Line

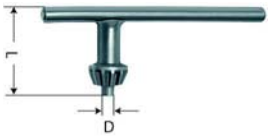


Item no.	Size	Clamping capacity mm	Mount	Concentricity deviation max. mm	External Ø mm	Length opened mm	Length closed mm	Key size
1261225[1)]	10	1-10	1/2"-20	0,35	33,5	49,5	61,5	S2 A
1261226[1)]	10	1-10	3/8"-24	0,35	33,5	49,5	61,5	S2 A
1261227[1)]	13	1,5-13	1/2"-20	0,35	42,5	59	74,5	S2 A
1261228[1)]	13	1,5-13	3/8"-24	0,35	42,5	59	74,5	S2 A

[1)] blister packaging

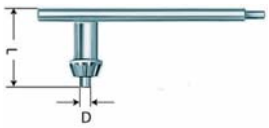
Drill chuck keys BFS

A01
Keys with **DIN toothing 6349** for key-type drill chucks



Item no.	Size	D mm	L mm	Weight g
026411	S1	4	30	25
205989	S2 A	6	41	50
025835	S3	8	50	100
025839	S4	9	55	115

A01
Keys with **DIN toothing 6349** for key-type drill chucks



Item no.	Size	D mm	L mm	Weight g
309380	S2 AT	6	42	50
309382	S 3T	8	51	90

A01
Key with **Jacobs-toothing**



Item no.	Size	D mm	L mm	Weight g
307319	S14	6,1	30	50

Tapping chucks GSF

A03
GSF without locking pin



Item no.	Size	Mount	Square clamping width mm	For taps	External Ø mm	Key	Set of jaws
319605	9	B10	3-9	M 3,5-14	28	**026416**	**309341**
303081	9	B12	3-9	M 3,5-14	28	**026416**	**309341**

A03
GSF with locking pin for an additional lock of the cone

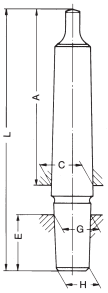


Item no.	Size	Mount	Square clamping width mm	For taps	External Ø mm	Key	Set of jaws
307158	9	B12	3-9	M 3,5-14	28	**026416**	**309341**

Taper shank arbors KD

A04
Taper shank arbors with drill chuck taper DIN 238 completely hardened and ground



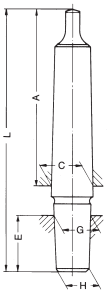


Item no.	Morse taper DIN 228 B	Hole for alignment pin	L mm	A mm	C mm	E mm	G mm	H mm	Weight g
014897	1	B10	86	62	12,065	14,5	10,095	9,4	55
014898	1	B12	89	62	12,065	18,5	12,065	11,1	65
014899	1	B16	97	62	12,065	24	15,733	14,5	90
014900	1	B18	106	62	12,065	32	17,78	16,2	110
018755[1)]	1	B18	97	62	12,065	25	17,431	16,2	95
014904	2	B10	103,5	75	17,78	14,5	10,095	9,4	130
014905	2	B12	106,5	75	17,78	18,5	12,065	11,1	135
014906	2	B16	110,5	75	17,78	24	15,733	14,5	160
014907	2	B18	117,5	75	17,78	32	17,78	16,2	180
018756[1)]	2	B18	108,5	75	17,78	25	17,431	16,2	165
014908	2	B22	128,5	75	17,78	40,5	21,793	19,8	245
014911	3	B12	125	94	23,825	18,5	12,065	11,1	280
014912	3	B16	134	94	23,825	24	15,733	14,5	310
014913	3	B18	141	94	23,825	32	17,78	16,2	320
018757[1)]	3	B18	132	94	23,825	25	17,431	16,2	320
014914	3	B22	147	94	23,825	40,5	21,793	19,8	390
014915	3	B24	158	94	23,825	50,5	23,825	21,3	440
014916	4	B16	159	117,5	31,267	24	15,733	14,5	625
014917	4	B18	168	117,5	31,267	32	17,78	16,2	660
018758[1)]	4	B18	159	117,5	31,267	25	17,431	16,2	640
014918	4	B22	176	117,5	31,267	40,5	21,793	19,8	715
014919	4	B24	185	117,5	31,267	50,5	23,825	21,3	770
014920	5	B16	196	149,5	44,399	24	15,733	14,5	1600
014921	5	B18	204,5	149,5	44,399	32	17,78	16,2	1600
018759[1)]	5	B18	195,5	149,5	44,399	25	17,431	16,2	1560
014922	5	B22	213,5	149,5	44,399	40,5	21,793	19,8	1650
014923	5	B24	224,5	149,5	44,399	50,5	23,825	21,3	1700

[1)] for SUPRA and SPIRO with shortened pick up taper
Taper shank arbors with tapped shank (type 238) or cylindrical shank type (type 237) on request

A04
Taper shank arbors with Jacobs drill chuck taper completely hardened and ground





Item no.	Morse taper DIN 228 B	Hole for alignment pin	L mm	A mm	C mm	E mm	G mm	H mm	Weight g
014970	1	J1	86,5	62	12,065	16,7	9,754	8,5	50
014971	1	J2	92	62	12,065	22,2	14,199	12,4	70
014972	1	J3	101	62	12,065	31	20,599	19	50
014974	1	J6	95	62	12,065	25,4	17,17	15,9	50
014976	2	J1	101	75	17,78	16,7	9,754	8,5	130
014977	2	J2	106,5	75	17,78	22,2	14,199	12,4	160
014978	2	J3	115,5	75	17,78	31	20,599	19	200
014980	2	J33	109,5	75	17,78	25,4	15,85	14,2	160
014981	2	J6	109,5	75	17,78	25,4	17,17	15,9	165
014983	3	J2	126	94	23,825	22,2	14,199	12,4	310
014984	3	J3	135	94	23,825	31	20,599	19	350
014987	3	J33	129	94	23,825	25,4	15,85	14,2	310
014988	3	J6	129	94	23,825	25,4	17,17	15,9	310
014991	4	J3	161	117,5	31,267	31	20,599	19	475
014995	4	J6	155	117,5	31,267	25,4	17,17	15,9	620

Reducing sleeves RH

A05
Precision version DIN 2185 completely hardened, ground internal and external



Item no.	External taper MT	Internal taper MT	L mm	Weight approx. g
017017	1	0	80	30
017018	2	1	92	95
017019	3	1	99	250
017020	3	2	112	190
017021	4	1	124	550
017022	4	2	124	480
017023	4	3	140	360
017024	5	1	156	1700
017025	5	2	156	1520
017026	5	3	156	1360
017027	5	4	171	950
017028	6	2	218	4300
017029	6	3	218	4100
017030	6	4	218	3600
017031	6	5	218	2550

A05
Taper drift



Item no.	For MT	Length mm	Weight g
017075	0	90	14
017076	1+2	140	70
017077	3	190	150
017078	4	225	310
017079	5+6	265	650

A05
Taper drift for one-hand-operation



Item no.	For MT	Length mm	Weight g
317236	1-3	320	320
317258	4-6	380	520

Extensions sleeves VLH

A05
Precision version DIN 2187 completely hardened, ground internal and external



Item no.	External taper MT	Internal taper MT	D mm	L1 mm	L2 mm	Weight g
029122	1	1	20	145	83	190
029123	1	2	30	160	98	340
029124	2	1	20	160	85	250
029125	2	2	30	175	100	400
029126	2	3	36	196	121	840
029127	3	1	20	175	81	400
029128	3	2	30	194	100	550
029129	3	3	36	215	121	1000
029130	3	4	48	240	146	1500
029131	4	1	20	200	82,5	800
029132	4	2	30	215	97,5	850
029133	4	3	36	240	122,5	1300
029134	4	4	48	265	147,5	1900
029135	4	5	63	300	182,5	3310
029136	5	1	20	232	82,5	1800
029137	5	2	30	247	97,5	1900
029138	5	3	36	268	118,5	2150
029139	5	4	48	300	150,5	2750
029140	5	5	63	335	185,5	4200
029141	6	4	48	355	145	5420
029142	6	5	63	390	180	6750

Drill and reamer extensions BV

A05
Precision version completely hardened, ground internal and external



Item no.	External taper MT	Internal taper MT	D mm	L1 mm	L2 mm	Weight approx. g
029143	1	1	20	200	138	250
029144	1	1	20	250	188	375
029145	1	1	20	300	238	500
029146	1	1	20	350	288	625
029147	1	1	20	400	338	750
029148	1	1	20	450	388	875
029149	1	1	20	500	438	1000
029150	2	2	25	200	125	430
029151	2	2	25	250	175	625
029152	2	2	25	300	225	820
029153	2	2	25	350	275	1015
029154	2	2	25	400	325	1200
029155	2	2	25	450	375	1400
029156	2	2	25	500	425	1600
029157	2	2	25	600	525	1800
029158	3	3	32	250	156	1000
029159	3	3	32	300	206	1300
029160	3	3	32	350	256	1550
029161	3	3	32	400	306	1850
029162	3	3	32	450	356	2100
029163	3	3	32	500	406	2400
029164	3	3	32	600	506	2700
029165	4	4	40	300	182,5	1650
029166	4	4	40	350	232,5	2150
029167	4	4	40	400	282,5	2650
029168	4	4	40	450	332,5	3100
029169	4	4	40	500	382,5	3600
029170	4	4	40	600	482,5	4200

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LIVE CENTRES
FACE DRIVERS

2015/2016

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

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

Dynamism
Variety
Security
Partnership
Globality
Innovation

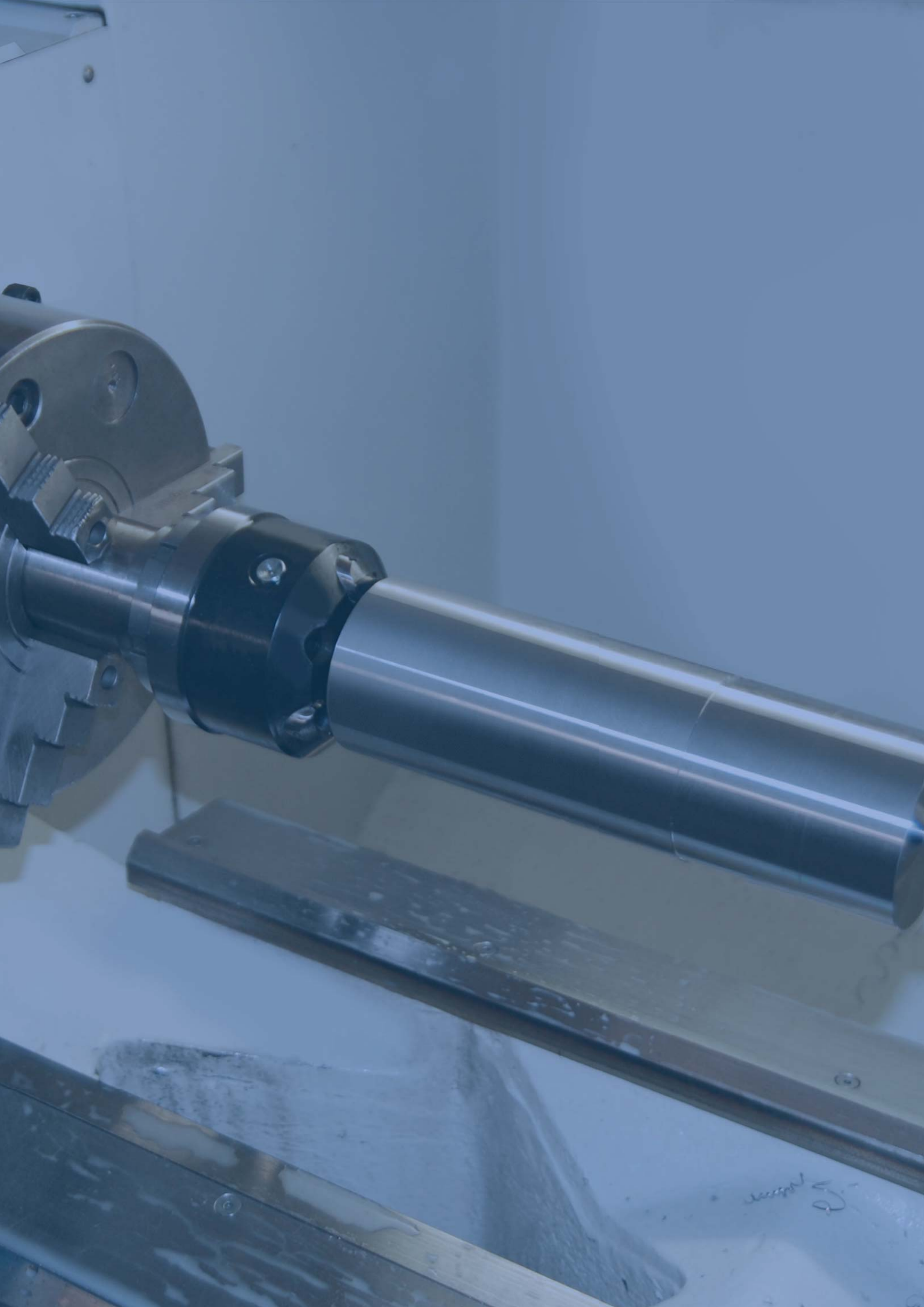




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Errors and corrections are reserved!

Operation guide





PRO	HM Pro Carbide insert						HMG Pro With carbide insert and draw-off nut					
Size MT	2	3	3	4	5	6	2	3	3	4	5	6
Workpiece weight max. (kg)	120	240	360	500	1000	1800	120	240	360	500	1000	1800
Concentricity deviation max. (mm)	0,005					0,01	0,005					0,01
Speed max min^{-1}	7000	6300	5000	3800	3000	2600	7000	6300	5000	3800	3000	2600
Page	2008						2009					





PRO	H Pro Standard design										HG Pro Standard design with draw-off nut					
Size MT	0	1	2	3	3	4	5	6	6	Metr.80	2	3	3	4	5	6
Workpiece weight max. (kg)	10	100	200	400	500	800	2000	3500	5000	7500	200	400	500	800	2000	3500
Concentricity deviation max. (mm)	0,01	0,005						0,008	0,01	0,015	0,005					0,008
Speed max min^{-1}	15000	7000	7000	6300	5000	3800	3000	2600	1500	1500	7000	6300	5000	3800	3000	2600
Page	2010										2011					





PRO	HZA Pro Cylindrical shank			HP Pro High precision design				
Size ZA / MT	ZA 20	ZA 25	ZA 32	2	3	4	5	6
Workpiece weight max. (kg)	130	200	400	200	500	800	2000	3500
Concentricity deviation max. (mm)	0,005			0,003				
Speed max min^{-1}	7000	5000	3800	7000	5000	3800	3000	2600
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PRO & ORANGE LINE	HVL Pro Extended centre point						HVLN Pro Extended centre point, profiled				Orange Line Orange Line		
Size MT	1	2	3	4	5	6	2	3	4	5	3	4	5
Workpiece weight max. (kg)	80	140	400	500	1200	2500	100	150	180	280	300	500	630
Concentricity deviation max. (mm)	0,01	0,005				0,01	0,005				0,005		
Speed max min^{-1}	7000	7000	5000	3800	3000	2600	7000	5000	3800	3000	8500	6000	4500
Page	2014						2015				2016		

Operation guide





HEAVY SPEED	Heavy Standard design			Heavy Standard design with draw-off nut			Speed Extended centre point, with carbide insert			
Size MT	4	5	6	4	5	6	2	3	4	5
Workpiece weight max. (kg)	1000	2000	3000	1000	2000	3000	100	100	250	250
Concentricity deviation max. (mm)	0,005			0,005			0,01			
Speed max min^{-1}	7000	6000	4800	7000	6000	4800	12000	12000	9000	9000
Page	2017			2018			2019			





SLIM	Slim Standard design					Slim Extended centre point					Slim Extended centre point, profiled			
Size MT	2	3	4	5	6	2	3	4	5	6	2	3	4	5
Workpiece weight max. (kg)	200	400	800	1600	3500	170	340	700	1400	3000	50	100	150	180
Concentricity deviation max. (mm)	0,005			0,01	0,02	0,008			0,01	0,02	0,008			0,01
Speed max min^{-1}	7000	7000	6300	4300	3000	7000	7000	6300	4300	3000	7000	7000	6300	4300
Page	2020					2021					2022			





CONTROL FLEX	AC Control Standard design				AC-VL Control Extended centre point				Flex Interchangeable inserts					
Size MT	3	4	5	6	3	4	5	6	2	3	3	4	5	6
Workpiece weight max. (kg)	400	800	1600	3200	260	550	1100	2500	40	130	150	250	650	900
Concentricity deviation max. (mm)	0,01			0,015	0,01			0,015	0,01					0,015
Speed max min^{-1}	4000	3500	2500	1800	4000	3500	2500	1800	7000	6300	5000	3800	3000	2600
Page	2023				2024				2025					

Operation guide



MZK	Revolving centering tapers Pointed				
Size MT	2	3	4	5	6
Workpiece weight max. (kg)	200	400	800	1600	2500
Concentricity deviation max. (mm)	0,01	0,008			
Speed max min^{-1}	6000	6000	4000	4000	2500
Page	2030				



MZK	Revolving centering tapers Cone truncated, 60 °						
Size MT	2	2	3	3	4	4	5
Workpiece weight max. (kg)	200	300	400	600	400	800	800
Concentricity deviation max. (mm)	0,008						
Speed max min^{-1}	6000	5000	5000	4000	5000	4000	4000
Page	2030						



MZK	Revolving centering tapers Cone truncated, 75 °											
Size MT	2	3	3	4	4	4	5	5	5	6	6	6
Workpiece weight max. (kg)	300	400	600	400	800	1200	800	1600	2000	1600	2000	4000
Concentricity deviation max. (mm)	0,008					0,01	0,008	0,01				0,015
Speed max min^{-1}	5000	5000	4000	5000	4000	2800	4000	2800	2200	2800	2200	1200
Page	2030											







MZK	Revolving centering tapers with interchangeable inserts			Revolving centering tapers with interchangeable inserts and draw-off nut			Fixed shafts with interchangeable inserts		
Size MT	4	5	6	4	5	6	4	5	6
Workpiece weight max. (kg)	800	1600	3000	1000	2000	3500	2000	4800	12000
Concentricity deviation max. (mm)	0,005			0,005			0,003		
Speed max min^{-1}	3800	3000	2600	7000	6000	4800	-	-	-
Page	2031			2031			2031		

Operation guide





FZS	Dead centres With full carbide tip				Dead centres Full point, carbide insert and regrinding line			
Size MT	2	3	4	5	2	3	4	5
Concentricity deviation max. (mm)	0,005				0,005			
Page	2034				2034			



FZS	Dead centres Full point						
Size MT	0	1	2	3	4	5	6
Concentricity deviation max. (mm)	0,005						
Page	2034						





FZS	Dead centres Full point, draw-off nut and SW				Dead centres Full point, draw-off nut, SW and extended point			
Size MT	3	4	5	6	3	4	5	6
Concentricity deviation max. (mm)	0,005				0,005			
Page	2035				2035			



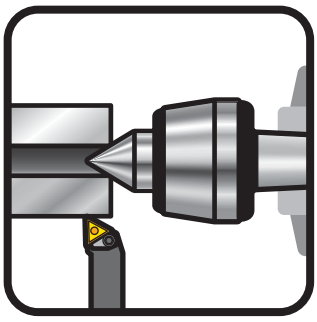


FZS	Dead centres Half point with carbide insert				Dead centres Half point			
Size MT	2	3	4	5	2	3	4	5
Concentricity deviation max. (mm)	0,005				0,01			
Page	2035				2035			

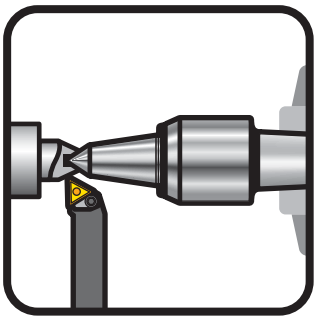
Dead centres in high precision design on request.



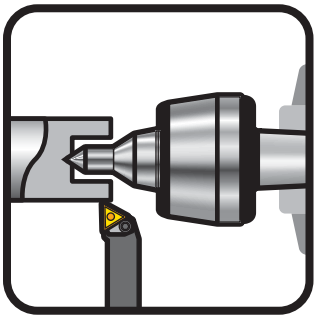
THE RIGHT LIVE CENTRE FOR EVERY APPLICATION



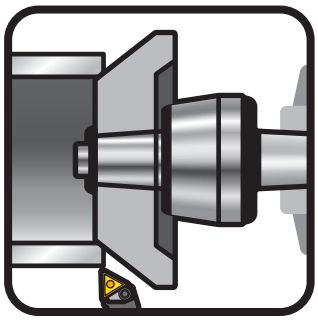
For small and large centres



For cramped work area



For lower-lying centres



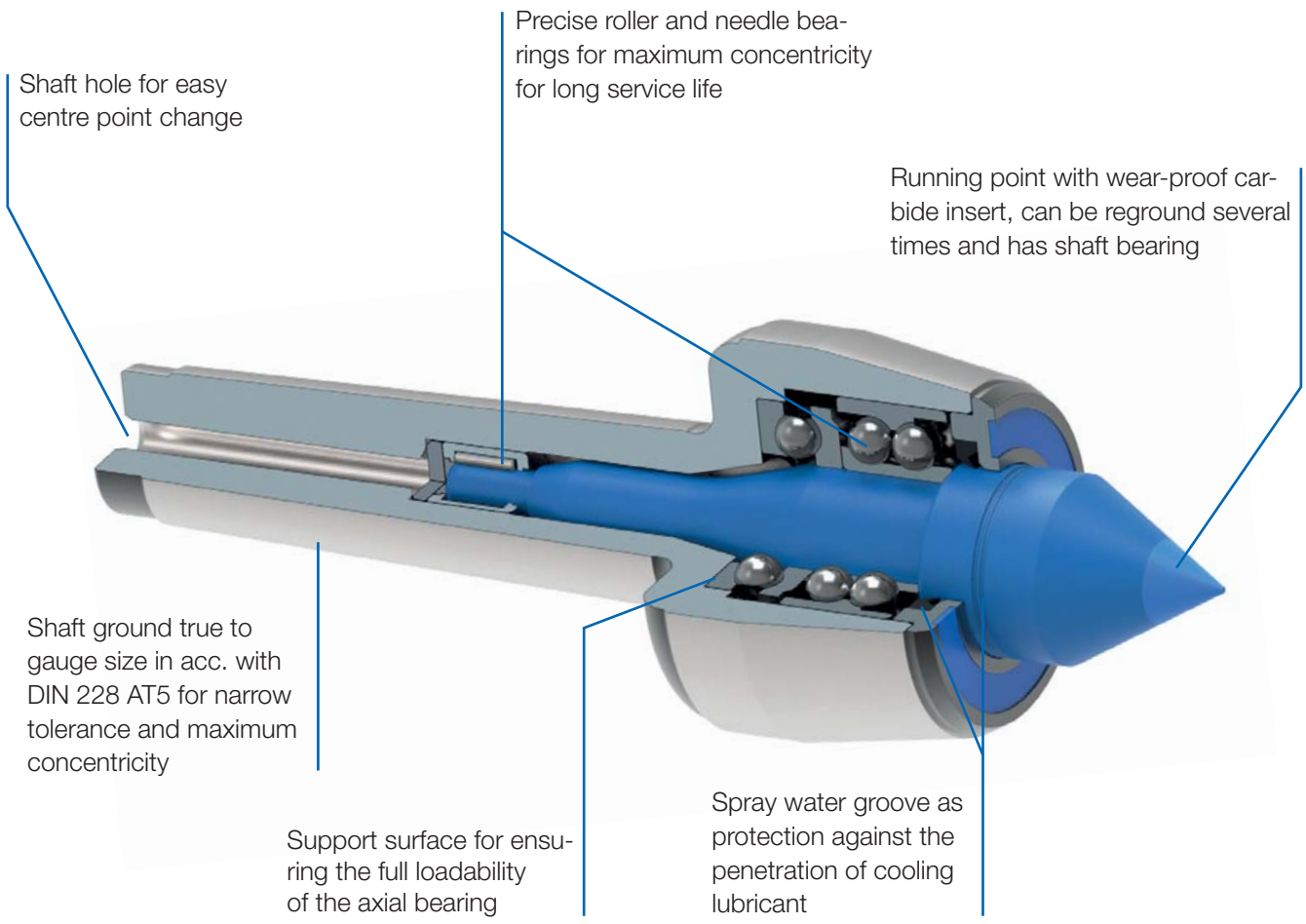
For large boreholes

LIVE CENTRES

The requirement for high cutting capacities and high working precision demands an additional support by a revolving live centre for many workpieces due to their shape and length. Thanks to their precision bearings, RÖHM live centres offer optimal force absorption and a maximum concentricity deviation of up to 0.003 mm. Thanks to the lifetime lubrication, the centre points are maintenance-free.

ADVANTAGES AT A GLANCE

- Maximum concentricity and optimal force absorption thanks to proven precision bearings
- Special lubrication for long service life and little required maintenance
- Minimum interference contour thanks to slender housing shape



Pro - carbide insert



APPLICATION

For counter-clamping workpieces on turning and grinding machines.

TYPE

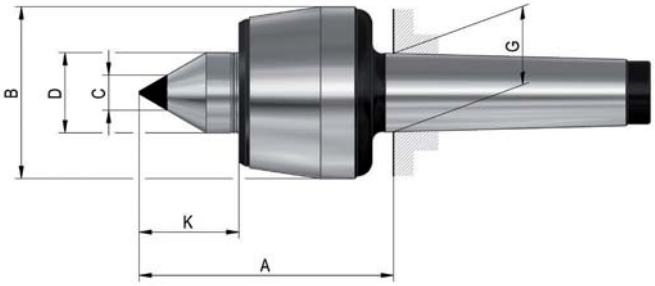
Centre point with wear-proof carbide insert.

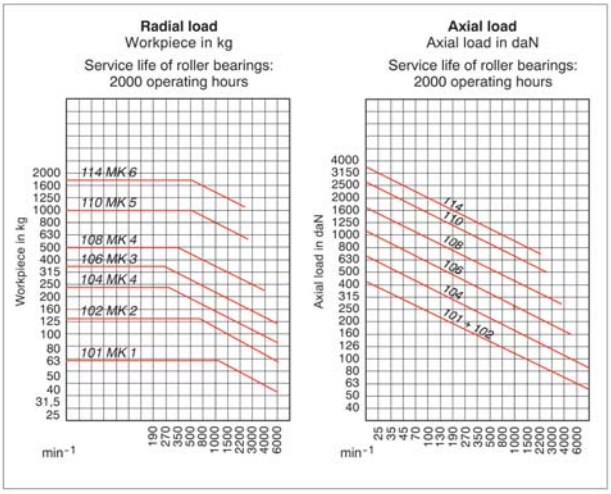
CUSTOMER BENEFITS

- Maximum service life and wear resistance thanks to carbide insert
- High concentricity and stability thanks to 3-fold bearing
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
HM Pro **with carbide insert,** body hardened and ground - tip angle 60°

Item no.	032140	090089	237413	093306	221016	221017
Mount MT	2	3	3	4	5	6
Size	102	104	106	108	110	114
A mm	65	70,5	79,5	102,5	129	152
B mm	43	48,5	58,5	68,5	88,5	102,5
C mm	11	11	14	14	18	18
D mm	20	22	25	32	40	50
G mm	17,78	23,825	23,825	31,267	44,399	63,348
K mm	24	27	30,5	40	49,5	57
Weight approx. g	600	900	1300	2300	4700	10000
Workpiece weight max. kg	120	240	360	500	1000	1800
Concentricity deviation max. mm	0,005	0,005	0,005	0,005	0,005	0,01
Speed max. min^{-1}	7000	6300	5000	3800	3000	2600
Spare live centres	**1241742**	**1241743**	**1241744**	**1241745**	**1241746**	**1241747**

▲ on request

Pro - carbide insert



APPLICATION

For counter-clamping workpieces on turning and grinding machines.

TYPE

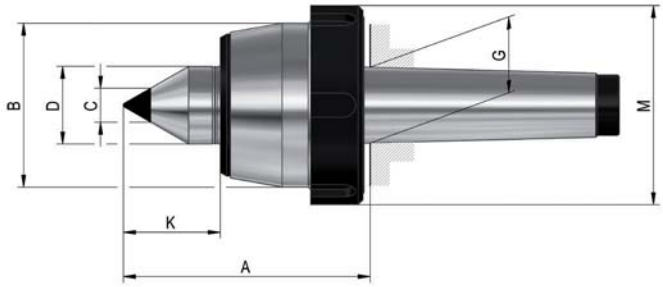
Centre point with wear-proof carbide insert.
With draw-off nut.

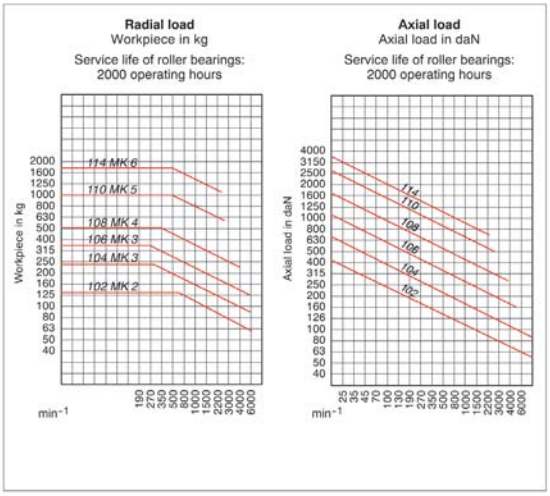
CUSTOMER BENEFITS

- Maximum service life and wear resistance thanks to carbide insert
- High concentricity and stability thanks to 3-fold bearing
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
HMG Pro **with draw-off nut and carbide insert,** body hardened and ground - tip angle 60°

Item no.	221021	221022	221023	221024	221025	221026
Mount MT	2	3	3	4	5	6
Size	102	104	106	108	110	114
A mm	65	70,5	79,5	102,5	129	152
B mm	45	50	60	70	90	105
C mm	11	11	14	14	18	18
D mm	20	22	25	32	40	50
G mm	17,78	23,825	23,825	31,265	44,399	63,348
K mm	24	27	30,5	40	49,5	57
M mm	56	62	74	82	105	120
Weight approx. g	600	1000	1400	2400	5200	10500
Workpiece weight max. kg	120	240	360	500	1000	1800
Concentricity deviation max. mm	0,005	0,005	0,005	0,005	0,005	0,01
Speed max. min⁻¹	7000	6300	5000	3800	3000	2600
Spare live centres	**1241742**	**1241743**	**1241744**	**1241745**	**1241746**	**1241747**

▲ on request

Pro - standard design



APPLICATION

For counter-clamping workpieces on turning and grinding machines.

TYPE

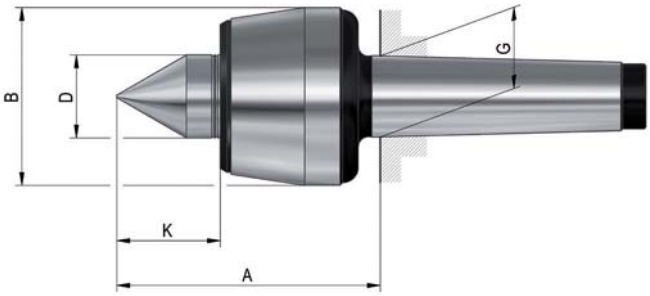
All-round live centre in classical design for nearly any standard clamping situation.

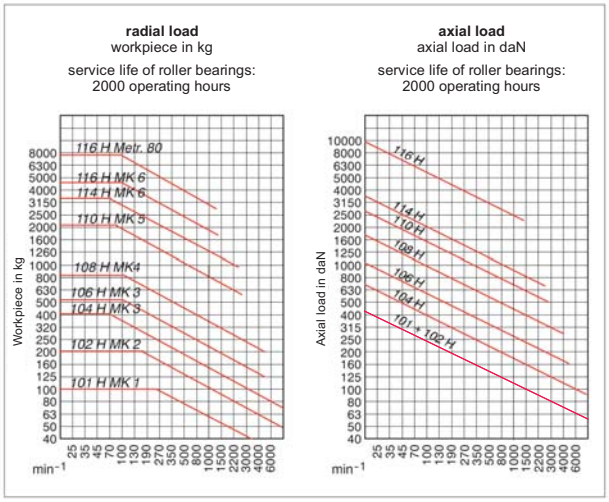
CUSTOMER BENEFITS

- Proven 3-fold bearing for high axial and radial load
- Lifetime lubrication for minimum required maintenance
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES-

- Body hardened and ground (MT 1 - Metr. 80)
- Tip angle 60°





A06
H Pro, **body hardened and ground** - tip angle 60°

Item no.	061740[1)]	043400	043115	042315	042776	042175	042843	043532	093439	093440
Mount MT	0	1	2	3	3	4	5	6	6	Metr. 80
Size	100	101	102	104	106	108	110	114	116	116
A mm	44	60,5	65	70,5	79,5	102,5	129	152	196	196
B mm	25	34,5	43	48,5	58,5	68,5	88,5	102,5	138,5	138,5
D mm	10	15	20	22	25	32	40	50	60	60
G mm	9,045	12,065	17,78	23,825	23,825	31,267	44,399	63,348	63,348	80
K mm	11	17	24	27	30,5	40	49,5	57	66	66
Weight approx. g	200	400	500	800	1300	2300	4700	10200	17800	23000
Workpiece weight max. kg	10	100	200	400	500	800	2000	3500	5000	7500
Concentricity deviation max. mm	0,01	0,005	0,005	0,005	0,005	0,005	0,005	0,008	0,01	0,015
Speed max. min^{-1}	15000	7000	7000	6300	5000	3800	3000	2600	1500	1500
Spare live centres	**1241727**	**1241726**	**1241725**	**1241724**	**1241723**	**1241722**	**1241721**	**1241728**	**1241729**	**1241730**

1) body only ground not hardened

▲ on request

Pro - standard design



APPLICATION

For counter-clamping workpieces on turning and grinding machines.

TYPE

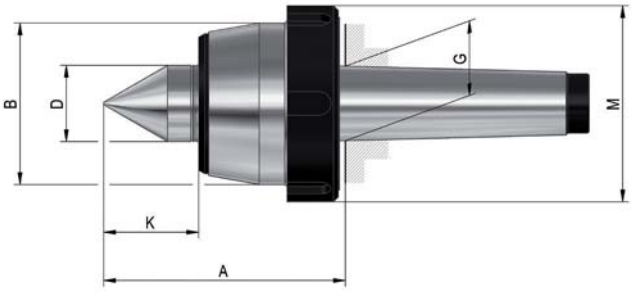
All-round live centre in classical design for nearly any standard clamping situation.
With draw-off nut.

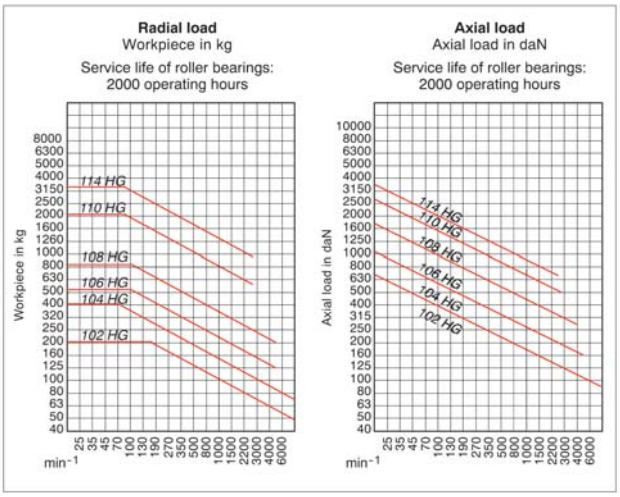
CUSTOMER BENEFITS

- Proven 3-fold bearing for high axial and radial load
- Lifetime lubrication for minimum required maintenance
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground (MT 2 - 6)
- Tip angle 60°





A06
HG Pro, **with draw-off nut,** body hardened and ground - tip angle 60°

Item no.	221018	221019	205036	207148	074390	221020
Mount MT	2	3	3	4	5	6
Size	102	104	106	108	110	114
A mm	65	70,5	79,5	102,5	129	152
B mm	45	50	60	70	90	105
D mm	20	22	25	32	40	50
G mm	17,78	23,825	23,825	31,267	44,399	63,348
K mm	24	27	30,5	40	49,5	57
M mm	56	62	74	82	105	120
Weight approx. g	600	1000	1400	2400	5200	10500
Workpiece weight max. kg	200	400	500	800	2000	3500
Concentricity deviation max. mm	0,005	0,005	0,005	0,005	0,005	0,008
Speed max. min⁻¹	7000	6300	5000	3800	3000	2600
Spare live centres	**1241725**	**1241724**	**1241723**	**1241722**	**1241721**	**1241728**

Pro - cylindrical shank



APPLICATION

For the counter-clamping of workpieces on turning and grinding machines using rotary chucks, collet chucks and tool take-ups.
Take-up for tool magazine / turret.

TYPE

All-round live centre with cylindrical shank.

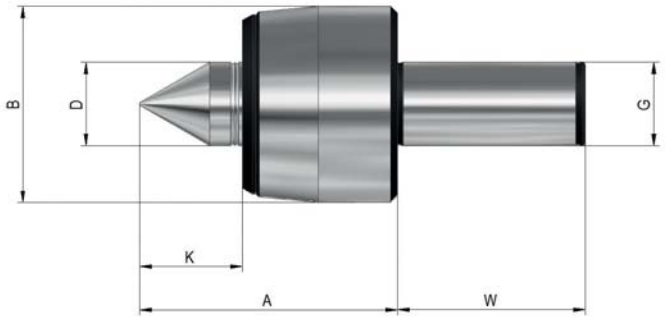
CUSTOMER BENEFITS

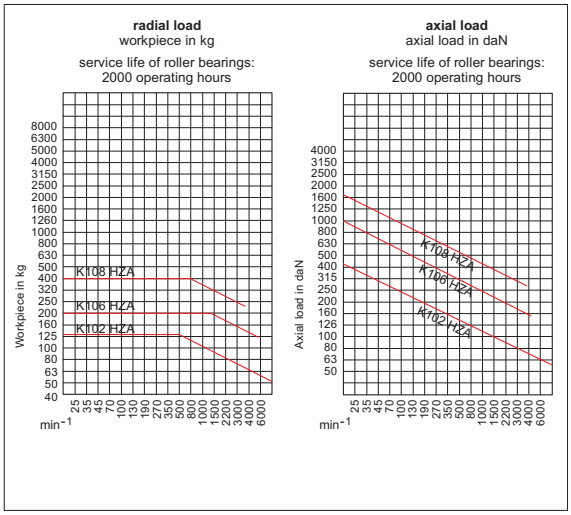
- Proven 3-fold bearing for high axial and radial load
- Lifetime lubrication for minimum required maintenance
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°

Note:
Live centres with cylindrical shank and clamping surface on request





A06
HZA Pro **with cylindrical shank,** body hardened and ground - tip angle 60°

Item no.	**1316054**	**1316055**	**1316056**
Mount MT	ZA20	ZA25	ZA32
Size	102	106	108
A mm	58	76,8	93,1
B mm	43	48,5	68,5
D mm	20	25	32
G mm	20	25	32
K mm	24	30,5	40
Weight approx. g	414	891	1474
Workpiece weight max. kg	130	200	400
Concentricity deviation max. mm	0,005	0,005	0,005
Speed max. min^{-1}	7000	5000	3800
Spare live centres	**1241725**	**1241723**	**1241722**

Pro - high precision design



APPLICATION

For counter-clamping workpieces on turning and grinding machines for highest demands.

TYPE

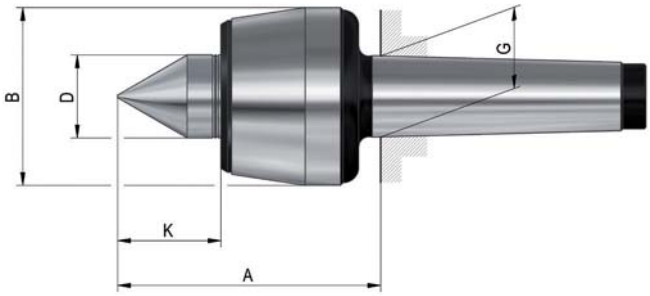
High precision design.

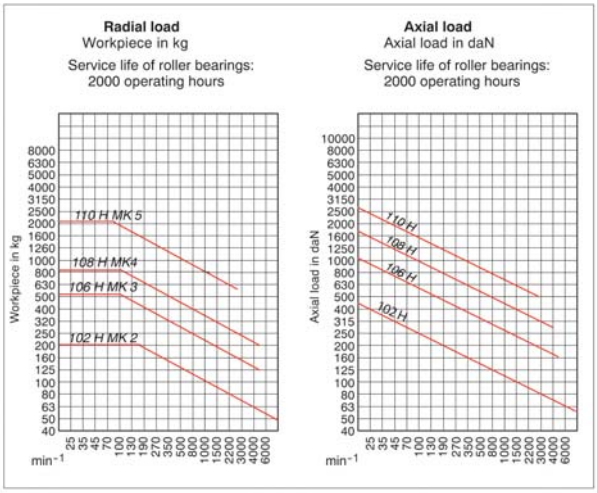
CUSTOMER BENEFITS

- Maximum concentricity deviation of **0.003 mm** for maximum precision
- Lifetime lubrication for minimum required maintenance
- Proven 3-fold bearing for high axial and radial load

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
HP Pro **precision version,** body hardened and ground - tip angle 60°

Item no.	082392	318227	082394	082395	1263871
Mount MT	2	3	4	5	6
Size	102	106	108	110	114
A mm	65	82	102,5	129	151,6
B mm	43	55	68,5	88,5	102,5
D mm	20	25	32	40	50
G mm	17,78	23,825	31,267	44,399	63,348
K mm	24	30,5	40	49,5	56,9
Weight approx. g	500	1300	2300	4700	8761
Workpiece weight max. kg	200	500	800	2000	3500
Concentricity deviation max. mm	0,003	0,003	0,003	0,003	0,003
Speed max. min^{-1}	7000	5000	3800	3000	2600
Spare live centres	**1241725**	**1243613**	**1241722**	**1241721**	**1241728**

Pro - extended centre point



APPLICATION

For counter-clamping workpieces on turning and grinding machines.
Especially suited for cramped work area between centre point and workpiece.

TYPE

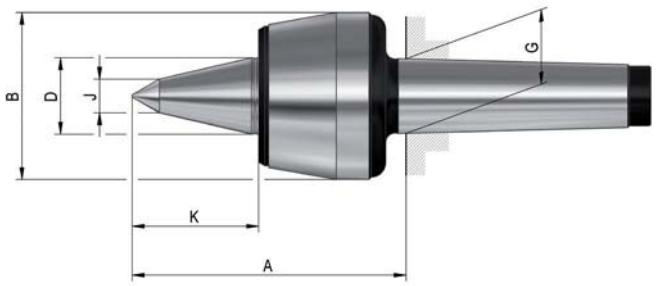
All-round live centre with extended centre point.

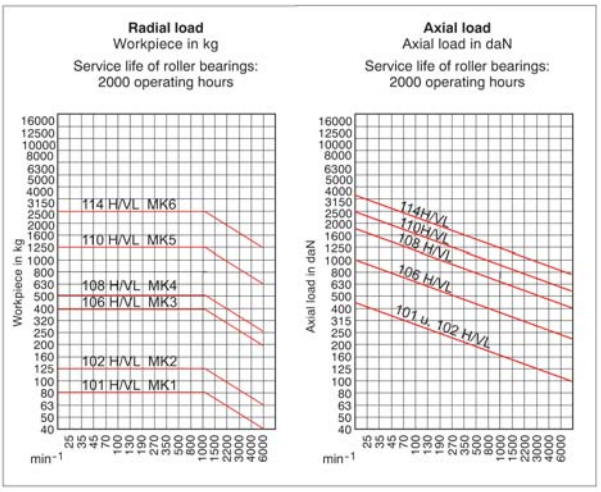
CUSTOMER BENEFITS

- Enlarged work area and better workpiece accessibility thanks to profiled centre point
- High concentricity and stability thanks to 3-fold bearing
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
HVL Pro **with extended centre point,** body hardened and ground - tip angle 60°

Item no.	058668	058669	058670	058671	058672	058673
Mount MT	1	2	3	4	5	6
Size	101	102	106	108	110	114
A mm	70,5	75	95,5	114,5	143,5	172,5
B mm	34,5	43	58,5	68,5	88,5	102,5
D mm	15	20	25	32	40	50
G mm	12,065	17,78	23,825	31,267	44,399	63,348
K mm	27	34	47	53	64	78
J mm	9	10	12	14	16	18
Weight approx. g	400	500	1300	2300	4800	10200
Workpiece weight max. kg	80	140	400	500	1200	2500
Concentricity deviation max. mm	0,01	0,005	0,005	0,005	0,005	0,01
Speed max. min^{-1}	7000	7000	5000	3800	3000	2600
Spare live centres	**1241731**	**1241732**	**1241733**	**1241734**	**1241735**	**1241736**

▲ on request

Pro - profiled, extended centre point



APPLICATION

For counter-clamping workpieces on turning and grinding machines.
Especially suited for cramped work area between centre point and workpiece as well as low-lying workpiece centres.

TYPE

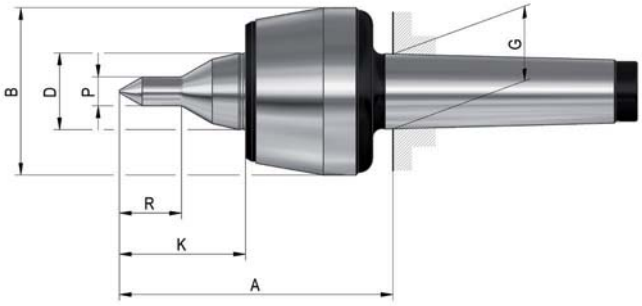
All-round live centre with profiled centre point.

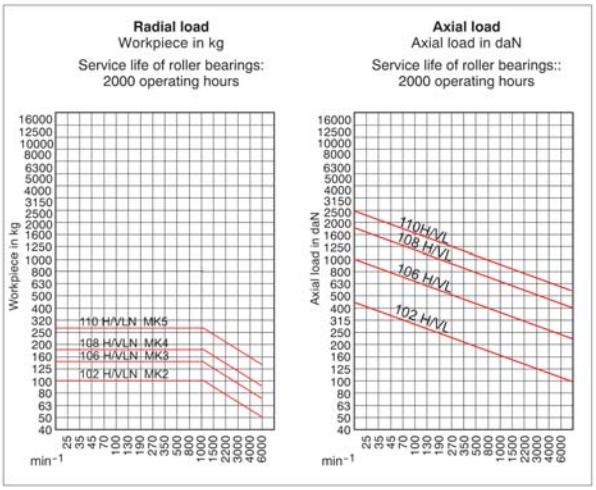
CUSTOMER BENEFITS

- Enlarged work area and better workpiece accessibility thanks to profiled centre point
- High concentricity and stability thanks to 3-fold bearing
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





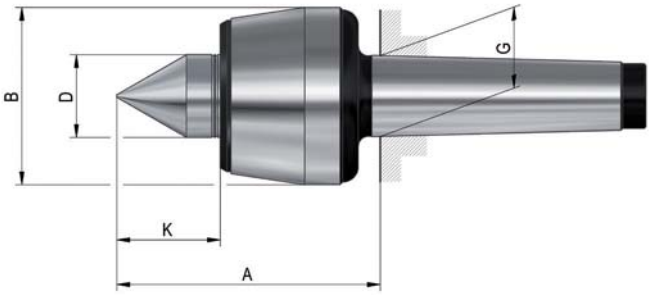
A06
HVLN Pro **with profiled, extended centre point,** body hardened and ground - tip angle 60°

Item no.	**1241689**	**1241691**	**1241693**	**1241694**
Mount MT	2	3	4	5
Size	102	106	108	110
A mm	75	95,5	114,5	143,5
B mm	43	58,5	68,5	88,5
D mm	20	25	32	40
G mm	17,78	23,825	31,267	44,399
K mm	34	47	53	64
P mm	8	10	12	14
R mm	16	20	26	30
Workpiece weight max. kg	100	150	180	280
Concentricity deviation max. mm	0,005	0,005	0,005	0,005
Speed max. min^{-1}	7000	5000	3800	3000
Weight approx. g	320	460	1000	2600
Spare live centres	**1243677**	**1243678**	**1243679**	**1243680**

Orange Line

ORANGE LINE





APPLICATION

For counter-clamping workpieces on turning and grinding machines.

TYPE

All-round live centre in classical design for all basic requirements for turning machining.

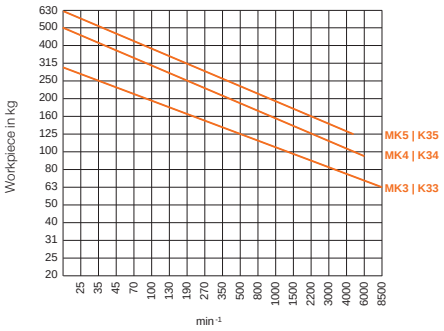
CUSTOMER BENEFITS

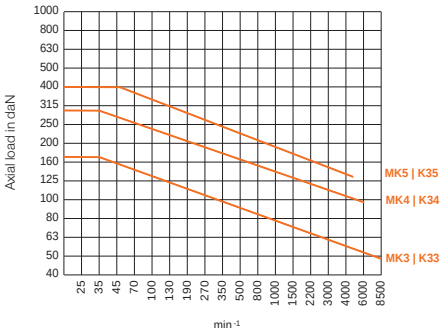
- Running tip through-hardened, and therefore can be reground as desired
- Lifetime lubrication for minimum required maintenance
- Good price/performance ratio

TECHNICAL FEATURES

- Body ground
- Tip angle 60°

Note:
For higher rotation speed at reduced lateral load





A06
Orange Line, body only ground - tip angle 60°

Item no.	**1267217**	**1267218**	**1267219**
Mount MT	3	4	5
Size	K33	K34	K35
A mm	82,5	101,5	128
B mm	55	68,5	88,5
D mm	25	32	40
G mm	23,825	31,267	44,399
K mm	30	40	49,5
Weight approx. g	1000	1800	4300
Workpiece weight max. kg	300	500	630
Concentricity deviation max. mm	0,005	0,005	0,005
Speed max. min^{-1}	8500	6000	4500
Spare live centres	**1243613**	**1241722**	**1241721**

Heavy - standard design



APPLICATION

For counter-clamping especially heavy workpieces on turning and grinding machines.
Especially suitable for use on NC-machines.

TYPE

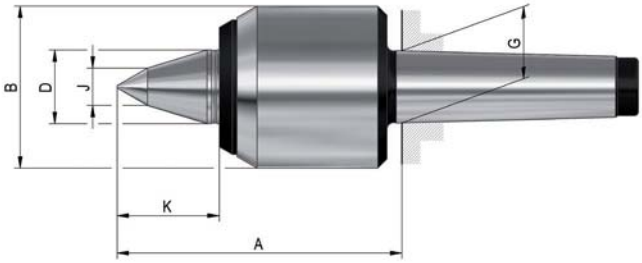
Universal version with extended centre point for heavy workpieces.

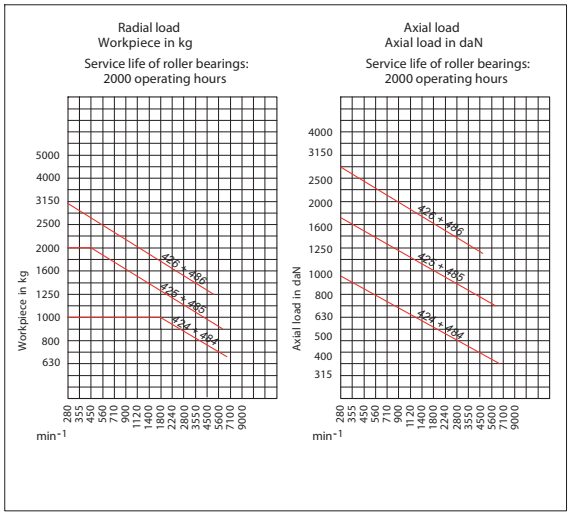
CUSTOMER BENEFITS

- Robust 4-fold precision bearing for high speeds as well as high axial and radial loads
- Reliable and safe clamping of heavy workpieces
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
Heavy especially **for high load at high speeds,** body hardened and ground - tip angle 60°

Item no.	**303598**	**303599**	**301696**
Mount MT	4	5	6
Size	424	425	426
A mm	122	150	180
B mm	70	95	120
D mm	32	42	58
G mm	31,267	44,399	63,348
J mm	16	20	26
K mm	44,5	59,5	76
Weight approx. g	2600	5500	11500
Workpiece weight max. kg	1000	2000	3000
Concentricity deviation max. mm	0,005	0,005	0,005
Speed max. min^{-1}	7000	6000	4800
Spare live centres	**1241762**	**1241763**	**1241764**

Heavy - standard design



APPLICATION

For counter-clamping especially heavy workpieces on turning and grinding machines.
Especially suitable for use on NC-machines.

TYPE

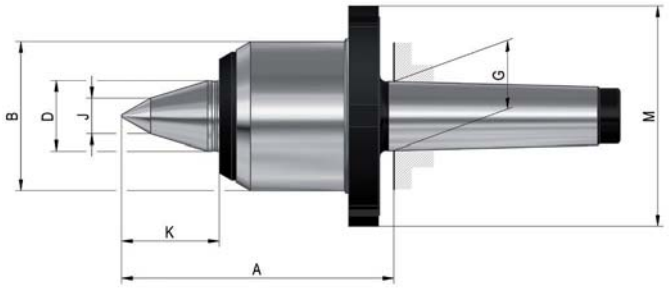
Universal version with extended centre point for heavy workpieces.
With draw-off nut.

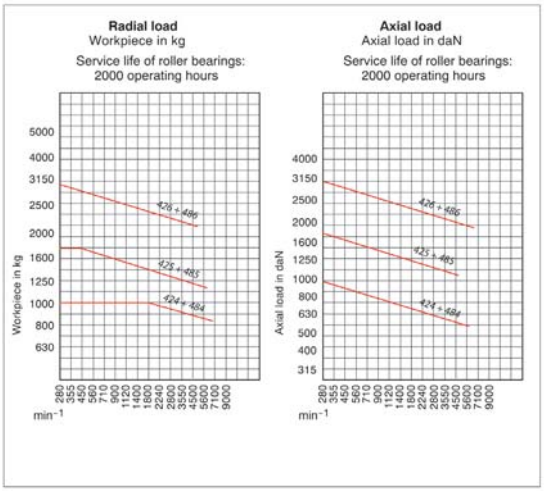
CUSTOMER BENEFITS

- Robust 4-fold precision bearing for high speeds as well as high axial and radial loads
- Reliable and safe clamping of heavy workpieces
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
Heavy **with draw-off nut,** especially **for high load at high speeds,** body hardened and ground - tip angle 60°

Item no.	**304521**	**304522**	**304523**
Mount MT	4	5	6
Size	484	485	486
A mm	122	150	180
B mm	70	95	120
D mm	32	42	58
G mm	31,267	44,399	63,348
J mm	16	20	26
K mm	44,5	59,5	76
M mm	100	125	155
Weight approx. g	2800	5400	12300
Workpiece weight max. kg	1000	2000	3000
Concentricity deviation max. mm	0,005	0,005	0,005
Speed max. min^{-1}	7000	6000	4800
Spare live centres	**1241762**	**1241763**	**1241764**

▲ on request

Speed - extended centre point



APPLICATION

For counter-clamping workpieces on turning and grinding machines.
Especially suitable for complex machining at high speeds.

TYPE

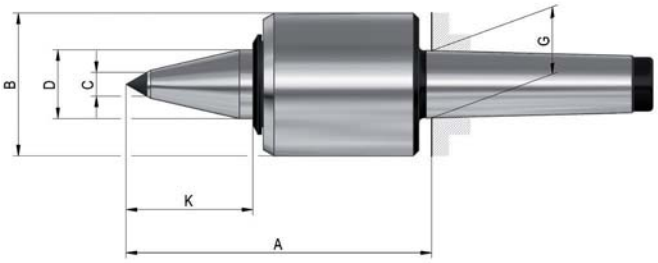
Special design for very high speeds with extended centre point and wear-resistant carbide insert.

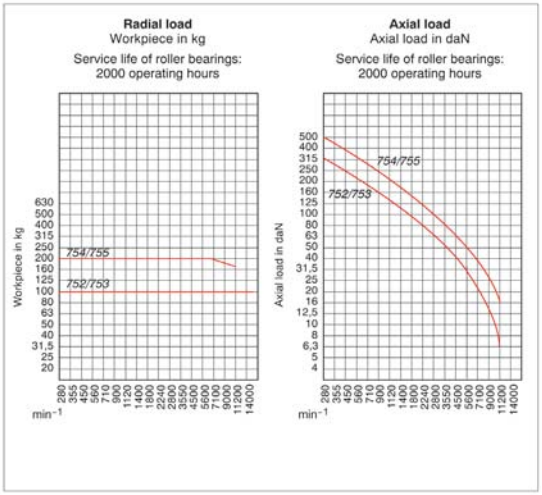
CUSTOMER BENEFITS

- Maximum rigidity for high speeds up to 12000 rpm thanks to compact design
- Enlarged work area and better workpiece accessibility thanks to profiled centre point
- Maximum concentricity deviation of 0.01 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
Speed **extended NC-centre point** with **carbide insert**, for high speed body, hardened and ground - tip angle 60°

Item no.	772389	772390	772391	772392
Mount MT	2	3	4	5
Size	752	753	754	755
A mm	99	99	141	141
B mm	45	45	66	66
C mm	7	7	11	11
D mm	20	20	32	32
G mm	17,78	23,825	31,267	44,399
K mm	40	40	63	63
Weight approx. g	1200	1600	2600	5000
Workpiece weight max. kg	100	100	250	250
Concentricity deviation max. mm	0,01	0,01	0,01	0,01
Speed max. min^{-1}	12000	12000	9000	9000
Spare live centres	**790267**	**790267**	**790291**	**790291**

Slim - standard design



APPLICATION

For counter-clamping workpieces on turning and grinding machines.
Especially suited for cramped work area between centre point and workpiece.

TYPE

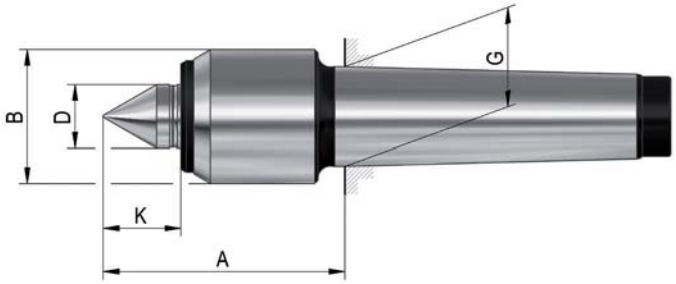
Compact design with minimum casing diameter.

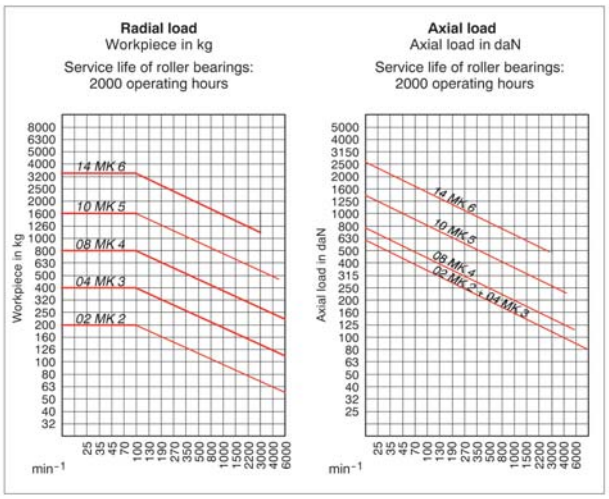
CUSTOMER BENEFITS

- Enlarged work area and better workpiece accessibility thanks to narrow casing diameter
- Maximum rigidity at high speeds thanks to compact design
- Maximum concentricity deviation of 0.005 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
Slim **with small casing diameter,** body hardened and ground - tip angle 60°

Item no.	**005336**	**005429**	**005469**	**005490**	**005547**
Mount MT	2	3	4	5	6
Size	02	04	08	10	14
A mm	62	62	75,5	106	143
B mm	32	34	42	58	80
D mm	15	15	20	30	42
G mm	17,78	23,825	31,267	44,399	63,348
K mm	19,5	19,5	24,5	37	49,5
Weight approx. g	300	400	1000	2600	7100
Workpiece weight max. kg	200	400	800	1600	3500
Concentricity deviation max. mm	0,005	0,005	0,005	0,01	0,02
Speed max. min^{-1}	7000	7000	6300	4300	3000
Spare live centres	**1241748**	**1241749**	**1241750**	**1241751**	**1241752**

Slim - extended centre point



APPLICATION

For counter-clamping workpieces on turning and grinding machines.
Especially suited for cramped work area between centre point and workpiece as well as low-lying workpiece centres.

TYPE

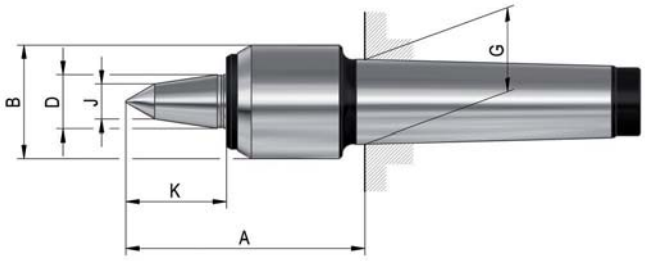
Compact design with minimum casing diameter.
With extended centre point.

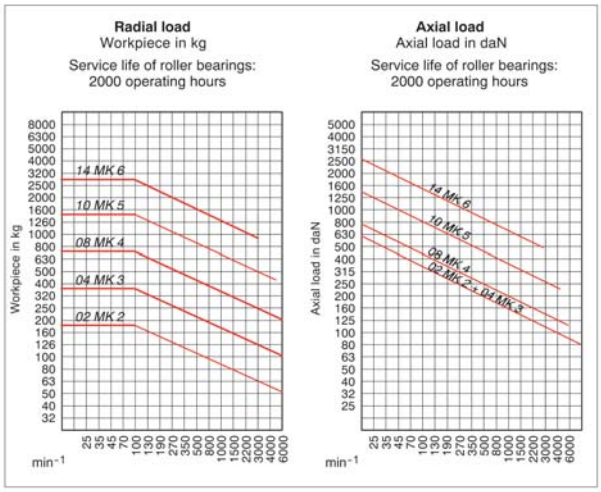
CUSTOMER BENEFITS

- Enlarged work area and better workpiece accessibility thanks to narrow casing diameter and extended centre point
- Maximum rigidity at high speeds thanks to compact design
- Maximum concentricity deviation of 0.008 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
Slim **with small casing diameter** and **extended centre point,** body hardened and ground - tip angle 60°

Item no.	362080	362081	362082	362083	362084
Mount MT	2	3	4	5	6
Size	02	04	08	10	14
A mm	73	74	88,5	119	164
B mm	32	34	42	58	80
D mm	15	15	20	30	42
G mm	17,78	23,825	31,267	44,399	63,348
K mm	29,5	32	37,5	51,5	70,5
J mm	10	11	13	14	18
Weight approx. g	320	460	1000	2600	7100
Workpiece weight max. kg	170	340	700	1400	3000
Concentricity deviation max. mm	0,008	0,008	0,008	0,01	0,02
Speed max. min^{-1}	7000	7000	6300	4300	3000
Spare live centres	**1241753**	**1241754**	**1241755**	**1241756**	**1241757**

Slim - profiled, extended centre point



APPLICATION

For counter-clamping workpieces on turning and grinding machines.
Especially suited for cramped work area between centre point and workpiece.

TYPE

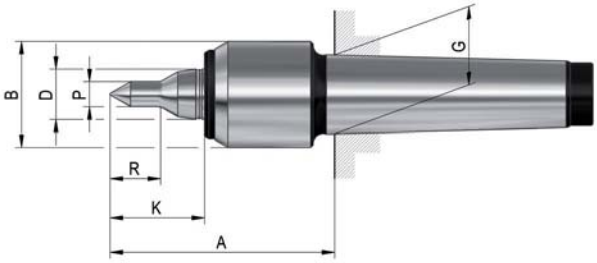
Compact design with minimum casing diameter.
With extended and profiled centre point.

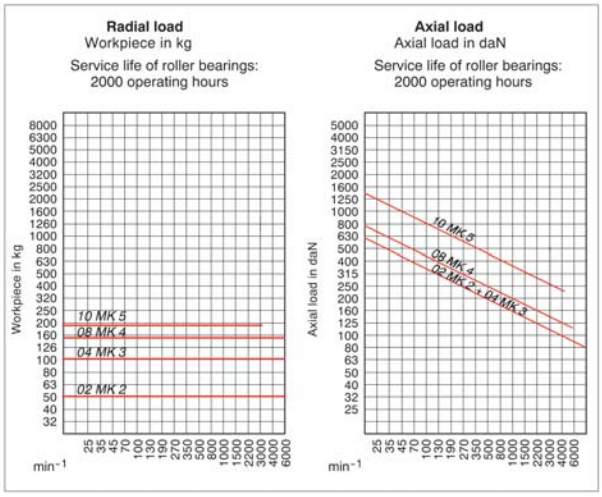
CUSTOMER BENEFITS

- Enlarged work area and better workpiece accessibility thanks to narrow casing diameter and extended and profiled centre point
- Maximum rigidity at high speeds thanks to compact design
- Maximum concentricity deviation of 0.008 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
Slim **with small casing diameter** and **profiled and extended centre point,** body hardened and ground - tip angle 60°

Item no.	1241695	1243505	1243507	1243509
Mount MT	2	3	4	5
Size	02	04	08	10
A mm	73	74	88,5	119
B mm	32	34	42	58
D mm	15	15	20	30
G mm	17,78	23,825	31,267	44,399
K mm	29,5	32	37,5	51,5
P mm	6	8	10	12
R mm	12	16	20	26
Workpiece weight max. kg	50	100	150	180
Concentricity deviation max. mm	0,008	0,008	0,008	0,01
Speed max. min^{-1}	7000	7000	6300	4300
Weight approx. g	320	460	1000	2600
Spare live centres	**1241758**	**1241759**	**1241760**	**1241761**

▲ on request

Control - standard design



APPLICATION

For counter-clamping workpieces on turning and grinding machines.
Optimally suited as counter-centre for face drivers.

TYPE

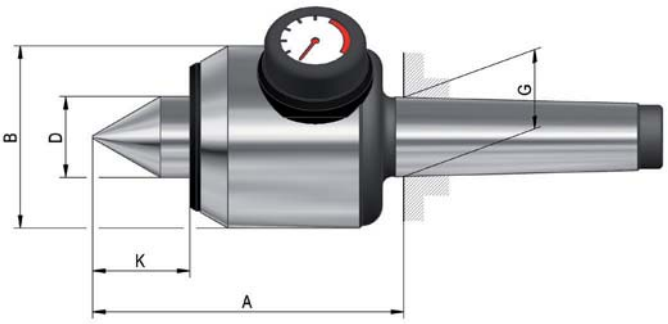
With pressure display and length compensation.

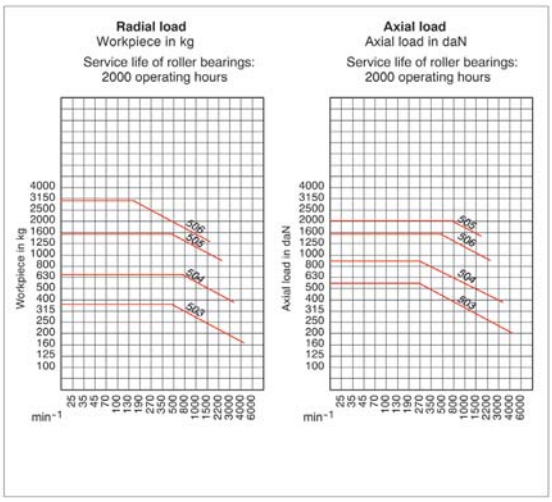
CUSTOMER BENEFITS

- Fast adjustment and check of axial load by means of pressure display
- Resilient centre point for safe, deformation-free workpiece clamping
- Maximum concentricity deviation of 0.01 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
AC Control **with pressure display** and **length compensation,** as counter-centre for face drivers, body hardened and ground - tip angle 60°

Item no.	**060798**	**060874**	**060906**	**060915**
Mount MT	3	4	5	6
Size	503	504	505	506
A mm	105	123,5	160,5	202
B mm	64	72	95	120
D mm	25	32	40	52
G mm	23,825	31,267	44,399	63,348
K mm	31	38,5	49	59
Weight approx. g	2100	3500	8300	17000
Spring way max. mm[1)]	1,6	2	1,8	2,7
Axial load max. N	5500	9000	15000	20000
Workpiece weight max. kg	400	800	1600	3200
Concentricity deviation max. mm	0,01	0,01	0,01	0,015
Speed max. min^{-1}	4000	3500	2500	1800
Spare live centres	**009192**	**009205**	**009325**	**009413**

[1)] at max. axial load

Control - extended centre point



APPLICATION

For counter-clamping workpieces on turning and grinding machines.
Especially suited as counter-centre for face drivers as well as for cramped work area between centre point and workpiece.

TYPE

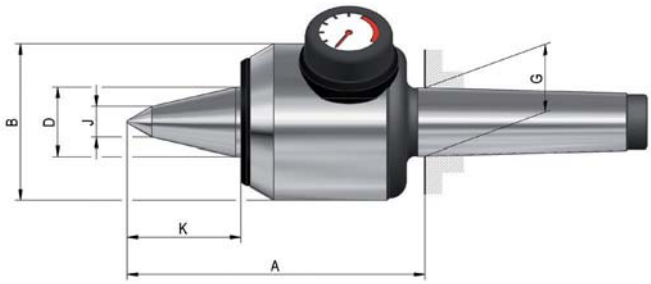
With pressure display, length compensation and extended live centre.

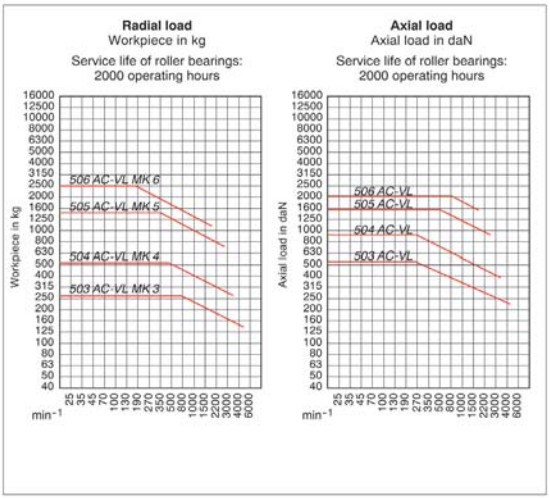
CUSTOMER BENEFITS

- Fast adjustment and check of axial load by means of pressure display
- Enlarged work area and better workpiece accessibility thanks to extended centre point
- Resilient live centre for safe, deformation-free workpiece clamping
- Maximum concentricity deviation of 0.01 mm for maximum precision

TECHNICAL FEATURES

- Body hardened and ground
- Tip angle 60°





A06
AC-VL Control with **pressure display, length compensation and extended centre point**, as counter-centre for face drivers, body hardened and ground - tip angle 60°

Item no.	079920	079921	079922	079923
Mount MT	3	4	5	6
Size	503	504	505	506
A mm	120	137,5	177,5	223
B mm	64	72	95	120
D mm	25	32	40	52
G mm	23,825	31,267	44,399	63,348
K mm	45,5	52,5	66	80
J mm	11	14	15	24
Weight approx. g	2200	3600	8400	17500
Spring way max. mm[1)]	1,6	2	1,8	2,7
Axial load max. N	5500	9000	15000	20000
Workpiece weight max. kg	260	550	1100	2500
Concentricity deviation max. mm	0,01	0,01	0,01	0,015
Speed max. min^{-1}	4000	3500	2500	1800
Spare live centres	**079924**	**079925**	**079926**	**079927**

[1)] at max. axial load

▲ on request

Flex - interchangeable inserts



APPLICATION

For counter-clamping workpieces on turning and grinding machines.

TYPE

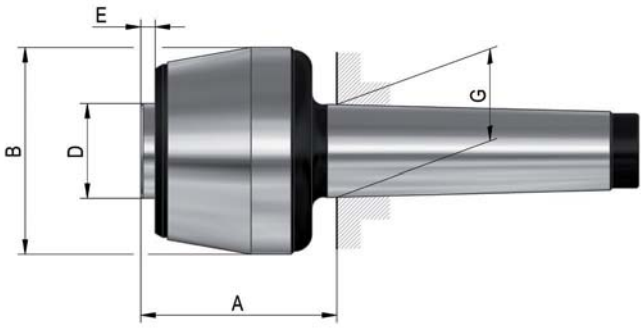
With interchangeable inserts made of wear-resistant tool steel for maximum flexibility.

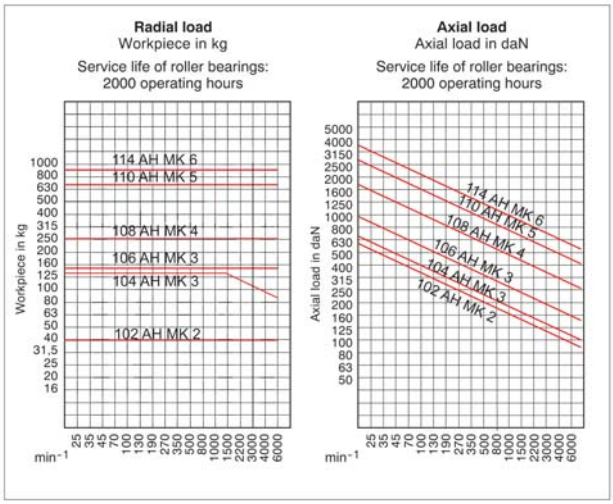
CUSTOMER BENEFITS

- Wide range of applications thanks to interchangeable inserts
- Quick change of interchangeable inserts

TECHNICAL FEATURES

- Body hardened and ground
- Inserts through-hardened and ground



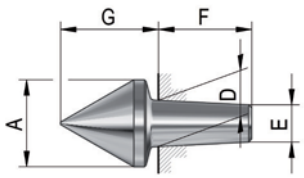


A06
Flex for **interchangeable inserts,** body hardened and ground

Item no.	061030	061031	061032	061038	061039	061040
Mount MT	2	3	3	4	5	6
Size	102	104	106	108	110	114
A mm	45	48	55	67	85	101
B mm	43	48,5	58,5	68,5	88,5	102,5
D mm	20	22	25	32	40	50
E mm	4	4	5,5	5	6	6
G mm	17,78	23,825	23,825	31,267	44,399	63,348
Concentricity deviation max. mm	0,01	0,01	0,01	0,01	0,01	0,015
Speed max. min^{-1}	7000	6300	5000	3800	3000	2600
Workpiece weight max. kg	40	130	150	250	650	900
Weight without inserts	440	750	1100	1900	4400	8600
Weight g	900	1700	2200	3700	8000	-
Spare live spindle	**009836**	**009838**	**009843**	**009870**	**009872**	**009874**

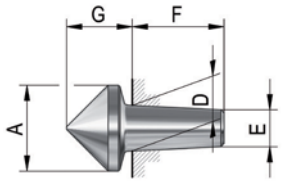
Interchangeable inserts

A06
Interchangeable inserts **60°**



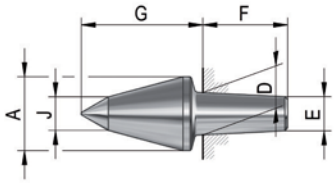
Item no.	Size	A mm	D mm	E mm	F mm	G mm
070725	102	16	7	5,2	18	20
070728	104	20	12	9,6	24	24
070731	106	24	12	9,6	24	27,5
070734	108	28	15	12	30	31,5
070737	110	38	22	18,5	35	43
070740	114	50	28	24	40	54

A06
Interchangeable inserts **90°**



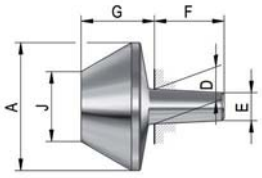
Item no.	Size	A mm	D mm	E mm	F mm	G mm
070727	102	16	7	5,2	18	14,5
070730	104	20	12	9,6	24	16,5
070733	106	24	12	9,6	24	19
070736	108	28	15	12	30	21,5
070739	110	38	22	18,5	35	29
070742	114	50	28	24	40	36

A06
Interchangeable inserts **60°VL**



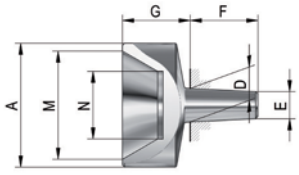
Item no.	Size	A mm	D mm	E mm	F mm	G mm	J mm
070719	102	14	7	5,2	18	25	6
070720	104; 106	18	12	9,6	24	30	8
070721	108	26	15	12	30	43	12
070722	110	32	22	18,5	35	55	13
070723	114	42	28	24	40	70	18,5

A06
Interchangeable inserts for tubular workpieces **60°**



Item no.	Size	A mm	D mm	E mm	F mm	G mm	J mm
070700	102	25	7	5,2	18	21	10
070701	104	35	12	9,6	24	26	15
070702	106	45	12	9,6	24	27	25
070703	108	55	15	12	30	31,5	30
070704	110	70	22	18,5	35	39	40
070705	114	100	28	24	40	52	55

A06
Interchangeable inserts **A** for centreless workpieces **60°**

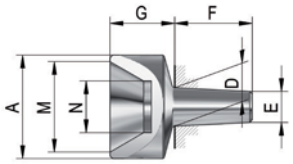


Item no.	Size	A mm	D mm	E mm	F mm	G mm	M mm	N mm
070707	102	25	7	5,2	18	18	20	10
070708	104	35	12	9,6	24	24	30	15
070709	106	45	12	9,6	24	25	40	25
070710	108	55	15	12	30	30	48	30
070711	110	70	22	18,5	35	39	63	40
070712	114	100	28	24	40	52	90	55

▲ on request

Interchangeable inserts

A06
Interchangeable inserts **B** for centreless workpieces **60°**



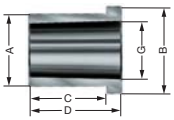
Item no.	Size	A mm	D mm	E mm	F mm	G mm	M mm	N mm
228620	102	16	7	5,2	18	12	12	6
228621	106	22	12	9,6	24	16	18	10
228622	108	40	15	12	30	25	35	20
308632	110	52	22	18,5	35	30	45	30

A06
Extractor



Item no.	For size
061707	102
061708	104/106/108
061709	110/114

A14
Mounting sleeve for clamping the face driver in the rotary chuck



Item no.	MT inside	A mm	B mm	C mm	D mm	G mm
085033	3	32	39	32	40	23,825
085034	4	40	47	42	50	31,267
085035	5	55	62	52	60	44,399
085036	6	75	83	62	70	63,448

Flex - interchangeable inserts



APPLICATION

For counter-clamping workpieces on turning and grinding machines.

TYPE

With interchangeable inserts made of wear-resistant tool steel for maximum flexibility.

CUSTOMER BENEFITS

- Wide range of applications thanks to interchangeable inserts
- Quick change of interchangeable inserts

TECHNICAL FEATURES

- Body hardened and ground
- Inserts through-hardened and ground

Included in scope of delivery:
- 1 basic body for interchangeable inserts
- 1 extractor
- 1 insert 60°, 90°, 60°VL
- 1 insert or tubular workpieces 60°
- 2 inserts for centreless workpieces 60°
- 1 insert 60° cone
- 2 inserts interior cone hollow
- Inclusive wooden case

A06
Complete with all inserts in a sturdy wooden case

Item no.	061702	061703	061704	061705	061706
Mount MT	2	3	3	4	5
Size	102	104	106	108	110
Workpiece weight max. kg	40	130	150	250	650
Weight g	900	1700	2200	3700	8000

REVOLVING CENTERING TAPER

For counter-clamping workpieces with large boreholes, (e.g. pipes) on turning and grinding machines, in one set-up. The centre point of the revolving centering taper from RÖHM is hardened and ground for maximum wear resistance.

REVOLVING CENTERING TAPER







- Large clamping range for a wide range of boreholes and centres
- Robust precision bearing for high axial and radial loads

REVOLVING CENTERING TAPER WITH INTERCHANGEABLE INSERTS









- Maximum flexibility thanks to use of exchangeable centering taper attachments
- Quick change of centering taper attachment in case of wear

MZK



APPLICATION

For counter-clamping workpieces with large boreholes, such as pipes on lathes and grinding machines.

TYPE

Revolving centering taper in pointed version or cone truncated version.

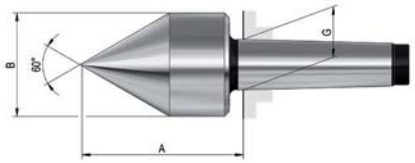
CUSTOMER BENEFITS

- Large clamping range for a wide range of boreholes and centres
- Proven 3-fold bearing for high axial and radial load

TECHNICAL FEATURES

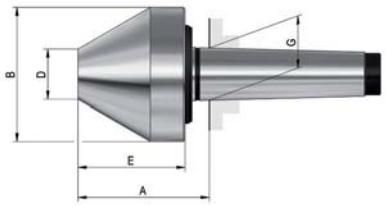
- Body hardened and ground

A06
Revolving centering taper, **pointed,** as revolving centre for tubular workpieces as well as centre for machining standard workpieces



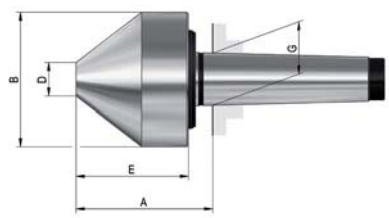
Item no.	Size	Mount MT	A mm	B mm	G	Workpiece weight max. kg	Concentricity deviation max. mm	Speed max. min^{-1}	Weight g
010613	272	2	61	42	17,78	200	0,01	6000	400
010635	273	3	79	56	23,825	400	0,008	6000	1100
010638	274	4	100	64	31,267	800	0,008	4000	1600
010642	275	5	115,5	78	44,399	1600	0,008	4000	3600
306396	276	6	153	105	63,348	2500	0,008	2500	10000

A06
Revolving centering taper, **cone truncated, 60°**



Item no.	Size	Mount MT	A mm	B mm	D mm	E mm	G	Workpiece weight max. kg	Concentricity deviation max. mm	Speed max. min^{-1}	Weight g
301616	171a	2	65	50	20	52	17,78	200	0,008	6000	1200
301556	172	2	77	80	30	64	17,78	300	0,008	5000	2000
301557	172a	3	77	80	30	64	23,825	400	0,008	5000	2200
221605	173	3	96,5	120	30	83	23,825	600	0,008	4000	4200
301558	172b	4	78,5	80	30	64	31,267	400	0,008	5000	2300
044023	173a	4	98	120	30	83	31,267	800	0,008	4000	4500
090483	173b	5	99	120	30	83	44,399	800	0,008	4000	5300

A06
Revolving centering taper, **cone truncated, 75°**



Item no.	Size	Mount MT	A mm	B mm	D mm	E mm	G	Workpiece weight max. kg	Concentricity deviation max. mm	Speed max. min^{-1}	Weight g
301559	172	2	80	80	20	67	17,78	300	0,008	5000	2000
301560	172a	3	80	80	20	67	23,825	400	0,008	5000	2000
062211	173	3	85,5	120	30	72	23,825	600	0,008	4000	4200
301561	172b	4	81,5	80	20	67	31,267	400	0,008	5000	2400
062224	173a	4	87	120	30	72	31,267	800	0,008	4000	4300
062299	174	4	107	170	50	90	31,267	1200	0,01	2800	9700
062232	173b	5	88	120	30	72	44,399	800	0,008	4000	5100
063614	174a	5	106	170	50	90	44,399	1600	0,01	2800	10600
063662	175	5	146,5	250	75	130	44,399	2000	0,01	2200	34000
063633	174b	6	107,5	170	50	90	63,348	1600	0,01	2800	13300
063656	175a	6	148	250	75	130	63,348	2000	0,01	2200	37000
063680	176	6	184	350	120	168	63,348	4000	0,015	1200	82000

▲ on request

MZK



APPLICATION

For counter-clamping workpieces with large boreholes, such as pipes on lathes and grinding machines.

TYPE

With interchangeable centering taper attachments.
Optionally with draw-off nut or fixed shaft.

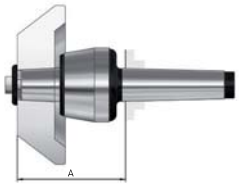
CUSTOMER BENEFITS

- High flexibility thanks to interchangeable centering taper attachments
- Quick change of interchangeable centering taper attachments

TECHNICAL FEATURES

- Body hardened and ground
- Centering taper inserts hardened and ground

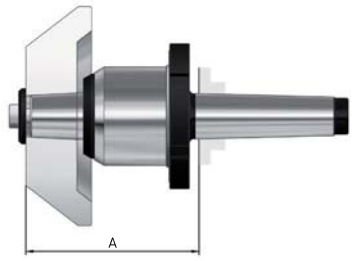
A06
Revolving centering taper



Item no.	Size	Mount MT	A mm	Workpiece weight max. kg	Concentricity deviation max. mm	Speed max. min^{-1}	Weight g
304562	108	4	103	800	0,005	3800	2200
304563	110	5	128	1600	0,005	3000	4800
304564	114	6	159	3000	0,005	2600	12000

With fastening screw and disc, without centering taper attachment

A06
Revolving centering tapers **with draw-off nut**, for high load



Item no.	Size	Mount MT	A mm	Workpiece weight max. kg	Concentricity deviation max. mm	Speed max. min^{-1}	Weight g
304583	494	4	118	1000	0,005	7000	3200
304584	495	5	140	2000	0,005	6000	6500
304585	496	6	168	3500	0,005	4800	13500

With fastening screw and disc, without centering taper attachment

A07
Fixed shafts



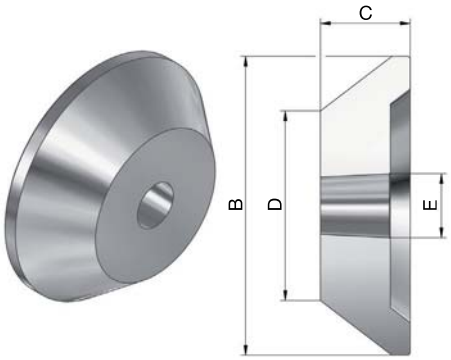
Item no.	Mount MT	A mm	Workpiece weight max. kg	Concentricity deviation max. mm	Weight g
304580	4	45	2000	0,003	800
304581	5	60	4800	0,003	2000
304582	6	70	12000	0,003	5500

With fastening screw and disc, without centering taper attachment

MZK

A06
Suitable inserts AZ for **centering tapers ,** standard version, taper 75°





Item no.	Size	for MT	B mm	C mm	D mm	E mm	Weight g
304565[1]	1	4	60	68	5	32	900
304566	2	4	100	45	45	32	1500
304567	3	4	150	45	95	32	4100
304568	4	4	200	45	145	32	6000
304569	5	4	250	45	195	32	8500
304570	1	5	100	43	45	40	1500
304571	2	5	150	43	95	40	4400
304572	3	5	200	43	145	40	6100
304573	4	5	250	43	195	40	8100
304574	5	5	300	43	245	40	11600
304575	1	6	150	54	95	50	3000
304576	2	6	200	54	145	50	8100
304577	3	6	250	54	195	50	11100
304578	4	6	300	54	245	50	14000
304579	5	6	350	54	295	50	18800

[1] without fixing by screw and washer

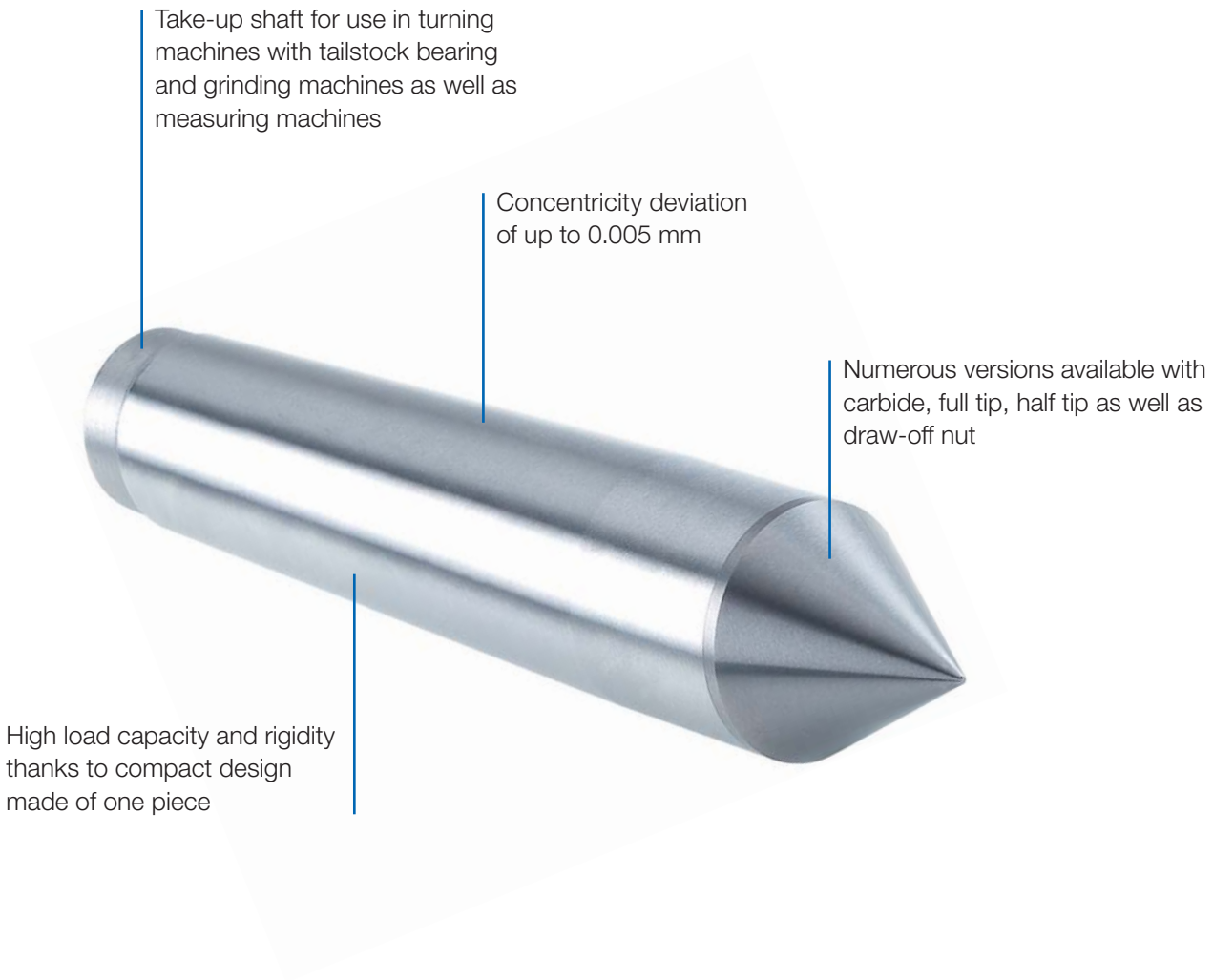
▲ on request

DEAD CENTRES

Optimally suited for the counter-clamping of workpieces on turning machines with tailstock bearing and grinding machines in one set-up as well as for measurement technology. The dead centres are hardened and ground.

ADVANTAGES AT A GLANCE

- High wear resistance thanks to tool steel / carbide insert
- High load capacity and rigidity thanks to compact design
- Concentricity deviation of up to 0.005 mm



FZS



APPLICATION

For counter-clamping workpieces on lathes with tailstock bearing and grinding machines.

TYPE

Designs with concentricity of 0.003 mm or higher are available on request.

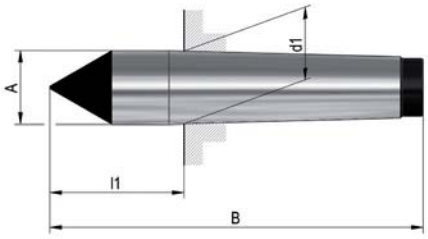
CUSTOMER BENEFITS

- High wear resistance thanks to tool steel / carbide insert
- High load capacity and rigidity since tips are one piece

TECHNICAL FEATURES

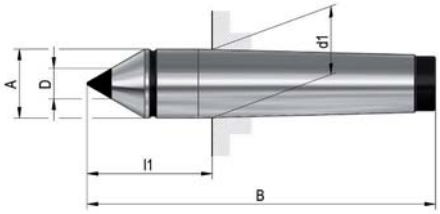
- Dead centres are hardened and ground

A07
DIN 806, full point, ground, with full carbide tip



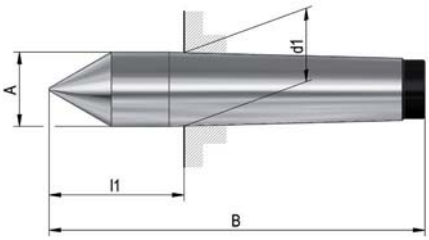
Item no.	Mount MT	A mm	B mm	d1 mm	l1 mm	Weight g
326786	2	18	100	17,78	36	175
306402	3	24,1	125	23,825	44	400
221398	4	31,6	160	31,267	57,5	855
326816	5	44,7	200	44,399	70,5	2160

A07
DIN 806, full point, ground, **with carbide insert and regrinding line**



Item no.	Mount MT	A mm	B mm	D mm	d1 mm	l1 mm	Weight g
017171	2	18	100	7	17,78	36	155
017172	3	24,1	125	11	23,825	44	360
017173	4	31,6	160	14	31,267	57,5	770
017174	5	44,7	200	18	44,399	70,5	1950

A07
DIN 806, full point, material: Mat.

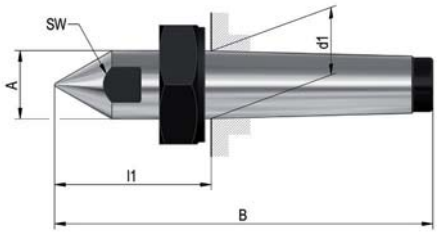


Item no.	Mount MT	A mm	B mm	d1 mm	l1 mm	Weight g
013706	0	9,2	70	9,045	20	30
013707	1	12,2	80	12,065	26,5	60
013709	2	18	100	17,78	36	150
013711	3	24,1	125	23,825	44	340
013712	4	31,6	160	31,267	57,5	760
013715	5	44,7	200	44,399	70,5	1920
013718	6	63,8	270	63,348	88	5200

▲ on request

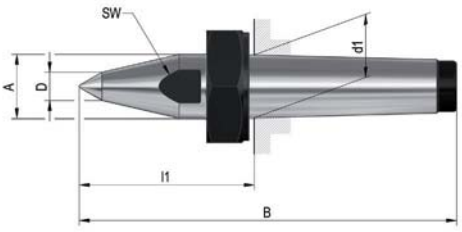
FZS

A07
Similar **DIN 807, full point,** with draw-off nut, material: Mat.



Item no.	Mount MT	A mm	B mm	C	d1 mm	l1 mm	Key-width SW	Weight g
005654	3	24,1	138	M27x1,5	23,825	57	19	580
005357	4	31,6	175	M36x1,5	31,267	72,5	27	800
005381	5	44,7	217	M48x1,5	44,399	87,5	36	2900
005426	6	63,8	290	M68x1,5	63,348	108	55	7200

A07
Similar **DIN 807, full point,** with draw-off nut, with extended point, material: Mat.



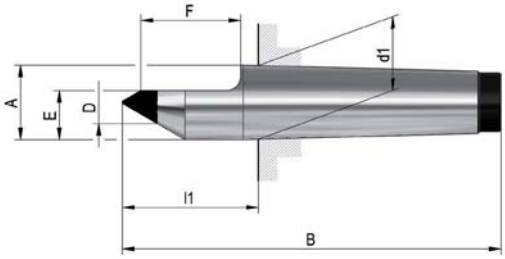
Item no.	Mount MT	A mm	B mm	C	D mm	d1 mm	l1 mm	Key-width SW	Weight g
249576	3	24,1	148	M27x1,5	10	23,825	67	19	600
249577	4	31,6	186,5	M36x1,5	14	31,267	84	27	1285
249578	5	44,7	242	M48x1,5	16	44,399	112	36	3000
249579	6	63,8	330	M68x1,5	20	63,348	148	55	7900

A07
Draw-off nut



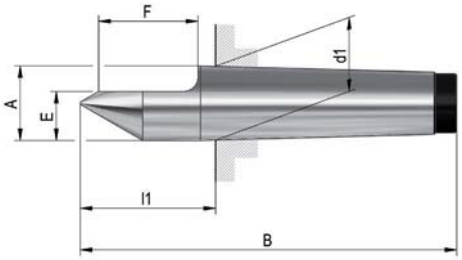
Item no.	C	H mm	Key-width SW	Weight g
005656	M27x1,5	17,5	41	110
005359	M36x1,5	21	55	240
005383	M48x1,5	23	75	480
005428	M68x1,5	25,5	100	900

A07
DIN 806, half point, ground only, **with carbide insert**



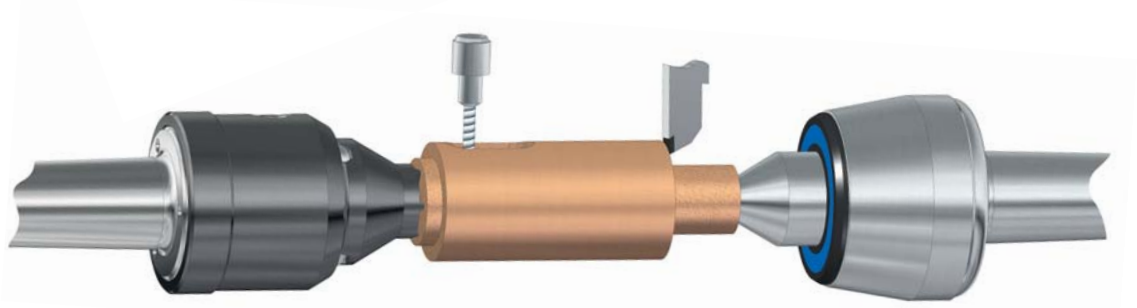
Item no.	Mount MT	A mm	B mm	D mm	E mm	F mm	d1 mm	l1 mm	Weight g
027439	2	18	100	7	11	30	17,78	36	150
027440	3	24,1	125	11	15	38	23,825	44	335
026571	4	31,6	160	14	21	50	31,267	57,5	750
027441	5	44,7	200	18	29,4	63	44,399	70,5	1830

A07
DIN 806, half point, material: Mat.



Item no.	Mount MT	A mm	B mm	E mm	F mm	d1 mm	l1 mm	Weight g
013868	2	18	100	11	30	17,78	36	145
013870	3	24,1	125	15	38	23,825	44	310
013871	4	31,6	160	21	50	31,267	57,5	710
013997	5	44,7	200	29,4	63	44,399	70,5	1925

TURNING AND MILLING IN ONE SET-UP



Application example - face driver CoE in combination with a revolving live centre.
Turning and milling workpieces in one set-up.

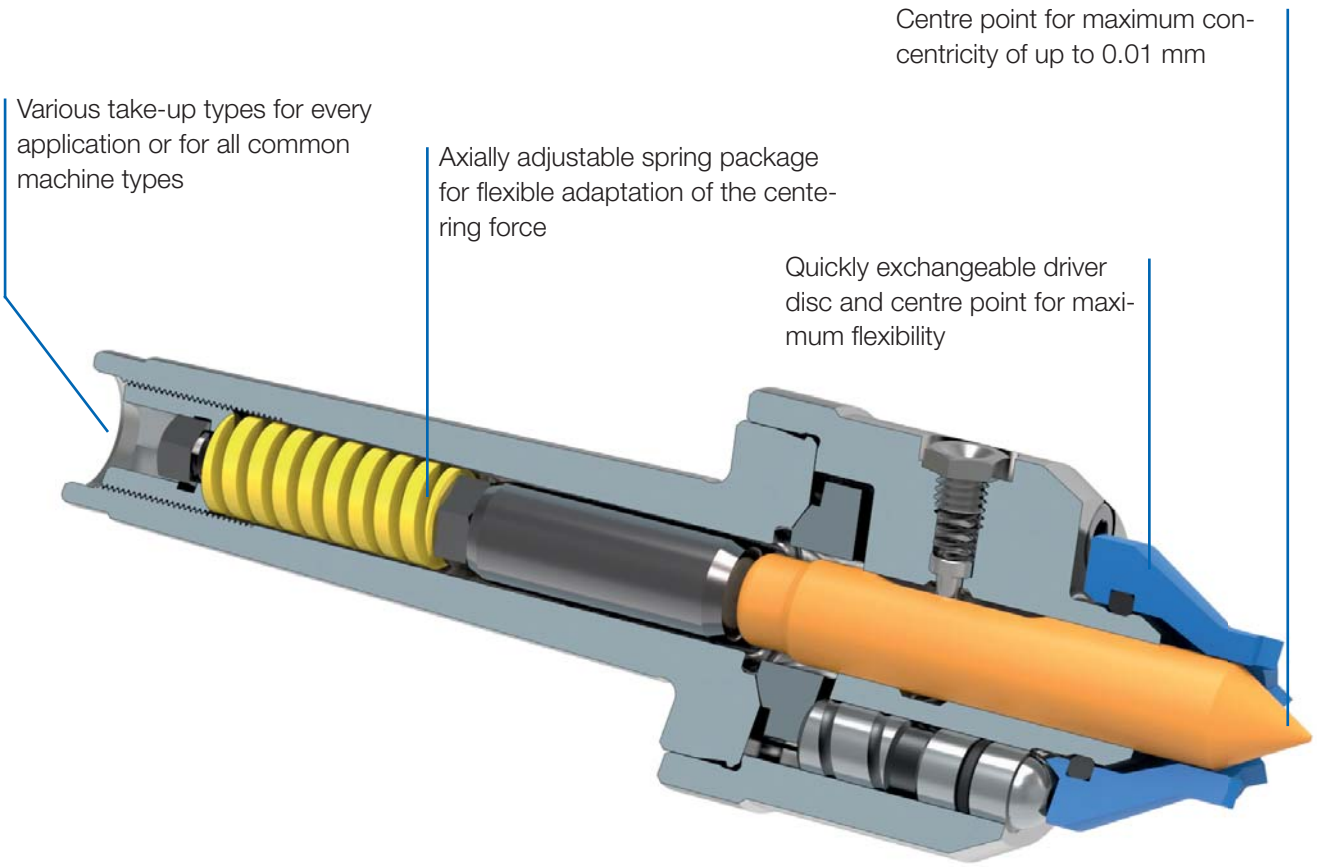
Video CoE

CONSTANT FACE DRIVERS

The Constant face drivers of RÖHM are optimally suited for the rational turning and milling of workpieces over their entire length. All Constant face drivers are developed according to the modular principle, so that a universal exchange of a large multitude of driver discs and centre points is possible.

ADVANTAGES AT A GLANCE

- Maximum flexibility thanks to the modular principle
- High concentricity thanks to narrow tolerances
- Constant clamping force thanks to mechanical or hydraulic pressure compensation, even for uneven workpiece faces



Operation guide

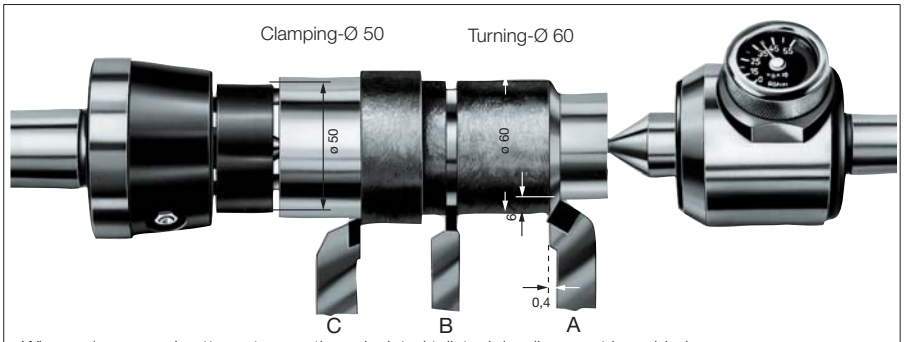






TYPE	CoE	CoA	CoK
Machining	Turning and milling in one set-up **Patended compensating driving disc, radially backlash-free**	Turning	Turning For machining workpieces which are highly unbalanced, very heavy, for high chip removal or for irregular cutting
Concentricity deviation max.	up to 0.01 mm	up to 0.015 mm	up to 0.01 mm
Actuation	not power-operated	not power-operated	power-operated
Pressure compensation	mechanical	mechanical / hydraulic	mechanical
Workpiece weight	up to 100 kg	up to 100 kg	up to 350 kg
Centre point	resilient	resilient	fixed
Clamping-Ø	8 - 80 mm	8 - 80 mm	8 - 80 mm
Adapter	with morse taper / with cylindrical shank	with morse taper / with morse taper and draw-off nut / with cylindrical shank for clamping in lathe chucks / with short taper / in flange type	with centring mount for adapter plate
Page	2040	2043	2052

Clamping power diagramm



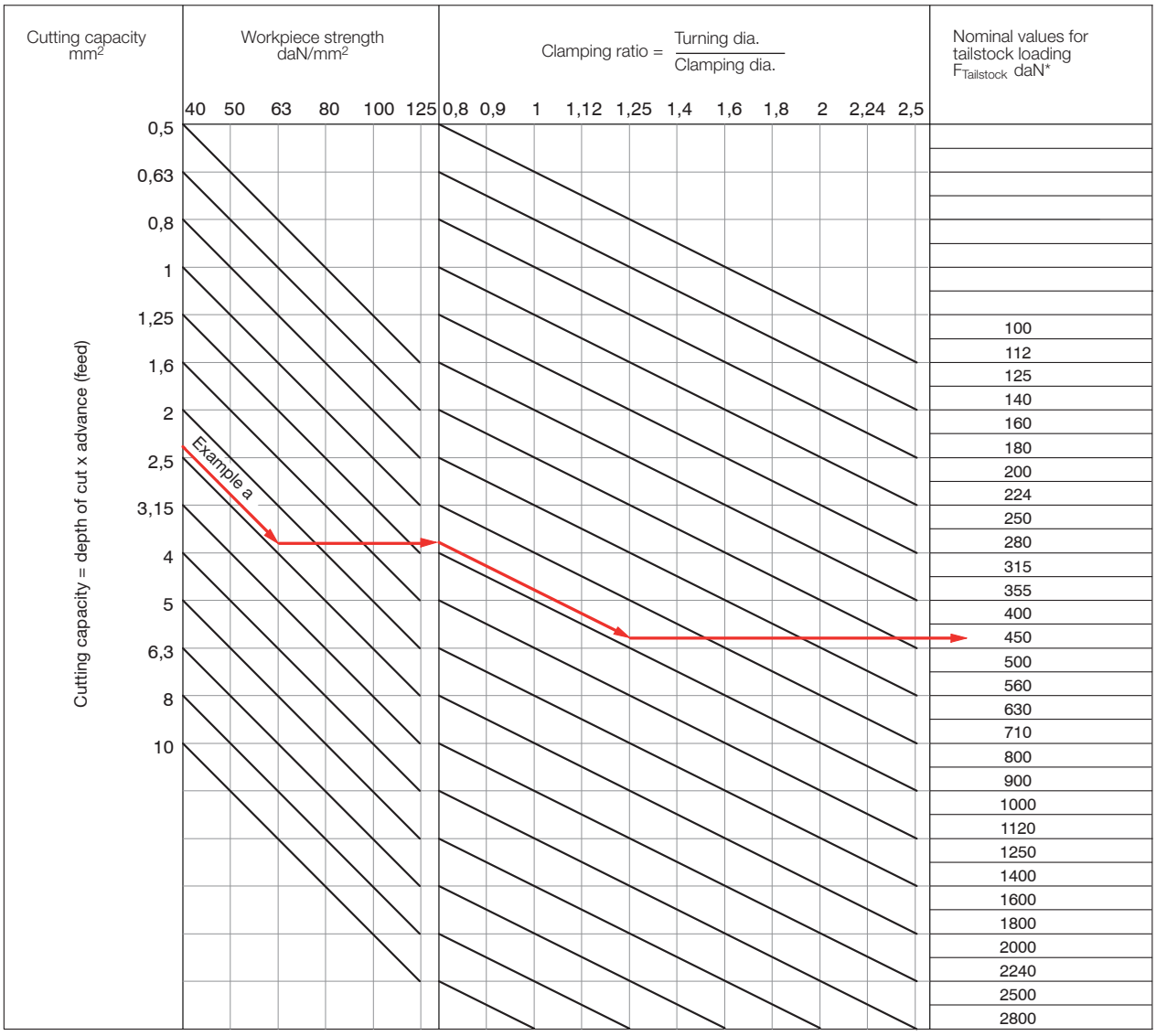
When using several cutters at once, the calculated tailstock loading must be added.

Example

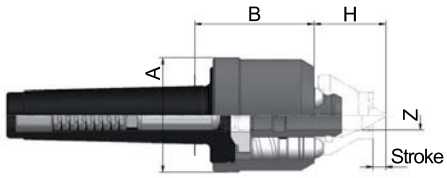
A	Turning against the headstock	
	1. Cutting capacity: 6 x 0,4	= 2,4 mm^2
	2. Workpiece strength:	= 63 daN/mm^2
	3. Clamping ratio: 60 : 50	= 1,2
	4. Tailstock loading from graph: $F_{Tailstock}$	= 450 daN
*	Conversation factor for:	
B	Radial grooving	$F_{Tailstock}$ x 1,5
C	Turning against tailstock	$F_{Tailstock}$ x 2

Workpiece strength daN/mm^2	40	50	63	80	100	125
Material	St 34-37	St 42	St 50	St 60-70	20 MnCr 5	18CrNi 8
	9-15 S 20	C 10	C 15-22	C 35-45	C 60	30 CrMoV 9
	GG 14-35	GG 40	22 S 20	16 MnCr 5	15 CrNi 6	50 CrMo 4
	GGG-38	GGG-42	GGG-50	GGG-60	GGG-80	105 WCr 6

The RÖHM slide rule, Item No. 88231 may also be used for easy calculation of the axial clamping power.



CoE



APPLICATION

For the rational **turning and milling** of workpieces on its entire length without reclamping with max. precision.

TYPE

Basic body with morse taper and mechanical pressure compensation.
Clamping circuit Ø 8-80 mm.
Workpiece weight max. 100 kg.

CUSTOMER BENEFITS

- For **turning and milling** in one set-up
- Compensating driving disc, radially backlash-free
- Maximum concentricity of up to 0.01 mm
- Stable and constant workpiece length stop on the front side thanks to resilient centre point
- Maximum flexibility thanks to universal exchange of driving disc and centre point

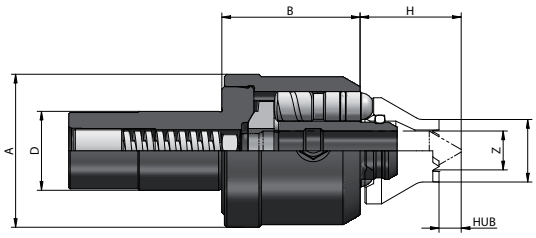
TECHNICAL FEATURES

- Guide value for axially permissible total load on 3 support pistons: 9000 N

A14
Basic body with morse taper (all basic bodies without driving disc and centre) **mechanical**

Item no.	MT	A mm	B mm	H mm	Z mm	Driving disc stroke mm	Weight approx. g
310065	3	62	65	max. 38 min. 26	16	10	1800
310066	4	62	65	max. 38 min. 26	16	10	1900
310068	5	62	65	max. 38 min. 26	16	10	2000

Other take-ups available on request



APPLICATION

For the rational **turning and milling** of workpieces on its entire length without reclamping with max. precision.

TYPE

Basic body with cylindrical shank and mechanical pressure compensation.
Clamping circuit Ø 8-80 mm.
Workpiece weight max. 100 kg.

CUSTOMER BENEFITS

- For **turning and milling** in one set-up
- Compensating driving disc, radially backlash-free
- Maximum concentricity of up to 0.01 mm
- Stable and constant workpiece length stop on the front side thanks to resilient centre point
- Maximum flexibility thanks to universal exchange of driving disc and centre point

TECHNICAL FEATURES

- Guide value for axially permissible total load on 3 support pistons: 9000 N

A14
Basic body with cylindrical shank (all basic bodies without driving disc and centre) **mechanical**

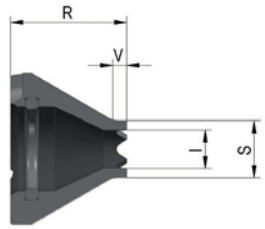
Item no.	Centre Ø mm	A mm	B mm	H mm	Z mm	Driving disc stroke mm	Weight approx. g
310071	25	62	56	max.38 min.26	16	10	1900
310072	32	62	56	max.38 min.27	16	10	2000

Other take-ups available on request

▲ on request

Accessories CoE

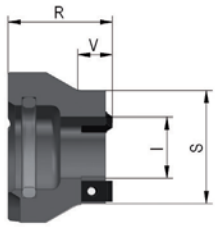
A14
Driving discs, toothed, **right- and left-hand rotation**, free from play



Item no.	Clamping circuit Ø S mm	Approx. turning range	l mm	R mm	V mm	Assoc. centre point Ø Y mm	Axial load max. N
1209000	8	9-16	4,5	38	4	4	4000
1209001	10	11-20	4,5	38	4	4	6000
1209002	12	13-24	7	36	4	6	6000
1209003	16	17-32	11	33	4	10	6000
1209004	20	21-40	13	30	4	12	8000
1209005	25	26-50	17	30	8	16	9000
1209006	32	33-64	22	30	10	16	9000

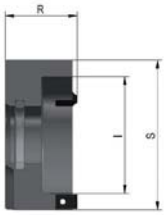
Driving discs with carbide toothing on request

A14
Driving discs, with interchangeable carbide driving plates 6 x 3.2, **right- and left-hand rotation**, free from play



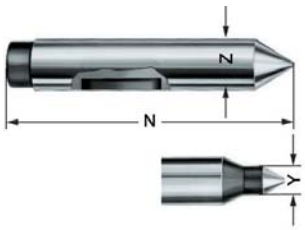
Item no.	Clamping circuit Ø S mm	Approx. turning range	l mm	R mm	V mm	Assoc. centre point Ø Y mm	Axial load max. N
1209007	20	21-40	7	30	8	6	9000
1209008	25	26-50	11	30	8	10	9000
1209009	32	33-64	17,5	30	10	16	9000
1209010	40	41-80	27	30	16	16	9000

A14
Driving discs, with interchangeable carbide driving plates 6 x 3.2, which can be used on 4 sides, **right- and left-hand rotation**, free from play



Item no.	Clamping circuit Ø S mm	Approx. turning range	l mm	R mm	Assoc. centre point Ø Y mm	Axial load max. N
1209011	50	51-100	36	30	16	9000
1209012	63	64-126	49	30	16	9000
1209013	80	81-160	66	30	16	9000

A14
Centres



Item no.	Clamping circuit Ø S mm	N mm	Y mm	Z mm
1209016	8-10	90	4	16
1209017	12	90	6	16
1209018	16	90	10	16
1209019	20	90	12	16
1209020	25-80	90	16	16

Centering taper on request

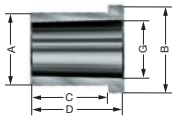
A14
Carbide driving plates, right- and left-hand rotation



Item no.	Size	Clamping circuit Ø mm
088970	6x3,2	20-32

Accessories CoE

A14
Mounting sleeve, for clamping the face driver in the lathe chuck



Item no.	MT inside	A mm	B mm	C mm	D mm	G mm
085033	3	32	39	32	40	23,825
085034	4	40	47	42	50	31,267
085035	5	55	62	52	60	44,399

CoE - product ranges

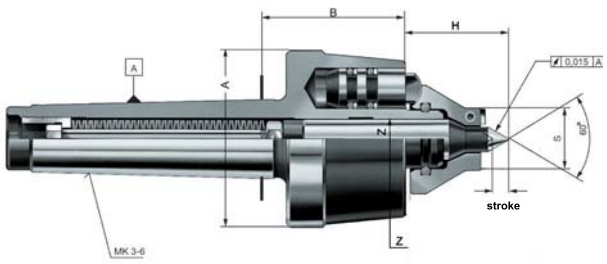
A14
CoE-small assortment in wooden box, mechanical pressure compensation, clamping circuit ø 12-50, turning range 13-100 mm
Included in delivery: 1x basic body, 4x driving discs (clamping circuit Ø 12, 20, 32, 50), 3x centre points (centering Ø 6, 12, 16)



Item no.	MT	Weight approx. g
1209048	3	3600
1209049	4	3870
1209050	5	4550

▲ on request

CoA



APPLICATION

For the rational turning of workpieces on its entire length without reclamping with max. precision.

TYPE

Basic body with morse taper and hydraulic pressure compensation.
Clamping circuit Ø 8-80 mm.
Workpiece weight max. 100 kg.

CUSTOMER BENEFITS

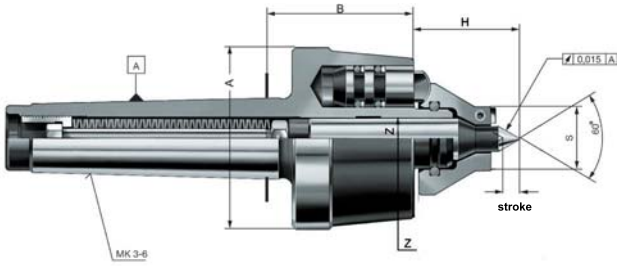
- Constant clamping force thanks to hydraulic pressure compensation, even for uneven workpiece faces
- Stable and constant workpiece length stop on the front side thanks to resilient centre point
- Maximum concentricity of up to 0.015 mm
- Maximum flexibility thanks to universal exchange of driving disc and centre point

TECHNICAL FEATURES

- Guide value for axially permissible total load on 3 support pistons: 20.000 N

A14
Basic body with **morse taper** (basic body without driving disc and centre), **hydraulic**

Item no.	MT	A mm	B mm	H mm	Z mm	Driving disc stroke mm	Weight approx. g
088173	3	70	54	max. 45 min. 26	16	10	1600
088174	4	70	56,5	max. 45 min. 26	16	15	1800
088175	5	70	56,5	max. 45 min. 26	16	15	2800
088176	6	70	56,5	max. 45 min. 26	16	15	4400



APPLICATION

For the rational turning of workpieces on its entire length without reclamping with max. precision.

TYPE

Basic body with morse taper and hydraulic pressure compensation.
Clamping circuit Ø 8-80 mm.
Workpiece weight max. 100 kg.

CUSTOMER BENEFITS

- Constant clamping force thanks to hydraulic pressure compensation, even for uneven workpiece faces
- Stable and constant workpiece length stop on the front side thanks to resilient centre point
- Maximum concentricity of up to 0.015 mm
- Maximum flexibility thanks to universal exchange of driving disc and centre point

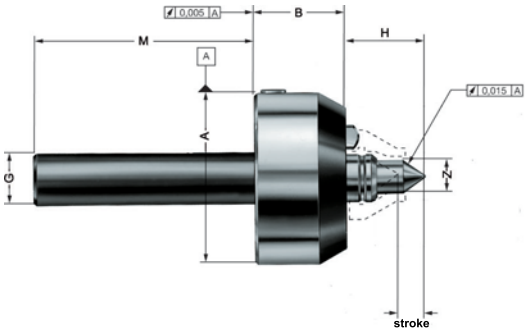
TECHNICAL FEATURES

- Guide value for axially permissible total load on 3 support pistons: 20.000 N

A14
Basic body with **morse taper**, with **draw-off nut** (basic body without driving disc and centre), **hydraulic**

Item no.	MT	A mm	B mm	H mm	Z mm	Driving disc stroke mm	Weight approx. g
088177	3	82	54	max. 45 min. 26	16	10	1800
088178	4	82	56,5	max. 45 min. 26	16	15	2200
088179	5	82	56,5	max. 45 min. 26	16	15	3000
088180	6	82	56,5	max. 45 min. 26	16	15	4600

CoA



APPLICATION

For the rational turning of workpieces on its entire length without reclamping with max. precision.

TYPE

Basic body with cylindrical shank and hydraulic pressure compensation.
Clamping circuit Ø 8-80 mm.
Workpiece weight max. 100 kg.

CUSTOMER BENEFITS

- Constant clamping force thanks to hydraulic pressure compensation, even for uneven workpiece faces
- Stable and constant workpiece length stop on the front side thanks to resilient centre point
- Maximum concentricity of up to 0.015 mm
- Maximum flexibility thanks to universal exchange of driving disc and centre point

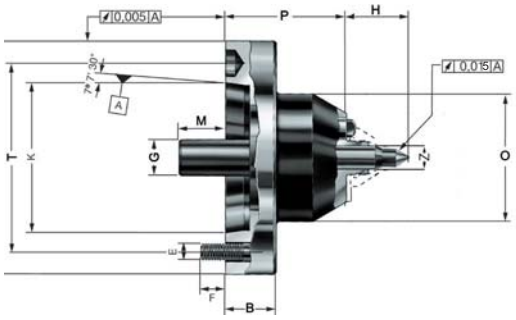
TECHNICAL FEATURES

- Guide value for axially permissible total load on 3 support pistons: 20.000 N

A14
Basic body with **cylindrical shank** for clamping in lathe chucks, with **spring package** (basic body without driving disc and centre) **mechanical / hydraulic**

Item no.	A mm	B mm	G mm	H mm	M mm	Z mm	Driving disc stroke mm	Weight approx. g
088074[1)]	85	45	25	max. 45 min. 26	110	16	15	2300
313085[2)]	85	45	25	max. 45 min. 26	110	16	15	2300

[1)] with hydraulic compensation
[2)] with mechanical compensation



APPLICATION

For the rational turning of workpieces on its entire length without reclamping with max. precision.

TYPE

Basic body with short taper and mechanical pressure compensation.
Clamping circuit Ø 8-80 mm.
Workpiece weight max. 100 kg.

CUSTOMER BENEFITS

- Constant clamping force thanks to mechanical pressure compensation, even for uneven workpiece faces
- Stable and constant workpiece length stop on the front side thanks to resilient centre point
- Maximum concentricity of up to 0.015 mm
- Maximum flexibility thanks to universal exchange of driving disc and centre point

TECHNICAL FEATURES

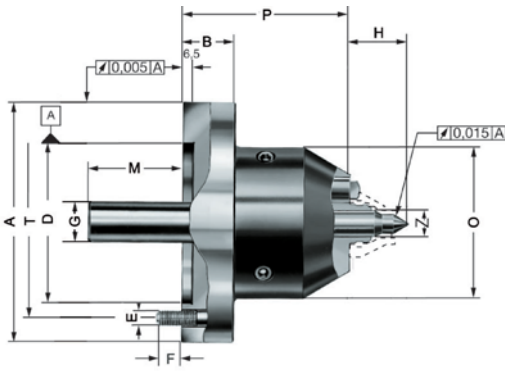
- Guide value for axially permissible total load on 3 support pistons: 20.000 N

A14
Basic body with **short taper ISO 702-1** (DIN 55026), with **spring package** (basic body without driving disc and centre) **mechanical**

Item no.	Short-taper	A mm	B mm	E	F mm	G mm	H mm	K mm	M mm	O mm	P mm	T mm	Z mm	Driving disc stroke mm	Weight approx. g
313905	5	133	-	M 10	15	25	max. 45 min. 26	82,563	32	90	86	104,8	16	11	6500
313906	6	165	35	M 12	18	25	max. 45 min. 26	106,375	32	90	86	133,4	16	11	7000
313907	8	210	40	M 16	23	25	max. 45 min. 26	139,719	32	90	86	171,4	16	11	8100

▲ on request

CoA



APPLICATION

For the rational turning of workpieces on its entire length without reclamping with max. precision.

TYPE

Basic body with centring mount and hydraulic / mechanical pressure compensation.
Clamping circuit Ø 8-80 mm.
Workpiece weight max. 100 kg.

CUSTOMER BENEFITS

- Constant clamping force thanks to hydraulic / mechanical pressure compensation, even for uneven workpiece faces
- Stable and constant workpiece length stop on the front side thanks to resilient centre point
- Maximum concentricity of up to 0.015 mm
- Maximum flexibility thanks to universal exchange of driving disc and centre point

TECHNICAL FEATURES

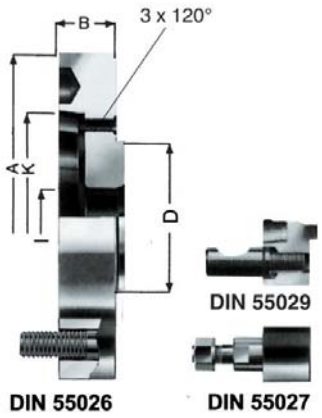
- Guide value for axially permissible total load on 3 support pistons: 20.000 N

A14
Basic body flange type, with **spring set** (basic body without driving disc and centre) **mechanical / hydraulic**

Item no.	A mm	B mm	D mm	E	F mm	G mm	H mm	M mm	O mm	P mm	T mm	Z mm	Driving disc stroke mm	Weight approx. g
088046[1)]	142	30	100	M 10	15	25	max. 45 min. 26	61	90	98	120	16	15	7300
313910[2)]	142	30	100	M 10	15	25	max. 45 min. 26	61	90	98	120	16	15	7300

[1)] with hydraulic compensation
[2)] with mechanical compensation

Adapter plate CoA



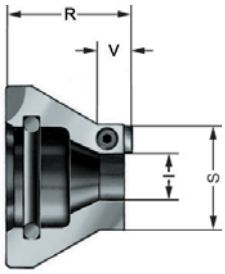
A14
Adapter plate **short taper**

Item no.	Design	Taper	A mm	B mm	D mm	l mm	K mm	Weight approx. g
088485	ISO 702-1	5	140	30	100	38	82,563	3100
088486	ISO 702-1	6	167	35	100	38	106,39	4800
088487	ISO 702-1	8	216	40	100	38	139,735	8700
088488	ISO 702-1	11	280	45	100	38	196,885	17000
088480	ISO 702-3	5	140	30	100	38	82,563	3100
088481	ISO 702-3	6	167	35	100	38	106,39	4800
088482	ISO 702-3	8	216	40	100	38	139,735	8700
088483	ISO 702-3	11	280	45	100	38	196,885	17000
088495	ISO 702-2	5	140	30	100	38	82,563	3100
088496	ISO 702-2	6	167	35	100	38	106,39	4800
088497	ISO 702-2	8	216	40	100	38	139,735	8700
088498	ISO 702-2	11	280	45	100	38	196,885	17000

▲ on request

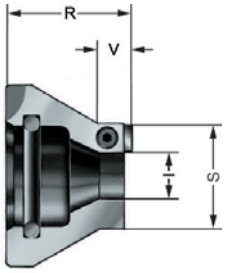
Accessories CoA

A14
Driving discs, with interchangeable carbide driving plates 6 x 3.2, **right- and left-hand rotation**



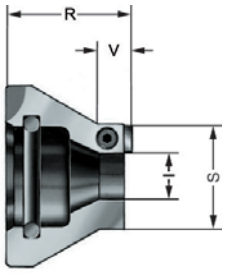
Item no.	Clamping circuit Ø S mm	Approx. turning range	l mm	R mm	V mm	Assoc. centre point Ø Y mm	Axial load max. N
088545	20 H	21-40	7	30	5	6	8000
088546	25 H	26-50	11	30	8	10	8000
088547	32 H	33-64	17,5	30	10	16	8000

A14
Driving discs, with interchangeable carbide driving plates 6 x 3.2, **right-hand rotation**



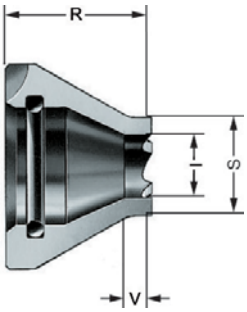
Item no.	Clamping circuit Ø S mm	Approx. turning range	l mm	R mm	V mm	Assoc. centre point Ø Y mm	Axial load max. N
089065	20 H	21-40	7	30	5	6	8000
089066	25 H	26-50	11	30	8	10	8000
089067	32 H	33-64	17,5	30	10	16	8000

A14
Driving discs, with interchangeable carbide driving plates 6 x 3.2, **left-hand rotation**



Item no.	Clamping circuit Ø S mm	Approx. turning range	l mm	R mm	V mm	Assoc. centre point Ø Y mm	Axial load max. N
089085	20 H	21-40	7	30	5	6	8000
089086	25 H	26-50	11	30	8	10	8000
089087	32 H	33-64	17,5	30	10	16	8000

A14
Driving discs, toothed, **right- and left-hand rotation**

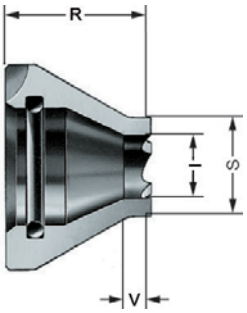


Item no.	Clamping circuit Ø S mm	Approx. turning range	l mm	R mm	V mm	Assoc. centre point Ø Y mm	Axial load max. N
088541	8	9-16	4,5	38	4	4	4000
088542	10	11-20	4,5	38	4	4	6000
088543	12	13-24	7	36	4	6	6000
088544	16	17-32	11	33	4	10	6000

Driving discs with carbide toothing on request

Accessories CoA

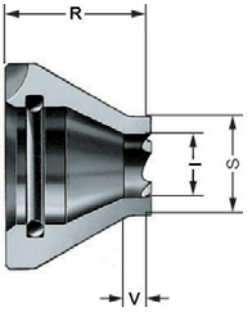
A14
Driving discs, toothed, **right-hand rotation**



Item no.	Clamping circuit Ø S mm	Approx. turning range	I mm	R mm	V mm	Assoc. centre point Ø Y mm	Axial load max. N
088061	8	9-16	4,5	38	4	4	4000
088062	10	11-20	4,5	38	4	4	6000
088063	12	13-24	7	36	4	6	6000
088064	16	17-32	11	33	4	10	6000
088065	20	21-40	13	30	4	12	8000
088066	25	26-50	17	30	8	16	10000
088067	32	33-64	22	30	10	16	12500

Driving discs with carbide toothing, friction lining or diamond grain on request

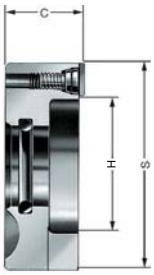
A14
Driving discs, toothed, **left-hand rotation**



Item no.	Clamping circuit Ø S mm	Approx. turning range	I mm	R mm	V mm	Assoc. centre point Ø Y mm	Axial load max. N
088081	8	9-16	4,5	38	4	4	4000
088082	10	11-20	4,5	38	4	4	6000
088083	12	13-24	7	36	4	6	6000
088084	16	17-32	11	33	4	10	6000
088085	20	21-40	13	30	4	12	8000
088086	25	26-50	17	30	8	16	10000
088087	32	33-64	22	30	10	16	12500

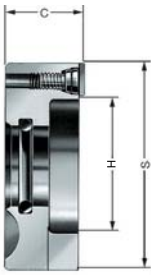
Driving discs with carbide toothing on request

A14
Driving discs, with interchangeable carbide driving plates 6 x 3.2, **right- and left-hand rotation**



Item no.	Clamping circuit Ø S mm	Approx. turning range	H mm	C mm	Assoc. centre point Ø Y mm	Axial load max. N
088548	40	41-80	20	24	16	14000
088549	50	51-100	28	24	16	14000
088550	63	64-126	41	24	16	14000
088551	80	81-160	58	24	16	14000

A14
Driving discs, with interchangeable carbide driving plates 6 x 3.2, **right-hand rotation**

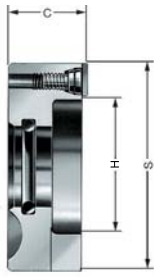


Item no.	Clamping circuit Ø S mm	Approx. turning range	H mm	C mm	Assoc. centre point Ø Y mm	Axial load max. N
088068	40	41-80	20	24	16	14000
088069	50	51-100	28	24	16	14000
088070	63	64-126	41	24	16	14000
088071	80	81-160	58	24	16	14000

▲ on request

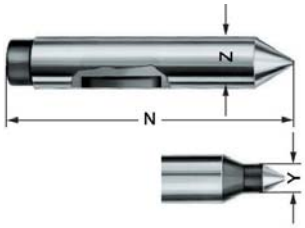
Accessories CoA

A14
Driving discs, with interchangeable carbide driving plates 6 x 3.2, **left-hand rotation**



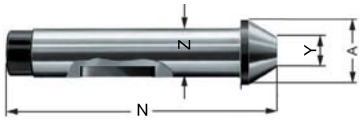
Item no.	Clamping circuit Ø S mm	Approx. turning range	H mm	C mm	Assoc. centre point Ø Y mm	Axial load max. N
088088	40	41-80	20	24	16	14000
088089	50	51-100	28	24	16	14000
088090	63	64-126	41	24	16	14000
088091	80	81-160	58	24	16	14000

A14
Centres, CoA



Item no.	Clamping circuit Ø S mm	N mm	Y mm	Z mm
088351	8-10	90	4	16
088352	12	90	6	16
088353	16	90	10	16
088354	20	90	12	16
088355	25-80	90	16	16
086758	25-80	110	16	16

A14
Centres, CoA



Item no.	Taper Ø		N mm	Z mm	Weight approx. g
	A mm	Y mm			
086619	21	10	90	16	136
086620	27	16	90	16	153
688878	34	23	90	16	190
086621	40	29	90	16	210
688880	48	37	90	16	250
086622	56	45	90	16	312

A14
Carbide driving plates, right- and left-hand rotation



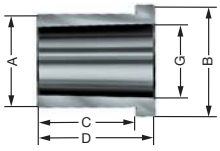
Item no.	Size	Clamping circuit Ø mm
088970	6x3,2	20-32
087931	9,5x3,2	40-80

A14
Carbide driving plates, right- **or** left-hand rotation



Item no.	Size	Clamping circuit Ø mm
088810	6x3,2	20-32
088209	9,5x3,2	40-80

A14
Mounting sleeve, for clamping the face driver in the rotary chuck



Item no.	MT inside	A mm	B mm	C mm	D mm	G mm
085033	3	32	39	32	40	23,825
085034	4	40	47	42	50	31,267
085035	5	55	62	52	60	44,399
085036	6	75	83	62	70	63,448

Accessories CoA

C15
Threaded pin



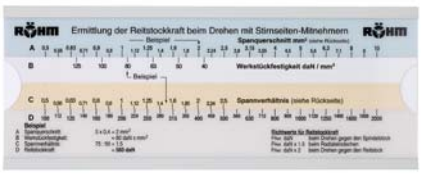
Item no.	Size	Clamping circuit Ø mm
234695	M 4 x 6	20
048205	M 5 x 8	25+32
088205	M 5 x 8	40-80

C15
O-ring



Item no.	Size
006252	21,82x3,53

A14
RÖHM slide rule for determining the axial tailstock force



Item no.
088230

▲ on request

CoA - product ranges

A14
Basic equipment in a carton, hydraulic pressure compensation, clamping dia. 12 + 32 mm, turning range 13-64 mm



Item no.	MT	right-hand rotation	left-hand rotation	With draw-off nut	Weight approx. g
088553	3	●			2100
088557	3	●		●	2400
088573	3		●		2100
088577	3		●	●	2400
088554	4	●			2400
088558	4	●		●	2700
088574	4		●		2400
088578	4		●	●	2700
088555	5	●			3300
088559	5	●		●	3600
088575	5		●		3300
088579	5		●	●	3600
088556	6	●			4900
088560	6	●		●	5200
088576	6		●		4900
088580	6		●	●	5200

A14
Small assortment in wooden box, hydraulic pressure compensation, clamping dia. 12-50 mm, turning range 13-100 mm



Delivery includes:
- Basic body
- Driving discs clamping circuit (S) 12 / 20 / 32 / 50
- Centres-Ø (Y) 6 / 12

Item no.	MT	right-hand rotation	left-hand rotation	With draw-off nut.	Weight approx. g
088501	3	●			3900
088511	3	●		●	4200
088521	3		●		3900
088531	3		●	●	4200
088502	4	●			4300
088512	4	●		●	4600
088522	4		●		4300
088532	4		●	●	4600
088503	5	●			4900
088513	5	●		●	5200
088523	5		●		4900
088533	5		●	●	5200
088504	6	●			6600
088514	6	●		●	6800
088524	6		●		6600
088534	6		●	●	6800

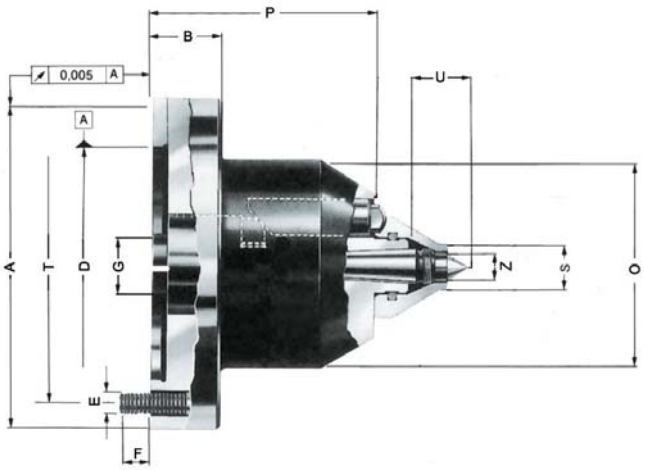
A14
L**arge assortment** in wooden box, hydraulic pressure compensation, clamping dia. 10-80 mm, turning range 11-160 mm



Delivery includes:
- Basic body
- Driving discs clamping circuit (S) 10 /12 / 16 / 20 / 25 / 32 / 40 / 50 /63 / 80
- Centres-Ø (Y) 4 /6 / 10 / 12 / 16

Item no.	MT	right-hand rotation	left-hand rotation	With draw-off nut.	Weight approx. g
088218	3	●			5600
088223	3		●		5600
088233	3	●		●	5900
088238	3		●	●	5900
088219	4	●			6000
088224	4		●		6000
088234	4	●		●	6300
088239	4		●	●	6300
088220	5	●			6600
088225	5		●		6600
088235	5	●		●	6900
088240	5		●	●	6900
088221	6	●			8300
088226	6		●		8300
088236	6	●		●	8500
088241	6		●	●	8500

CoK 8-80 mm



APPLICATION

For machining workpieces with high unbalance, heavy weight, high chip removal or irregular cutting.

TYPE

Force-actuated face driver with mechanical pressure compensation.
Clamping circuit Ø 8-80 mm.
Workpiece weight max. 350 kg.

CUSTOMER BENEFITS

- Maximum concentricity of up to 0.01 mm
- Workpiece longitudinal stop realized in centering
- Low centering force, even at max. cutting load
- Maximum flexibility thanks to universal exchange of driving disc and centre point

TECHNICAL FEATURES

- The drivers are pressed against the workpiece with force-actuation

C15
Basic body (without centre, without draw-off nut) **mechanical**

Item no.	A mm	B mm	D mm	E	F mm	G mm	O mm	P mm	T mm	Z mm	Driving disc stroke mm	Weight approx. g
313900	142	30	100	M 10	15	25	90	93	120	15	5	6500

Draw-off nut M 14x1.5 Id.No. 089229

Adapter plate CoK



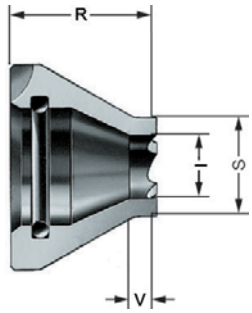
A14
Adapter plate **short taper**

Item no.	Design	Taper	A mm	B mm	D mm	I mm	K mm	Weight approx. g
088485	ISO 702-1	5	140	30	100	38	82,563	3100
088486	ISO 702-1	6	167	35	100	38	106,39	4800
088487	ISO 702-1	8	216	40	100	38	139,735	8700
088488	ISO 702-1	11	280	45	100	38	196,885	17000
088480	ISO 702-3	5	140	30	100	38	82,563	3100
088481	ISO 702-3	6	167	35	100	38	106,39	4800
088482	ISO 702-3	8	216	40	100	38	139,735	8700
088483	ISO 702-3	11	280	45	100	38	196,885	17000
088495	ISO 702-2	5	140	30	100	38	82,563	3100
088496	ISO 702-2	6	167	35	100	38	106,39	4800
088497	ISO 702-2	8	216	40	100	38	139,735	8700
088498	ISO 702-2	11	280	45	100	38	196,885	17000

▲ on request

Accessories CoK

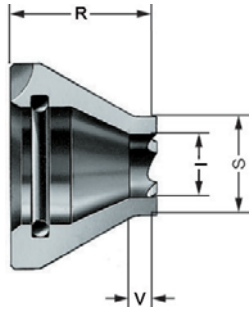
A14
Driving discs, toothed, **right-hand rotation**



Item no.	Clamping circuit Ø S mm	Approx. turning range	l mm	R mm	V mm	Assoc. centre point Ø Y mm	Axial load max. N
088061	8	9-16	4,5	38	4	4	4000
088062	10	11-20	4,5	38	4	4	6000
088063	12	13-24	7	36	4	6	6000
088064	16	17-32	11	33	4	10	6000
088065	20	21-40	13	30	4	12	8000
088066	25	26-50	17	30	8	16	10000
088067	32	33-64	22	30	10	16	12500

Driving discs with carbide toothing, friction lining or diamond grain on request

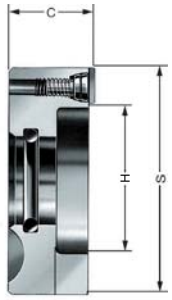
A14
Driving discs, toothed, **left-hand rotation**



Item no.	Clamping circuit Ø S mm	Approx. turning range	l mm	R mm	V mm	Assoc. centre point Ø Y mm	Axial load max. N
088081	8	9-16	4,5	38	4	4	4000
088082	10	11-20	4,5	38	4	4	6000
088083	12	13-24	7	36	4	6	6000
088084	16	17-32	11	33	4	10	6000
088085	20	21-40	13	30	4	12	8000
088086	25	26-50	17	30	8	16	10000
088087	32	33-64	22	30	10	16	12500

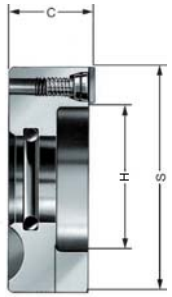
Driving discs with carbide toothing on request, friction lining or diamond grain on request

A14
Driving discs, with interchangeable carbide driving plates 6 x 3.2, **right-hand rotation**



Item no.	Clamping circuit Ø S mm	Approx. turning range	H mm	C mm	Assoc. centre point Ø Y mm	Axial load max. N
088068	40	41-80	20	24	16	14000
088069	50	51-100	28	24	16	14000
088070	63	64-126	41	24	16	14000
088071	80	81-160	58	24	16	14000

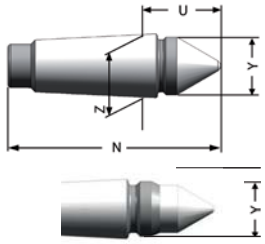
A14
Driving discs, with interchangeable carbide driving plates 6 x 3.2, **left-hand rotation**



Item no.	Clamping circuit Ø S mm	Approx. turning range	H mm	C mm	Assoc. centre point Ø Y mm	Axial load max. N
088088	40	41-80	20	24	16	14000
088089	50	51-100	28	24	16	14000
088090	63	64-126	41	24	16	14000
088091	80	81-160	58	24	16	14000

Accessories CoK

C15
Centres, CoK



Item no.	Clamping circuit Ø S mm	N mm	U mm	Y mm	Z mm	Workpiece weight max. g
088121	8-10	67,5	28	4	15	55
088122	12	67	28	6	15	75
088123	16	67	28	10	15	150
088124	20-32	64	25	12	15	250
085002	40-80	60	21	M 14x1,5	15	350

A14
Carbide driving plates, right- **or** left-hand rotation


088209

Item no.	Size	Clamping circuit Ø mm
088209	9,5x3,2	40-80

A14
Carbide driving plates, right- and left-hand rotation


087931

Item no.	Size	Clamping circuit Ø mm
087931	9,5x3,2	40-80

C15
Clamping spindle



Item no.	Size	Clamping circuit Ø mm
088205	M 5 x 8	40-80

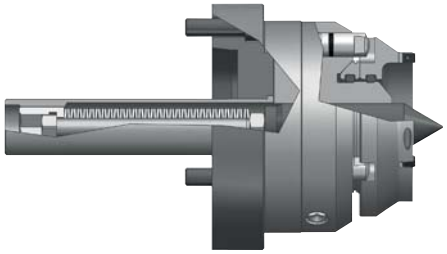
C15
O-ring



Item no.	Size
006252	21,82x3,53

▲ on request

Special solutions

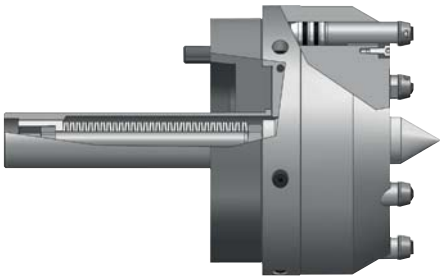


CoM - mechanical pressure compensation with driving disc

APPLICATION
For clamping large and heavy workpieces, as well as workpieces with extremely uneven faces.

TYPE
Basic body and adapter plate with disc spring package and morse taper or short taper.

CUSTOMER BENEFITS
- Resilient, stable centre point, axially adjustable
- Workpiece weight up to 500 kg
- Clamping circuit diameter 50-250 mm
- Interchangeable driving disc



CoB - hydraulic pressure compensation with driving pin

APPLICATION
For clamping large and heavy workpieces, as well as workpieces with extremely uneven faces.

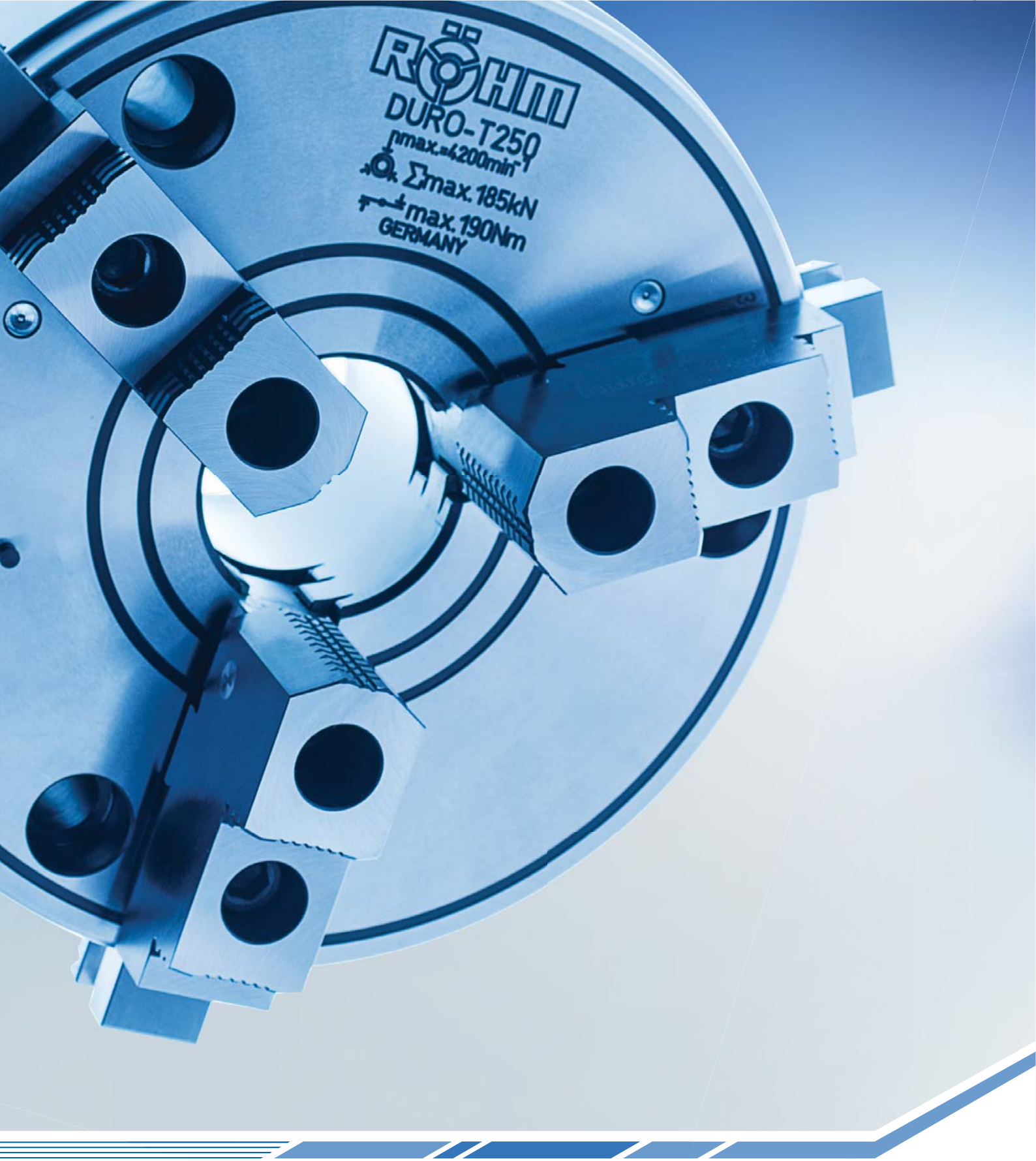
TYPE
Basic body with morse taper or short taper. Adapter plate with disc spring package.

CUSTOMER BENEFITS
- Resilient, stable centre point, axially adjustable
- Workpiece weight up to 500 kg / 1000 kg
- Clamping circuit diameter 63-160 mm

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driven by technology

Id.-Nr. 1178262 / 0915 AU



LATHE CHUCKS
INDEPENDENT CHUCKS

RÖHM
driven by technology

2015/2016

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

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

Dynamism
Variety
Security
Partnership
Globality
Innovation


RÖHM
DURO-T200
nmax=4600min-1
Smax. 114kN
max. 155Nm
GERMANY
Achtung



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LATHE CHUCKS I INDEPENDENT CHUCKS

Key bar chucks with quick-acting jaw change system

DURO-T 3009
DURO-TA 3018
DURO-TA XT 3025

Geared scroll chucks in steel design

ZS - ZSU 3034
Orange Line 3042
ZS Hi-Tru 3048
ES 3059
KRF 3066
BAV 3070
Adapter plates 3071

Steel independent chucks

USE - USU 3074
UGE - UGU 3080

Errors and corrections are reserved!

Operation guide







TYPE	DURO-T	DURO-TA	DURO-TA XT	ZS - ZSU	Orange Line
	Key bar chucks with quick-acting jaw change system			Geared scroll chucks	
Chucking capacities	3 - 630 mm	3 - 646 mm	8 - 1190 mm	2 - 1224 mm	3 - 315 mm
Mount	Cylindrical centre mount DIN 6350 ISO 702-3 (DIN 55027)	Cylindrical centre mount DIN 6350	Individual	Cylindrical centre mount DIN 6350 ISO 702-2 (DIN 55029) ISO 702-3 (DIN 55027) DIN 6350 BVV (mounting from front)	Cylindrical centre mount DIN 6350
Through-hole	✔			✔	✔
Number of jaws	3	3	3	3 / 4	3 / 4
Types of jaws					
Workpiece					
Machining					
Rotating/ Stationary					
Clamping					
Clamping force	■■■■■□	■■■■■□	■■■■■□	■■■□□	■■■□□
Speed max.	■■■■■■	■■■■■■	■■■□□	■■■□□	■■□□□
Precision	■■■■■□	■■■■■□	■■■□□	■■□□□	■■□□□
Feature	quick-acting jaw change system	grinding chuck with quick-acting jaw change system	weight reduced	with splash water groove and control edge	with splash water groove and control edge
Page	3009	3018	3025	3034	3042

✔ yes

3-jaw chuck

4-jaw chuck

pipe

bar

disc

flange

asymmetrical workpiece

Operation guide







TYPE	ZS Hi-Tru	ES	KRF	USE - USU	UGE - UGU
	Geared scroll chucks			Independent chucks	
Chucking capacities	2 - 315 mm	3 - 630 mm	2 - 200 mm	20 - 1270 mm	8 - 1250 mm
Mount	Cylindrical centre mount DIN 6350	Cylindrical centre mount DIN 6351	Cylindrical centre mount DIN 6350	Cylindrical centre mount ISO 702-2 (DIN 55029) ISO 702-3 (DIN 55027)	Cylindrical centre mount ISO 702-2 (DIN 55029) ISO 702-3 (DIN 55027)
Through-hole	✔	✔	✔	✔	✔
Number of jaws	3	3 / 4	3 / 4	4	4
Types of jaws	inside jaw + outside jaw, reversible jaw	reversible jaw	reversible jaw	inside jaw + outside jaw, reversible jaw	inside jaw + outside jaw, reversible jaw
Workpiece	base jaw, base and top jaw	base jaw, base and top jaw	base jaw, base and top jaw	base jaw, base and top jaw	base jaw, base and top jaw
Machining	lenght machining, side machining	lenght machining, side machining		lenght machining, side machining	lenght machining, side machining
Rotating/ Stationary	rotating, stationary	rotating, stationary	stationary	rotating, stationary	rotating, stationary
Clamping	self-centering	self-centering	self-centering	self-centering	self-centering
Clamping force	■■■□□	■■■□□	■□□□□	■■□□□	■■□□□
Speed max.	■■■□□	■■■□□	■□□□□	■■□□□	■□□□□
Precision	■■■■■	■■□□□	■□□□□	■■□□□	■■□□□
Feature	radial precision adjustment, with special seal for grinding machines	independently adjustable jaws	keyless clamping, specially for measu-ring and grinding machines	independently adjustable jaws	independently adjustable jaws
Page	3048	3059	3066	3074	3080

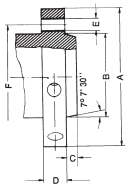
inside jaw + outside jaw
reversible jaw
rotating
independently adjustable
base jaw
lenght machining
stationary
base and top jaw
side machining
self-centering

Machine spindle noses for DIN and ASA B 5.9

Machine spindle noses (not included in the scope of delivery)

ISO 702-2 (DIN 55029 and ASA B 5.9 D1)
Camlock fixing (ISO 702-2)

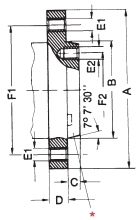




Spindle nose size	A	B	C	D	E	F
3	92,1	53,985	11,1	31,8	3x15,1	70,66
4	117,5	63,525	11,1	33,3	3x16,7	82,55
5	146	82,575	12,7	38,1	6x19,8	104,8
6	181	106,390	14,3	44,5	6x23	133,4
8	225,4	139,735	15,9	50,8	6x26,2	171,4
11	298,5	196,885	17,5	60,3	6x31	235
15	403	285,800	19	69,9	6x35,7	330,2
20	546	412,800	21	82,5	6x42,1	463,6

Latest edition of relevant DIN standard applies in each case

Typ A1-A2, B1-B2



A1: Tapped holes in flange (outer bolt circle) and inner bolt circle. From taper size 4 with driver.

A2: Tapped holes in flange (outer bolt circle) without inner bolt circle.

Spindle nose size	A	B	$C_{-0,025}$	D	Holes on outer bolt circle (F1) E1	Outer bolt circle F1	Holes on inner bolt circle (F2) E2	Inner bolt circle F2
A1 (corresponds ISO 702-1)								
5	133,4	82,575	14,288	22,2	11x $^{7}/_{16}$-14 UNC	104,8	8x $^{7}/_{16}$-14 UNC	61,9
6	165,1	106,390	15,875	25,4	11x $^{1}/_{2}$-13 UNC	133,4	8x $^{1}/_{2}$-13 UNC	82,6
8	209,5	139,735	17,462	28,6	11x $^{5}/_{8}$-11 UNC	171,4	8x $^{5}/_{8}$-11 UNC	111,1
11	279,4	196,885	19,05	34,9	11x $^{3}/_{4}$-10 UNC	235	8x $^{3}/_{4}$-10 UNC	165,1
15	381	285,800	20,638	41,3	12x $^{7}/_{8}$-9 UNC	330,2	11x $^{7}/_{8}$-9 UNC	247,6
20	520	412,800	22,225	47,6	12x 1-8 UNC	463,6	12x $^{1-8}$ UNC	368,3

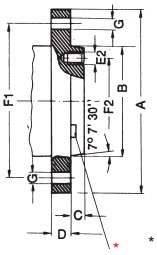


Spindle nose size	A	B	C	D	Holes on outer bolt circle (F1) E1	Outer bolt circle F1
A2 (entspricht ISO 702-1)						
3	92,1	53,985	11,1	15,9	3x $^{7}/_{16}$-14 UNC	70,66
4	108	63,525	11,1	19	11x $^{7}/_{16}$-14 UNC	82,55
5	133,4	82,575	12,7	22,2	11x $^{7}/_{16}$-14 UNC	104,8
6	165,1	106,390	14,3	25,4	11x $^{1}/_{2}$-13 UNC	133,4
8	209,5	139,735	15,9	28,6	11x $^{5}/_{8}$-11 UNC	171,4
11	279,4	196,885	17,5	34,9	11x $^{3}/_{14}$-10 UNC	235
15	381	285,800	19	41,3	12x $^{7}/_{8}$-9 UNC	330,2
20	520	412,800	20,6	47,6	12x 1-8 UNC	463,6

B1: Through-holes in flange (outer bolt circle), tapped holes in inner bolt circle - from taper size 4 with driver.

B2: Through-holes in flange (outer bolt circle) **without** inner bolt circle.

Spindle nose size	A	B	$C_{-0,025}$	D	F1 G	Outer bolt circle F1	Holes on inner bolt circle (F2) E2	Inner bolt circle F2
B1								
5	133,4	82,575	14,288	22,2	11x11,9	104,8	8x $^{7}/_{16}$-14 UNC	61,9
6	165,1	106,390	15,875	25,4	11x13,5	133,4	8x $^{1}/_{2}$-13 UNC	82,6
8	209,5	139,735	17,462	28,6	11x16,7	171,4	8x $^{5}/_{8}$-11 UNC	111,1
11	279,4	196,885	19,05	34,9	11x20,2	235	8x $^{3}/_{4}$-10 UNC	165,1
15	381	285,800	20,638	41,3	12x23,4	330,2	11x $^{7}/_{8}$-9 UNC	247,6
20	520	412,800	22,225	47,6	12x26,6	463,6	12x 1-8 UNC	368,3



* From taper size 4 with driver

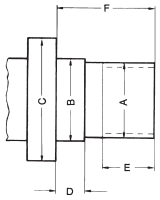
Spindle nose size	A	B	C	D	G	Outer bolt circle F1
B2						
3	92,1	53,985	11,1	15,9	3x11,9	70,66
4	108	63,525	11,1	19	11x11,9	82,55
5	133,4	82,575	12,7	22,2	11x11,9	104,8
6	165,1	106,390	14,3	25,4	11x13,5	133,4
8	209,5	139,735	15,9	28,6	11x16,7	171,4
11	279,4	196,885	17,5	34,9	11x20,2	235
15	381	285,800	19	41,3	12x23,4	330,2
20	520	412,800	20,6	47,6	12x26,6	463,6

Machine spindle noses for DIN and ASA B 5.9

Machine spindle noses (not included in the scope of delivery)

DIN 800, with thread

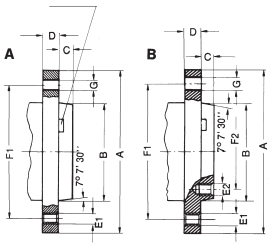




Mean tol. A	Bg5	Minimum C	D	E	F
M20	21	30	6,3	10	20
M24	25	36	8	12	24
M33	34	50	9	14	30
M39	40	56	10	16	35
M45	46	67	11	18	40
M52	55	80	12	20	45
M60	62	90	14	22	50
M76x6	78	112	16	30	63
M105x6	106	150	20	40	80

DIN 55021
From taper size 4 with driver





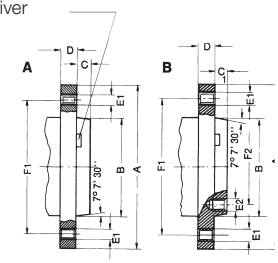
Spindle nose size	A	B	C	D	Holes on outer bolt circle (F1) E1	G	Outer bolt circle F1	Holes on inner bolt-circle (F2) E2	Inner bolt circle F2
3	102	53,985	11	16	3xM10	3x10,5	75	-	-
4	112	63,525	11	20	3xM10	3x10,5	85	-	-
5	135	82,575	13	22	7xM10	4x10,5	104,8	8xM10	61,9
6	170	106,390	14	25	7xM12	4x13	133,4	8xM12	82,6
8	220	139,735	16	28	7xM16	4x17	171,4	8xM16	111,1
11	290	196,885	18	35	12xM20	6x21	235	11xM20	165,1
15	380	285,800	20	42	12xM24	6x25	330,2	11xM24	247,6
20	520	412,800	21	48	12xM24	6x25	463,6	11xM24	368,3

Form A: Tapped holes and through-holes in flange (**without** inner bolt circle)

Form B: Tapped holes and through-holes in flange (outer bolt circle) **and** tapped holes in inner bolt circle

ISO 702-1 (DIN 55026)
From taper size 4 with driver





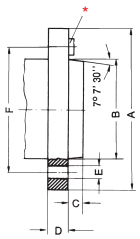
Spindle nose size	A	B	C	C_1	D	Holes on outer bolt circle E1	Outer bolt circle F1	Holes on inner bolt circle (F2) E2	Inner bolt circle F2
3	92	53,983	11	-	16	3xM10	70,6	-	-
4	108	63,521	11	-	20	11xM10	82,6	-	-
5	133	82,573	13	14,288	22	11xM10	104,8	8xM10	61,9
6	165	106,385	14	15,875	25	11xM12	133,4	8xM12	82,6
8	210	139,731	16	17,462	28	11xM16	171,4	8xM16	111,1
11	280	196,883	18	19,05	35	11xM20	235	8xM20	165,1
15	380	285,791	19	20,638	42	12xM24	330,2	11xM24	247,6
20	520	412,795	21	22,225	48	12xM24	463,6	11xM24	368,3

Form A: Tapped holes in flange (outer bolt circle) without inner bolt circle.

Form B: Tapped holes in flange (outer bolt circle) and in inner bolt circle.

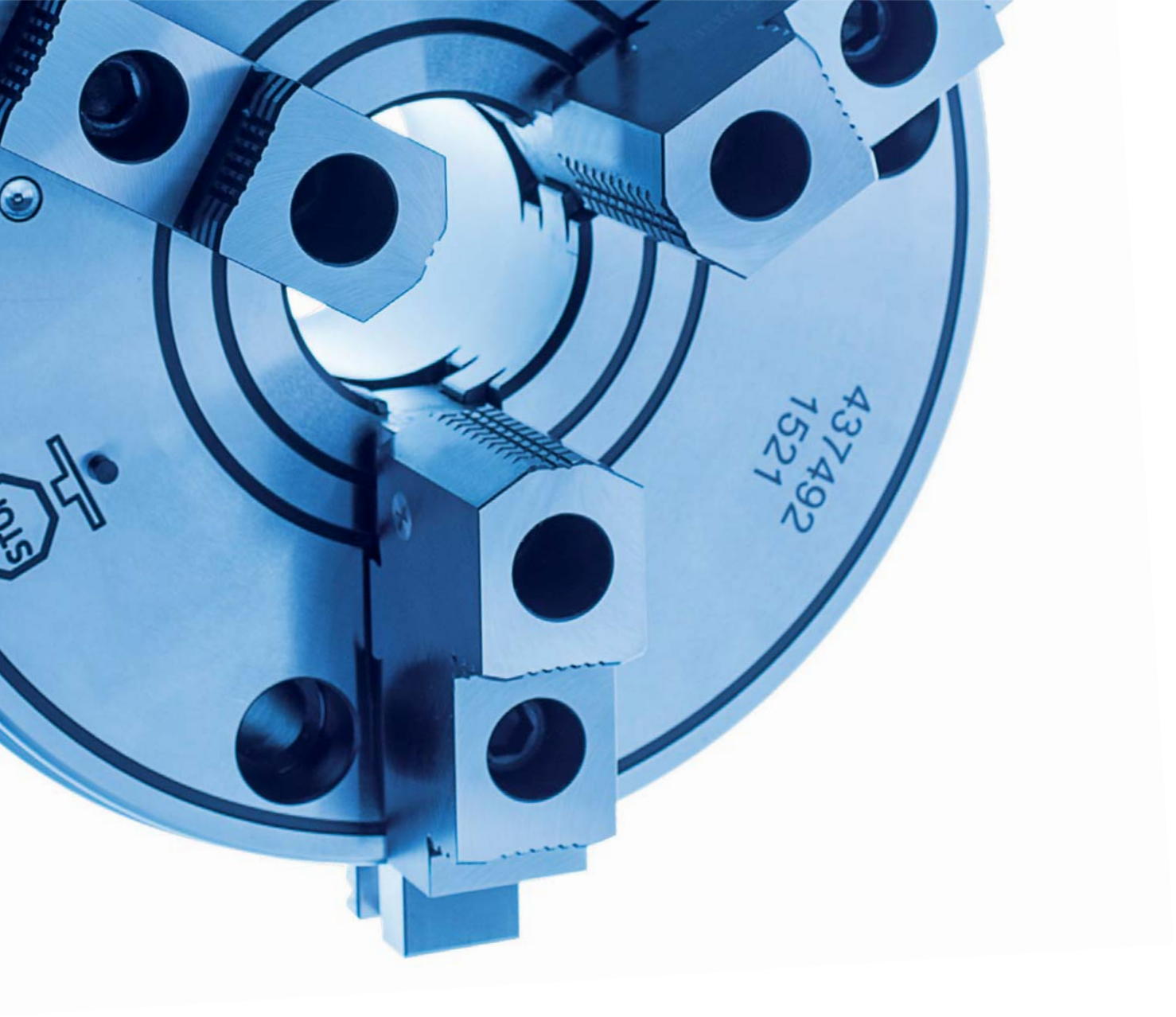
ISO 702-3 (DIN 55027 und 55022)
With bayonet ring fixing (ISO 702/III)





* From taper size 4 with driver

Spindle nose size	A	B	C	D	Number of holes x E	F
3	102	53,985	11	16	3x21	75
4	112	63,525	11	20	3x21	85
5	135	82,575	13	22	4x21	104,8
6	170	106,390	14	25	4x23	133,4
8	220	139,735	16	28	4x29	171,4
11	290	196,885	18	35	6x36	235
15	400	285,800	19	42	6x43	330,2
20	540	412,800	21	48	6x43	463,6



QUICK-ACTING JAW CHANGE SYSTEM

The RÖHM key bar chucks with quick-acting jaw change system convince in two ways. On the one hand the jaws can be quickly and easily turned, changed or offset over the entire clamping range within a few seconds. On the other the key bar chucks convince with maximum clamping forces and maximum accurancy thanks to direct force transfer via the key bar system. Large, straight surfaces transmitting the force from the key bar to the jaw teeth guarantee long life and produce a very high clamping force combined with an accurancy which is twice high as required by DIN 6386. The high clamping force is achieved without much physical effort by manually turning the key.





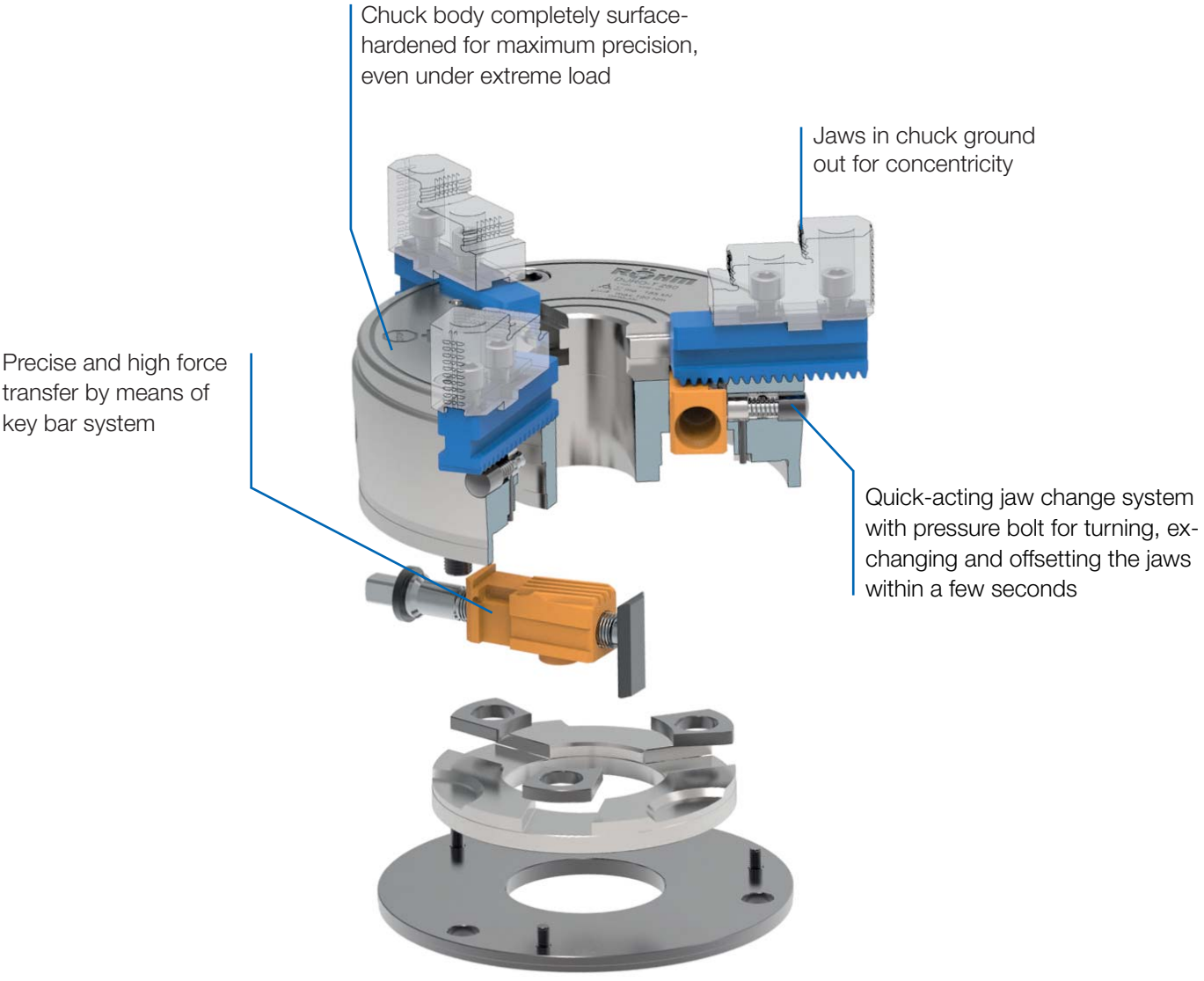
Video DURO-T

KEY BAR CHUCK WITH QUICK-ACTION JAW CHANGE SYSTEM

The RÖHM key bar chucks with quick-acting jaw change system are used successfully in areas where extremely high clamping forces, high concentricity and reliable long-term repeatability are required. Thanks to the quick-acting jaw change system, the jaws can be quickly and easily turned, changed or offset over the entire clamping range within a few seconds.

ADVANTAGES AT A GLANCE

- Maximum clamping forces thanks to direct force transfer via the key bar system
- Maximum concentricity and axial run-out tolerance
- High user-friendliness thanks to quick-acting jaw change system



DURO-T

The DURO-T key bar chuck guarantees maximum precision, maximum clamping force and is completely balanced ex works

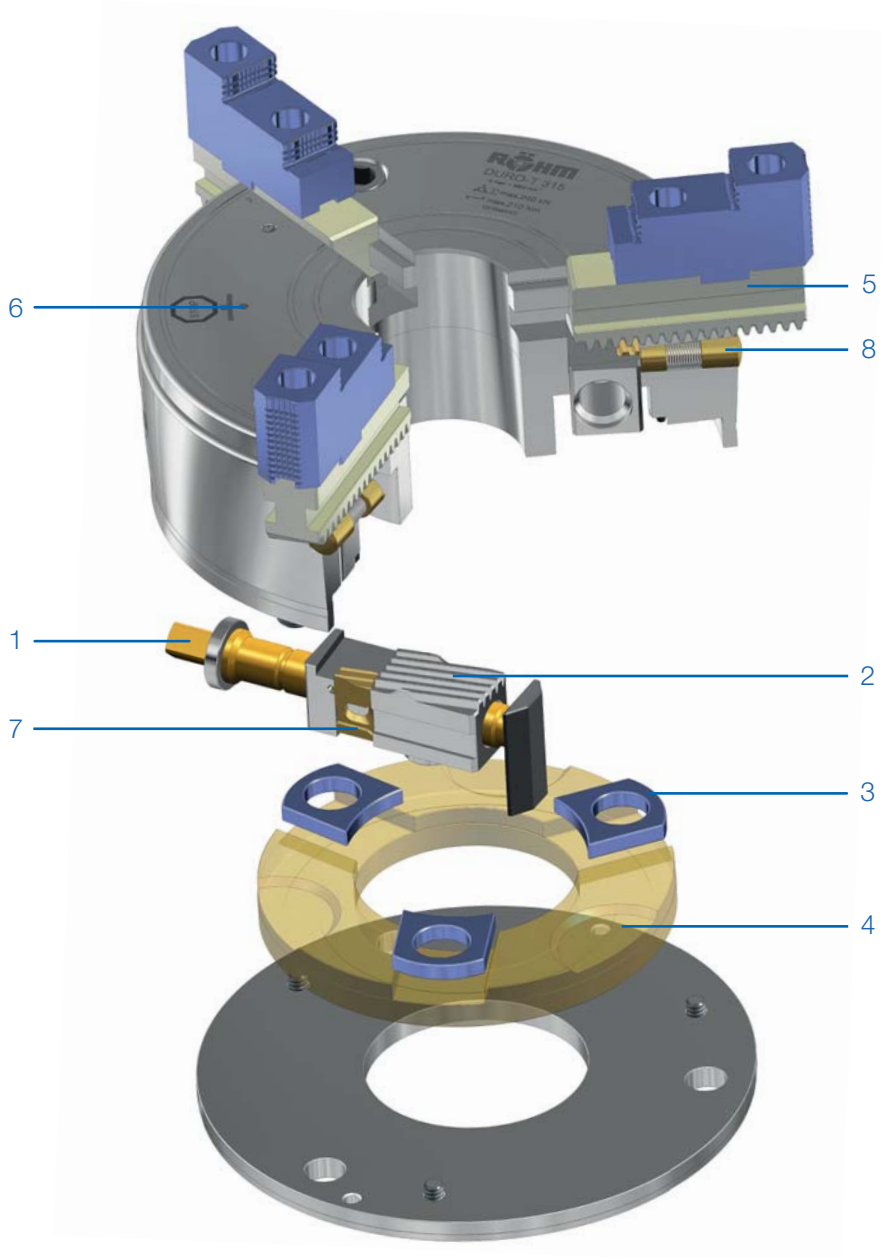
Principle of operation

Thanks to the tangentially arranged threaded spindle (1), the force is transferred via a key bar (2) having an internal thread. The key bar moves the drive ring via a slide (3). Two other slides in the drive ring (4) transfer the forces to the other two key bars. The key bars having an inclined profile engage in the base jaws (5), thereby guaranteeing exact, centric clamping. The jaws can be quickly and easily turned, changed or offset over the entire clamping range within a few seconds. To do this, the key bars must be disengaged by turning the key to the left; the indicator pin (6) will project here. In this position, the jaws are secured against being hurled out in the event the machine spindle is started up unintentionally. Therefore, the gate valve (7) of each jaw must be unlocked via the corresponding pressure bolt (8) on the outer diameter of the chuck.

Large, straight-line force transfer surfaces between the key bar and jaw toothing yield a very high clamping force over a long service life and precision which is twice as high as prescribed by DIN 6386. The high clamping force is achieved without exerting any special amount of force by manually turning the key.

Lubrication

To maintain the clamping force, rotary chucks must be lubricated regularly. You will find corresponding information in the operating instructions which are enclosed with every chuck. For easy maintenance, DURO-T chucks are equipped with three additional grease nipples on the front side.



DURO-T



APPLICATION

Optimized for turning applications, which require extremely high clamping forces, maximum concentricity, as well as reliable long-term repeatability.
In combination with a base plate, stationary use on milling machines, dividing units and machining centers.

TYPE

Key bar chuck with quick-action jaw change system.
Guaranteed maximum jaw precision as far as these are only used on the same chuck, and base and top jaws are kept screwed on for recurring work.

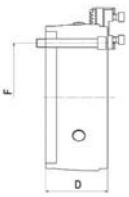
CUSTOMER BENEFITS

- Maximum clamping force thanks to key bar system
- Concentricity and axial run-out tolerance twice as exact as required in DIN precision class 1
- Very high jaw-change repeatability
- Balanced and jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With jaw safeguard
- Chuck body completely surface-hardened
- Visual marking for quick jaw adjustment
- External shape incl. splash-water edge
- Fastening options for strongly stressed sliding surfaces
- Incl. safety key
- High corrosion protection

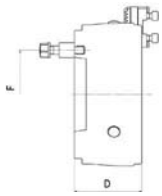
A08
Cylindrical centre mount



Size	Inch	Through-hole mm	**With one-piece reversible jaws**	**With base jaws and reversible top jaws**	D mm	Speed max. min^{-1}	Max. Torque Nm	Max. total clamping force kN
125	5	32	**437475**	**-**	46,5	6000	40	23
160	6 1/4	42	**437476**	**437490**	63	5400	120	73
200	8	52	**437477**	**437491**	81	4600	155	114
250	10	62	**437478**	**437492**	92	4200	190	185
315	12 1/2	87	**437479**	**437493**	111	3300	210	240
400	15 3/4	102	**437480**	**437494**	118	2200	260	260
500	20	162	**437481**	**437495**	118	1900	320	290
630	25	252	**-**	**437496**	143	1100	350	320

1) at size 630 chuck body without convex outer contours
Further sizes and mountings available on request

A08
ISO 702-3 (DIN 55027), with studs and locknuts



Size	Mount short taper	Through-hole mm	**With one-piece reversible jaws**	**With base jaws and reversible top jaws**	D mm	F mm	Speed max. min^{-1}	Max. Torque Nm	Max. total clamping force kN
125	5	32	**437499**	**-**	67	104,8	6000	40	23
160	5	42	**437501**	**437548**	78	104,8	5400	120	73
160	6	42	**437502**	**437549**	85	133,4	5400	120	73
200	5	52	**437504**	**437551**	96	104,8	4600	155	114
200	6	52	**437505**	**437552**	97	133,4	4600	155	114
250	6	62	**437509**	**437556**	108	133,4	4200	190	185
250	8	62	**437510**	**437557**	110	171,4	4200	190	185
315	8	87	**437512**	**437559**	129	171,4	3300	210	240
315	11	87	**437513**	**437560**	131	235	3300	210	240
400	8	102	**437515** ▲	**437562** ▲	138	171,4	2200	260	260
400	11	102	**437516** ▲	**437563** ▲	138	235	2200	260	260
500	11	162	**437519** ▲	**437566** ▲	156	235	1900	320	290
500	15	162	**437520** ▲	**437567** ▲	163	330,2	1900	320	290
630	11	192	**-**	**437568** ▲	165	235	1100	350	320
630	15	252	**-**	**437569** ▲	167	330,2	1100	350	320

1) at size 630 chuck body without convex outer contours
Further sizes and mountings available on request

Jaws DURO-T

A28
One-piece jaw EB, set**,** diagonally toothing, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
212121	125	set	50	34	14
094000	160	set	77,7	45	20
094001	200	set	94,7	60	22
094002	250	set	114	70	26
094003	315	set	130	79	32
094043	400/500	set	167	93	45

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A28
Unstepped Jaw BL, set**,** diagonally toothing, unstepped, soft, material 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
304864	125	set	53	34	14
241699	160	set	84,4	45	20
249678	200	set	98,4	60	22
249679	250	set	118,7	70	26
249680	315	set	136,6	79	32
249681	400/500	set	173,6	93	45

A28
Reversible top jaw UB, set**,** hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
094012	160	set	61,5	32,5	20,4
094013	200	set	70,5	38	24,4
094014	250	set	92	50	34,4
094015	315	set	107	56	35,7
094045	400/500	set	130	72	50,4
140715	630	Satz	185	102	68

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A28
Unstepped top jaw AB, set**, standard design**, soft, material 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
212123	125	set	55	25,5	20,7
094008	160	set	85	36,5	20,3
094009	200	set	105	40	22
094010	250	set	125	50	30,4
094011	315	set	145	50	34,3
094046	400/500	set	180	73	50,5
140716	630	set	260	102	68

1) larger design

A28
Unstepped top jaw AB, set**, extendend design**, soft, material 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
137055	160	set	85	42,5	24,4
137056	200	set	105	51	34,3
137057	250	set	125	75	50,5
137058	315	set	145	74	50,5

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Jaws DURO-T

A28
Base jaw GB, set, diagonally toothing, with mounting bolts



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw width
212119	125	set	47	14
094004	160	set	74	20
094005	200	set	90	22
094006	250	set	110	26
094007	315	set	125	32
094044	400/500	set	160	45
140194	630	set	230	65

C 21
Reversible claw-type top jaws, standard design, tongue and groove, **small clamping range**, 1 piece hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137060	160	66	37,5	24
137119	400/500	124	62	50
151289	630	144	78	70

C 21
Reversible claw-type top jaws, standard design, tongue and groove, **large clamping range**, 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137061	160	66	37,5	20
137064	200	81	43	24
137108	250	90	55	34
137114	315	100	62	34
137120	400/500	124	62	50

C 21
Reversible claw-type top jaws, standard design, tongue and groove, **middle sized clamping range**, 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137062	160	56	37,5	20
137065	200	66	43	24
137109	250	72	55	34
137115	315	86	62	34
137121	400/500	100	62	50

C 21
Reversible claw-type top jaws, large design, tongue and groove, **small clamping range**, 1 piece hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137066	160/200	79	43	34
137110	250	80	55	50
137116	315	93	62	50

Configure your individual clamping jaws online! www.web2product.biz

Jaws DURO-T

C 21
Reversible claw-type top jaws, large design, tongue and groove, **large clamping range**, 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137067	160/200	81	43	34
137111	250	90	55	50
137117	315	106	62	50

C 21
Reversible claw-type top jaws, large design, tongue and groove, **middle sized clamping range**, 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137068	160/200	66	43	34
137112	250	72	55	50
137118	315	86	62	50

C 21
Draw-down jaws, without clamping inserts, **diagonally toothing**, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
141037	160	84,4	43,5	20
141039	200	98,4	47,5	22
141041	250	118,7	58,5	26
141043	315	136,4	63,9	32
141045	400/500	173,6	73,4	45

C 21
Draw-down jaws, additional clamping range, for interchangeable clamping inserts, **diagonally toothing**, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
141038	160	84,4	43,5	20
141040	200	98,4	47,5	22
141042	250	118,7	58,5	26
141044	315	136,4	63,9	32
141046	400	173,6	73,4	45
141048	500	173,6	73,4	45

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Jaws DURO-T

C 15
Interchangeable clamping inserts, 1 piece **with claws**



Item no.	Chuck Size
141049	160/200
141052	250/315
141055	400/500/630

C 15
Interchangeable clamping inserts, 1 piece with **serrated toothing**



Item no.	Chuck Size
141050	160/200
141053	250/315
141056	400/500

C 15
Interchangeable clamping inserts, 1 piece **with heat treatable surface**



Item no.	Chuck Size
141051	160/200
141054	250/315
141057	400/500

C15
Jaw mounting bolt, 1 piece



Item no.	Size	Thread	Contents of delivery
243893	125	M6x10	piece
200182	160/200	M8x1x22	piece
200183	250	M12x1,5x30	piece
202402	315	M12x1,5x35	piece
227618	400/500	M16x1,5x40	piece
249388	630	M20x50	piece

Accessories DURO-T

A08

Base plate with fixing slots
Complete with mounting screws and fixed T-slot nuts. Other sizes available on request.



Item no.	Size
143163	160
143165	200
143167	250

A08

Key



Item no.	Size	Square	L mm
212124	125	8	85
094016	160	10	140
094017	200	12	160
094018	250	14	220
094019	315	17	230
094047	500	19	250
332938	630	24	410

Only for stationary used chucks

A08

Safety key



Item no.	Size	Square	L mm
242172	125	8	85
242173	160	10	140
242174	200	12	160
242175	250	14	220
242176	315	17	230
242177	500	19	250
332939	630	24	410

corresponding with DIN 1550 for rotating chucks

A08

Chip guard, set



Item no.	Size	Contents of delivery
212122	125	set
236439	160	set
236440	200	set
236441	250	set
236442	315	set
236443	500	set

C15

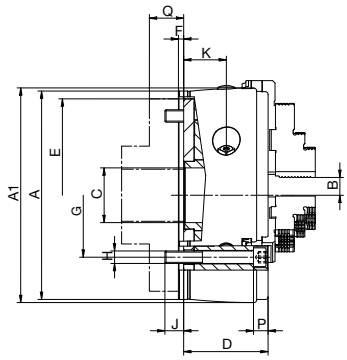
Special grease F80 **for lathe chucks**
For lubrication and conservation of chucking power

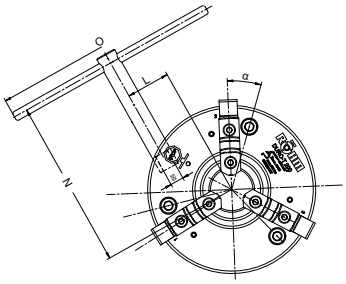


Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

▲ on request

Technical Data DURO-T





Chuck size A		125	160	200	250	315	400	500	630
Outer diameter	A1	128	164	206	256	322	407	507	630
Jaw movement	B	4,8	6,2	6,8	8	10,2	12,5	12,5	14
Bore	C	32	42	52	62	87	102	162	252
Bore cab be enlarged	C max.	35	45	55	75	102	130	180	270
	D	46,5	63	81	92	111	118	118	143
	E^{H6}	115	145	185	235	300	380	460	580
	F	4	5	5	6	6	6	6	6
	G	100	125	160	200	250	315	400	520
	H	3xM8	3xM10	3xM12	3xM16	3xM20	3xM24	3xM24	3xM24
	J	12	15	18	25	30	37	37	37
	K	22,5	31,5	43	47	59	57,7	57,5	72
	L	32,5	42	53,5	66,5	86	110	152,5	196
	M	SW8	SW10	SW12	SW14	SW17	SW19	SW19	SW24
	N	117	182	211	284	309	359	356	570
	O	180	210	270	450	500	600	600	600
	P	8,5	13	14	17	21	25	25	29
Min. thickness of flange	Q	17	30	30	35	35	40	45	55
Moment of inertia GD2 1)	kgm^2	0,01	0,03	0,10	0,29	0,87	2,37	5,78	17,04
	α	21° 35´	22°	18°	19°	17°	20°	42°	69° 30´
approx. kg	kg	4,0	9,3	18,6	34,5	64	112	166	300

1) The moment of inertia was measured with base jaws but without top jaws or back plate
The bore could be enlarged (measure C, at surcharge)
Enlarged bore max.

Max. permissible speed

The maximum permissible speed has been fixed so that 1/3 of the gripping force is still available as residual gripping force if the maximum grippping is applied and the chuck is fitted with its heaviest jaws. The jaws may not project beyond the outside diameter of the chuck. The chuck must be in perfect condition. The specification DIN 6386 Part 1 shall be observed.

Chuck size		125	160	200	250	315	400	500	630
Max. speed	min^{-1}	6000	5400	4600	4200	3300	2200	1900	1100

Gripping force

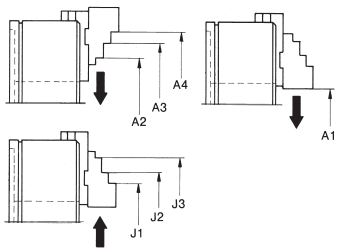
The gripping force is the sum total of all jaw forces acting radially on the stationary workpiece.
The specified gripping forces are standard values.
They apply to chucks in a perfect condition which have been lubricated with RÖHM grease F79 and F80.

Chuck size		125	160	200	250	315	400	500	630
Torque applied on key 1)	Nm	10	40	60	70	80	90	100	100
Total gripping force 1)	kN	8,5	30	48	66	80	95	102	102
Torque applied on key	Nm	40	120	155	190	210	260	320	350
Max. total gripping force	kN	23	73	114	185	240	260	290	320

1) maintaining the accuracy

At this torque the clamping jaws have been ground at the factory,
for testing the chuck must be clamped with this torque

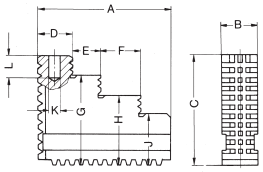
Chuck capacities of jaw steps



Chuck size			125	160	200	250	315	400	500	630
External chucking	Jaw position	A1	3-30	5-51	7-70	8-97	12-131	16-168	40-256	20-322
		A2	31-65	45-91	58-123	82-172	93-216	119-278	167-360	200-490
		A3	63-97	89-135	114-179	-	-	-	-	-
		A4	95-129	115-161	142-207	163-253	201-323	260-413	308-501	360-650
Internal chucking		J1	26-59	67-105	71-131	99-182	102-213	120-272	166-360	184-489
		J2	57-91	93-132	99-159	-	-	-	-	-
		J3	89-123	135-174	154-214	178-261	207-319	260-412	306-500	341-646

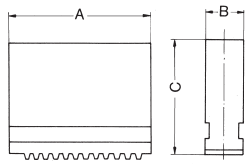
Jaw dimensions DURO-T

Reversible one-piece jaw **EB**, hardened and ground, jaw steps not ground



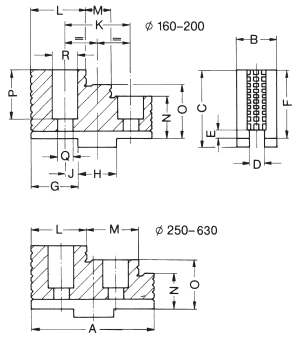
Chuck size	125	160	200	250	315	400+500
A	50	77,7	94,7	114	130	167
B	14	20	22	26	32	45
C	34	45	60	70	79	93
D	10,7	20,6	23	41,5	40,2	50,5
E	16	18,9	19,5	40,3	54	71
F	16	22	28	-	-	-
G	29	37,5	50	56	64	73
H	24	30	40	-	-	-
J	19	22,5	30	42	49	53
K	-	8	10	13	13	20
L	-	16	15	19,5	19,5	30
Jaw approx. kg	0,400	0,500	0,635	1,135	1,835	3,665

Block jaw **BL**, unstepped, soft, thread and jaw guides hardened and ground



Chuck size	125	160	200	250	315	400+500
A	53	84,4	98,4	118,7	136,6	173,6
B	14	20	22	26	32	45
C	34	45	60	70	79	93
Jaw approx. kg	0,435	0,500	0,900	1,535	2,400	5

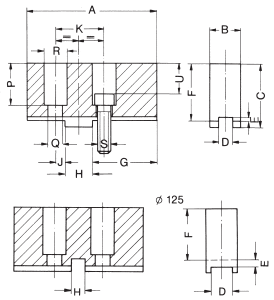
Reversible top jaw **UB**, completely hardened, cross tenon ground, jaw steps not ground



Chuck size	160	200	250	315	400+500	630
A	61,5	70,5	92	107	130	185
B	20,4	24,4	34,4	35,7	50,4	68
C	37	43	55	62	79	110
D	8	10	12	12	18	24
E	3	3,5	3,5	3,5	4,5	4,5
F	32,5	38	50	56	72	102
G	22,5	25,5	30	35,5	41,4	59
H	18	20	20	26	30	40
J	7	10	10	14	15	21
K	32	40	40	54	60	82
L	26,5	28,5	41	40	51	80
M	13	14	40,5	54	71	80
N	17,5	18	22	26	32	42
O	25	28	36	41	52	72
P	23,5	29	39	40	57	82
Q	9	9	14	14	18	22
R	15	15	20	20	26	33
T[1)]	38,5	45	57	63,6	80,6	114
Jaw approx. kg	0,200	0,335	0,800	1,135	2,535	6,350

1) Dimension marked on base jaw

Unstepped soft top jaw **AB**, for turning out special chucking diameters

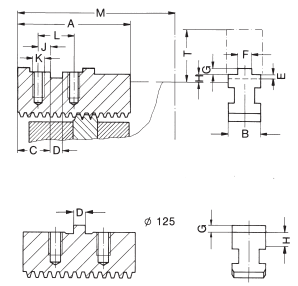


Dimensions for extendend design

Chuck size	125	160		200		250		315		400+500	630
A	55	85	**85**	105	**105**	125	**125**	145	**145**	180	260
B	20,7	20,3	**24,4**	22	**34,3**	30,4	**50,5**	34,3	**50,5**	50,5	68
C	31,3	41	**47**	45	**56**	55	**80**	56	**80**	80	110
D	14	8	**8**	10	**10**	12	**12**	12	**12**	18	24
E	3,3	3	**3**	3,5	**3,5**	3,5	**3,5**	3,5	**3,5**	4,5	4,5
F	25,5	36,5	**42,5**	40	**51**	50	**75**	50	**74**	73	102
G	25	42	**42**	50	**50**	70	**70**	74	**74**	100	150
H	5	18	**18**	20	**20**	20	**20**	26	**26**	30	40
J	7,5	7	**7**	10	**10**	10	**10**	14	**14**	15	21
K	20	32	**32**	40	**40**	40	**40**	54	**54**	60	82
P	24	27,5	**33,5**	31	**42**	39	**54**	34	**48**	58	83
Q	6,5	9	**9**	9	**9**	14	**14**	14	**14**	18	22
R	11	15	**15**	15	**15**	20	**20**	20	**20**	26	33
S	M6	M8x1	**M8x1**	M8x1	**M8x1**	M12x1,5	**M12x1,5**	M12x1,5	**M12x1,5**	M16x1,5	M20
T[1)]	32	42,5	**48,5**	47	**58**	57	**72**	57,6	**71,6**	81,6	114
U	18	19,5	**25,5**	23	**34**	27	**42**	22	**36**	42	63
Jaw approx. kg	0,200	0,435	**0,600**	0,735	**1,400**	1,500	**3,700**	2,265	**4,800**	4,500	13,350

1) Dimension marked on base jaw

Base jaws **GB,** hardened and ground



Chuck size	125	160	200	250	315	400+500	630
A	47	74	90	110	125	160	230
B	14	20	22	26	32	45	65
C	21	19	23	26	30	35	52
D	5	18	20	20	26	30	40
E	-	5	5,5	5,5	6,5	7,5	9
F	-	8	10	12	12	18	24
G	2,8	2,5	3	3	3	4	4
H	3,55	6	7	7	7,6	8,6	12
J	7,5	7	10	10	14	15	21
K	M6	M8x1	M8x1	M12x1,5	M12x1,5	M16x1,5	M20
L	20	32	40	40	54	60	82
M	72	103	129	163	196	250 | 294	399
Jaw approx. kg	0,200	0,265	0,365	0,700	1,065	2,350	5,665

Notes

DURO-TA - sealed design



APPLICATION

Specially for grinding machines.
Optimized for extremely high clamping forces, maximum concentricity, as well as reliable long-term repeatability.

TYPE

Key bar chuck with quick-action jaw change system.
Guaranteed maximum jaw precision as far as these are only used on the same chuck, and base and top jaws are kept screwed on for recurring work.

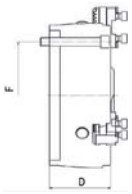
CUSTOMER BENEFITS

- Maximum clamping force thanks to key bar system
- With cover for protection against dust on the face
- Very high jaw-change repeatability

TECHNICAL FEATURES

- With jaw safeguard
- Chuck body completely surface-hardened
- Visual marking for quick jaw adjustment
- External shape incl. splash-water edge
- Fastening options for strongly stressed sliding surfaces
- Incl. safety key
- High corrosion protection

A08
Cylindrical centre mount



Size	Inch	With base jaws	With inside and outside jaw	D mm	Speed max. min^{-1}	Max. Torque Nm	Max. total clamping force kN
160	6 1/4	**439606**	**439605**	63	5400	120	73
200	8	**439608**	**439607**	81	4600	155	114
250	10	**439610**	**439609**	92	4200	190	185

Further sizes and mountings available on request

▲ on request

Jaws DURO-TA

A28
Outside jaw DB, set, inward stepped jaw, hardened



Item no.	Chuck Size	Contents of delivery	Jaw width
329041	160	set	20
329042	200	set	22
329043	250	set	26

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A28
Inside jaw BB, set, outward stepped jaw, hardened



Item no.	Chuck Size	Contents of delivery	Jaw width
329038	160	set	20
329039	200	set	22
329040	250	set	26

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A28
Unstepped top jaw AB, **set, soft**, material 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
329044	160	set	90	36,5	20,3
329045	200	set	100	40	22
094010	250	set	125	50	30,4

A28
Base jaw GB, **set,** hardened, with mounting bolts



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
329047	160	set	74	8	20
329048	200	set	90	10	22
329049	250	set	110	12	26

C15
Jaw mounting bolt, 1 piece



Item no.	Chuck Size	Thread	Contents of delivery
200182	160/200	M8x1x22	piece
200183	250	M12x1,5x30	piece

Configure your individual clamping jaws online! www.web2product.biz

Accessories DURO-TA

A08

Base plate with fixing slots
Complete with mounting screws and fixed T-slot nuts. Other sizes available on request.



Item no.	Size
143163	160
143165	200
143167	250

A08

Key



Item no.	Size	Square	L mm
094016	160	10	140
094017	200	12	160
094018	250	14	220

Only for stationary used chucks

A08

Safety key



Item no.	Size	Square	L mm
242173	160	10	140
242174	200	12	160
242175	250	14	220

corresponding with DIN 1550 for rotating chucks

A08

Chip guard, set



Item no.	Size	Contents of delivery
236439	160	set
236440	200	set
236441	250	set

A08

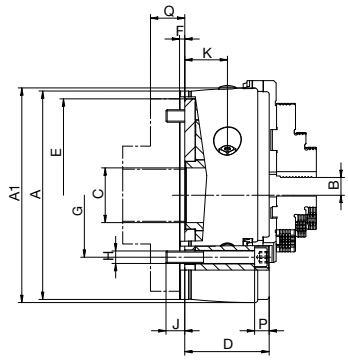
Special grease F80 for **lathe chucks**
For lubrication and conservation of chucking power

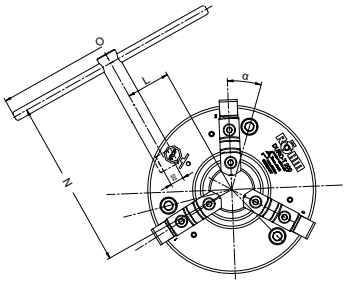


Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

▲ on request

Technical data DURO-TA





Chuck size		160	200	250
Outer diameter	A	160	206	255
Jaw movement	B	6,2	6,8	8
Bore	C	42	52	62
Bore can be enlarged	C max.	45	55	75
	D	63	81	92
	E^{H6}	145	185	235
	F	5	5	6
	G	125	160	200
	H	3xM10	3xM12	3xM16
	J	15	18	25
	K	31,5	43	47
	L	42	53,5	66,5
	M	SW10	SW12	SW14
	N	182	211	284
	O	210	270	450
	P	13	14	17
Min. thickness of flange	Q	30	30	35
Moment of inertia 1)	kgm^2	0,03	0,10	0,29
	α	22°	18°	19°
Weight approx	kg	9,5	20°	35

1) The moment of inertia was measured with base jaws but without top jaws or back plate
The bore could be enlarged (measure C, at surcharge)

Enlarged bore max.

Max. permissible speed
The maximum permissible speed has been fixed so that 1/3 of the gripping force is still available as residual gripping force if the maximum grippping is applied and the chuck is fitted with its heaviest jaws. The jaws may not project beyond the outside diameter of the chuck. The chuck must be in perfect condition. The specification DIN 6386 Part 1 shall be observed.

Chuck size		160	200	250
Max. speed	min^{-1}	5400	4600	4200

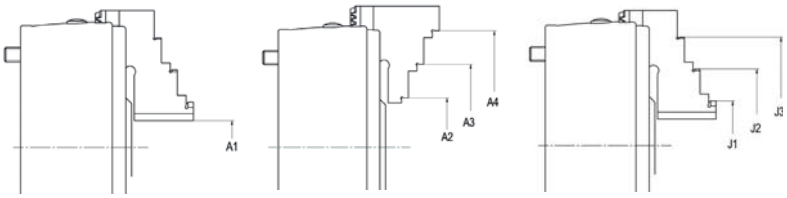
Gripping force
The gripping force is the sum total of all jaw forces acting radially on the stationary workpiece.
The specified gripping forces are standard values.
They apply to chucks in a perfect condition which have been lubricated with RÖHM grease F79 and F80.

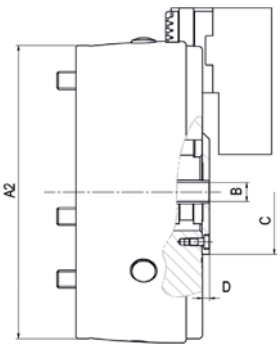
Chuck size		160	200	250
Torque applied on key in1)	Nm	20	30	35
Total gripping force1)	kN	15	24	33
Torque applied on key in	Nm	120	155	190
Max. total gripping force	kN	73	114	185

1) maintaining the accuracy

Chucking capacities of jaw steps

Chuck size			160	200	250
External chucking	Jaw position.	A1	5-51	7-70	8-97
		A2	45-91	58-123	82-172
		A3	89-135	114-179	-
		A4	115-161	142-207	163-253
Internal chucking		J1	67-105	71-131	99-182
		J2	93-132	99-159	-
		J3	135-174	154-214	178-261

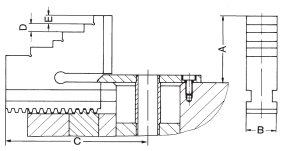




Chuck dimensions DURO-TA - Main dimensions (other dimensions on the table on the top)

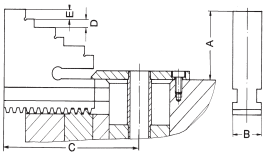
Chuck size		160	200	250
Outer diameter	A	160	206	255
External chucking with BB-jaws		3-46	3-60	5-66
External chucking with DB-jaws		23-160	32-200	65-243
Internal chucking with BB jaws		28-156	32-195	47-225
Central bor for coolant	B	13	13	13
	C	70	85	92
	D	5	6	5

Jaw dimensions and chucking capacity DURO-TA



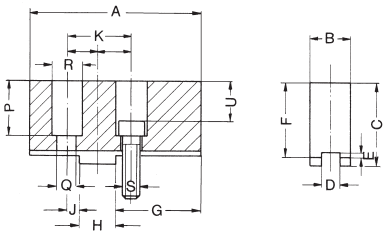
Outward stepped jaw **BB**

Chuck size	160	200	250
A	46	55	60
B	20	22	26
C max.	95	120	143,5
C min.	72	91	113
D	5	7	6
E	6	6	8
Jaw approx. kg	0,465	0,643	1,065



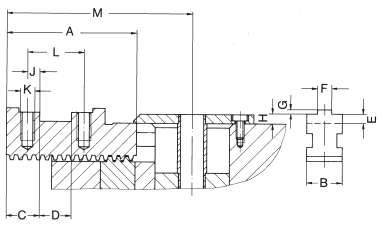
Inward stepped jaw **DB**

Chuck size	160	200	250
A	43	50	50
B	20	22	26
C max.	95	120	143,5
C min.	72	91	113
D	5	7	6
E	6	6	8
Jaw approx. kg	0,435	0,600	1,065



Unstepped soft top jaw **AB**

Chuck size	160	200	250
A	90	100	125
B	20,3	22	30
C	41	45	55
D	8	10	12
E	3	3,5	3,5
F	36,5	40	50
G	55	61	70
H	18	20	20
J	6	6	10
K	30	32	40
P	27,5	31	39
Q	9	9	14
R	15	15	20
S	M8x1	M8x1	M12x1,5
U	19,5	23	27
Jaw approx. kg	0,435	0,800	1,500



Base jaw **GB**

Chuck size	160	200	250
A	74	90	110
B	20	22	26
C	17	19	26
D	18	20	20
E	5	5,5	5,5
F	8	10	12
G	2,5	7	7
H	6	20	20
J	7	6	10
K	M8x1	M8x1	M12x1,5
L	32	32	40
M max.	105	127	148,5
M min.	91	103	125
Jaw approx. kg	0,335	0,365	0,700

Notes

DURO-TA XT

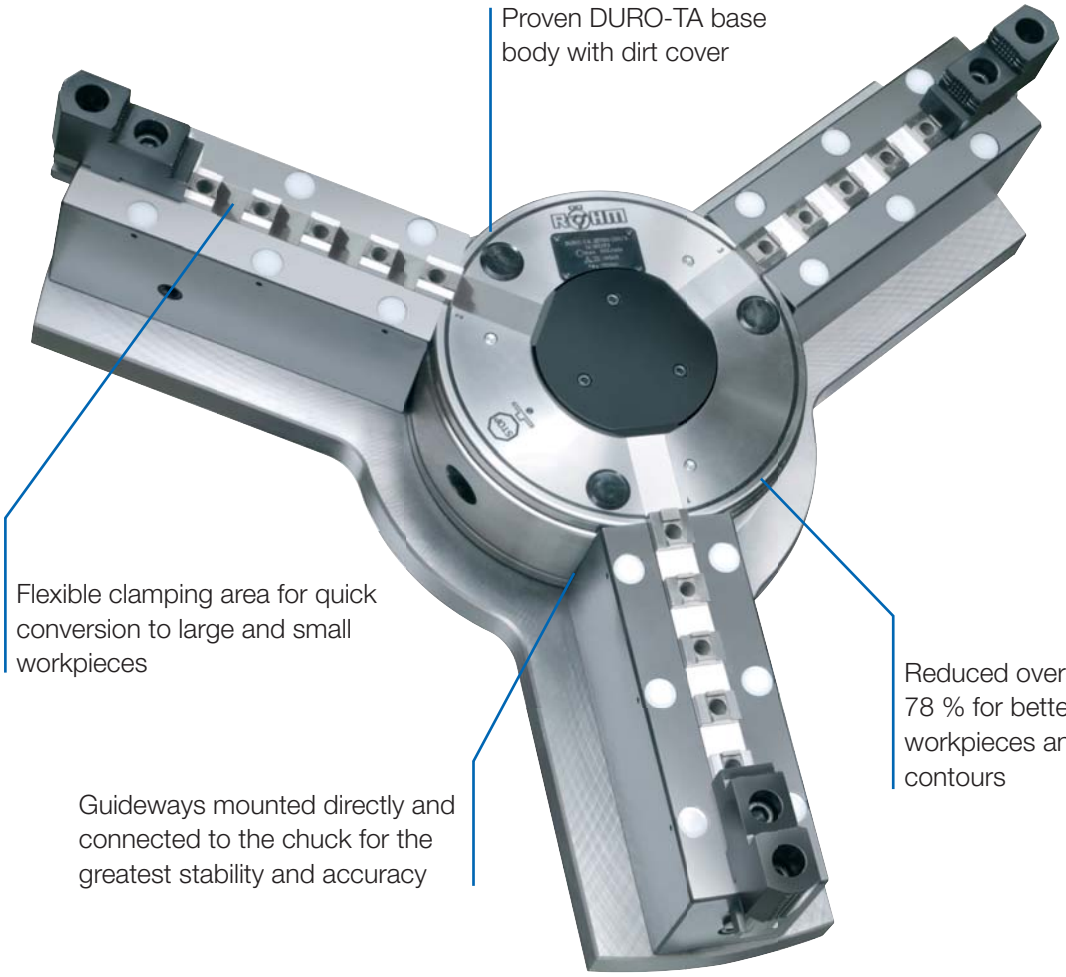
Equipped with extended and easy to assemble guideways the new lightweight DURO-TA XT is convincing with a flexible clamping area for machining large and small workpieces. Weight-reducing by up to 75 % makes maximum utilisation of the machine's potential possible.

Guideways

The new DURO-TA XT has an innovative concept for guideways that guarantees flexible and weight-reducing use. In contrast to other large chucks, the DURO-TA XT is up to 75 % lighter and that way makes maximum utilisation of the machine's potential possible and clamping of higher workpiece weights. Through the extended and easy to assemble guideways, the clamping area can be set flexibly and hence converted quickly to large and small workpieces. Through the direct mount on the base body, the guideways guarantee extremely high rigidity, stability and protection against penetration by dirt and dust.

Principle of operation

Thanks to the tangentially arranged threaded spindle, the force is transferred via a key bar having an internal thread. The key bar moves the drive ring via a slide. Two other slides in the drive ring transfer the forces to the other two key bars. The key bars having an inclined profile engage in the base jaws, thereby guaranteeing exact, centric clamping.



DURO-TA XT



APPLICATION

On turning and milling machines.

TYPE

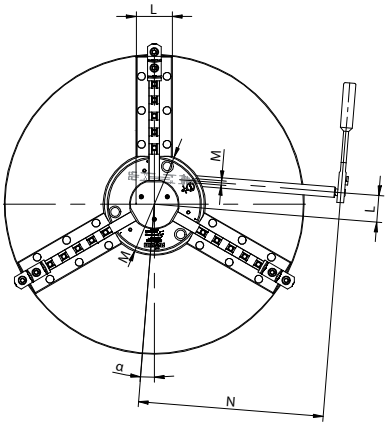
Key bar chuck (DURO-TA) with removable guideways.

CUSTOMER BENEFITS

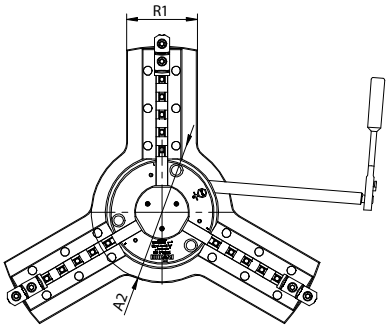
- Weight reduction by up to 75 %
- Maximum flexibility and faster conversion
- Innovative design with minimum interference contour and maximum stability

TECHNICAL FEATURES

- Weight reduction by up to 75 % allows maximum utilization of the machine potential and the clamping of heavier workpieces
- Flexible clamping range thanks to elongated guideways for faster conversion between large and small workpieces
- Easy dismounting of the guideways for clamping smaller workpieces
- Minimum interference contour and better workpiece accessibility thanks to compact design and a reduced design height by up to 78 %
- High stability thanks to direct support of the permanently screwed guideways



full base plate



max. lightweight base plate

A08

DURO-TA XT key bar chuck, with complete base plate

Item no.	Size	Clamping range external with extended jaws mm	Clamping range external with standard jaws * mm	Interfering contour ** mm	Jaw travel mm	Weight kg	Speed max. min^{-1}	Max. Torque Nm	Max. total clamping force kN	Weight reduction compared to a standard chuck %
180312	750 (250)	145-715	8-253	804 / 769	8	183	800	190	185	75
180313	1000 (315)	220-995	12-323	1082 / 1014	10,2	365	570	210	190	68
180314 ▲	1250 (500)	220-1190	40-501	1305	12,5	640	570	320	290	65

Customized adaptations of the base plate for further weight reduction on the machine table on request

* By disassembling of the stripping cap and use of standard reversible jaws

** By shortening of the base jaws. Please consider shorter clamping ranges

Further sizes and mountings available on request

Jaws DURO-TA XT

A28
One-piece jaw EB, set, diagonally toothing, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
094002	250	set	114	70	26
094003	315	set	130	79	32
094043	400/500	set	167	93	45

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.
Jaws only usable in basic chuck.

A28
Unstepped Jaw BL, set, diagonally toothing, unstepped, soft, material 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
249679	250	set	118,7	70	26
249680	315	set	136,6	79	32
249681	400/500	set	173,6	93	45

Jaws only usable in basic chuck.

A28
Reversible top jaw UB, set, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
094014	250	set	92	50	34,4
094015	315	set	107	56	35,7
094045	400/500	set	130	72	50,4

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.
Jaws only usable in basic chuck.

A28
Base jaw GB, set, diagonally toothing, with mounting bolts



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw width
094006	250	set	110	26
094007	315	set	125	32
094044	400/500	set	160	45

Jaws only usable in basic chuck.

C 21
Draw-down jaws, without clamping inserts, **diagonally toothing**, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
141041	250	118,7	58,5	26
141043	315	136,4	63,9	32
141045	400/500	173,6	73,4	45

Jaws only usable in basic chuck.

C 21
Draw-down jaws, additional clamping range, for interchangeable clamping inserts, **diagonally toothing**, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
141042	250	118,7	58,5	26
141044	315	136,4	63,9	32
141048	500	173,6	73,4	45

Jaws only usable in basic chuck.

▲ on request

Jaws DURO-TA XT

C 15
Interchangeable clamping inserts, 1 piece, **with claws**



Item no.	Chuck Size
141052	250/315
141055	400/500/630

Jaws only usable in basic chuck.

C 15
Interchangeable clamping inserts, 1 piece, **with serrated toothing**



Item no.	Chuck Size
141053	250/315
141056	400/500

Jaws only usable in basic chuck.

C 15
Interchangeable clamping inserts, 1 piece, **with heat treatable surface**



Item no.	Chuck Size
141054	250/315
141057	400/500

Jaws only usable in basic chuck.

A28
Reversible top jaw UB, set, hardened



Id.-Nr.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
180410	750	set	92	50	34,4
180411	1000	set	107	56	35,7
180412	1250	set	130	72	50,4

Additionally or later purchased, hardened jaws must be ground out in the chuck..
For jaws which are applied later, send in the chuck.

A28
Unstepped top jaw AB, **set, standard design**, soft, material 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
094010	250	set	125	50	30,4
094011	315	set	145	50	34,3
094046	400/500	set	180	73	50,5

C 21
Reversible claw-type top jaws, standard design, tongue and groove, **small clamping range,** 1 piece hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137119	400/500	124	62	50

Jaws DURO-TA XT

C 21
Reversible claw-type top jaws, **standard design,** tongue and groove, **middle sized clamping range**, 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137109	250	72	55	34
137115	315	86	62	34
137121	400/500	100	62	50

C 2
Reversible claw-type top jaws, standard design, tongue and groove, **large clamping range**, 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137108	250	90	55	34
137114	315	100	62	34
137120	400/500	124	62	50

C 21
Reversible claw-type top jaws, large design, tongue and groove, **small clamping range**, 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137110	250	80	55	50
137116	315	93	62	50

C 21
Reversible claw-type top jaws, large design, tongue and groove, **middle sized clamping range**, 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137112	250	72	55	50
137118	315	86	62	50

C 21
Reversible claw-type top jaws, large design, tongue and groove, **large clamping range,** 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137111	250	90	55	50
137117	315	106	62	50

Accessories DURO-TA XT

C15

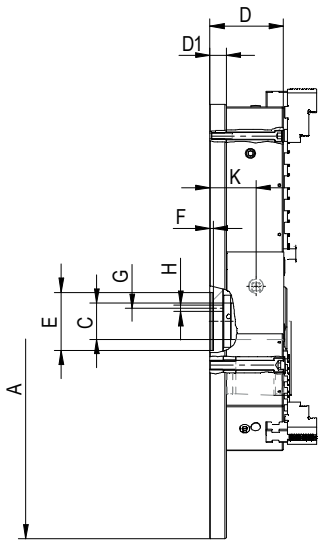
Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

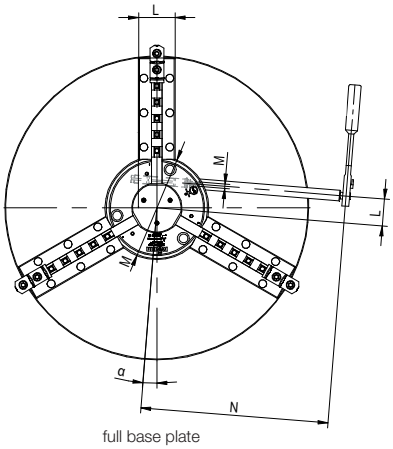
▲ on request

Technical data DURO-TA XT

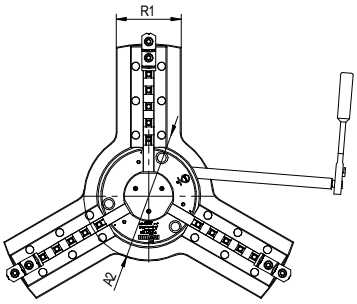


Chuck size A		750	1000	1250
Outer diameter Chuck	A1	256	322	507
Outer diameter Base plate	A2	320	400	590
Jaw movement	B	8	10,2	12,5
Bore 1)	C	62	87	162
	D	127	152	160
	D^1	28	34	35
	E^{H6}	100	100	100
	F	6	6	6
	G	45	45	45
	H	11	11	11
	K	79,5	98,0	97,5
	L	66,5	86	152,5
	M	SW14	SW17	SW19
	N	464	565	724
	R	90	100	130
	R1	160	180	210
	S	370	495	615
Moment of inertia GD2 2)	kgm^2	10,52	37,92	98,70
Moment of inertia GD2 2) 3)	kgm^2	5,66	18,10	48,93
	α	4,6°	4,6°	4,5°
approx. kg	kg	183	365	640
approx. kg 3)	kg	127	233	436

1) With dirt cover
2) The moment of inertia was measured with base jaws but without top jaws
3) With max. lightweight base plate



full base plate



max. lightweight base plate

Max. permissible speed

The maximum permissible speed has been fixed so that 1/3 of the gripping force is still available as residual gripping force if the maximum grippping is applied and the chuck is fitted with its heaviest jaws. The jaws may not project beyond the outside diameter of the chuck. The chuck must be in perfect condition. The specification DIN 6386 Part 1 shall be observed.

Chuck size		750	1000	1250
Max. speed	min^{-1}	800	570	450

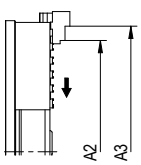
Gripping force

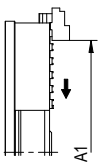
The gripping force is the sum total of all jaw forces acting radially on the stationary workpiece.
The specified gripping forces are standard values.
They apply to chucks in a perfect condition which have been lubricated with RÖHM grease F79 and F80.

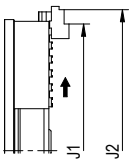
Chuck size		750	1000	1250
Torque applied on key 1)	Nm	70	80	100
Total gripping force 1)	kN	66	80	102
Torque applied on key	Nm	190	210	320
Max. total gripping force	kN	185	240	290

1) Maintaining the accuracy

At this torque the clamping jaws have been ground at the factory,
for testing the chuck must be clamped with this torque







Chuck capacities of jaw steps

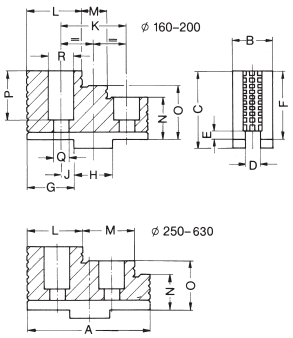
Chuck size			750	1000	1250
External chucking	Jaw position	A1	144-618	215-864	215-1140
		A2	144-638	330-890	199-1159
		A3	224-719	223-995	340-1200
Internal chucking		J1	227-700	298-946	318-1141
		J2	307-780	404-1052	459-1282
max. interfering contour			808/**773	1086/**1018	1309

** By shortening of the base jaws. Please consider shorter clamping ranges.

Jaw dimensions DURO-TA XT

Reversible top jaw UB, completely hardened, cross tenon ground, jaw steps not ground

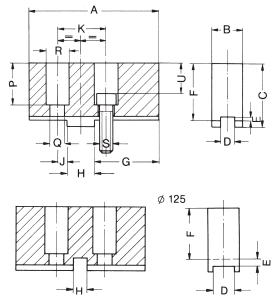
Jaws only usable in basic chuck.



Chuck size	750	1000	1250
A	92	107	130
B	34,4	35,7	50,4
C	55	62	79
D	12	12	18
E	3,5	3,5	4,5
F	50	56	72
G	30	35,5	41,4
H	20	26	30
J	10	14	15
K	40	54	60
L	41	40	51
M	40,5	54	71
N	22	26	32
O	36	41	52
P	39	40	57
Q	14	14	18
R	20	20	26
T[1)]	57	63,6	80,6
Jaw approx. kg	0,800	1,135	2,535

1) Dimension marked on base jaw

Unstepped soft top jaw **AB**, for turning out special chucking diameters

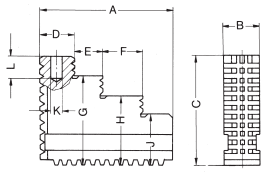


Dimensions for extendend design

Chuck size	750		1000		1250
A	125	**125**	145	**145**	180
B	30,4	**50,5**	34,3	**50,5**	50,5
C	55	**80**	56	**80**	80
D	12	**12**	12	**12**	18
E	3,5	**3,5**	3,5	**3,5**	4,5
F	50	**75**	50	**74**	73
G	70	**70**	74	**74**	100
H	20	**20**	26	**26**	30
J	10	**10**	14	**14**	15
K	40	**40**	54	**54**	60
P	39	**54**	34	**48**	58
Q	14	**14**	14	**14**	18
R	20	**20**	20	**20**	26
S	M12x1,5	**M12x1,5**	M12x1,5	**M12x1,5**	M16x1,5
T[1)]	57	**72**	57,6	**71,6**	81,6
U	27	**42**	22	**36**	42
Jaw approx. kg	1,500	**3,700**	2,265	**4,800**	4,500

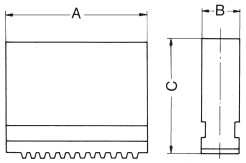
1) Dimension marked on base jaw

Reversible one-piece jaw **EB**, hardened and ground, jaw steps not ground
Jaws only usable in basic chuck.



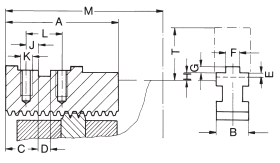
Chuck size	750	1000	1250
A	114	130	167
B	26	32	45
C	70	79	93
D	41,5	40,2	50,5
E	40,3	54	71
F	-	-	-
G	56	64	73
H	-	-	-
J	42	49	53
K	13	13	20
L	19,5	19,5	30
Jaw approx. kg	1,135	1,835	3,665

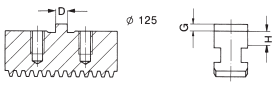
Blockbacken **BL**, ungestuft, ungehärtet, Verzahnung und Führung gehärtet und geschliffen. **Jaws only usable in basic chuck.**



Chuck size	750	1000	1250
A	118,7	136,6	173,6
B	26	32	45
C	70	79	93
Jaw approx. kg	1,535	2,400	5

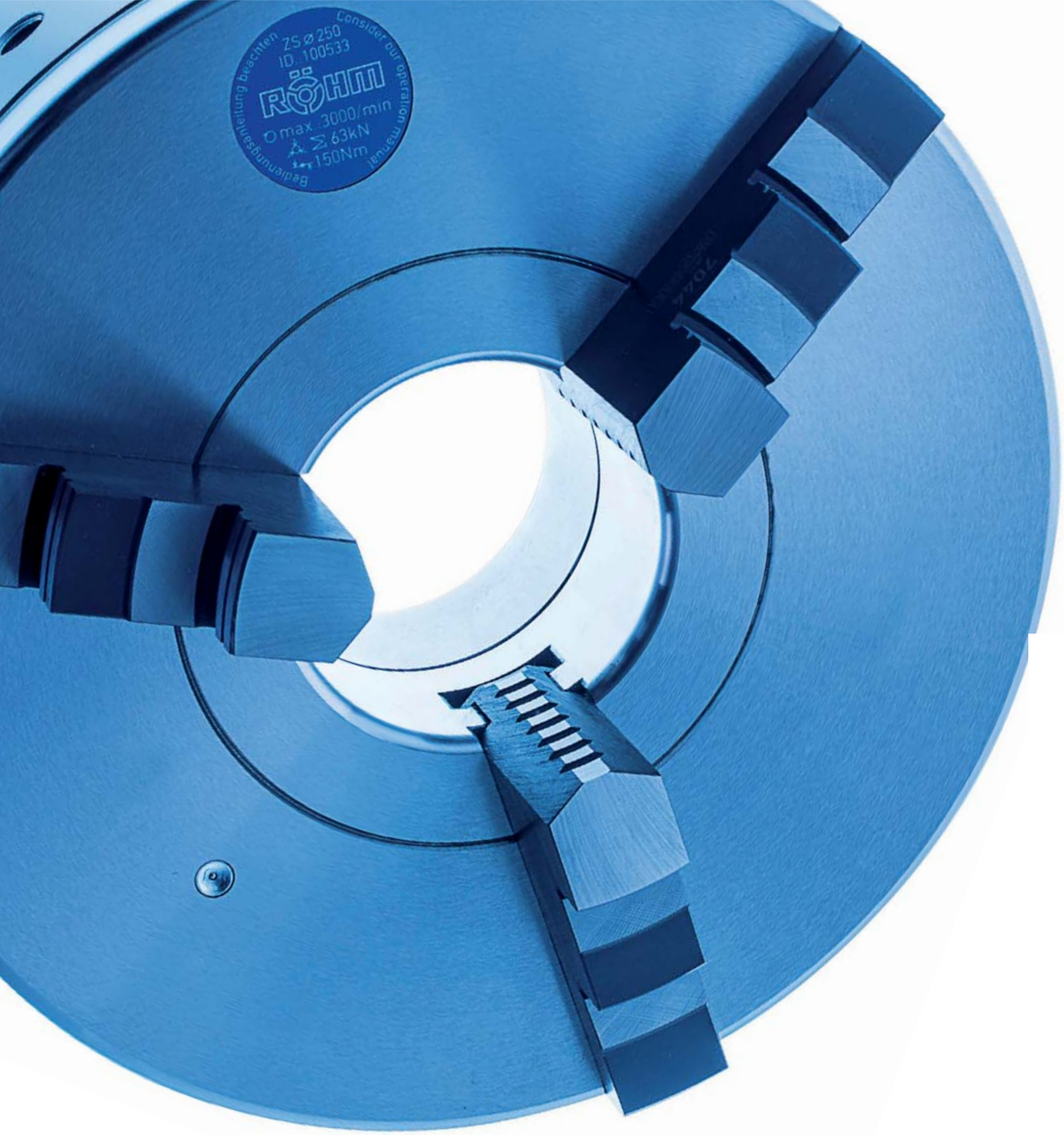
Base jaws **GB**, hardened and ground
Jaws only usable in basic chuck.





Chuck size	750	1000	1250
A	110	125	160
B	26	32	45
C	26	30	35
D	20	26	30
E	5,5	6,5	7,5
F	12	12	18
G	3	3	4
H	7	7,6	8,6
J	10	14	15
K	M12x1,5	M12x1,5	M16x1,5
L	40	54	60
M	163	196	250 294
Jaw approx. kg	0,700	1,065	2,350

Notes



PROVEN CHUCK WITH SPIRAL RING

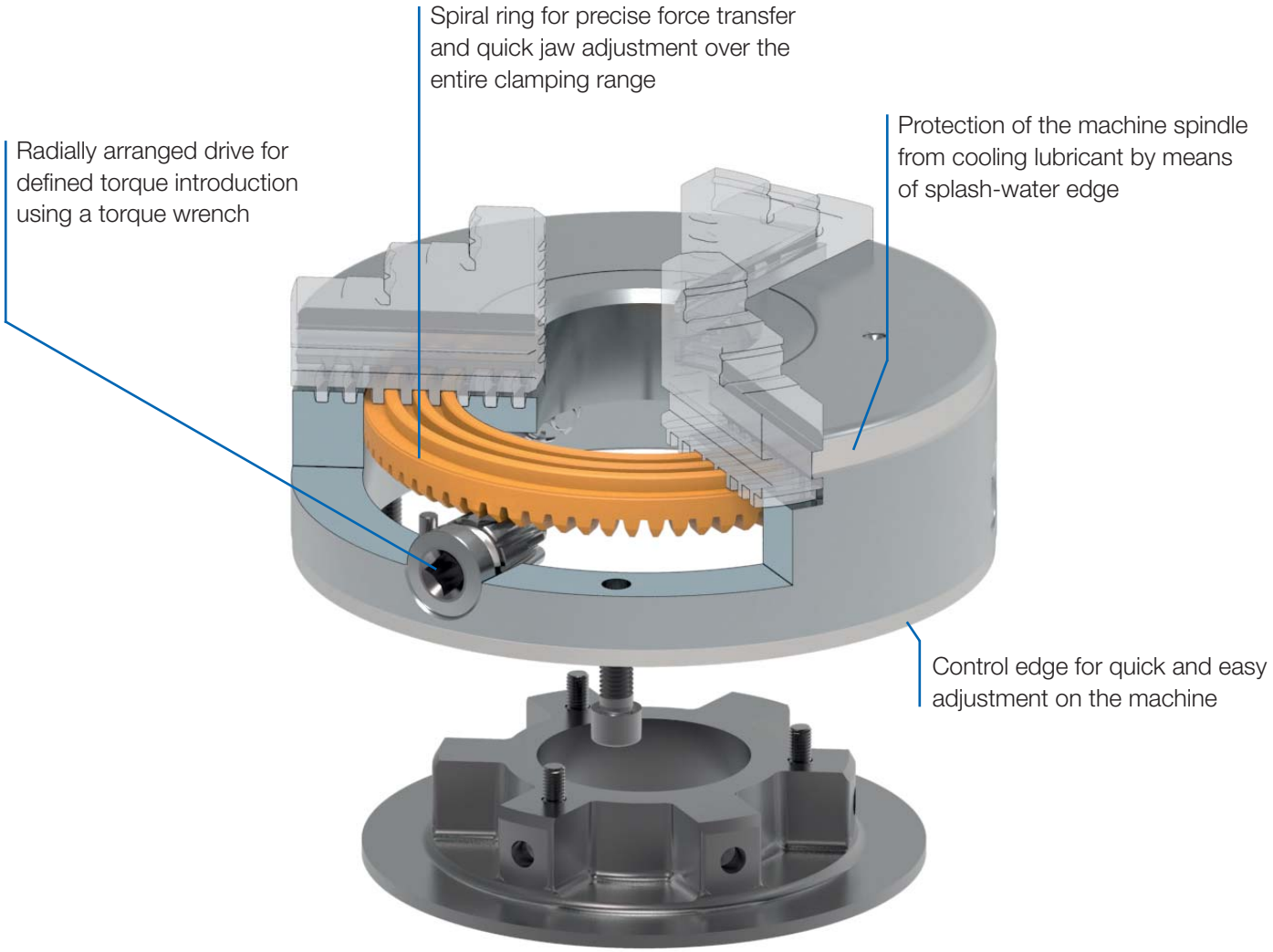
The RÖHM geared scroll chucks have already been in use for decades and have proven themselves a thousand times over. The jaws can be quickly adjusted over the entire clamping range by means of the spiral ring. Using the radially arranged drive, the force is transferred to the hardened spiral ring via a bevel gearing and further conducted to the clamping jaws via the spiral.

GEARED SCROLL CHUCKS

The RÖHM geared scroll chucks have proven themselves a thousand times over and have already been used successfully on lathes, rotary tables and dividing attachments for decades. The jaws can be adjusted over the entire clamping range in order to be able to very quickly clamp workpieces with a wide clamping diameter range without offsetting the jaws.

ADVANTAGE AT A GLANCE

- Quick jaw adjustment over the entire clamping range
- Proven chuck with optimal price/performance ratio
- Protection of the machine spindle by means of splash-water edge



ZS - ZSU



APPLICATION

Proven rotary chuck for use in areas requiring high clamping forces, high concentricity as well as reliable long-term repeatability.
For universal use on lathes, rotary tables, dividing units, etc.

TYPE

Geared scroll chucks in steel design.

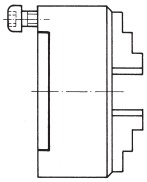
CUSTOMER BENEFITS

- High clamping force
- Special flat design with direct mounting
- The jaws can be adjusted over the entire clamping range by turning the key. This allows workpieces with different clamping diameters to be quickly clamped
- Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With one-piece jaws or with base and top jaws
- Steel bodies and spiral ring
- Die-forged, series-balanced, hardened

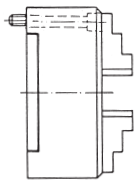
A09
DIN 6350; cylindrical centre mount



Size	Cylindrical centre mount	Through-hole mm	**3 jaw chuck with inside and outside jaw**	**4 jaw chuck with inside and outside jaw**	**3 jaw chuck with base and reversible top jaw**	**4 jaw chuck with base and reversible top jaw**	Speed max. min^{-1}	Torque Nm	Total clamping force kN
80	56	19	**102513**	**102505**	-	-	7000	30	13
100	70	20	**101782**	**102130**	**101788**	**102136**	6300	60	27
125	95	32	**101672**	**106075**	**101678**	**106081**	5500	80	31
160	125	42	**100717**	**101164**	**100725**	**101170**	4600	110	47
200	160	55	**100186**	**100466**	**100189**	**100484**	4000	140	55
250	200	76	**100533**	**101030**	**100541**	**101036**	3000	150	63
315	260	103	**101344**	**101598**	**101350**	**101901**	2300	180	69
400	330	136	**102062**	**102330**	**102068**	**102336**	1800	240	92
500	420	190	**102555**	**103340**	**102585**	**103346**	1300	260	100
630	545	240	**102720**	**102856**	**102726**	**102862**	850	280	105
800	710	380	**104913**	**104917**	-	-	700	300	110
1000	910	460	**104925**	**104929**	-	-	560	450	115
1250	910	550	**104941**	**104945**	-	-	450	450	115

Further sizes and mountings available on request

A09
mounting from front; DIN 6350, Cylindrical centre mount



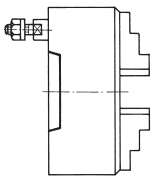
Size	Cylindrical centre mount	Through-hole mm	**3 jaw chuck with inside and outside jaw**	**4 jaw chuck with inside and outside jaw**	Speed max. min^{-1}	Torque Nm	Total clamping force kN
125	95	32	**120155**	**124447**	5500	80	31
160	125	42	**115568**	**125802**	4600	110	47
200	160	55	**113158**	**113160**	4000	140	55
250	200	76	**114304**	**114306**	3000	150	63
315	260	103	**120270**	**129946**	2300	180	69
400	330	136	**123475** ▲	**134401** ▲	1800	240	92
500	420	190	**127616** ▲	**123465** ▲	1300	260	100
630	545	240	**128545** ▲	**135061** ▲	850	280	105

Further sizes and mountings available on request

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ZS - ZSU

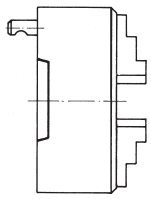
A09
ISO 702-3 (DIN 55027), DIN 55022; with studs and locknuts, optional DIN 55021 with set screw and nut



Size	Mount short taper	Through-hole mm	3 jaw chuck with inside and outside jaw	4 jaw chuck with inside and outside jaw	3 jaw chuck with base and reversible top jaw	4 jaw chuck with base and reversible top jaw	Speed max. min^{-1}	Torque Nm	Total clamping force kN
125	4	32	**101692**	**107015**	**101695**	**107021**	5500	80	31
160	4	42	**100740**	**101184**	**100743**	**101187**	4600	110	47
160	5	42	**100744**	**101188**	**100747**	**101191**	4600	110	47
200	5	55	**100152**	**100472**	**100155**	**101420**	4000	140	55
200	6	55	**100156**	**101422**	**100159**	**101428**	4000	140	55
250	6	76	**100555**	**101050**	**100564**	**101059**	3000	150	63
250	8	76	**100556**	**101051**	**100565**	**101060**	3000	150	63
315	6	103	**101364**	**101919**	**101373**	**101922**	2300	180	69
315	8	103	**101365**	**101923**	**101374**	**101926**	2300	180	69
315	11	103	**101366**	**101927**	**101375**	**101930**	2300	180	69
400	8	136	**102202**	**101876**	**102208**	**101882**	1800	240	92
400	11	136	**102210**	**101884**	**102216**	**101890**	1800	240	92
500	11	190	**102548** ▲	**102971** ▲	**102554** ▲	**102977** ▲	1300	260	100
500	15	190	**102915** ▲	**103227** ▲	**102921** ▲	**103233** ▲	1300	260	100
630	11	192,7	**102752** ▲	**102888** ▲	**102758** ▲	**102894** ▲	850	280	105
630	15	240	**102760** ▲	**103084** ▲	**102766** ▲	**103090** ▲	850	280	105

Further sizes and mountings available on request

A09
ISO 702-2 (DIN 55029); ASA B 5.9, Type D, with studs for Camlock



Size	Mount short taper	Through-hole mm	3 jaw chuck with inside and outside jaw	4 jaw chuck with inside and outside jaw	3 jaw chuck with base and reversible top jaw	4 jaw chuck with base and reversible top jaw	Speed max. min^{-1}	Torque Nm	Total clamping force kN
125	4	32	**108895**	**109208**	**105870**	**105872**	5500	80	31
160	4	42	**108897**	**109210**	**105882**	**105886**	4600	110	47
160	5	42	**109150**	**109213**	**105898**	**106302**	4600	110	47
200	5	55	**109151**	**109214**	**106330**	**106334**	4000	140	55
200	6	55	**109154**	**109217**	**106346**	**106350**	4000	140	55
250	6	76	**109155**	**109218**	**106386**	**106390**	3000	150	63
250	8	76	**109159**	**109222**	**106402**	**106406**	3000	150	63
315	6	103	**109156**	**109219**	**106442**	**106446**	2300	180	69
315	8	103	**109160**	**109223**	**106458**	**106462**	2300	180	69
315	11	103	**109165**	**109228**	**106474**	**106478**	2300	180	69
400	8	136	**109161**	**109224**	**106498**	**106602**	1800	240	92
400	11	136	**109166**	**109229**	**106614**	**106618**	1800	240	92
500	11	190	**109167** ▲	**109230** ▲	**103274** ▲	**106646** ▲	1300	260	100
500	15	190	**109170** ▲	**109233** ▲	**103275** ▲	**103271** ▲	1300	260	100
630	11	192,7	**109168** ▲	**109231** ▲	**106658** ▲	**106662** ▲	850	280	105
630	15	240	**109171** ▲	**109234** ▲	**103328** ▲	**106251** ▲	850	280	105

Further sizes and mountings available on request

Jaws ZS - ZSU

A09
Inside jaw BB DIN 6350, outward stepped jaw, hardened



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
80	**110155**	**110063**	37	26	12
100	**110156**	**110064**	48	33,5	14
125	**110157**	**110065**	52	41,5	18
160	**110159**	**110067**	61	47,5	18
200	**110160**	**110068**	69	53,5	20
250	**110161**	**110069**	90	67,5	24
315	**110162**	**110070**	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Outside jaw DB DIN 6350, inward stepped jaw, hardened



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
80	**110165**	**110073**	37	26	12
100	**110166**	**110074**	48	33,5	14
125	**110167**	**110075**	52	41,5	18
160	**110169**	**110077**	61	47,5	18
200	**110170**	**110078**	69	53,5	20
250	**110171**	**110079**	90	67,5	24
315	**110016**	**110080**	130	79,5	34
400	**110017**	**110081**	130	79,5	34
500/630	**110018**	**110082**	190	95	42

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped jaw BL DIN 6350, unstepped, soft, 16MnCr5



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
80	**107588**	**107598**	37	26	12
100	**107589**	**107599**	48	33,5	14
125	**107590**	**107600**	52	41,5	18
160	**107592**	**107602**	61	47,5	18
200	**107593**	**107603**	69	53,5	20
250	**107594**	**107604**	90	67,5	24
315	**107595**	**107605**	130	79,5	34
400	**107596**	**107644**	130	79,5	34
500/630	**107597**	**107645**	190	95	42

A09
Base jaw GB DIN 6350 with fixing screw



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw width
100	**107500**	**107542**	46	14
125	**107501**	**107543**	55	18
160	**107503**	**107545**	65	18
200	**107504**	**107546**	78	20
250	**107505**	**107547**	92	24
315	**107506**	**107548**	108	34
400	**107507**	**107549**	127	34
500	**107508**	**107550**	165	42
630	**107509**	**107551**	203	42
800	**105272**	**141616**	291	55
1000	**105274**	**141611**	329	55
1250	**105275**	**141614**	367	55

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Jaws ZS - ZSU

A09
Reversible top jaws UB DIN 6350, hardened



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**108045**	**108053**	47	29,5	22
125	**108046**	**108054**	56	37,5	26
160	**107936**	**107938**	66,7	41,5	28
200	**107937**	**107939**	79,5	42,5	30
250	**108049**	**108057**	95,3	52,5	36
315	**108050**	**108058**	109,5	57,5	42
400	**108051**	**108059**	127	64,5	42
500/630	**108052**	**108060**	127	79,5	50
800	**105081**	**105085**	210	89	68
1000/1250	**105098**	**105101**	210	110	68

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

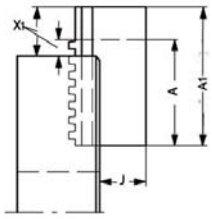
A09
Unstepped top jaw AB DIN 6350, soft, material 16MnCr5



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**107633**	**107641**	53	30	22,5
125	**107634**	**107642**	62	38	26,5
160	**108581**	**108583**	74	42	28,5
200	**108582**	**108584**	87	43	30,5
250	**107637**	**107579**	103	53	36,5
315	**107638**	**107580**	120	58	42,5
400	**107639**	**107581**	137	65	42,5
500/630	**107640**	**107582**	140	80	50,5
800	**105103**	**105105**	210	89	68
1000/1250	**105107**	**105109**	210	110	68

A09
Unstepped jaw BL, special length, soft, 16MnCr5 DIN 6350

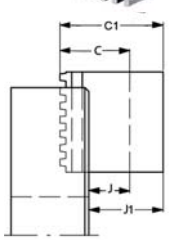




Chuck Size	3-jaw set	4-jaw set	A1	X1 max.	A mm	J mm	X max. mm
200	**130031**	**137073**	100	50	69	32,5	19
250	**132658**	**137074**	120	56	90	41	26
315	**132184**	**129894**	160	70	130	46	40
400	**137075**	**130442**	160	70	130	42	40
500/630	**131540**	**137076**	220	80	190	55	50
200	**130033**	**137077**	120	70	69	32,5	19
250	**128880**	**130610**	140	76	90	41	26
315	**118908**	**137078**	200	110	130	46	40
400	**137079**	**137080**	200	110	130	42	40
500/630	**137081**	**137082**	280	140	190	55	50
315	**121367**	**133691**	250	160	130	46	40
400	**137087**	**137088**	250	160	130	42	40

A09
Unstepped jaw BL, special height, soft, 16MnCr5 DIN 6350



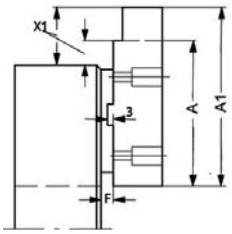


Chuck Size	3-jaw set	4-jaw set	C1 mm	J1	C mm	J mm
200	**125710**	**132972**	80	58,5	54	32,5
250	**122188**	**134796**	100	73	68	41
315	**132186**	**137091**	110	76	80	46
400	**137092**	**131655**	110	72	80	42
500/630	**137093**	**137094**	150	110	95	55
200	**125712**	**137095**	120	98,5	54	32,5
250	**122189**	**130630**	130	103	68	41
315	**137096**	**137097**	140	106	80	46
400	**137098**	**137099**	140	102	80	42
500/630	**125117**	**137100**	200	160	95	55
200	**125714**	**137101**	150	128,5	54	32,5
250	**137102**	**137103**	150	123	68	41
315	**137104**	**130340**	160	126	80	46
400	**132879**	**110109**	160	122	80	42

Jaws ZS - ZSU

A09
Top jaw AB, special length, soft, 16MnCr5 DIN 6350

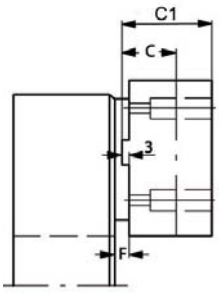




Chuck Size	3-jaw set	4-jaw set	A1	X1 max.	F mm	A mm	X max. mm
200	**110086**	**148139**	100	43	6,8	87	30
250	**112122**	**129289**	130	63	8	103	36
315	**110624**	**143764**	160	76	5,5	120	36
400	**110626**	**141277**	160	53	8,5	137	30
500/630	**103014**	**103393**	170	75	8,5	140	45
200	**112120**	**148657**	120	63	6,8	87	30
250	**125428**	**128700**	150	83	8	103	36
315	**112091**	**147754**	200	116	5,5	120	36
400	**112118**	**141263**	200	93	8,5	137	30
500/630	**110632**	**148234**	220	125	8,5	140	45
250	**104710**	**146013**	180	113	8	103	36
315	**112089**	**147860**	250	166	5,5	120	36
400	**103654**	**149974**	260	153	8,5	137	30
500/630	**112127**	**148235**	280	185	8,5	140	45

A09
Top jaw AB, special height, soft, 16MnCr5 DIN 6350

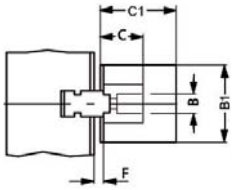




Chuck Size	3-jaw set	4-jaw set	C1 mm	C mm	F mm
200	**132155**	**132181**	60	43	6,8
250	**119645**	**135867**	70	53	8
315	**110435**	**149975**	80	58	5,5
400	**126385**	**118373**	90	65	8,5
500/630	**128590**	**149985**	100	80	8,5
200	**128564**	**149976**	80	43	6,8
250	**128571**	**134999**	100	53	8
315	**110437**	**129691**	110	58	5,5
400	**110628**	**135426**	120	65	8,5
500/630	**110630**	**149977**	130	80	8,5
250	**128573**	**149978**	150	53	8
315	**128569**	**141671**	150	58	5,5
400	**128567**	**139591**	160	65	8,5
500/630	**128588**	**140427**	160	80	8,5

A09
Top jaw AB, special width and height, soft, 16MnCr5 DIN 6350





Chuck Size	3-jaw set	4-jaw set	B1 mm	C1 mm	B mm	C mm
200	**105057**	**105061**	40	70	30.5	43
250	**137090**	**141338**	50	80	36.5	53
315	**143053**	**149979**	60	90	42	58
400	**131567**	**149980**	60	90	42.5	65
500/630	**137084**	**149981**	80	110	50.5	80
200	**133259**	**149982**	50	80	30.5	43
250	**133653**	**137526**	60	90	36.5	53
315	**143057**	**149983**	80	110	42	58
400	**137086**	**149984**	80	110	42.5	65

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Jaws ZS - ZSU

C15
Mounting bolt for top jaws bolt 1



Item no.	Size	Thread	Contents of delivery
249299	100	M6x20	piece
236949	125	M8x25	piece
334571	160/200	M8x30	piece
233025	250	M12x40	piece
233026	315	M12x45	piece
220565	400	M16x50	piece
249003	500/630	M20x80	piece

C15
Mounting bolt for top jaws bolt 2



Item no.	Size	Thread	Contents of delivery
216528	100	M6x16	piece
233058	125/160/200	M8x20	piece
227692	250	M12x25	piece
233030	315	M12x30	piece
220564	400	M16x35	piece
233047	500/630	M20x40	piece

Accessories ZS - ZSU

A09

Base plates for lathe chucks with **cylindrical centre mount**
DIN 6350



Item no.	Size
162793	160
162401	200
163036	250
133705	315

A09

Unfinished adapter plates for **cylindrical mount**
The unfinished back plate must be machined and fitted on both machine and chuck side



Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017123	74	3	80	56	45	15	-
017113	80	3 ¼	92	56	47	15	20
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017125	140	5 ½	150	80	58	20	25
017116	160	6 ¼	170	80	58	20	30
017117	200	8	210	92	66	22	40
017118	250	10	260	105	92	25	50
017119	315	12 ½	330	165	100	30	50
017124	350	14	365	180	120	30	60

A09

Chip guard, piece



Item no.	Size	Contents of delivery
108500	80/85	piece
108501	100/110	piece
108502	125	piece
108503	140/160	piece
108504	200	piece
108505	250	piece
108506	315/350/400	piece
108508	500/630	piece

A09

Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

Accessories ZS - ZSU

A09

Scroll



Item no.	Size
102521	74
102183	80/85
101754	100
112660	110
101721	125
105827	140
100303	160
100003	200
100203	250
101552	315
105228	350
102497	400
162973	500
162964	630

A09

Driving pinion



Item no.	Size	Square
102522	74	6
102184	80	6
113198	85	6
101755	100	8
112662	110	8
101722	125	9
105828	140	9
100304	160	10
100005	200	11
100204	250	12
112267	270	12
101553	315	14
105229	350	14
102498	400	17
162974	500	19
162965	630	19

A09

Pinion holder screw



Item no.	Size
102523	74
102185	85
100305	160
100006	270
101554	315
102499	400
103300	630

A09

Standard key



Item no.	Size	Square	Hexagon	Length mm
006325	74	-	6	55
107426	80/85	6	-	62
107427	100/110	8	-	75
107428	125/140	9	-	80
107429	160	10	-	90
107430	200/230	11	-	100
107431	250/270	12	-	100
107432	315	14	-	110
107433	350	14	-	140
107434	400	17	-	140
107435	500/630	19	-	150

A09

Safety key with ejector



Item no.	Size	Square	Length mm
154370	80/85	6	110
154371	100/110	8	130
154372	125/140	9	130
154373	160	10	160
154374	200/230	11	160
154375	250/270	12	160
154376	315	14	200
154377	350	14	200
154378	400	17	250
154379	500/630	19	250

A09

Elongated safety key with ejector



Item no.	Size	Square	Length mm
154683	125/140	9	170
154685	160	10	180
154687	200/230	11	200
154689	250/270	12	200
154695	315	14	250

A09

Safety adapter with ejector

for actuating the chuck with torque (defined torque introduction)

Item no.	Size	Square	Inch
178566	80/85	6	3/8
178567	100/110	8	1/2
178568	125/140	9	1/2
178569	160	10	1/2
178570	200/230	11	1/2
178571	250/270	12	1/2
178572	315/350	14	1/2
178573	400	17	1/2
178574	500/630/700/800	19	3/4
178575	1000/1250	24	3/4

A09

Mounting screws

with **cylindrical centre rim**



Item no.	Size	Thread	Contents of delivery
249299	74-85	M6x20	piece
334571	100-140	M8x30	piece
249301	160-230	M10x35	piece
233025	250-270	M12x40	piece
220565	315-350	M16x50	piece
229183	400-630	M16x60	piece

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Accessories ZS - ZSU

C15

Mounting screws
for lathe chucks with direct **short-taper**, **for front mounting**



Item no.	Size	Thread	Contents of delivery	Chuck Size	Taper size
302195	74	M10x55	piece	160	5
200184	80	M10x65	piece	200	5
233006	85	M12x65	piece	200	6
233075	100	M10x90	piece	250	5
216549	110	M12x70	piece	250	6
302194	125	M16x70	piece	250	8
242954	140	M12x100	piece	315	6
358816	160	M16x85	piece	315	8
243665	200/230	M12x130	piece	350	6
236516	315	M16x110	piece	400	8
615744	350	M20x95	piece	400	11
010210	400	M20x130	piece	500	11
328925	500	M20x145	piece	630	11
367648	630	M24x125	piece	630	15

C15

Set screw with nut DIN 55021



Item no.	Thread	For taper	Quantity
107453	M10x30	4	3
107455	M10x35	5	4
107456	M12x40	6	4
107457	M16x45	8	4
107458	M20x55	11	6
127618	M24x65	15	6

A09

Stud for Camlock ISO 702-2 (DIN 55029) **and cylindrical studs**



Item no.	Thread	For taper	Quantity
178364	M10x1	3	3
178365	M10x1	4	3
178366	M12x1	5	6
178367	M16x1,5	6	6
178368	M20x1,5	8	6
178369	M22x1,5	11	6
178370	M24x1,5	15	6
178371	M27x2	20	6

A09

Stud and locknut ISO 702-3 (DIN 55027)



Item no.	Thread	Contents of delivery	For taper	Quantity
107447	M10x34	piece	3	3
107448	M10x39	piece	4	3
107449	M10x43	piece	5	4
107450	M12x50	piece	6	4
107451	M16x60	piece	8	4
107452	M20x75	piece	11	6
125650	M24x90	piece	15	6
130636	M24x100	piece	20	6

A09

Stud for Camlock ASA B 5.9 (DIN 55029) **and cylindrical studs**



Item no.	Thread	For taper	Quantity
107465	7/16-20x35	3	3
107466	7/16-20x37	4	3
107467	½-20x43	5	6
107468	5/8-18x49	6	6
107469	¾-16x55,5	8	6
107470	7/8-14x67	11	6
127621	1-14x76	15	6
130637	1½-12x89	20	6

Orange Line

ORANGE LINE



APPLICATION

Proven rotary chuck for use in areas requiring high clamping forces, high concentricity as well as reliable long-term repeatability.
Cross tenon to ISO 3442 and ASA B 5.8.

TYPE

Geared scroll chucks in cast iron design.
Special flat design with direct mounting.

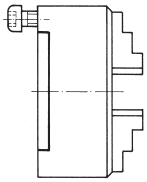
VORTEILE

- Good price/performance ratio
- Special flat design with direct mounting
- The jaws can be adjusted over the entire clamping range by turning the key. This allows workpieces with different clamping diameters to be quickly clamped
- Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With one set each of one-piece outward- and inward stepped jaws
- Vibration-damping body made of special cast iron
- Spiral ring die-forged as well as balanced and hardened

A09
DIN 6350; cylindrical centre mount, form A



Size	Cylindrical centre mount	Through-hole mm	**3 jaw chuck with inside and outside jaw**	**4 jaw chuck with inside and outside jaw**	Speed max. min^{-1}	Torque Nm	Total clamping force kN
100	70	20	**101781**	**102129**	4500	60	27
125	95	32	**101628**	**106074**	4000	80	31
160	125	42	**100300**	**100325**	3600	110	47
200	160	55	**100000**	**100465**	3000	140	55
250	200	76	**100200**	**100834**	2500	150	63
315	260	103	**101248**	**101567**	2000	180	69

▲ on request

Jaws Orange Line

A09
Inside jaw BB DIN 6350, outward stepped jaw, hardened



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**110156**	**110064**	48	33,5	14
125	**110157**	**110065**	52	41,5	18
160	**110159**	**110067**	61	47,5	18
200	**110160**	**110068**	69	53,5	20
250	**110161**	**110069**	90	67,5	24
315	**110162**	**110070**	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Outside jaw DB DIN 6350, inward stepped jaw, hardened



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**110166**	**110074**	48	33,5	14
125	**110167**	**110075**	52	41,5	18
160	**110169**	**110077**	61	47,5	18
200	**110170**	**110078**	69	53,5	20
250	**110171**	**110079**	90	67,5	24
315	**110016**	**110080**	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped jaw BL DIN 6350, unstepped, soft, 16MnCr5



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**107589**	**107599**	48	33,5	14
125	**107590**	**107600**	52	41,5	18
160	**107592**	**107602**	61	47,5	18
200	**107593**	**107603**	69	53,5	20
250	**107594**	**107604**	90	67,5	24
315	**107595**	**107605**	130	79,5	34

A09
Base jaw GB DIN 6350, with fixing screw



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw width
100	**107500**	**107542**	46	14
125	**107501**	**107543**	55	18
160	**107503**	**107545**	65	18
200	**107504**	**107546**	78	20
250	**107505**	**107547**	92	24
315	**107506**	**107548**	108	34

A09
Reversible top jaws UB DIN 6350, hardened



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**108045**	**108053**	47	29,5	22
125	**108046**	**108054**	56	37,5	26
160	**107936**	**107938**	66,7	41,5	28
200	**107937**	**107939**	79,5	42,5	30
250	**108049**	**108057**	95,3	52,5	36
315	**108050**	**108058**	109,5	57,5	42

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

Configure your individual clamping jaws online! www.web2product.biz

Jaws Orange Line

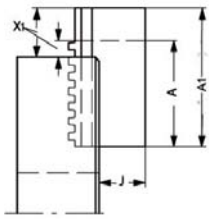
A09
Unstepped top jaw AB DIN 6350, soft, material 16MnCr5



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**107633**	**107641**	53	30	22,5
125	**107634**	**107642**	62	38	26,5
160	**108581**	**108583**	74	42	28,5
200	**108582**	**108584**	87	43	30,5
250	**107637**	**107579**	103	53	36,5
315	**107638**	**107580**	120	58	42,5

A09
Unstepped jaw BL, special length, soft, 16MnCr5, DIN 6350

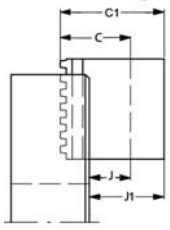




Chuck Size	3-jaw set	4-jaw set	A1	X1 max.	A mm	J mm	X max. mm
200	**130031**	**137073**	100	50	69	32,5	19
250	**132658**	**137074**	120	56	90	41	26
315	**132184**	**129894**	160	70	130	46	40
200	**130033**	**137077**	120	70	69	32,5	19
250	**128880**	**130610**	140	76	90	41	26
315	**118908**	**137078**	200	110	130	46	40
315	**121367**	**133691**	250	160	130	46	40

A09
Unstepped jaw BL, special height, soft, 16MnCr5, DIN 6350

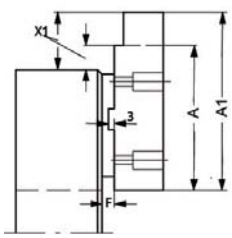




Chuck Size	3-jaw set	4-jaw set	C1 mm	J1	C mm	J mm
200	**125710**	**132972**	80	58,5	54	32,5
250	**122188**	**134796**	100	73	68	41
315	**132186**	**137091**	110	76	80	46
200	**125712**	**137095**	120	98,5	54	32,5
250	**122189**	**130630**	130	103	68	41
315	**137096**	**137097**	140	106	80	46
200	**125714**	**137101**	150	128,5	54	32,5
250	**137102**	**137103**	150	123	68	41
315	**137104**	**130340**	160	126	80	46

A09
Top jaw AB, special length, soft, 16MnCr5, DIN 6350





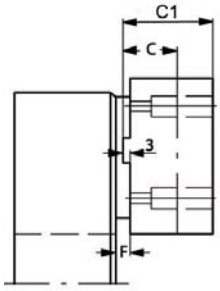
Chuck Size	3-jaw set	4-jaw set	A1	X1 max.	F mm	A mm	X max. mm
200	**110086**	**148139**	100	43	6,8	87	30
250	**112122**	**129289**	130	63	8	103	36
315	**110624**	**143764**	160	76	5,5	120	36
200	**112120**	**148657**	120	63	6,8	87	30
250	**125428**	**128700**	150	83	8	103	36
315	**112091**	**147754**	200	116	5,5	120	36
250	**104710**	**146013**	180	113	8	103	36
315	**112089**	**147860**	250	166	5,5	120	36

▲ on request

Jaws Orange Line

A09
Top jaw AB, special height, soft, 16MnCr5 DIN 6350

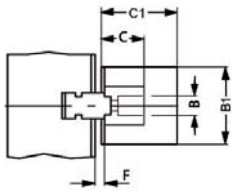




Chuck Size	3-jaw set	4-jaw set	C1 mm	C mm	F mm
200	**132155**	**132181**	60	43	6,8
250	**119645**	**135867**	70	53	8
315	**110435**	**149975**	80	58	5,5
200	**128564**	**149976**	80	43	6,8
250	**128571**	**134999**	100	53	8
315	**110437**	**129691**	110	58	5,5
250	**128573**	**149978**	150	53	8
315	**128569**	**141671**	150	58	5,5

A09
Top jaw AB, special width and height, soft, 16MnCr5 DIN 6350





Chuck Size	3-jaw set	4-jaw set	B_1 mm	C1 mm	B mm	C mm
200	**105057**	**105061**	40	70	30.5	43
250	**137090**	**141338**	50	80	36.5	53
315	**143053**	**149979**	60	90	42	58
200	**133259**	**149982**	50	80	30.5	43
250	**133653**	**137526**	60	90	36.5	53
315	**143057**	**149983**	80	110	42	58

C15
Mounting bolt for top jaws, bolt 1



Item no.	Size	Thread	Contents of delivery
249299	100	M6x20	piece
236949	125	M8x25	piece
334571	160	M8x30	piece
233025	250	M12x40	piece
233026	315	M12x45	piece

C15
Mounting bolt for top jaws, bolt 2



Item no.	Size	Thread	Contents of delivery
216528	100	M6x16	piece
233058	125/160/200	M8x20	piece
227692	250	M12x25	piece
233030	315	M12x30	piece

Configure your individual clamping jaws online! www.web2product.biz

Accessories Orange Line

A09

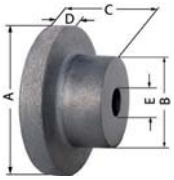
Base plates for lathe chucks with **cylindrical centre mount**
DIN 6350



Item no.	Size
162793	160
162401	200
163036	250
133705	315

A09

Unfinished adapter plates for **cylindrical mount**
The unfinished back plate must be machined and fitted on both machine and chuck side



Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017116	160	6 ¼	170	80	58	20	30
017117	200	8	210	92	66	22	40
017118	250	10	260	105	92	25	50

A09

Chip guard, piece



Item no.	Size	Contents of delivery
108501	100/110	piece
108502	125	piece
108503	140/160	piece
108504	200	piece
108505	250	piece
108506	315/350/400	piece

A09

Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

A09

Scroll



Item no.	Size
101754	100
112660	110
101721	125
105827	140
100303	160
100003	200
100203	250
101552	315

A09

Driving pinion



Item no.	Size	Square
101755	100	8
112662	110	8
101722	125	9
105828	140	9
100304	160	10
100005	200	11
100204	250	12
112267	270	12
101553	315	14

A09

Pinion holder screw



Item no.	Size
100305	160
100006	270
101554	315

A09

Standard key



Item no.	Size	Square	Length mm
107427	100/110	8	75
107428	125/140	9	80
107429	160	10	90
107430	200/230	11	100
107431	250/270	12	100
107432	315	14	110

A09

Safety key with ejector



Item no.	Size	Square	Length mm
154371	100/110	8	130
154372	125/140	9	130
154373	160	10	160
154374	200/230	11	160
154375	250/270	12	160
154376	315	14	200

A09

Elongated safety key with ejector



Item no.	Size	Square	Length mm
154683	125/140	9	170
154685	160	10	180
154687	200/230	11	200
154689	250/270	12	200
154695	315	14	250

▲ on request

Accessories Orange Line

A09

Safety adapter with ejector
for actuating the chuck with torque (defined torque introduction)



Item no.	Size	Square	Inch
178567	100/110	8	1/2
178568	125/140	9	1/2
178569	160	10	1/2
178570	200/230	11	1/2
178571	250/270	12	1/2
178572	315/350	14	1/2

A09

Mounting screws
with **cylindrical centre rim**



Item no.	Size	Thread	Contents of delivery
334571	100-140	M8x30	piece
249301	160-230	M10x35	piece
233025	250-270	M12x40	piece
220565	315-350	M16x50	piece

C15

Mounting screws
for lathe chucks with direct **short-taper, for front mounting**



Item no.	Size	Thread	Contents of delivery	Chuck Size	Taper size
233075	100	M10x90	piece	250	5
216549	110	M12x70	piece	250	6
302194	125	M16x70	piece	250	8
242954	140	M12x100	piece	315	6
358816	160	M16x85	piece	315	8
243665	200/230	M12x130	piece	350	6
236516	315	M16x110	piece	400	8

C15

Set screw with nut DIN 55021



Item no.	Thread	For taper	Quantity
107453	M10x30	4	3
107455	M10x35	5	4
107456	M12x40	6	4
107457	M16x45	8	4
107458	M20x55	11	6
127618	M24x65	15	6

A09

Stud for Camlock ISO 702-2 (DIN 55029) **and cylindrical studs**



Item no.	Thread	For taper	Quantity
178364	M10x1	3	3
178365	M10x1	4	3
178366	M12x1	5	6
178367	M16x1,5	6	6
178368	M20x1,5	8	6
178369	M22x1,5	11	6
178370	M24x1,5	15	6
178371	M27x2	20	6

A09

Stud and locknut ISO 702-3 (DIN 55027)



Item no.	Thread	Contents of delivery	For taper	Quantity
107447	M10x34	piece	3	3
107448	M10x39	piece	4	3
107449	M10x43	piece	5	4
107450	M12x50	piece	6	4
107451	M16x60	piece	8	4
107452	M20x75	piece	11	6
125650	M24x90	piece	15	6
130636	M24x100	piece	20	6

A09

Stud for Camlock ASA B 5.9 (DIN 55029) **and cylindrical studs**



Item no.	Thread	For taper	Quantity
107465	7/16-20x35	3	3
107466	7/16-20x37	4	3
107467	½-20x43	5	6
107468	5/8-18x49	6	6
107469	¾-16x55,5	8	6
107470	7/8-14x67	11	6
127621	1-14x76	15	6
130637	1½-12x89	20	6

ZS Hi-Tru



APPLICATION

Optimized for machining workpieces which must be produced with **maximum concentricity.**
Can be universally used, but is especially advantageous on turning and grinding machines as well as dividing units.

TYPE

Face spiral chuck in steel design, with which the workpiece can be adjusted very sensitively to the desired concentricity via 3 tangentially arranged adjusting spindles.

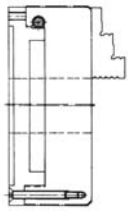
CUSTOMER BENEFITS

- Radial fine adjustment for maximum concentricity
- repeatability 0.015 mm
- adjusting accuracy within 0.005 mm
- precision adjustment without opening the mounting screws
- Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With one set each of turning and drilling jaws
- Hardened adjusting spindles, as well as their support surfaces
- Hardened spiral ring
- Steel take-up flange

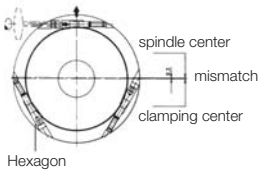
A09
ZS Hi-Tru, with one set outward stepped jaws and one set inward stepped jaws DIN 6350; cylindrical centre mount, Form A

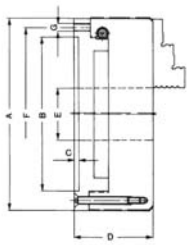


Item no.	Size	Cylindrical centre mount	Through-hole mm	Speed max. min^{-1}	Torque Nm	Total clamping force kN
180259	80	56	19	7000	30	13
180261	100	70	20	6300	60	27
180263	125	95	32	5500	80	31
180265	160	125	42	4600	110	47
180267	200	160	55	4000	140	55
180269	250	200	76	3000	150	63
180271	315	260	103	2300	180	69

On request from size 125 with 6 jaws or with short-taper mount to ISO 702-3 (DIN 55027) or ISO 702-2 (DIN 55029) Camlock
Further sizes and mountings available on request

DIN 6350
Dimensions ZS Hi-Tru
Cylindrical centre mount, Form A





Size A	Zoll	B$^{+0,02}$	C	D	F	G	Hexagon	Weight
ZS Hi-Tru, with one set outward stepped jaws and one set inward stepped jaws								
80	3$^{1/4}$	56	3	50,5	67	3xM6	4	1,7
100	4	70	3	63	83	3xM8	5	3,6
125	5	95	4	72	108	3xM8	5	5,6
160	6$^{1/4}$	125	4	81	140	3xM10	6	10
200	8	160	4	89,5	176	3xM10	6	17,2
250	10	200	5	102	224	3xM12	8	34,5
315	12$^{1/2}$	260	5	122	286	3xM16	8	57,5

▲ on request

Jaws ZS Hi-Tru

A09
Inside jaw BB DIN 6350, outward stepped jaw, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
110155	80	set	37	26	12
110156	100	set	48	33,5	14
110157	125	set	52	41,5	18
110159	160	set	61	47,5	18
110160	200	set	69	53,5	20
110161	250	set	90	67,5	24
110162	315	set	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Outside jaw DB DIN 6350, inward stepped jaw, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
110165	80	set	37	26	12
110166	100	set	48	33,5	14
110167	125	set	52	41,5	18
110169	160	set	61	47,5	18
110170	200	set	69	53,5	20
110171	250	set	90	67,5	24
110016	315	set	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped jaw BL DIN 6350, unstepped, soft, 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
107588	80	set	37	26	12
107589	100	set	48	33,5	14
107590	125	set	52	41,5	18
107592	160	set	61	47,5	18
107593	200	set	69	53,5	20
107594	250	set	90	67,5	24
107595	315	set	130	79,5	34

A09
Base jaw GB DIN 6350, with fixing screw



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw width
107500	100	set	46	14
107501	125	set	55	18
107503	160	set	65	18
107504	200	set	78	20
107505	250	set	92	24
107506	315	set	108	34

A09
Reversible top jaws UB DIN 6350, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
108045	100	set	47	29,5	22
108046	125	set	56	37,5	26
107936	160	set	66,7	41,5	28
107937	200	set	79,5	42,5	30
108049	250	set	95,3	52,5	36
108050	315	set	109,5	57,5	42

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

Configure your individual clamping jaws online! www.web2product.biz

Jaws ZS Hi-Tru

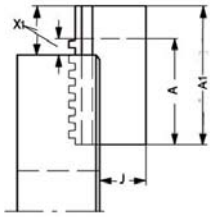
A09
Unstepped top jaw AB DIN 6350, soft, material 16MnCr5



Item no.	Chuck size	Contents of delivery	Jaw length	Jaw height	Jaw width
107633	100	Satz	53	30	22,5
107634	125	Satz	62	38	26,5
108581	160	Satz	74	42	28,5
108582	200	Satz	87	43	30,5
107637	250	Satz	103	53	36,5
107638	315	Satz	120	58	42,5

A09
Unstepped jaw BL, special length, soft, 16MnCr5, DIN 6350

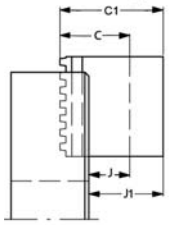




Item no.	Chuck size	A1 mm	X1 max. mm	A	J	X max.
130031	200	100	50	69	32,5	19
132658	250	120	56	90	41	26
132184	315	160	70	130	46	40
130033	200	120	70	69	32,5	19
128880	250	140	76	90	41	26
118908	315	200	110	130	46	40
121367	315	250	160	130	46	40

A09
Unstepped jaw BL, special height, soft, 16MnCr5, DIN 6350

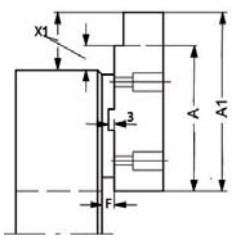




Item no.	Chuck size	C1	J1 mm	C	J
125710	200	80	58,5	54	32,5
122188	250	100	73	68	41
132186	315	110	76	80	46
125712	200	120	98,5	54	32,5
122189	250	130	103	68	41
137096	315	140	106	80	46
125714	200	150	128,5	54	32,5
137102	250	150	123	68	41
137104	315	160	126	80	46

A09
Top jaw AB, special length, soft, 16MnCr5, DIN 6350





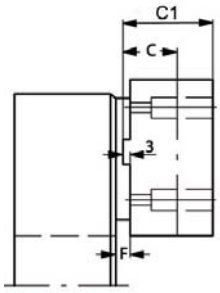
Item no.	Chuck size	A1 mm	X1 max. mm	F	A	X max.
110086	200	100	43	6,8	87	30
112122	250	130	63	8	103	36
110624	315	160	76	5,5	120	36
112120	200	120	63	6,8	87	30
125428	250	150	83	8	103	36
112091	315	200	116	5,5	120	36
104710	250	180	113	8	103	36
112089	315	250	166	5,5	120	36

▲ on request

Jaws ZS Hi-Tru

A09
Top jaw AB, special height, soft, 16MnCr5, DIN 6350

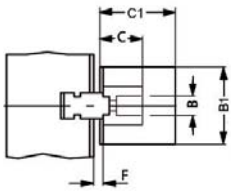




Item no.	Chuck size	C1	C	F
132155	200	60	43	6,8
119645	250	70	53	8
110435	315	80	58	5,5
128564	200	80	43	6,8
128571	250	100	53	8
110437	315	110	58	5,5
128573	250	150	53	8
128569	315	150	58	5,5

A09
Top jaw AB, special width and height, soft, 16MnCr5, DIN 6350





Item no.	Chuck size	B1	C1	B	C
105057	200	40	70	30.5	43
137090	250	50	80	36.5	53
143053	315	60	90	42	58
133259	200	50	80	30.5	43
133653	250	60	90	36.5	53
143057	315	80	110	42	58

C15
Mounting bolt for top jaws, bolt 1



Item no.	Chuck size	Thread	Contents of delivery
249299	100	M6x20	Stück
236949	125	M8x25	Stück
334571	160/200	M8x30	Stück
233025	250	M12x40	Stück
233026	315	M12x45	Stück

C15
Mounting bolt for top jaws, bolt 2



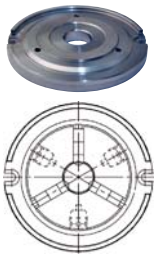
Id.-Nr.	Chuck size	Thread	Contents of delivery
216528	100	M6x16	Stück
233058	125/160/200	M8x20	Stück
227692	250	M12x25	Stück
233030	315	M12x30	Stück

Configure your individual clamping jaws online! www.web2product.biz

Accessories ZS Hi-Tru

A09

Base plates for lathe chucks with **cylindrical centre mount**
DIN 6350



Item no.	Size
162793	160
162401	200
163036	250
133705	315

A09

Unfinished adapter plates for **cylindrical mount**
The unfinished back plate must be machined and fitted on both machine and chuck side



Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017113	80	3 ¼	92	56	47	15	20
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017116	160	6 ¼	170	80	58	20	30
017117	200	8	210	92	66	22	40
017118	250	10	260	105	92	25	50

A09

Chip guard, piece



Item no.	Size	Contents of delivery
108500	80/85	piece
108501	100/110	piece
108502	125	piece
108503	140/160	piece
108504	200	piece
108505	250	piece
108506	315/350/400	piece

A09

Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

A09

Scroll



Item no.	Size
102183	80/85
101754	100
101721	125
100303	160
100003	200
100203	250
101552	315

A09

Driving pinion



Item no.	Size	Hexagon
178473	100	9
178474	110	9
178475	125	10
178476	140	10
178477	160	11
178478	200	12
178480	250	14
178482	315	17

A09

Pinion holder screw



Item no.	Size
102185	85
100305	160
100006	270
101554	315

A09

Standard key



Item no.	Size	Square	Length mm
107426	80/85	6	62
107427	100/110	8	75
107428	125/140	9	80
107429	160	10	90
107430	200/230	11	100
107431	250/270	12	100
107432	315	14	110

A09

Safety key with ejector



Item no.	Size	Square	Length mm
154370	80/85	6	110
154371	100/110	8	130
154372	125/140	9	130
154373	160	10	160
154374	200/230	11	160
154375	250/270	12	160
154376	315	14	200

A09

Elongated safety key with ejector



Item no.	Size	Square	Length mm
154683	125/140	9	170
154685	160	10	180
154687	200/230	11	200
154689	250/270	12	200
154695	315	14	250

A09

Safety adapter with ejector
for actuating the chuck with torque (defined torque introduction)



Item no.	Size	Square	Inch
178566	80/85	6	3/8
178567	100/110	8	1/2
178568	125/140	9	1/2
178569	160	10	1/2
178570	200/230	11	1/2
178571	250/270	12	1/2
178572	315/350	14	1/2

A09

Mounting screws
with **cylindrical centre rim**



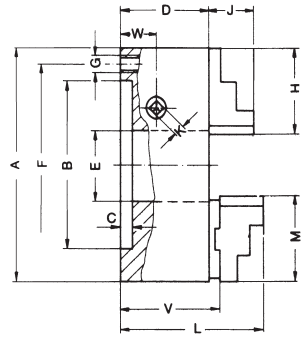
Item no.	Size	Thread	Contents of delivery
249299	74-85	M6x20	piece
334571	100-140	M8x30	piece
249301	160-230	M10x35	piece
233025	250-270	M12x40	piece
220565	315-350	M16x50	piece

▲ on request

Chuck dimensions ZS - ZSU and Orange Line

For mounting on dividing heads and other attachments from the front, the lathe chucks with a cylindrical centre mount can also be supplied pre-drilled (at surcharge) G1, it is also possible to enlarge the bore (measure E, at surcharge)

Cylindrical centre mount DIN 6350

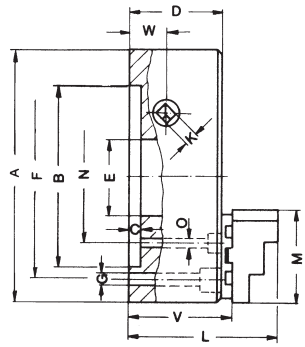


Enlarged bore max.

Size A	74	80	85	100	110	125	140	160	200	250	315	350	400	500	630
B^{H6}	56	56	60	70	80	95	105	125	160	200	260	290	330	420	545
C	2,5	3	3	3	3	4	4	4	4	5	5	6	5	5	7
D	32,5	39,5	39,5	50	50	56	60	65	73,5	82	95	100	105	120	135
E	15	19	19	20	27	32	40	42	55	76	103	115	136	190	240
E_{max}	-	-	-	21	-	33	43	50	70	92	114	120	150	210	253
F	63	67	72	83	95	108	120	140	176	224	286	318	362	458	586
G	3xM6	3xM6	3xM6	3xM8	3xM8	3xM8	3xM8	3xM10	3xM10	3xM12	3xM16	3xM16	3xM16	6xM16	6xM16
G_1	-	-	-	-	-	3xØ9*	-	3xØ10,5	3xØ11	3xØ14	3xØ14	-	3xØ18	6xØ18	6xØ18
H	32	37	37	48	48	52	61	61	69	90	130	130	130	190	190
J	14	14	14	18	18	22,5	22,5	26	32,5	40	46	45	43	54,5	54,5
K	6[1)]	6	6	8	8	9	9	10	11	12	14	14	17	19	19
L	-	-	-	80,5	-	95,5	106	108	119,6	139,6	155	168,5	171,5	201,5	216,5
M	-	-	-	47	47	56	66,7	66,7	79,5	95	109,5	127	127	127	127
V	-	-	-	53,6	53,6	61	67,7	69,7	80,2	89,9	100,4	110,4	113,4	128,4	143,3
W	13	14,5	14,5	18	18	20	21	22,45	25,7	26,5	30	34	35	38	48
approx kg.	1	1,3	1,9	2,9	3,4	4,5	5,8	8,2	14,6	25,7	44,2	56	80	126	208

G1 = Mounting from front * 4-jaw

Cylindrical centre mount

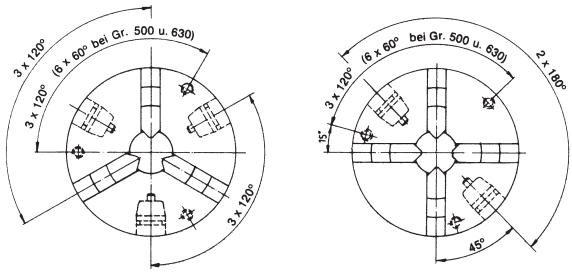


Enlarged bore max.

SIze	ØA	700	800	1000	1250
	B	610	710	910	910
	C[2)]	$7^{+0,03}$	$7^{+0,03}$	$7^{+0,03}$	$7^{+0,03}$
	D	147	147	157	157
	E	310	380	460	550
	$E_{max.}$	330	420	580	580
	F	660	760	950	950
3-Jaw 4-Jaw	G	6xØ22 8xØ22	6xØ22 8xØ22	6xØ26 8xØ26	6xØ26 6xØ26
	K	19	19	24	24
	L	240,6	240,6	269,6	269,6
	M	210	210	210	210
	N	360	460	610	610
3-Jaw 4-Jaw	O	6xØ18 4xØ18	6xØ18 4xØ18	6xØ18 4xØ18	6xØ18 6xØ18
	V	158	158	166	166
	W	48	48	53	53
	ca. kg	280	350	590	850

1) Hexagon 2) Adaptor plate dimension 7-0,03

Position of fixing screws and pinions on lathe chucks with cylindrical centre mount sizes 74-630 (size 350 on request)

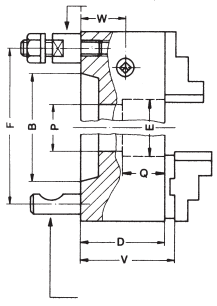


Short taper mount

DIN 55021, with setscrews and locknuts



DIN 55027, with setscrews and locknuts



DIN 55029, with studs for Camlock

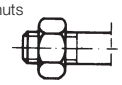
Size	A	100	125		140			160			200			
Taper size		3	3	4	3	4	5	3	4	5	3	4	5	6
	B	53,9	53,9	63,5	53,9	63,5	82,5	53,9	63,5	82,5	53,9	63,5	82,5	106,4
	D	75	69	69	74	74	74	66	66	66	74,5	74,5	74,5	74,5
	E	20	32	32	40	40	40	42	42	42	51,2	55	55	55
DIN Caml.	F	75 70,6	75 70,6	85 82,5	75 70,6	85 82,5	104,8	75 70,6	85 82,5	104,8	75 70,6	85 82,5	104,8	133,4
	P	-	-	-	-	-	-	-	-	-	51,2	-	-	-
	Q	-	-	-	-	-	-	-	-	-	33	-	-	-
	V	78,3	73,7	73,7	81,7	81,7	81,7	70,7	70,7	70,7	81,2	81,2	81,2	81,2
	W	43	33	33	35	35	35[1)]	23,45	23,45	23,45	26,7	26,7	26,7	26,7
Mounting holes	DIN	3	3	3	3	3	4	3	3	4	3	3	4	4
		3	3	3	3	3	6	3	3	6	3	3	6	6
	ca. kg	4	5,5		7			8,5			15,5			

1) 50 with Camlock, other dimensions in the table on the top

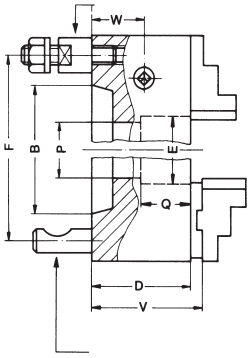
Chuck dimensions ZS - ZSU and Orange Line

Short taper mount

DIN 55021,
with setscrews and locknuts



DIN 55027,
with studs and nuts



DIN 55029,
with studs for Camlock

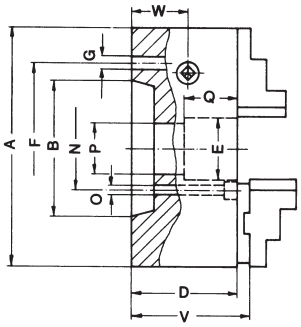
Size A		250				315				350			400		
Taper size		4	5	6	8	5	6	8	11	6	8	11	6	8	11
B		63,5	82,5	106,4	139,7	82,5	106,4	139,7	196,9	106,4	139,7	196,9	106,4	139,7	196,6
D		83	83	83	83	96	96	96	104	122	122	122	106	106	106
E		60,7	76	76	76	79,6	103	103	103	103	115	115	103	136	136
F	DIN	85	104,8	133,4	171,4	104,8	133,4	171,4	235	133,4	171,4	235	133,4	171,4	235
	Caml.	82,5													
P		60,7	-	-	-	79,6	-	-	-	103	-	-	103	-	-
Q		40,5	-	-	-	49	-	-	-	81	-	-	54	-	-
V		90,9	90,9	90,9	90,9	101,4	101,4	101,4	109,4	127,4	127,4	127,4	114,4	114,4	114,4
W		27,5	27,5	27,5	27,5	31	31	31	39	56	56	56	36	36	36
Mounting holes	DIN	3	4	4	4	4	4	4	6	4	4	6	4	4	6
	Caml.	3	6	6	6	6	6	6	6	6	6	6	6	6	6
approx. kg		30				50				71			84		

Size A		500			630		700		800		1000		1250	
Taper size		8	11	15	11	15	11	15	15	20	15	20	15	20
B		139,7	196,9	285,8	196,9	285,8	196,9	285,8	285,8	412,8	285,8	412,8	285,8	412,8
D		122	122	122	137	137	149	149	149	149	159	159	159	159
E		136	190	190	192,7	240	310	310	380	380	460	460	550	550
F		171,4	235	330,2	235	330,2	235	330,2	330,2	463,6	330,2	463,6	330,2	463,6
P		136	-	-	192,7	-	192,7	281,2	281,2	-	281,2	407,5	281,2	407,5
Q		61	-	-	63	-	76	76	76	-	85	85	85	85
V		130,4	130,4	130,4	145,3	145,3	160	160	160	160	168	168	168	168
W		40	40	40	50	50	50	50	50	50	55	55	55	55
Mounting holes	DIN	4	6	6	6	6	6	6	6	6	6	6	6	6
	Caml.	6	6	6	6	6	6	6	6	6	6	6	6	6
approx. kg		150			225		280		350		590		850	

All other dimensions should be taken from the table about chucks with cylindrical centre mount

Short taper mount

DIN 55026
Mounting from front



Size A		160	200		250			315		350		400	
Taper size		5	5	6	5	6	8	6	8	6	8	8	11
B		82,5	82,5	106,4	82,5	106,4	139,7	106,4	139,7	106,4	139,7	139,7	196,9
D		66	74,5	74,5	83	83	83	96	96	122	122	106	106
E		42	42	55	76	55	76	103	76	103	76	136	125
F[2]		-	-	-	104,8	-	-	133,4	-	133,4	-	171,4	-
G		-	-	-	11[1]	-	-	14	-	14	-	18	-
N[3]		61,9	61,9	82,6	-	82,6	111,1	-	111,1	-	111,1	-	165,1
O		11[1]	11[1]	14	-	14	18	-	18	-	18	-	22
V		70,7	81,2	81,2	90,9	90,9	90,9	101,4	101,4	127,4	127,4	114,4	114,4
W		23,45	26,7	26,7	275	275	275	31	31	56	56	36	36
Mounting holes	*	3	3	6	3	6	6	6	6	6	6	6	6
	**	4	4	4	4	4	4	4	4	4	4	4	4
approx. kg		8	14,5		25			44,5		71		82	

Size ØA		500	630		700		800			1000		1250	
Taper Size		11	11	15	11	15	11	15	20	15	20	15	20
B		196,9	196,9	285,9	196,9	285,9	196,9	285,9	412,8	285,9	412,8	285,9	412,8
D		122	137	137	149	149	149	149	149	159	159	159	159
E		190	190	190	310	285	380	380	380	460	505	550	550
F[2]		235	235	-	235	330,2	235	330,2	463,6	330,2	463,6	330,2	463,62
G		22	22	-	22	26	22	26	26	26	26	26	26
N[3]		-	-	247,6	-	-	-	-	-	-	-	-	-
O		-	-	26	-	-	-	-	-	-	-	-	-
P		-	-	-	193	281,2	193	281,2	-	281,2	407,5	281,2	407,5
Q		-	-	-	76	76	76	76	-	85	85	85	85
V		130,4	145,3	145,3	159,9	159,9	159,9	159,9	159,9	168	168	168	168
W		40	50	60	50	50	50	50	50	55	55	55	55
Mounting holes	*	3	6	6	6	6	6	6	6	8	8	8	8
	**	4	8	8	8	8	8	8	8	8	8	8	8
approx. kg		139	220		295		350			590		850	

1) 12 with ASA B 5.9 inch thread

2) With DIN 55026 Forme A and B; DIN 55021 Forme A and B; ASA B 5.9 A1/A2

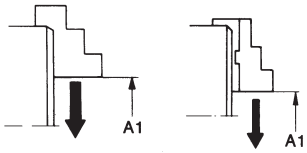
3) With DIN 55026 Forme B; ASA B 5.9 A1/B1

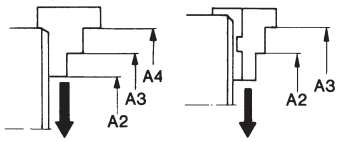
* 3-Jaw

** 4-Jaw

Chuck dimensions ZS - ZSU and Orange Line

External chucking





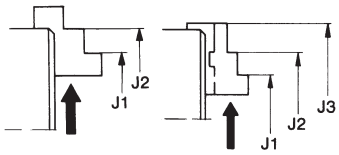
Ø 74-630 Ø 700-1250

Chucking capacities of jaw steps (standard values)

Size	74	80	85	100	110	125	140	160	200	250
A1 (BB)	2-24	2-30	2-30	3-38	3-42	3-53	3-53	4-72	4-100	5-122
A2 (DB)	2-24	2-30	2-30	3-38	3-42	3-53	3-53	3-72	4-100	5-122
A3 (DB)	23-46	27-55	27-55	38-71	39-77	39-89	47-97	47-116	56-152	73-190
A4 (DB)	45-68	52-80	52-80	70-100	70-100	75-125	91-140	91-160	104-200	131-250
max. swing dia.	88	104	104	128	138	157	174	194	238	302
Jaw movement	11	14	14	15	19	25	25	34	48	58

Size	315	350	400	500	630	700	800	1000	1250
A1	6-135	20-180	20-200	35-260	50-350	110-350	150-450	250-600	320-600
A2	6-135	20-180	20-200	35-260	50-350	280-672	325-853	425-1070	490-1150
A3	96-225	110-270	110-300	140-360	190-490	356-748	400-928	500-1150	564-1224
A4	186-315	200-350	200-400	280-500	330-630	-	-	-	-
max. swing dia.	395	440	480	600	730	1000	1170	1390	1476
Jaw movement	64	80	100	110	150	120	150	175	140

Internal chucking



Ø 74-630 Ø 700-1250

Size	74	80	85	100	110	125	140	160	200	250
J1	23-46	25-53	26-53	33-66	33-71	37-87	39-89	39-107	44-140	59-165
J2	45-68	50-78	50-78	65-94	65-104	73-123	83-132	83-152	92-186	119-236

Size	315	350	400	500	630	700	800	1000	1250
J1	96-224	100-260	100-300	135-355	150-450	212-648	251-855	356-1080	426-1162
J2	186-305	190-350	190-390	275-460	290-590	290-758	326-930	430-1150	500-1236
J3	-	-	-	-	-	526-922	566-1094	660-1314	740-1400

Clamping ranges for lathe chucks with individual adjustable jaws (EG-ES) are in approximate conformity with the above values. They are valid for 3- and 4-jaw chucks and lathe chucks with reversible jaws.
Do not exceed maximum chucking ranges.

Max. permissible speeds for ZG-ZS, ZGU-ZSU, ZG Hi-Tru chucks to DIN 6350

The maximum permissible speed has been fixed so that 1/3 of the gripping force is still available as residual gripping force if the maximum gripping is applied and the chuck is fitted with its heaviest jaws. The jaws may not project beyond the outside diameter of the chuck. The chuck must be in perfect condition. The speed limit for chucks with cast iron bodies is based on the permissible peripheral speed for cast iron. The specification DIN 6386 Part 1 shall be observed.

Size	3 and 4 jaws	
	Cast iron body	Steel body
74	5000	-
80	5000	7000
100	4500	6300
125	4000	5500
140	3700	5000
160	3600	4600
200	3000	4000
250	2500	3000
315	2000	2300
350	1700	1900
400	1600	1800
500	1000	1300
630	800	850
700	650	800
800	600	700
1000	480	560
1250	380	450

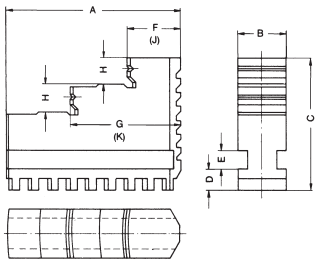
Claming force 3 jaw chuck ZS - ZSU, Orange Line, ZS Hi-Tru to DIN 6350

The clamping force is sum total of all jaw forces acting radially on the stationary workpiece. The clamping forces are approximate values. To obtain the specified clamping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM.

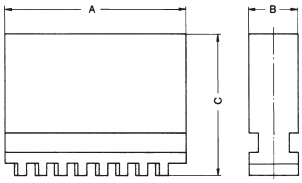
Size	Torque key	Total clamping force
74	30	11
80	30	13
100	60	27
125	80	31
140	90	40
160	11	47
200	140	55
250	150	63
315	180	69
350	210	74
400	240	92
500	260	100
630	280	105
700	280	105
800	300	110
1000	450	115
1250	450	115

Jaw dimensions ZS - ZSU, Orange Line, ZS Hi-Tru

Outward stepped jaw (inside jaw) **BB**



Unstepped jaw, soft (block jaw) **BL**



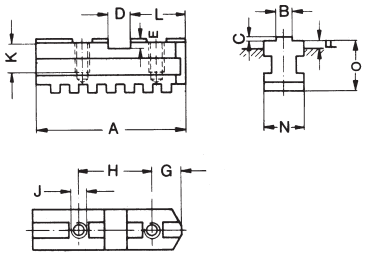
Dimensions F and G apply to outward stepped jaws **BB**
Dimensions J and K apply to inward stepped jaws **DB**

Size		74[1]	80/85	100/110	125	140	160	200	250	315	300/400	500/630
A		32	37	48	52	61	61	69	90	130	130	190
B		10	12	14	18	18	18	20	24	34	34	42
C		23	26	33,5	41,5	41,5	47,5	53,5	67,5	79,5	79,5	95
D		4,7	4,8	6,3	7,3	8,3	8,3	8,3	10,3	11,3	11,3	14,9
E		4	4,5	6	7	7	7	8	10	15	15	15
F		10	12	15	17	18	18	20	27	41,5	41,5	50
G		21	24,5	31	35	40	40	44	57	86,5	86,5	120
H		5	6	6	8	8	10	10	14	15	15	20
J		-	12	14	16	17	17	19	26	40	40	50
K		-	24,5	30	34	39	39	43	56	85	85	120
Jaw approx. kg	BB	0,03	0,05	0,1	0,2	0,22	0,25	0,3	0,7	1,8	1,8	3,8
	BL	0,05	0,08	0,15	0,27	0,32	0,38	0,52	1	2,4	2,4	5,2

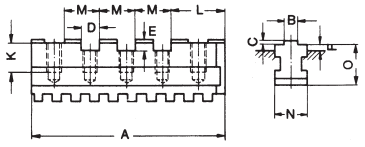
1) Reversible jaws

Base jaw **GB**

Ø 100-400

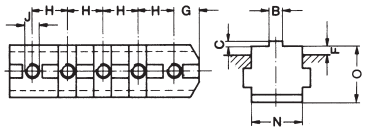


Ø 500-630



Size		100/110	125	140	160	200	250	315	350/400	500	630
A		46	55	65	65	78	92	108	127	165	203
$B_{-0,05}$		7,94	7,94	7,94	7,94	7,94	12,7	12,7	12,7	12,7	12,7
C		2,5	3,1	3,1	3,1	3,1	3,1	3,1	3,1	3,1	3,1
$D^{+0,01}$		9,5	12,68	12,68	12,68	12,68	19,03	19,03	19,03	19,03	19,03
E		6	7,6	7,6	7,6	7,6	7,6	7,6	10,8	10,8	10,8
F		3,4	4,8	7,8	4,8	6,8	8	5,5	10,5[2]	8,5	8,5
G		12	13	15,8	15,8	19	22,2	25,4	28,5	28,5	28,5
H		24	32	38,1	38,1	44,45	54	63,5	76,2	38,1	38,1
J	metr.	M6	M8	M8	M8	M8	M12	M12	M16	M20	M20
	UNC	1/4"-20	5/16"-18	3/8"-16	3/8"-16	3/8"-16	1/2"-13	1/2"-13	5/8"-11	3/4"-10	3/4"-10
K		12	14,5	16	16	16	20	25	29	33	33
L		19,25	22,6	28,5	28,5	34,9	39,7	47,6	57,1	57,1	57,1
M		-	-	-	-	-	-	-	-	38,1	38,1
N		14	18	18	18	20	24	34	34	42	42
O		19,5	24	27	27	28	35	40	45	49	49
Grooves		1	1	1	1	1	1	1	1	2	3
Tapped holes		2	2	2	2	2	2	2	2	4	5
Jaw approx. kg		0,06	0,12	0,17	0,17	0,22	0,4	0,78	1	1,72	2,1

Ø 700-1250

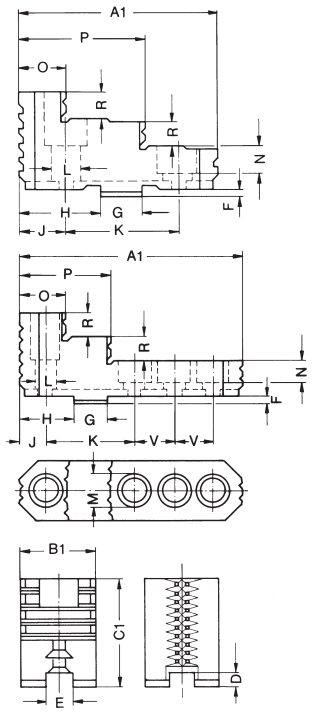


Size		700	800	1000	1250
A		253	291	329	367
$B_{-0,05}$		12,7	12,7	12,7	12,7
C		3,1	3,1	3,1	3,1
$D^{+0,01}$		19,03	19,03	19,03	19,03
E		10,8	10,8	10,8	10,8
F		11	11	9	9
G		28,5	28,5	28,5	28,5
H		38,1	38,1	38,1	38,1
J	metr.	M20	M20	M20	M20
	UNC	3/4"-10	3/4"-10	3/4"-10	3/4"-10
K		37	37	37	37
L		57,1	57,1	57,1	57,1
M		38,1	38,1	38,1	38,1
N		55	55	55	55
O		62	62	62	62
Grooves		4	5	6	7
Tapped holes		6	7	8	9
Jaw approx. kg		6,2	7,1	8	9

1) Reversible jaws 2) Size

Jaw dimensions ZS - ZSU, Orange Line, ZS Hi-Tru

Reversible top jaw **UB**

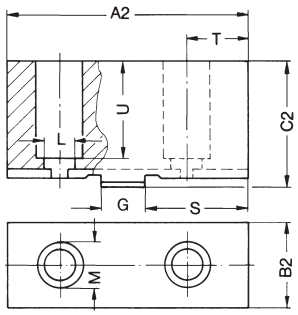


Chuck Size		100 110	125	140 160	200 230	250 270	315	350 400	500 630	700 800	1000 1250
A	1	47	56	66,7	79,5	95,3	109,5	127	127	210	210
	2	53	62	74	87	103	120	137	140	210	210
B	1	22	26	28	30	36	42	42	50	68	68
	2	22,5	26,5	28,5	30,5	36,5	42,5	42,5	50,5	68	68
C	1	29,5	37,5	41,5	42,5	52,5	57,5	64,5	79,5	89	110
	2	30	38	42	43	53	58	65	80	89	110
D		5,5	7,6	7,6	7,6	7,6	7,6	10,8	10,8	10,8	10,8
E		7,96	7,96	7,96	7,96	12,72	12,72	12,72	12,72	12,72	12,72
F		2,5	3,1	3,1	3,1	3,1	3,1	6,35	6,35	6,35	6,35
G		9,50	12,68	12,68	12,68	19,03	19,03	19,03	19,03	19,03	19,03
H		19,25	22,6	28,5	34,9	39,7	47,6	57,1	57,1	57,1	57,1
J		12	13	15,8	19	22,2	25,4	28,5	28,5	28,5	28,5
K		24	32	38,1	44,45	53,95	63,5	76,2	76,2	76,2	76,2
L		6,6	9	9[1] 10,5[2]	9[1] 10,5[2]	14	14	18	22	22	22
M		11	15	15[1] 16[2]	15[1] 16[2]	20	20	26	33	33	33
N		7	9	10	10	13,5	13,5	17	21	21,5	21,5
O		12	13	15,8	19	22,2	25,4	28,5	54,6	51	51
P		29,5	35	42,8	51,5	60,2	67,4	77	88,5	89	89
R		6	8	10	10	14	15	15	20	22	25
S		22,25	25,6	32,2	38,7	43,5	52,9	62,1	63,6	70	70
T		15	16	19,5	22,8	26	30,7	33,55	35	41,5	41,5
U		19	27	30	30	41	43	47	61	65	71
V		-	-	-	-	-	-	-	-	38,1	38,1
Jaw approx. kg	UB	0,12	0,19	0,27	0,39	0,66	1,02	1,27	2	4,45	6,1
	AB	0,21	0,34	0,5	0,7	1,2	1,86	2,18	3,04	8	10,8

Saw-tooth standard model

Cross-grooving
from size 250 available
from size 700 standard-model

Unstepped top jaw soft **AB**



Special-design jaws

for non-rotating clamping devices, for symmetrical components,
for machine vices and NC-compact vices
available in all desired modifications



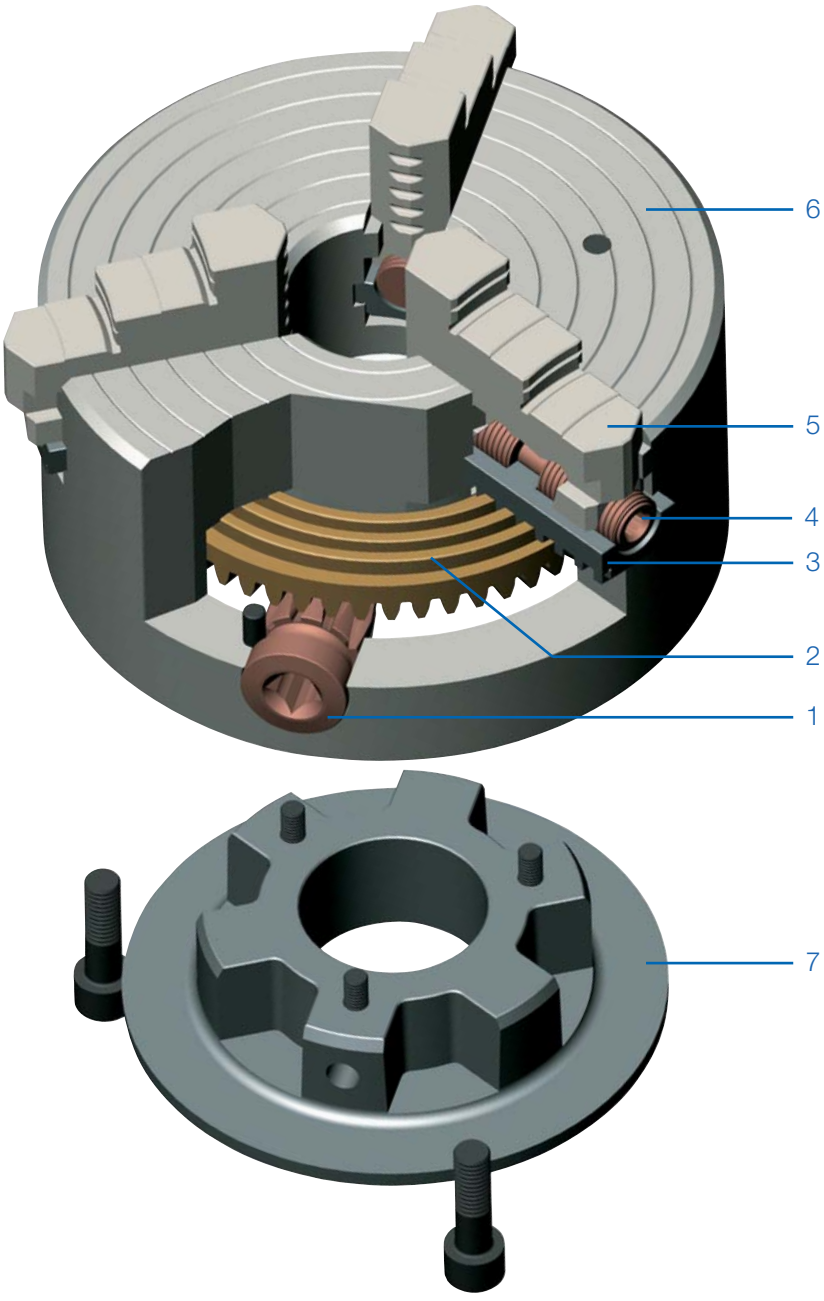
ES

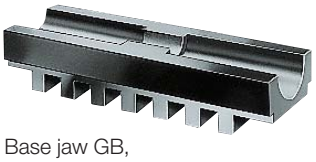
This chuck is used for aligning irregularly shaped workpieces.

Principle of operation
Through a radially arranged drive (1, hardened), the force is transferred via a bevel gearing to a hardened spiral ring (2) and further conducted via the spiral to the base jaws (3, hardened and ground), spindle (4, hardened) and reversible jaws (5, hardened and ground). The position of the workpiece can be adjusted by turning the spindle. Steel body (6), cover (7).

Clamping force transfer system
The jaws can be adjusted over the entire clamping range by turning the key.

Lubrication
To maintain the clamping force, rotary chucks must be lubricated regularly. You will find corresponding information in the operating instructions which are enclosed with every chuck. All rotary chucks are provided with grease nipples for easy maintenance.





Base jaw GB,
hardened and ground



Reversible top jaw UB,
hardened and ground



Unstepped jaw BL
unstepped, soft, material 16MnCr5

ES



APPLICATION

Optimized for the machining of irregularly shaped workpieces.

TYPE

Face spiral chucks in steel design with which irregularly shaped workpieces can be aligned via adjusting spindles.

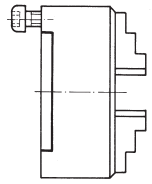
CUSTOMER BENEFITS

- Exact alignment of irregularly shaped workpieces
- Jaws centrically clamping and individually adjustable
- Die-forged spiral ring, series-balanced and hardened
- Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With one set each of base and reversible jaws
- Clamping wrench
- Dimensions and take-ups in acc. with DIN 6351
- Hardened spiral ring
- Die-forged steel body

A09
DIN 6351; cylindrical centre mount, form A



Size	Cylindrical centre mount	Through-hole mm	3 jaw chuck steel	4 jaw chuck steel	Torque Nm	Total clamping force kN
160	125	42	**111360**	**111789**	110	47
200	160	55	**111365**	**111793**	140	55
250	200	76	**111370**	**111797**	150	63
315	260	103	**111375**	**111801**	180	69
400	330	136	**111380** ▲	**111805** ▲	240	92
500	420	190	**111385** ▲	**111809** ▲	260	100
630	545	240	**111390** ▲	**111813** ▲	280	105

Further sizes and mountings available on request

Jaws ES

A09
Reversible jaw UB, hardened



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
160	**110118**	**110124**	69	50	20
200	**139666**	**139670**	85	57,5	24
250	**139667**	**139671**	90	67,5	24
315/400	**139668**	**139672**	130	79,5	34
500/630	**139669**	**139673**	190	95	42

A09
Unstepped jaw BL, unstepped, soft



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
160	**107669**	**107675**	69	50	20
200	**139674**	**139678**	85	57,5	24
250	**139675**	**139679**	90	67,5	24
315/400	**139676**	**139680**	130	79,5	34
500/630	**139677**	**139681**	190	95	42

A09
Base jaw GB, hardened



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
160	**107654**	**107662**	62	15,3	26
200	**139682**	**139686**	78	17,8	30
250	**139683**	**139687**	86	17,8	30
315	**139684**	**139688**	118	22,7	44
400	**139685**	**139689**	118	22,7	44
500/630	**107659**	**107667**	176	25	54

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Accessories ES

A09

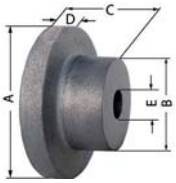
Base plates for lathe chucks with **cylindrical centre mount**
DIN 6350



Item no.	Size
162793	160
162401	200
163036	250
133705	315

A09

Unfinished adapter plates for **cylindrical mount**
The unfinished back plate must be machined and fitted on both machine and chuck side



Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017116	160	6 ¼	170	80	58	20	30
017117	200	8	210	92	66	22	40
017118	250	10	260	105	92	25	50

C15

Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

C15

Adjusting spindle



Item no.	For chuck size
103199	100
104251	125
104271	160
137735	200
137643	250
137701	400
137716	500

A09

Adjusting key



Item no.	For chuck size	Square	Hexagon
107444	160	5,5	-
139695	400	-	8
139696	500	-	12

A09

Scroll



Item no.	Size
101754	100
101721	125
100303	160
100003	200
100203	250
101552	315
102497	400
162973	500
162964	630

A09

Driving pinion



Item no.	Size	Hexagon
178473	100	9
178475	125	10
178477	160	11
178478	200	12
178480	250	14
178482	315	17
178483	400	19
178484	500	22
178485	630	22

A09

Pinion holder screw



Item no.	Size
100305	160
100006	270
101554	315
102499	400
103300	630

Accessories ES

A09

Standard key



Item no.	Size	Square	Length mm
107427	100/110	8	75
107428	125/140	9	80
107429	160	10	90
107430	200/230	11	100
107431	250/270	12	100
107432	315	14	110
107433	350	14	140
107434	400	17	140
107435	500/630	19	150

A09

Safety key with ejector



Item no.	Size	Square	Length mm
154371	100/110	8	130
154372	125/140	9	130
154373	160	10	160
154374	200/230	11	160
154375	250/270	12	160
154376	315	14	200
154377	350	14	200
154378	400	17	250
154379	500/630	19	250

A09

Elongated safety key with ejector



Item no.	Size	Square	Length mm
154683	125/140	9	170
154685	160	10	180
154687	200/230	11	200
154689	250/270	12	200
154695	315	14	250

A09

Safety adapter with ejector

for actuating the chuck with torque (defined torque introduction)



Item no.	Size	Square	Inch
178566	80/85	6	3/8
178567	100/110	8	1/2
178568	125/140	9	1/2
178569	160	10	1/2
178570	200/230	11	1/2
178571	250/270	12	1/2
178572	315/350	14	1/2

C15

Mounting screws

for lathe chucks with direct **short-taper**, **for front mounting**



Item no.	Size	Thread	Contents of delivery	Chuck Size	Taper size
233059	74	M10x70	piece	160	5
308436	80	M10x85	piece	200	5
200186	85	M12x85	piece	200	6
234615	100	M10x110	piece	250	5
302215	110	M12x90	piece	250	6
202439	125	M16x90	piece	250	8
316244	140	M12x120	piece	315	6
308439	160	M16x105	piece	315	8
342701	315	M16x130	piece	400	8
698878	350	M20x115	piece	400	11
011528	400	M20x155	piece	500	11
358815	500	M20x170	piece	630	11
202509	630	M24x150	piece	630	15

C15

Set screw with nut DIN 55021



Item no.	Thread	For taper	Quantity
107453	M10x30	4	3
107455	M10x35	5	4
107456	M12x40	6	4
107457	M16x45	8	4
107458	M20x55	11	6
127618	M24x65	15	6

A09

Stud and locknut ISO 702-3 (DIN 55027)



Item no.	Thread	Contents of delivery	For taper	Quantity
107447	M10x34	piece	3	3
107448	M10x39	piece	4	3
107449	M10x43	piece	5	4
107450	M12x50	piece	6	4
107451	M16x60	piece	8	4
107452	M20x75	piece	11	6
125650	M24x90	piece	15	6

A09

Stud for Camlock ASA B 5.9 (DIN 55029) and cylindrical studs



Item no.	Thread	For taper	Quantity
107465	7/16-20x35	3	3
107466	7/16-20x37	4	3
107467	½-20x43	5	6
107468	5/8-18x49	6	6
107469	¾-16x55,5	8	6
107470	7/8-14x67	11	6
127621	1-14x76	15	6

A09

Stud for Camlock ISO 702-2 (DIN 55029) and cylindrical studs

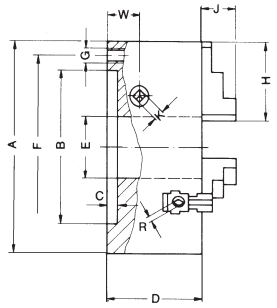


Item no.	Thread	For taper	Quantity
178364	M10x1	3	3
178365	M10x1	4	3
178366	M12x1	5	6
178367	M16x1,5	6	6
178368	M20x1,5	8	6
178369	M22x1,5	11	6
178370	M24x1,5	15	6
178371	M27x2	20	6

▲ on request

Chuck dimensions ES

Cylindrical centre mount DIN 6351



The bore could be enlarged (measure E, at surcharge)

Enlarged bore max.

Size A	100	125	160	200	250	315	400	500	630
B^{H6}	70	95	125	160	200	260	330	420	545
C	3	4	4	4	5	5	5	5	7
D	67	71	80	95,5	100	117	123	145	160
E	20	32	42	55	76	103	136	190	240
$E_{max.}$	21	33	50	70	92	114	150	210	253
F	83	108	140	176	224	286	362	458	586
G	3xM8	3xM8	3xM10	3xM10	3xM12	3xM16	3xM16	6xM16	6xM16
H	56	56	69	85	90	130	130	190	190
J	22	21	28	32,5	40,6	46,5	47	55	55
K	8	9	10	11	12	14	17	19	19
R*	5,5	5,5	5,5	8	8	8	8	12	12
W	20	20	22,45	25,7	26,5	30	35	38	48
approx. kg	4	6	10	18	29	54	88	145	240

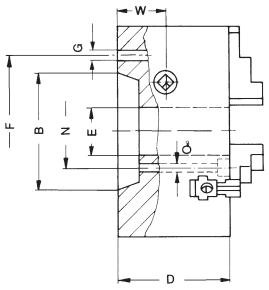
* from Ø 200 hexagon

Short taper mount

DIN 55021 with setscrews and nuts



DIN 55027 with studs and locknuts
Available on request!



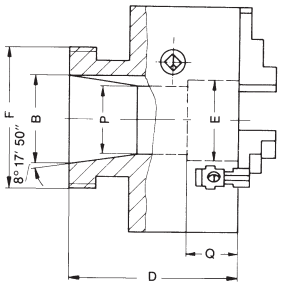
DIN 55029 with studs for camlock
Available on request!

Size A		125		160			200			250		
Short-taper size		3	4	4	5	6	4	5	6	5	6	8
B		53,9	63,5	63,5	82,5	106,4	63,5	82,5	106,4	82,5	106,4	139,7
D		84	84	81	81	81	96,5	96,5	96,5	101	101	101
E		32	32	42	42	42	55	55	55	76	76	76
F	DIN	75	85	85	104,8	133,4	85	104,8	133,4	104,8	133,4	171,4
	Camlock	70,6	82,5	82,5			82,5					
W		21	21	23,45	23,45	23,45	26,7	26,7	26,7	27,5	27,5	27,5
Mouting holes	DIN	3	3	3	4	4	3	4	4	4	4	4
	Camlock	3	3	3	6	6	3	6	6	6	6	6
approx. kg		6		10			19			30		

Size A		315			400		500		630	
Short-taper size		6	8	11	8	11	11	15	11	15
B		106,4	139,7	196,9	139,7	196,9	196,9	285,8	196,9	285,8
D		118	118	118	124	124	147	147	162	162
E		103	103	103	136	136	190	190	240	240
F		133,4	171,4	235	171,4	235	235	330,2	235	330,2
P		-	-	-	-	-	-	-	192,7	-
Q		-	-	-	-	-	-	-	88	-
W		31	31	31	36	36	40	40	50	50
Mouting holes	DIN	4	4	6	4	6	6	6	6	6
	Camlock	6	6	6	6	6	6	6	6	6
aporox. kg		56			92		155		250	

All other dimensions should be taken from the table on the top

DIN 55026
Mounting from front
Available on request!



Size A		160	200		250		315		400		500	630	
Short-taper size		5	5	6	6	8	6	8	8	11	11	11	15
B		82,5	82,5	106,4	106,4	139,7	106,4	139,7	139,7	196,9	196,9	196,9	285,8
D		81	96,5	96,5	101	101	118	118	124	124	147	162	162
E		42	42	55	55	76	103	76	136	125	190	190	190
F[3]		-	-	-	-	-	133,4	-	171,4	-	235	235	-
G		-	-	-	-	-	14	-	18	-	22	22	-
N[2]		61,9	61,9	82,6	82,6	111,1	-	111,1	-	165,1	-	-	247,6
O		11[1]	11[1]	14	14	18	-	18	-	22	-	-	26
W		23,45	26,7	26,7	27,5	27,5	31	31	36	36	40	50	50
Mouting holes	*	3	3	6	6	6	6	6	6	6	6	6	6
	**	4	4	4	4	4	4	4	4	4	8	8	8
approx. kg		10	19		30		56		92		154	250	238

1) 12 with ASA B 5.9 A1/A2 inch, all other dim. should be taken from the above table.

2) With DIN 55026 form B; ASA B 5.9 A1/B1
* 3-Jaw
** 4-Jaw

3)With DIN 55026 Form A and B; DIN 55021 Forme A and B; ASA B 5.9 A1/A2

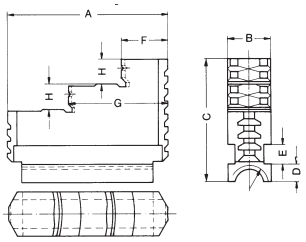
Chuck dimensions ES

Max. permissible speeds for chucks EG-ES to DIN 6351

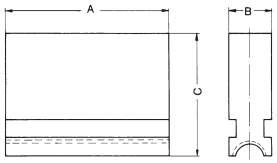
The specified values are only applicable for workpieces not exceeding a specific unbalance of 25 gmm/kg.

Size	3-Jaw Steel body	4-Jaw Steel body
100	-	-
125	-	-
160	3200	2850
200	2650	2350
250	2200	1900
315	1400	1220
400	1400	1220
500	880	770
630	750	660

Reversible jaw **UB**



Left-hand thread



Size	100	125	160	200	250	315	400	500	630
A	56	56	69	85	90	130	130	190	190
B	18	18	20	24	24	34	34	42	42
C	41,5	41,5	50	57,5	67,5	79,5	79,5	95	95
D	8,7	8,7	9,7	9,7	9,7	11,15	11,15	15	15
E	7	7	8	10	10	15	15	15	15
F	17	17	19	25	26	40	40	50	50
G	35	35	43	54	56	85	85	120	120
H	8	8	10	12	14	15	15	20	20
Thread	Tr14x3	Tr14x3	Tr16x4	Tr18x2	Tr18x2	Tr20x2	Tr20x2	Tr26x3	Tr26x3
approx. kg	0,18	0,18	0,3	0,53	0,7	1,7	1,7	3,7	3,7

Notes

KRF



APPLICATION

Three- and four-jaw chuck for positioning and conveying workpieces, e.g. on measuring machines.

TYPE

Face spiral chuck in cast iron version.

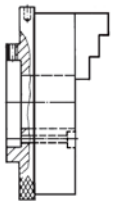
CUSTOMER BENEFITS

- Easy clamping of the workpiece by turning the clamping ring
- Sizes 125 - 200: 4 setscrews for fine adjustment
- Cast iron body
- Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- Face spiral chuck in cast iron version
- 6 jaw chuck for grinding twist drills on request available

A09
Lever scroll chucks KRF **cylindrical centre mount**



Size	Cylindrical centre mount	Through-hole mm	**3 jaw chuck with inside and outside jaw**	**4 jaw chuck with inside and outside jaw**	Torque Nm	Total clamping force kN
70	48	16	**148793**[1)]	**148794**	12	2,5
110	75	26	**148757**	**148772**	26	3,2
125	70	35	**150757**	**150758**	36	3,5
160	78,5	52	**150759**	**150760**	50	4
200	115	64	**150761**	**150762**	60	4,5

[1)] jaws reversible
Sizes 125 - 200: 4 setscrews for fine adjustment
Further sizes and mountings available on request

▲ on request

KRF - on base plate



APPLICATION

Three-jaw chuck with base plate for positioning and conveying workpieces, e.g. on measuring machines.

TYPE

Face spiral chuck in cast iron version.

CUSTOMER BENEFITS

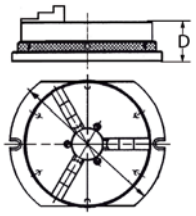
- Easy clamping of the workpiece by turning the clamping ring
- Sizes 125 - 200: 4 setscrews for fine adjustment
- Cast iron body

TECHNICAL FEATURES

- Mounted in the chuck with one set of jaws stepped outward (BB),
- One set of jaws stepped inward (DB),
- Size 70 with reversible jaws,
- Fastening screws

A09

Lever scroll chucks with base plate 3-jaw-chuck cast iron body



Item no.	Size	Through-hole mm	D mm	Torque Nm	Total clamping force kN
150595[1)]	70	16	46,4	12	2,5
150596	110	26	50	26	3,2
150597	125	35	59	36	3,5
150598	160	52	59	50	4
150599	200	64	69	60	4,5

[1)] jaws reversible

Further sizes and mountings available on request

Jaws KRF

A09
Inside jaw BB DIN 6350, outward stepped jaw, hardened



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
70	**110154**[1] ▲	**149305**	32	23	10
100	**110156**	**110064**	48	33,5	14
125	**110157**	**110065**	52	41,5	18
160	**110159**	**110067**	61	47,5	18
200	**110160**	**110068**	69	53,5	20

[1] Reversible, for use as turning or inside jaws
Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Outside jaw DB DIN 6350, inward stepped jaw, hardened



Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**110166**	**110074**	48	33,5	14
125	**110167**	**110075**	52	41,5	18
160	**110169**	**110077**	61	47,5	18
200	**110170**	**110078**	69	53,5	20

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped jaw BL DIN 6350, unstepped, soft, 16MnCr5

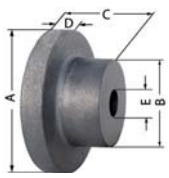


Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
70	**109114**[1]	**149304**	32	23	10
100	**107589**	**107599**	48	33,5	14
125	**107590**	**107600**	52	41,5	18
160	**107592**	**107602**	61	47,5	18
200	**107593**	**107603**	69	53,5	20

[1] Reversible

Accessories KRF

A09
Unfinished adapter plates for **cylindrical mount**
The unfinished back plate must be machined and fitted on both machine and chuck side



Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017116	160	6 ¼	170	80	58	20	30
017117	200	8	210	92	66	22	40

A09
Chip guard, piece



Item no.	Size	Contents of delivery
108501	100/110	piece
108502	125	piece
108503	140/160	piece
108504	200	piece

C15
Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Notes

BAV



APPLICATION

For turning out unhardened and grinding out hardened jaws, adjusting jaws reversible and infinitely variably adjustable.

TYPE

Lightweight design.

CUSTOMER BENEFITS

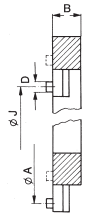
- The BAV cutting attachment is mainly used for turning the inside and outside diameters of soft jaws on 3-jaw chucks. It permits the chuck to be adjusted to the condition in which the work piece will be gripped within a few seconds (pretightening). This assures positive gripping and accurate concentricity of the machined clamping surfaces of the chuck jaws in the tightened condition.

TECHNICAL FEATURES

- Only applicable with base jaws (GB) and top jaws (AB)

A09

Jaw cutting attachment for **three-jaw chucks**



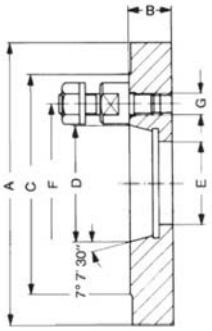
Item no.	Size	For chuck size	Clamping force max. kN	External Ø mm	Inner Ø	Overhang distance Ø J mm	Overhang distance Ø A mm	B mm	Thread	Weight approx. kg
220206	0	125	15	153	110	50-115	150-215	20	M5	1,6
220207	1	200	30	176	110	35-125	170-260	31	M8	3,4
220208	2	250	30	215	135	70-140	215-285	31	M8	5
220209	3	250	30	244	162	100-175	240-315	31	M8	5,7
220210	4	315	30	290	208	145-215	290-360	31	M8	6,9
220211	5	400	40	342	260	160-270	330-440	31	M10	8,5

▲ on request

Adapter plates

A09
Short-taper adapter plate ISO 702-3 (DIN 55027) and 55022 with studs and locknuts

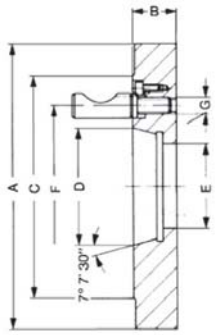




Item no.	Ø A mm	Taper	Inch	B mm	C mm	D mm	E mm	F mm	G	Weight approx. kg
319650	125	3	5	19	102	53,975	40	75	M10	2,3
319651	125	4	5	19	112	63,513	40	85	M10	2,2
319652	160	3	6 ¼	21	102	53,975	40	75	M10	3,9
319653	160	4	6 ¼	21	112	63,513	40	85	M10	3,9
319654	160	5	6 ¼	21	135	82,563	40	104,8	M10	4,6
319655	200	4	8	21	112	63,513	50	85	M10	6,4
319656	200	5	8	21	135	82,563	50	104,8	M10	7,4
319657	200	6	8	23	170	106,375	50	133,4	M12	8,4
319658	250	4	1	21	112	63,513	61	85	M10	10,2
319659	250	5	10	21	135	82,563	63	104,8	M10	11,6
319660	250	6	10	23	170	106,375	63	133,4	M12	13,3
319661	250	8	10	26	220	139,719	63	171,4	M16	13,8
319662	315	5	12 ¼	26	135	82,563	63	104,8	M10	18,6
319663	315	6	12 ¼	26	170	106,375	63	133,4	M12	21,5
319664	315	8	12 ¼	26	220	139,719	63	171,4	M16	22,6
319665	315	11	12 ¼	33	290	196,869	63	235	M20	25,2
319666	400	6	15 ¾	31	170	106,375	63	133,4	M12	35
319667	400	8	15,75	31	220	139,719	63	171,4	M16	37,2
319668	400	11	15,75	31	290	196,869	63	235	M20	42
319669	400	15	15,75	33	400	285,775	63	330,2	M24	42,1
319670	500	8	20	41	220	139,719	80	171,4	M16	62
319671	500	11	20	41	290	196,869	80	235	M20	67
319672	500	15	20	41	400	285,775	80	330,2	M24	68

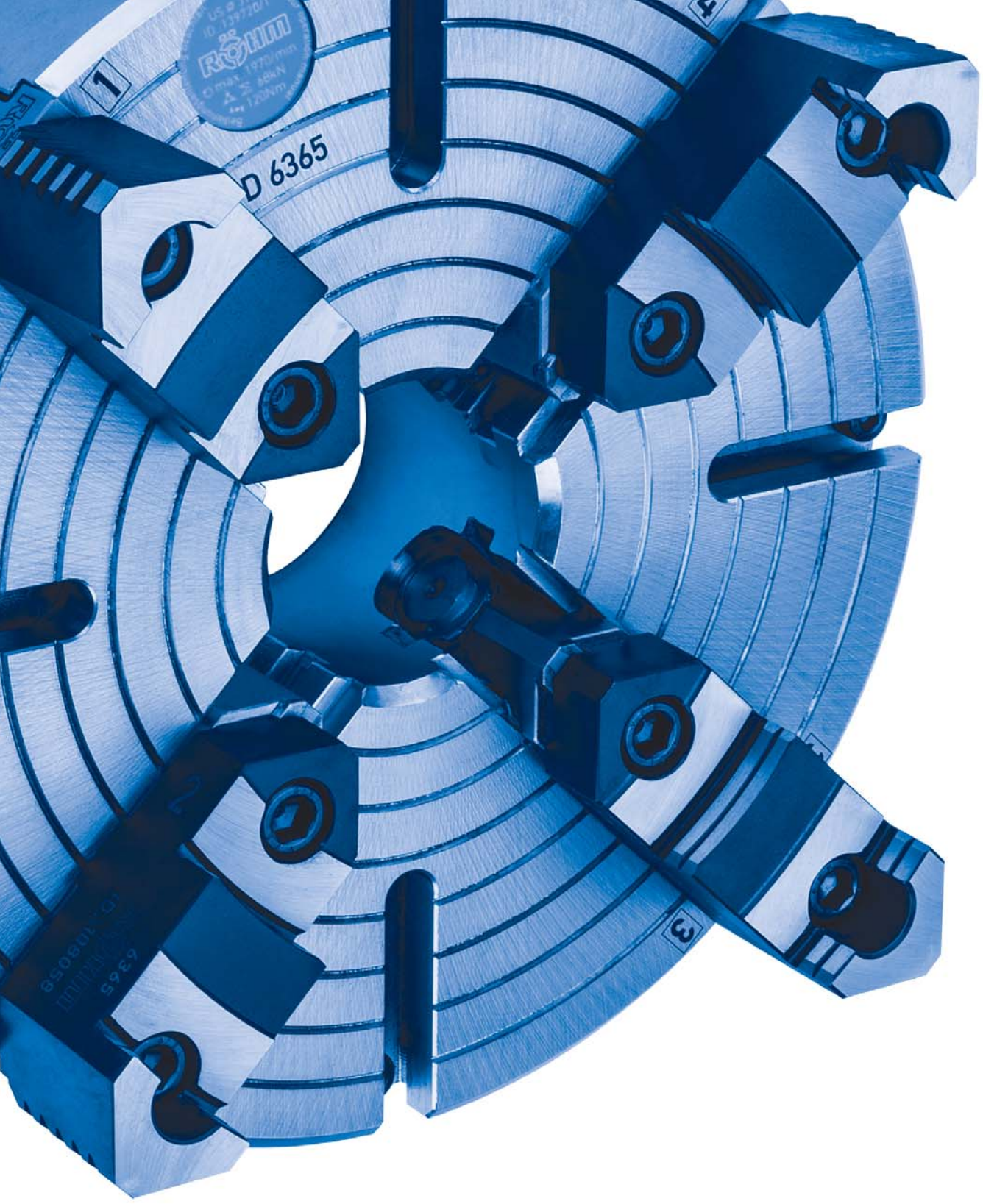
A09
Short-taper adapter plate ISO 702-2 (DIN 55029) **and ASA B 5.9 D1,** Camlock





Item no.	Ø A mm	Taper	Inch	B mm	C mm	D mm	E mm	F mm	G	Weight approx. kg
319673	125	3	5	27	92,1	53,975	40	70,66	7/16 - 20	2,3
319674	125	4	5	28	117,5	63,513	40	82,55	7/16 - 20	2,2
319675	160	3	6 ¼	27	92,1	53,975	40	70,66	7/16 - 20	3,9
319676	160	4	6 ¼	28	117,5	63,513	40	82,55	7/16 - 20	3,9
319677	160	5	6 ¼	31	146	82,563	40	104,8	½ - 20	4,6
319678	200	4	8	28	117,5	63,513	50	82,55	7/16 - 20	6,4
319679	200	5	8	31	146	82,563	50	104,8	½ - 20	7,4
319680	200	6	8	36	181	106,375	50	133,4	5/8 - 18	8,4
319681	250	4	1	28	117,5	63,513	61	82,55	7/16 - 20	10,2
319682	250	5	10	31	146	82,563	63	104,8	½ - 20	11,6
319683	250	6	10	36	181	106,375	63	133,4	5/8 - 18	13,3
319684	250	8	10	39	225,4	139,719	63	171,4	¾ - 16	13,8
319685	315	5	12 ¼	31	146	82,563	63	104,8	½ - 20	18,6
319686	315	6	12 ¼	36	181	106,375	63	133,4	5/8 - 18	21,5
319687	315	8	12 ¼	39	225,4	139,719	63	171,4	¾ - 16	22,6
319688	315	11	12 ¼	45	298,4	196,869	63	235	7/8 - 14	25,2
319689	400	6	15 ¾	36	181	106,375	63	133,4	5/8 - 18	35
319690	400	8	15,75	39	225,4	139,719	63	171,4	¾ - 16	37,2
319691	400	11	15,75	45	298,4	196,869	63	235	7/8 - 14	42
319692	400	15	15,75	50	403	285,775	63	330,2	1 - 14	42,1
319693	500	8	20	41	225,4	139,719	80	171,4	¾ - 16	62
319694	500	11	20	45	298,4	196,869	80	235	7/8 - 14	67
319695	500	15	20	50	403	285,775	80	330,2	1 - 14	68

Further sizes and designs, such as ISO 702-1, available on request!



JAWS INDIVIDUALLY ADJUSTABLE

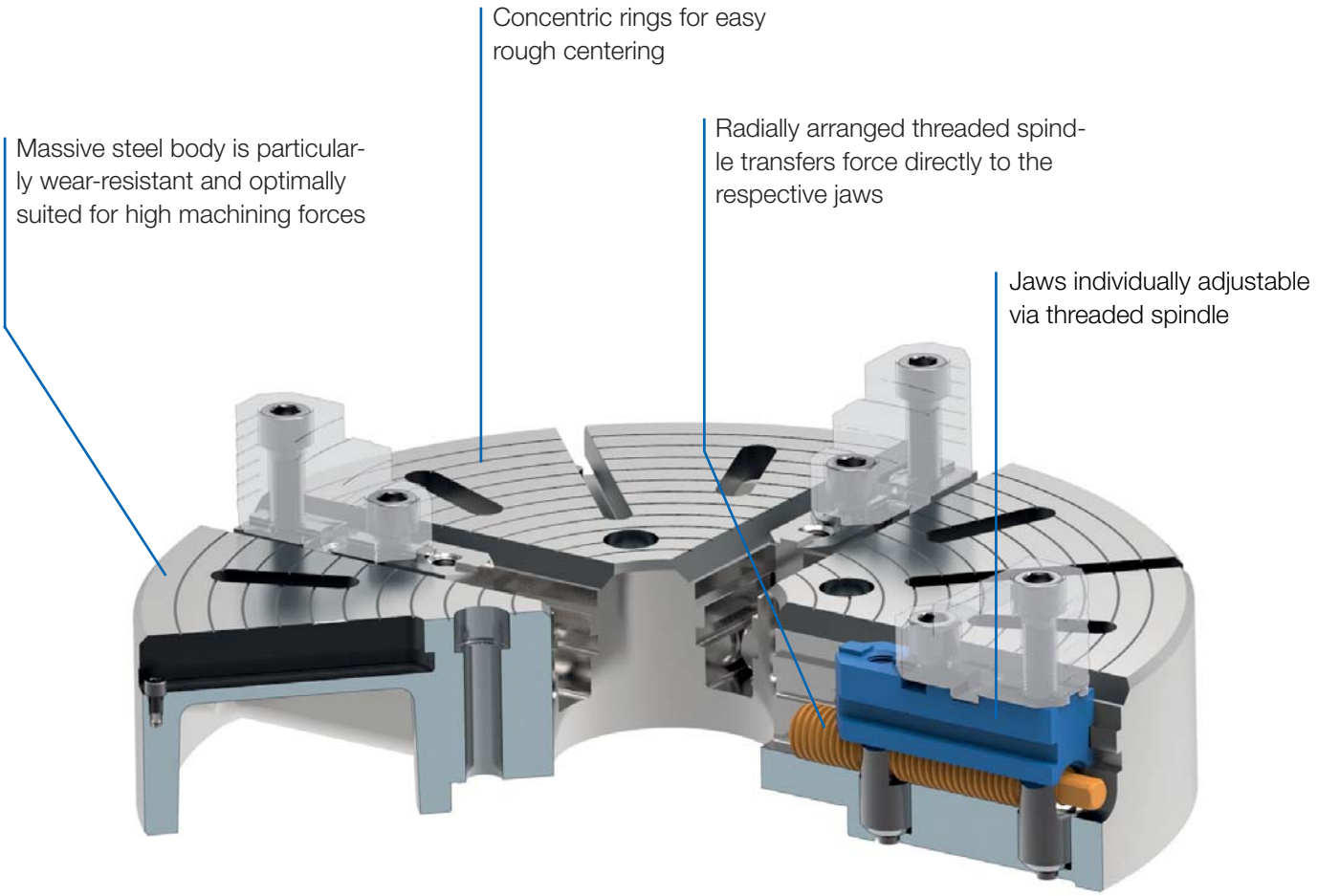
The four jaws can be independently adjusted via the threaded spindle, thereby allowing the safe and secure clamping of irregular, regular, as well as round workpieces.

INDEPENDENT CHUCKS

Independent chucks from RÖHM are particularly successful and effective when force has top priority. Due to the increased rigidity and optimal wear behavior, they are especially suitable for the initial machining of irregular, regular and round workpieces and make high machining forces and a longer machine service life possible.

ADVANTAGES AT A GLANCE

- Safe and easy clamping of irregular, regular, as well as round workpieces by four independently adjustable jaws
- Easy rough centering by means of concentric rings on the chuck body
- Direct force transfer through radially arranged threaded spindles



USE - USU



APPLICATION

Clamping chucks for lathes on which large, heavy or irregularly shaped workpieces are clamped for machining in the vertical or horizontal position.

TYPE

Independent four-jaw chuck in steel design. Jaws individually adjustable via threaded spindle (no central drive). Starting from size 315 with T-slots. Starting from size 1100 with T-slots and set-up slots.

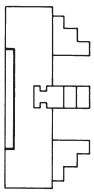
CUSTOMER BENEFITS

- Concentric rings for visual rough centering, fine centering using dial gauge

TECHNICAL FEATURES

- Steel design incl. clamping wrench and fastening screws, as well as 1 set of reversible or base and top jaws

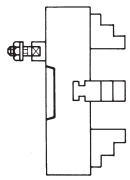
A26
Cylindrical centre mount (without mounting bolts)



Size	with one-piece reversible jaws	with base jaws and top jaws	Through-hole mm	Speed max. min^{-1}	Torque Nm	Clamping force/ jaw kN
260	139781 ▲	**137147 ▲**	70	2350	120	17
310	139796 ▲	**139720 ▲**	75	1970	120	17
400	139827 ▲	**135368 ▲**	95	1530	170	23
450	139842 ▲	**136944 ▲**	95	1360	170	23
500	139857 ▲	**135631 ▲**	95	1220	170	23
630	139887 ▲	**139723 ▲**	135	970	240	37
710	140800 ▲	**141097 ▲**	135	860	240	37
800	140801 ▲	**141106 ▲**	190	765	300	45

Further sizes and mountings available on request

A26
ISO 702-3 (DIN 55027), DIN 55022



Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min^{-1}	Torque Nm	Clamping force/ jaw kN
260	4	**139782 ▲**	**137163 ▲**	61	2350	120	17
260	5	**139783 ▲**	**137164 ▲**	70	2350	120	17
260	6	**139784 ▲**	**137165 ▲**	70	2350	120	17
310	5	**139797 ▲**	**139724 ▲**	75	1970	120	17
310	6	**139798 ▲**	**139725 ▲**	75	1970	120	17
310	8	**139799 ▲**	**139726 ▲**	75	1970	120	17
400	6	**139828 ▲**	**135371 ▲**	95	1530	170	23
400	8	**139829 ▲**	**135372 ▲**	95	1530	170	23
400	11	**139830 ▲**	**135358 ▲**	95	1530	170	23
450	6	**139843 ▲**	**136947 ▲**	95	1360	170	23
450	8	**139844 ▲**	**136948 ▲**	95	1360	170	23
450	11	**139845 ▲**	**136957 ▲**	95	1360	170	23
500	6	**139858 ▲**	**135632 ▲**	95	1220	170	23
500	8	**139859 ▲**	**135633 ▲**	95	1220	170	23
500	11	**139860 ▲**	**135696 ▲**	95	1220	170	23
630	8	**139888 ▲**	**139767 ▲**	136	970	240	37
630	11	**139889 ▲**	**139768 ▲**	136	970	240	37
630	15	**139890 ▲**	**139769 ▲**	136	970	240	37
710	8	**141088 ▲**	**141098 ▲**	136	860	240	37
710	11	**141089 ▲**	**141099 ▲**	136	860	240	37
800	8	**141092 ▲**	**600638 ▲**	200	765	300	45
800	11	**141093 ▲**	**141107 ▲**	192	765	300	45
800	15	**141094 ▲**	**141108 ▲**	192	765	300	45
900	11	-	**600639 ▲**	190	680	300	45
900	15	-	**600641 ▲**	190	680	300	45

Further sizes and mountings available on request

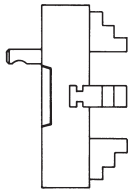
▲ on request

USE - USU

Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min^{-1}	Torque Nm	Clamping force/ jaw kN
1000	11	-	**141115** ▲	190	610	320	47
1000	15	-	**141116** ▲	190	610	320	47
1000	20	-	**600645** ▲	190	610	320	47
1100	11	-	**150500** ▲	190	555	320	47
1100	15	-	**600642** ▲	190	555	320	47
1100	20	-	**600646** ▲	190	555	320	47
1200	11	-	**150501** ▲	190	510	450	64
1200	15	-	**600643** ▲	190	510	450	64
1200	20	-	**600647** ▲	190	510	450	64

Further sizes and mountings available on request

A26
ISO 702-2 (DIN 55029); ASA B 5.9, type D, with studs for Camlock



Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min^{-1}	Torque Nm	Clamping force/ jaw kN
260	4	**139791** ▲	**137166** ▲	60	2350	120	17
260	5	**139792** ▲	**137254** ▲	70	2350	120	17
260	6	**139793** ▲	**137255** ▲	70	2350	120	17
310	5	**139806** ▲	**139733** ▲	75	1970	120	17
310	6	**139807** ▲	**139734** ▲	75	1970	120	17
310	8	**139808** ▲	**139735** ▲	75	1970	120	17
400	6	**139837** ▲	**135375** ▲	95	1530	170	23
400	8	**139838** ▲	**135376** ▲	95	1530	170	23
400	11	**139839** ▲	**135359** ▲	95	1530	170	23
450	6	**139852** ▲	**136951** ▲	95	1360	170	23
450	8	**139853** ▲	**136952** ▲	95	1360	170	23
450	11	**139854** ▲	**136955** ▲	95	1360	170	23
500	6	**139867** ▲	**135703** ▲	95	1220	170	23
500	8	**139868** ▲	**135704** ▲	95	1220	170	23
500	11	**139869** ▲	**135705** ▲	95	1220	170	23
630	8	**139897** ▲	**139776** ▲	136	970	240	37
630	11	**139898** ▲	**139777** ▲	136	970	240	37
630	15	**139899** ▲	**139778** ▲	136	970	240	37
710	8	**140804** ▲	**141102** ▲	136	860	240	37
710	11	**140805** ▲	**141103** ▲	136	860	240	37
710	15	-	**141418** ▲	136	860	240	37
800	11	**140810** ▲	**141111** ▲	192	765	300	45
800	15	**140811** ▲	**141112** ▲	192	765	300	45
900	11	-	**600660** ▲	190	680	300	45
900	15	-	**600661** ▲	190	680	300	45
1000	11	-	**141119** ▲	190	610	320	47
1000	15	-	**141120** ▲	190	610	320	47
1000	20	-	**600665** ▲	190	610	320	47
1100	11	-	**150504** ▲	190	555	320	47
1100	15	-	**600662** ▲	190	555	320	47
1100	20	-	**600666** ▲	190	555	320	47
1200	11	-	**150505** ▲	190	510	450	64
1200	15	-	**600663** ▲	190	510	450	64
1200	20	-	**600667** ▲	190	510	450	64

Further sizes and mountings available on request

Jaws USE - USU

A09
Reversible jaw EB, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
022985	260	set	85	64	35
022986	310	set	94	66	35
163108 ▲	400/450	set	112	80	40
163109 ▲	500	set	136	88	40
175358 ▲	630/710	set	172	108	45
247823 ▲	800	set	185	130	60

A09
Base jaw GB with fixing screw



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
304656 ▲	260	set	91	40,1	35
304657 ▲	310	set	107	40,1	35
304658 ▲	400/450	set	126	47,1	40
304659 ▲	500	set	164,4	47,1	40
304660 ▲	630	set	165	51,1	45
304661 ▲	710	set	202	51,1	45
304662 ▲	800/900/1000/1100	set	240	61,1	60
150543 ▲	1200	set	350	92,2	70

A09
Reversible top jaws UB DIN 6350, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
108057	260	set	95,3	52,5	36
108058	310	set	109,5	57,5	42
108059	400/450	set	127	64,5	42
108060	500/630/710	set	127	79,5	50
105085	800/900	set	210	89	68
105101	1000/1100/1200	set	210	110	68

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped top jaw AB DIN 6350, soft, material 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
107579	260	set	103	53	36,5
107580	310	set	120	58	42,5
107581	400/450	set	137	65	42,5
107582	500/630/710	set	140	80	50,5
105105	800/900	set	210	89	68
105109	1000/1100/1200	set	210	110	68

Configure your individual clamping jaws online! www.web2product.biz

Accessories USE - USU

A26
Adjusting spindle



Item no.	Size	Square	Hexagon
169142 ▲	260	10	-
166565 ▲	310	10	-
162110 ▲	400	13	-
162121 ▲	450	13	-
161629 ▲	500	13	-
161611 ▲	630	16	-
247826 ▲	800	18	-
150544 ▲	900	18	-
150545 ▲	1000	18	-
150546 ▲	1100	18	-
149776 ▲	1200	-	24

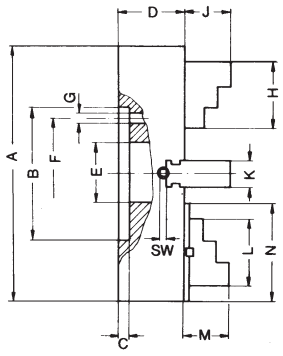
A26
Safety key



Item no.	Size	Square	Hexagon
160096 ▲	260/310	10	-
160097 ▲	400	13	-
160098 ▲	450/500	13	-
160099 ▲	630/710	16	-
160100 ▲	800/900/1000/1100	18	-
150548 ▲	1200	-	24

Chuck dimensions USE - USU

Cylindrical centre mount



Size A		260	310	400	450	500	630	710	800
B^{H8}		130	130	210	210	210	260	260	370
C		8	8	18	18	18	18	18	18
D	USE - USU	85	95	112,5	112,5	112,5	122,5	132,5	145
E	USE - USU	70	75	95	95	95	135	135	180
F		105	105	175	175	175	220	220	330
G		4x13,5	4x13,5	4x17	4x17	4x17	4x20,5	4x20,5	8x22
H		85	94	112	112	136	172	172	185
J		34	35	41,5	42	50	55,5	55,5	80
K		35	35	40	40	40	45	45	60
L		80	87	105	114	126	140	165	210
M		56,5	60,5	54	54	69	69	69	91
N		100	105	125	135	145	165	185	240
SW		10	10	13	13	13	16	16	18
approx. kg		23	32	52	76	91	150	190	270

1) Outer hexagon

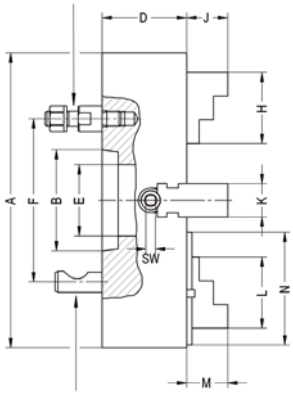
Short taper mount

DIN 55021 with setscrews and locknuts



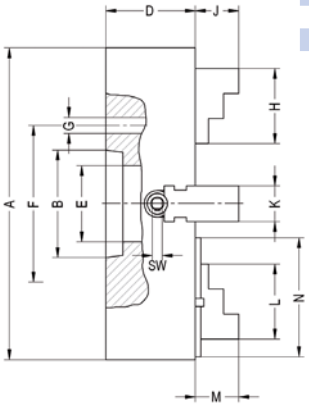
Size A			260			310			400			450			500			630		
Taper size			4[1]	5[2]	6	5	6	8	6	8	11	6	8	11	6	8	11	8	11	15
B			63,5	82,5	106,4	82,5	106,4	139,7	106,4	139,7	196,9	106,4	139,7	196,9	106,4	139,7	196,9	139,7	196,9	285,8
D			75			82			112,5			112,5			112,5			122,5		
E			61	70	70	75			95			95			95			135		
F	DIN	85	104,8		133,4	104,8	133,4	171,4	133,4	171,4	235	133,4	171,4	235	133,4	171,4	235	171,4	235	330,2
	Camlock	82,6																		
G			11	11	14	11	14	18	14	18	22	14	18	22	14	18	22	18	22	26
H			85			94			112			112			136			172		
J			34			35			42			42			50			55,5		
K	USE		35			35			40			40			40			45		
	USU		36			42			42			42			50			50		
L			95,3			109,5			127			127			127			127		
M			56,5			60,5			54			54			69			69		
N			91			107			126			126			164,4			165		
SW			10			10			13			13			13			16		
approx. kg			23			32			52			76			91			150		

DIN 55027 with studs and nuts



DIN 55029 with studs for camlock

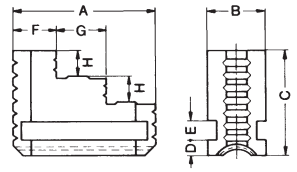
Size A		710			800		
Taper size		8	11	15	8	11	15
B		139,7	196,9	285,8	139,7	196,9	285,8
D		132,5			145		
E		135			180		
F		171,4	235	330,2	171,4	235	330,2
G		18	22	26	18	22	16
H		172			185		
J		55,5			80		
K	USE	45			60		
	USU	68			68		
L		210			210		
M		69			91		
N		202			240		
SW		16			18		
approx. kg		190			270		



DIN 55026 mounting from front
1) Not for DIN 55021 or A1/A2 inch
2) Not for A1/A2 inch

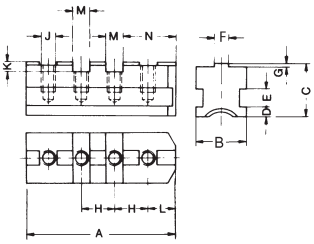
Jaw dimensions USE - USU

Reversible one-piece jaw EB



Size	260	310	400	450	500	630	710	800
A	85	94	112		136	172		185
B	35	35	40		40	45		60
C	64	66	80		88	108		130
D	10	10	10		10	12		14
E	12	12	14		14	14		18
F	27	30	36		42	52		55
G	29	32	38		46	60		65
H	14	15	19		23	26		30
approx. kg	0,8	0,9	1,6		2,25	3,5		4,2

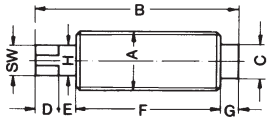
Base jaw GB



Size	260	310	400	450	630	710	800
A	91	107	126		165	202	240
B	35	35	40		45	45	60
C	40,1	40,1	47,1		51,1	51,1	61,1
D	10	10	10		12	12	14
E	12	12	14		14	14	18
F	12,7	12,7	12,7		12,7	12,7	12,7
G	3,1	3,1	3,1		3,1	3,1	3,1
H	54	63,5	76,2		38,1	38,1	38,1
J	M12	M12	M16		M20	M20	M20
K	7,6	7,6	10,8		10,8	10,8	10,8
L	21,2	24,4	27,5		27,5	27,5	27,5
M	19,03	19,03	19,03		19,03	19,03	19,03
N	38,7	46,6	56,1		56,1	56,1	56,1
Grooves	1	1	1		2	3	4
Tapped holes	2	2	2		4	5	6
approx. kg	0,8	0,9	1,1		1,4	2,2	2,8

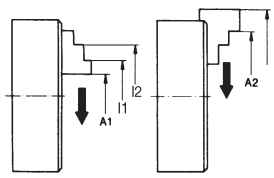
Reversible top jaw UB and unstepped top jaw

Adjusting spindle



Size	260	310	400	450	500	630	710	800
A	26	26	30	30		34	34	40
B	83,5	99	129	167		200	200	240
C	14	14	16	16		28	28	33
D	13	15	16	16		20,5	20,5	24
E	13,5	15	18,5	18,5		21,5	21,5	24
F	45	55	78	116		143	143	172
G	12	14	16,5	16,5		13,5	13,5	20
H	14	14	16	16		20	20	22
SW	10	10	13	13		16	16	18

1) with outer hexagon



Chucking capacities of jaw steps (standard values)

Size mm	260	310	400	450	500	630	710	800
A1 min.	20	20	35	40	40	60	130	190
A2 max.	260	295	400	450	500	585	690	800
l1 min.	75	80	90	100	145	145	145	170
l2 max.	260	310	400	450	520	650	730	820
max. swing. dia.	305	355	465	510	570	675	785	870

UGE - UGU



APPLICATION

Clamping chucks for lathes on which large, heavy or irregularly shaped workpieces are clamped for machining in the vertical or horizontal position.

TYPE

Independent four-jaw chuck in cast iron design. Jaws individually adjustable via threaded spindle (no central drive). Starting from size 400 with T-slots and set-up slots.

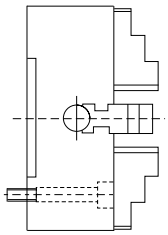
CUSTOMER BENEFITS

- Concentric rings for visual rough centering, fine centering using dial gauge

TECHNICAL FEATURES

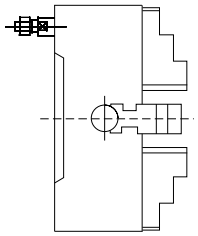
- Cast iron design incl. clamping wrench and fastening screws, as well as 1 set of reversible or base and top jaws

A26
cylindrical centre mount



Size	With one-piece reversible jaws	With base jaws and top jaws	Through-hole mm	Speed max. min^{-1}
160	**1189704** ▲	-	45	2000
200	**1189705** ▲	**1189780** ▲	56	1800
250	**1189706** ▲	**1189781** ▲	65	1500
315	**1189707** ▲	**1189782** ▲	80	1200
400	**1189708** ▲	**1189783** ▲	100	800
500	**1189709** ▲	**1189784** ▲	125	500

A26
ISO 702-3 (DIN 55027), DIN 55022; with studs and locknuts, optional DIN 55021 with set screw and nut

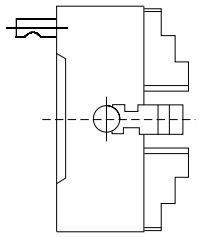


Size	Mount short taper	With one-piece reversible jaws	With reversible top jaws	Through-hole mm	Speed max. min^{-1}
200	5	**1189714** ▲	**1189789** ▲	56	1800
200	6	**1189715** ▲	**1189790** ▲	56	1800
250	5	**1189716** ▲	**1189791** ▲	65	1500
250	6	**1189717** ▲	**1189792** ▲	65	1500
250	8	**1189718** ▲	**1189793** ▲	65	1500
315	5	**1189719** ▲	**1189794** ▲	80	1200
315	6	**1189720** ▲	**1189795** ▲	80	1200
315	8	**1189721** ▲	**1189796** ▲	80	1200
400	6	**1189722** ▲	**1189797** ▲	100	800
400	8	**1189723** ▲	**1189798** ▲	100	800
400	11	**1189724** ▲	**1189799** ▲	100	800
500	6	**1189725** ▲	**1189800** ▲	100	500
500	8	**1189726** ▲	**1189801** ▲	125	500
500	11	**1189727** ▲	**1189802** ▲	125	500

▲ on request

UGE - UGU

A26
ISO 702-2 (DIN 55029); ASA B 5.9, Type D, with studs for Camlock



Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min^{-1}
200	4	**1189733** ▲	**1189812** ▲	56	1800
200	5	**1189734** ▲	**1189813** ▲	56	1800
200	6	**1189735** ▲	**1189943** ▲	56	1800
250	4	**1189736** ▲	**1189814** ▲	60	1500
250	5	**1189737** ▲	**1189815** ▲	65	1500
250	6	**1189738** ▲	**1189816** ▲	65	1500
250	8	**1189739** ▲	**1189817** ▲	65	1500
315	5	**1189740** ▲	**1189818** ▲	80	1200
315	6	**1189741** ▲	**1189819** ▲	80	1200
315	8	**1189742** ▲	**1189820** ▲	80	1200
400	6	**1189743** ▲	**1189821** ▲	100	800
400	8	**1189744** ▲	**1189822** ▲	100	800
400	11	**1189745** ▲	**1189823** ▲	100	800
500	8	**1189746** ▲	**1189824** ▲	125	500
500	11	**1189747** ▲	**1189825** ▲	125	500

Jaws UGE - UGU

A09
Reversible jaw EB, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189865 ▲	160	set	61,5	51	20
1189866 ▲	200	set	85	61,5	27
1189867 ▲	250	set	92	61,5	27
1189868 ▲	315	set	111	76,5	40
1189871 ▲	400	set	129	76,5	40
1189872 ▲	500	set	152,5	93,5	52

A09
Base jaw GB with mounting bolts



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189895 ▲	200	set	79	32	27
1189896 ▲	250	set	94	38	27
1189897 ▲	315	set	110	39	40
1189898 ▲	400	set	129	44	40
1189899 ▲	500	set	168	59	52

A09
Unstepped top jaw AB, soft



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189877 ▲	200	set	90	43,5	40
1189878 ▲	250	set	106	51,5	47
1189879 ▲	315	set	120	55	52
1189880 ▲	400	set	140	64,5	52
1189881 ▲	500	set	145	82	60

A09
Reversible top jaws UB, hardened

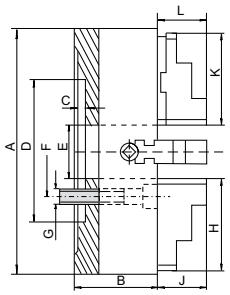


Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189886 ▲	200	set	82	43,5	34
1189887 ▲	250	set	96,5	51,5	34
1189888 ▲	315	set	112,5	55	42
1189889 ▲	400	set	129	64,5	42
1189890 ▲	500	set	136	74,5	54

▲ on request

Chuck dimensions UGE - UGU

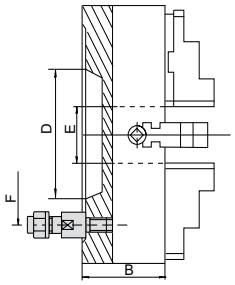
Cylindrical centre mount



Size	160	200	250	315	400	500
A	160	200	250	315	400	500
B	65	75	85	95	105	120
C	5	6	7	7	10	12
D^{H7}	65	75	150	175	200	270
E	45	56	65	80	100	125
F	95	95	104,8	133,4	171,4	235
G	4xM10	4xM10	4xM12	4xM16	4xM16	4xM20
H	61,5	85	96,5	111	129	152,5
J	31,5	35	40,3	49,8	49,8	59,8
L	-	46,4	60,4	60,9	72,3	90,3
K	-	82	96,5	112,5	129	136
approx. kg	7,5	10	25	39	61	105

Short taper mount

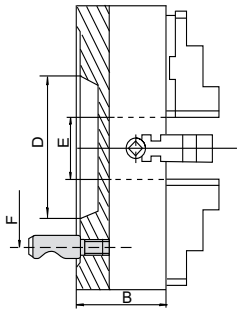
DIN 55027 with studs and locknuts



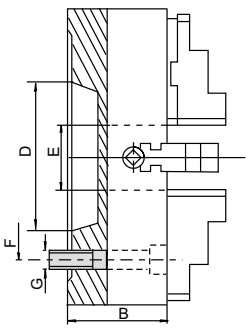
Size		200			250				315		
Taper size		4	5	6	4	5	6	8	5	6	8
B		75	75	75	85	85	85	85	95	95	95
D		63,5	82,5	106,3	63,5	82,5	106,3	139,7	82,5	106,3	139,7
E		56	56	56	60	65	65	65	80	80	80
F		85[1] / 82,6	104,8	133,4	82,6	104,8	133,4	171,4	104,8	133,4	171,4
Mounting holes	DIN	3	4	4	-	4	4	4	4	4	4
	Camlock	3	6	6	3	6	6	6	6	6	6
approx. kg		10	10	10	27,5	27,5	27,5	27,5	39,5	39,5	39,5

Size		400			500		
Taper size		6	8	11	6	8	11
B		105	105	105	120	120	120
D		106,3	139,7	196,8	106,3	139,7	196,8
E		100	100	100	100	125	125
F		133,4	171,4	235	133,4	171,4	235
Mounting holes	DIN	4	4	6	4	4	6
	Camlock	6	6	6	6	6	6
approx. kg		60	60	60	95,5	95,5	95,5

DIN 55029 with studs for camlock



DIN 55026 mounting from front

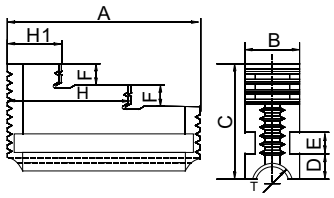


Size	200		250			315			400		
Taper size	5	6	5	6	8	5	6	8	6	8	11
B	75	75	85	85	85	95	95	95	105	105	105
D	82,5	106,3	82,5	106,3	139,7	82,5	106,3	139,7	106,3	139,7	196,8
E	50	50	65	65	65	80	80	80	100	100	100
F	104,8	133,4	104,8	133,4	171,4	104,8	133,4	171,4	133,4	171,4	235
G	4xM10	4xM12	8xM10	4xM12	4xM16	4xM10	8xM12	4xM16	8xM12	4xM16	4xM20
approx. kg	17	17	25,5	25,5	25,5	40	40	40	65	65	65

Size	500		
Taper size	6	8	11
B	120	120	120
D	106,3	139,7	196,8
E	100	125	125
F	133,4	171,4	235
G	4xM12	8xM16	8xM20
approx. kg	114	114	114

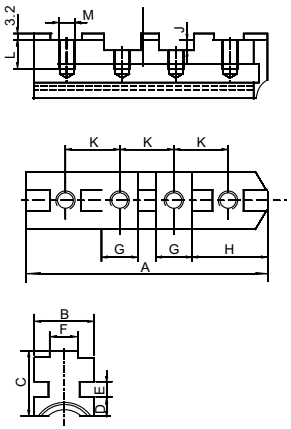
Jaw dimensions UGE - UGU

Reversible one-piece jaw EB



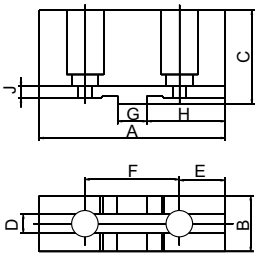
Size	160	200	250	315	400	500
A	61,5	85	92	111	129	152,5
B	20	27	27	40	40	52
C	51	61,5	61,	76,5	76,5	93,5
D	9	11,5	11,5	9,7	9,7	11,7
E	10	10	10	12	12	15
F	10	12	12	18	18	22
H1	20	30,5	30,5	27	32,5	35
H	41	58	65,5	67	78,5	93
Thread T	22x4	24x4	24x4	Tr32x6	Tr32x6	Tr36x6

Base jaw GB



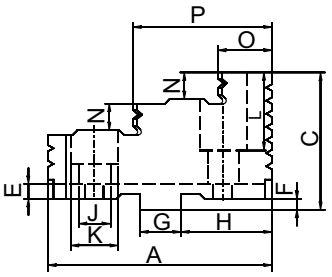
Size	200	250	315	400	500
A	79	94	110	129	168
B	27	27	40	40	52
C	32	38	39	44	59
D	11,5	11,5	9,7	9,7	11,7
E	10	10	12	12	15
$F_{-0,03}$	7,94	12,7	12,7	12,7	12,7
$G^{+0,01}$	12,69	19,04	19,04	19,04	19,04
H	33,2	37,5	45,4	54,9	55,5
J	4	4	4	7,2	7,2
K	22,25	27	31,75	38,1	38,1
L	14	20	17,5	22	33,5
M	3/8-16	1/2-13	1/2-13	5/8-11	3/4-10
Thread T	24x4	24x4	Tr32x6	Tr32x6	Tr36x6

Unstepped soft top jaw AB

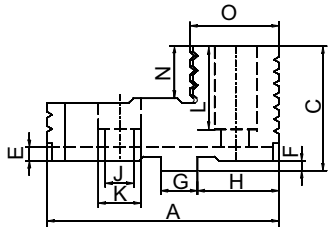


Size	200	250	315	400	500
A	90	106	120	140	145
B	40	47	52	52	60
C	43,5	51,5	55	64,5	82
D	7,95	12,71	12,71	12,71	12,71
E	24	27,5	30,7	34,4	34,4
F	44,5	54	63,5	76,2	76,2
G	12,69	19,04	19,04	19,04	19,04
H	40	45	53	63	63
J	4	4	4	4	4

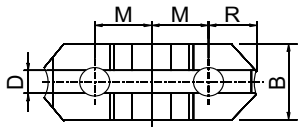
Reversible top jaw UB



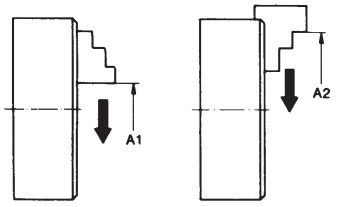
Ø 200-800mm



Ø 1000-12500 mm



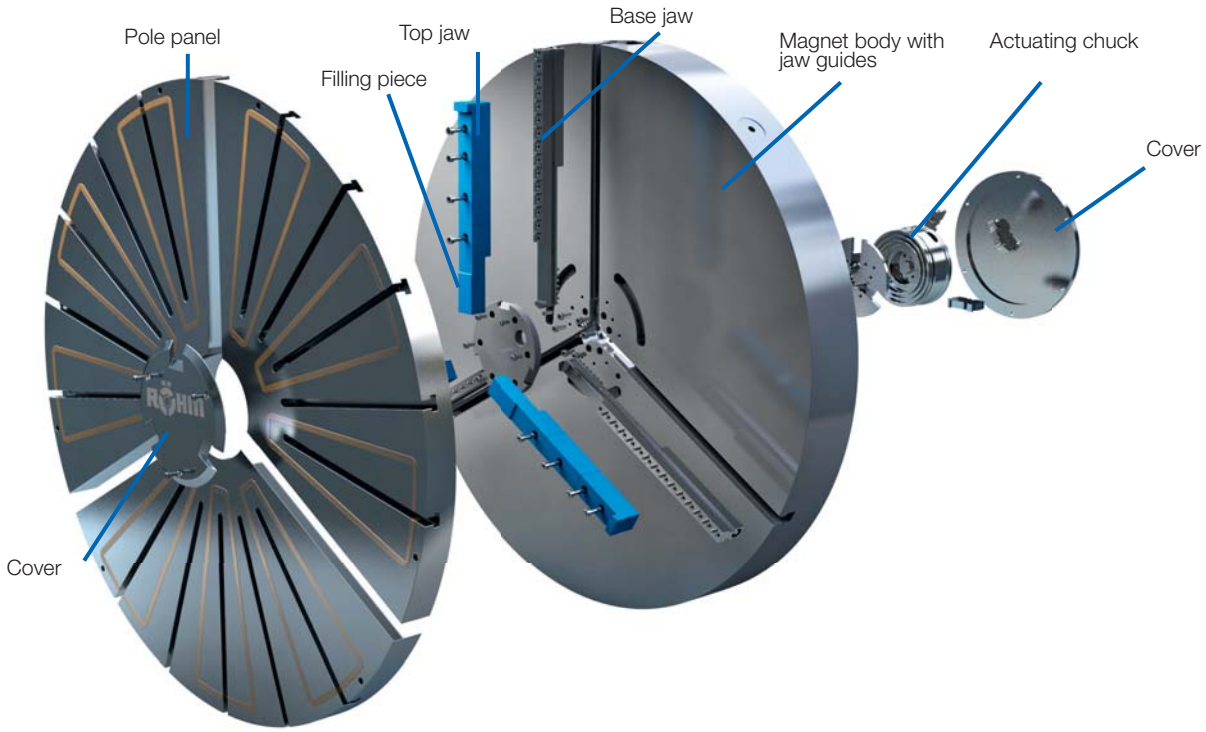
Size	200	250	315	400	500
A	82	96,5	112,5	129	136
B	34	34	42	42	54
C	43,5	51,5	55	64,5	74,5
D	7,95	12,71	12,71	12,71	12,71
E	4	4	4	4	4
$F_{-0,03}$	3,2	3,2	3,2	6,3	6,3
$G^{+0,01}$	12,69	19,04	19,04	19,04	19,04
H	35,2	40	47,9	57,4	58
J	11	14	14	18	22
K	18	20	20	26	33
L	21,5	26,5	27,5	32	39,5
M	3/8-16	1/2-13	1/2-13	5/8-11	3/4-10
N	9,5	12	13	13,5	18
O	22	25	27	26,5	37,5
P	53	62	70,5	79	87
R	19,3	22,5	25,7	28,8	29,4



Chucking capacities of jaw steps (standard values)

Size mm	160	200	250	315	400	500
A1 min.	8	10	10	15	20	45
A2 max.	160	200	250	315	400	500
max. swing. dia.	185	235	296	369	465	570

MZMF Hybrid chuck



Combined 2-jaw centering chuck with magnetic clamping plate

A precisely centered and deformation-free setup is of utmost importance, especially for easily deformable workpieces which require turning machining from all three sides within one working operation. Thanks to the combination of magnetic clamping force and deformation-free centering, workpieces, such as rings or other hard-to-grip parts having a wide range of sizes and contours, can be precisely clamped within seconds with the hybrid chuck MZMF.

Technische Merkmale:

- Set-up times reduced by up to 50%
- Machine downtimes reduced to a minimum
- 3-side machining for turning and grinding parts
- 16 individually adjustable adhesion stages
- Uniform and deformation-free setup
- Combined magnetic and centering chuck clamping are possible
- High process reliability for rational series production
- Fast amortization



Other special solutions

For special customer demands, RÖHM offers an individual range of special solutions, which goes far beyond the standard product range. From the smallest „micro technology“ clamping chuck for watches and jewelry machining to impressive chucks with a diameter of over 5.5 meters and weight of 25 tons for rail vehicles or the energy sector.



Machining of large bearings and rotary unions
Chuck for turning machining

- Constant clamping force at high speeds by means of centrifugal force compensation
- Integrated quick-acting jaw change system for mini mum setup times



Machining of large bearings and rotary unions
Chuck for drilling machining

- Centrically clamping wedge hook chuck
- Quickly adjustable clamping jaws and stops for minimum set-up times



Clamping chucks for rail traffic

- Clamping diameters of up to 1.3 meters with flexible set-up for individually changing workpiece sizes
- Automated jaw adjustment for inner and outer machining



Independent chucks for power plants and steel mills

- Clamping diameter of up to 5 meters
- Safe clamping using power spindles allows up to 50 tons of clamping force per jaw

For further informations of our special solutions in any areas visit our homepage:
http://www.roehm.biz/downloads/

F-senso chuck clamping force measuring device



With F-senso chuck, check both the clamping force as well as the speed behavior of the clamping device
Maximum flexibility through large clamping range from 75-175 mm by means of exchangeable pressure bolts and large measuring range from 0-100 kN per jaw. Suitable for 3-jaw chuck as well as vices. Dynamic clamping force measurement under rotation up to 8250 rpm. For clamping chucks, both the clamping force as well as the speed are measured. The centrifugal force behavior is transferred to the Tablet (included in delivery) in real time via Blue-Tooth and is evaluated with the already-installed software.

Video F-senso chuck

ADVANTAGES AT A GLANCE

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

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



C 15
Clamping force measurement device F-senso chuck

Item no.	179800
Measuring range / Clamping force kN	2 jaws: 0 - 200; 3 jaws: 0 - 300
Measuring range / Rotation speed min-1	0 - 8250
Accuracy	Force <0.5% / Rotation speed ±10 rpm within the complete measuring range
Clamping Ø mm	75 - 175
Dimensions (base unit)	Ø 75/80 x 130

Power-Grip zero-point clamping system





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

ADVANTAGES AT A GLANCE

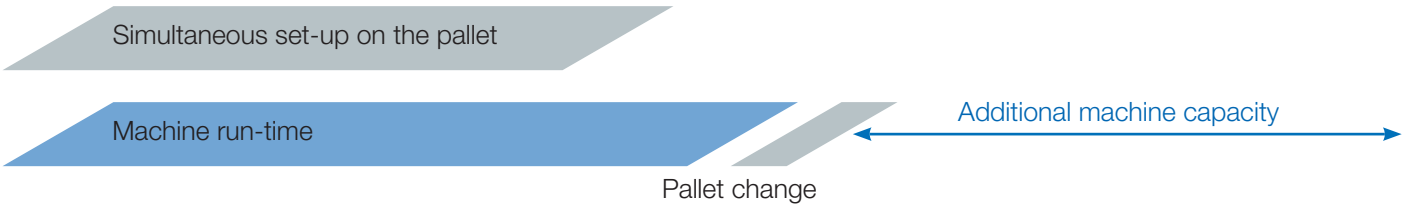
- Increase in productivity thanks to set-up time reduction up to 90 %
- Maximum precision and repeatability of 0.002 mm
- Palletizing and clamping device from one source

SET-UP TIME REDUCTION BY UP TO 90 %

Without palletizing system



With Power-Grip zero-point clamping system



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driven by technology

Id.-Nr. 1178263 / 0915 AU



VICES

2015/2016

RÖHM

driven by technology

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

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

Dynamism
Variety
Security
Partnership
Globality
Innovation


RKE 125



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VICES

NC-Compact vices

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RKK	4030

NC-Compact twin vices

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RKD-M	4046

NC-Compact self centering vices

RZM	4056
RKZ	4060
RKZ-M	4066

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RB-M - Orange Line	4082
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BOF	4112
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Grinding and inspection vice

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PLF	4119
PL-G	4119
PS-SV	4120
PS-ZD	4120

Errors and corrections are reserved!

Operation guide







TYPE	RKE				RKE-LV		RKK					
	NC-Compact vices											
Features	- Highest clamping precision - Clamping force presetting - Precise, wear-resistant body				- Very good accessibility for 5-axis machining - Clamping force presetting - Large clamping range		- Designed to resist deformation for the highest clamping precision - Greatest repeatability - Clamping force presetting					
Clamping system	mechanical-mechanical size 92: mechanical-hydraulic				mechanical-mechanical		mechanical-mechanical size 92: mechanical-hydraulic					
Force amplification	✔				✔		✔					
Set-up options	3-Side Duo-Tower Quattro-Tower				Base		3-Side Duo-Tower Quattro-Tower					
Machining centers with high working accuracy	✔✔				✔✔		✔✔					
Universal milling machines with high working accuracy	✔✔				✔✔		✔✔					
Universal milling machines standard version	✔				✔		✔					
Jig boring machines	✔✔				✔✔		✔✔					
5-axis machining	✔				✔✔		✔					
Grinding machines	✔				✔		✔					
Series production	✔				✔		✔					
For limited space	✔				✔✔		✔					
Jaw width mm	**92** [1]	**125** [1]	**160** [1]	**200** [1]	**125** [1]	**125** [3]	**92** [1]	**113** [2]	**113** [2]	**135** [2]	**160** [2]	**200** [2]
Clamping range (max.)	208	312	451	451	192	225	138	170	170	215	340	340
Length (opened) mm	346	479	634	634	372	372	330	424	424	483	618	618
Width mm	94	126	162	200	126	126	94	125	125	150	205	205
Height mm	112	140	165	175	140	130	112	133	133	148	179	189
Clamping force (max.) kN	25	40	60	60	40	40	25	30	40	40	60	60
Weight kg	15	41	79	85	29	29	15	35	35	50	107	108
Page	4012				4024		4030					

✔ yes

✔ suitable

✔✔ very suitable

[1] with stepped jaws
[2] with standard jaws
[3] with carrier jaws
[4] with claw-type jaws
[5] with heightend stepped jaws

Operation guide






TYPE	RKD		RKD-M		RZM		RKZ	RKZ-M				
	NC-Compact twin vices				NC-Compact self centering vices							
Features	- Double clamping - Greatest repeatability - Low rapid traverse		- Double, centric and compact wrench (removable middle jaw) - Greatest repeatability - Low rapid traverse		- Very large clamping stroke due to patented guide system - Open design for optimal chip flow - Overhead spindle for optimal power transmission		- Highest average precision and repeatability - Minimum collision contour	- Highest average precision and repeatability - Minimum collision contour				
Clamping system	mechanical-mechanical		mechanical		mechanical		mechanical-mechanical	mechanical				
Force amplification	✔		*		*		✔	*				
Set-up options	3-Side Duo-Tower Quattro-Tower		3-Side Duo-Tower Quattro-Tower		Base		3-Side Duo-Tower Quattro-Tower	Base				
Machining centers with high working accuracy	✔✔		✔✔		✔		✔✔	✔				
Universal milling machines with high working accuracy	✔✔		✔✔		✔		✔✔	✔				
Universal milling machines standard version	✔		✔✔		✔		✔	✔				
Jig boring machines	✔✔		✔✔		✔		✔✔	✔				
5-axis machining					✔✔		✔	✔				
Grinding machines	✔		✔		✔		✔	✔				
Series production	✔		✔		✔		✔	✔				
For limited space	✔		✔		✔✔		✔	✔				
Jaw width mm	**92** [1]	**125** [1]	**92** [1]	**125** [1]	**125** [4]	**125** [4]	**125** [1]	**50** [1]	**70** [1]	**92** [1]	**125** [1]	**125** [5]
Clamping range (max.)	127	180	127	180	142	222	298	111	153	208	269	269
Length (opened) mm	500	667	480	617	298	218	565	157	209	283	353	353
Width mm	94	126	94	126	125	125	126	52	72	94	126	126
Height mm	117	145	117	145	196,5	196,5	170	75	95	117	145	165
Clamping force (max.) kN	25	40	25	40	25	25	40	10	15	20	25	25
Weight kg	24	53	24	52	17,4	20,3	50,5	3,5	7	18	32,5	35
Page	4040		4046		4056		4060	4066				

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

Operation guide









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

✔ yes ✔ suitable ✔✔ very suitable

Operation guide







TYPE	MSR				RS					UZ				
	Machine vices													
Features	- Fast clamping range adjustment using the pin system				- Made of special steel casting for flexible application - Entire clamping range can be reached by turning the crank					- Centric clamping - Spindle covered in the working area				
Clamping system	mechanical				mechanical					mechanical				
Force amplification	*				*					*				
Set-up options	Base				Base					Base				
Machining centers with high working accuracy	✔				✔					✔				
Universal milling machines with high working accuracy	✔				✔					✔				
Universal milling machines standard version	✔				✔					✔				
Jig boring machines														
5-axis machining														
Grinding machines	✔				✔					✔				
Series production	✔				✔					✔				
For limited space	✔				✔					✔				
Jaw width mm	**125**	**150**	**150**	**175**	**92**	**113**	**135**	**160**	**200**	**113**	**135**	**160**	**200**	**250**
Clamping range (max.)	150	200	300	400	85	105	125	145	185	110	140	180	300	400
Length (opened) mm	401	487	587	701	362	423	510	575	675	358	408	495	655	767
Width mm	95	125	125	145	160	160	200	240	280	132	152	180	200	220
Height mm	80	100	100	118	79,6	89,6	103,6	119,6	144,6	92,6	105,1	123,6	141,6	147,6
Clamping force (max.) kN	30	50	50	60	18	25	35	45	55	15	22	24	25	28
Weight kg	12,7	25,6	29,5	51,2	12	13,5	25	40	65	12,4	19	31	52	71
Page	4100				4102					4106				

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

Operation guide



TYPE	BSS		BOF				BSH							DPV				DPV 3-W
	Drilling machine vices																	
Features	- Compact and stable construction - Entire clamping range can be reached by turning the crank		- Compact and stable construction - Entire clamping range can be reached by turning the crank - Long guidance of the movable jaws also in the outer clamping range				- Do-it-yourself version			- Robust and stable version				- Covering of the threaded spindle by cover sleeve - Constructional length remains the same - Entire clamping range can be reached by turning the crank				
Clamping system	mechanical manually operated		mechanical manually operated				mechanical manually operated							mechanical manually operated				
Force amplification																		
Set-up options	Base		Base				Base							Base				3-Side
Machining centers with high working accuracy																		
Universal milling machines with high working accuracy																		
Universal milling machines standard version																		
Jig boring machines																		
5-axis machining																		
Grinding machines																		
Series production	✔		✔				✔							✔				
For limited space																		
Jaw width mm	**110**	**135**	**90**	**110**	**135**	**160**	**65**	**80**	**100**	**80**	**100**	**120**	**140**	**80**	**100**	**120**	**150**	**100**
Clamping range (max.) mm	100	160	90	130	160	220	65	85	80	80	95	110	150	70	92	110	125	93
Length (opened) mm	510	587	195	315	365	445	125	150	170	200	215	260	300	154	175	225	238	189
Width mm	175	205	145	175	205	245	105	130	175	140	175	215	220	142	152	180	198	159
Height mm	72,5	80,5	60	72,5	80,5	95,5	43	46	47	70	75	85	85	58	63,5	63,5	65	65
Clamping force (max.) kN	10	10	8	10	12	15												
Weight kg	9,5	13,5	5,5	9,5	13,5	25	1,2	1,7	4,2	5	7	11	12,5	3,6	4,3	6,3	8,1	5,1
Page	4112		4112				4113							4114				4114

✔ yes ✔ suitable ✔✔ very suitable

Operation guide








TYPE	PL-S micro	PL-S	PLF	PL-G	PS-SV	PS-ZD
	Grinding and inspection vice					
Features	- Draw-down effect - Simple clamping and releasing with allen key - Clamping jaw adjustable in steps; engages automatically - No spindle		- Draw-down effect - Made of alloyed tool steel, hardened and finely ground - Horizontal and vertical ground prism - No spindle which could, become dirty during erosion	- Clamping and releasing with threaded spindle - Made of alloyed tool steel, hardened and finely ground	- Made of alloyed tool steel, hardened and finely ground - Bearing and location pins hardened and ground with a precision of 0.001 mm - The clamping device can be positively locked in any angular position	- Positive locking in any desired angular position by locking screws - Made of alloyed tool steel, hardened and finely ground - Can be rotated 360°
Clamping system	mechanical, manually operated		mechanical, manually operated	mechanical, manually operated	mechanical, manually operated	mechanical, manually operated
Force amplification						
Set-up options	Base		Base	Base	Base	Base
Machining centers with high working accuracy						
Universal milling machines with high working accuracy						
Universal milling machines standard version						
Jig boring machines						
5-axis machining						
Grinding machines	✔✔		✔✔	✔✔	✔✔	✔✔
Series production						
For limited space						

Jaw width mm	**34**	**45**	**70**	**90**	**120**	**50**	**73**	**100**	**60**	**73**	**88**	**70**	**90**	**70**	**120**
Clamping range (max.)	25	50	80	120	150	65	100	125	55	100	125	80	120	80	150
Length (opened) mm	75	110	160	210	280	140	190	245	110	210	250	160	210	180	270
Width mm	34	45	70	90	120	50	73	100	60	73	88	70	90	110	160
Height mm	35	45	62	80	90	50	67	90	50	67	88	93	113	137	210
Clamping force (max.) kN	2	2	2,5	3	4	1,6	2	5	2	4	4	6	7	-	-
Weight kg	0,35	1	3	5,8	13,5	1,4	4,1	7,3	1,6	4	7,6	5,3	11	11,1	43
Page	4118					4119			4119			4120		4120	

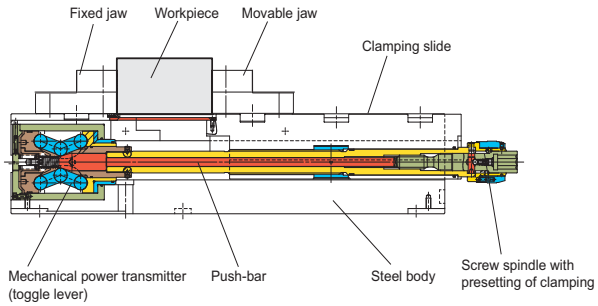
* Constant clamping force for each clamping process and high repeatabilityin combination with a torque wrench

Sectional view toggle lever principle

NC-COMPACT VICES RKE

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

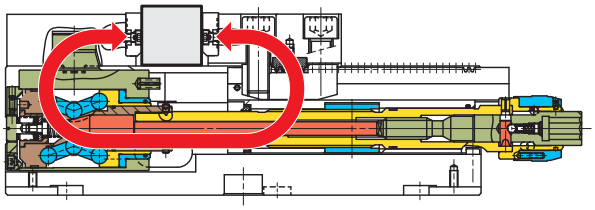
SECTIONAL VIEW RKE



RKK SIZE 2-5

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

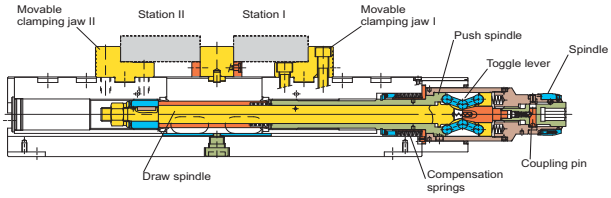
SECTIONAL VIEW RKK SIZE 2 - 5



RKD

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

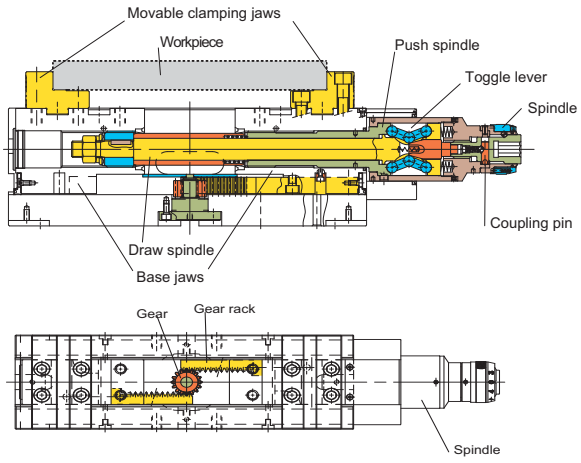
SECTIONAL VIEW RKD



RKZ

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

SECTIONAL VIEW RKZ



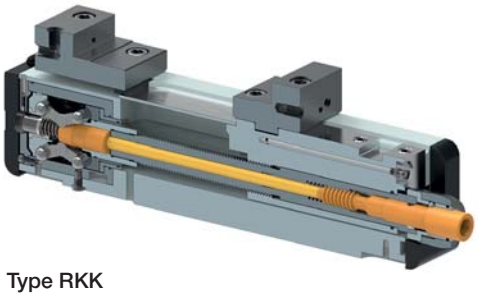
Functional description

CLAMPING SYSTEM MECHANICAL-MECHANICAL WITH TOGGLE LEVER

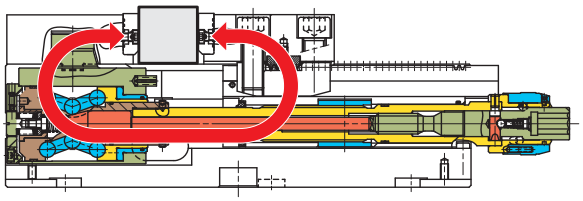
SINGLE CLAMPING

a) Clamping with power transmission
Mechanical pretensioning is achieved by turning the hand-crank. The threaded spindle with the large incline brings the movable clamping jaw into contact with the workpiece, whereby resistance can be noted on the hand-crank. Continuing to turn the crank in clockwise direction triggers automatic disengagement and switch to mechanical transmission. Further turning of the crank moves a pressure pin axially, which generates the high clamping force through spreading of the toggle lever.
b) Presetting of different clamping forces
To avoid damage to sensitive workpieces caused by excessive clamping force, different clamping forces can be preset. The presetting can be performed simply by turning the adjustment collar on the end of the spindle.
c) Mechanical clamping without power transmission
For consecutive clamping of multiple workpieces having uneven contact surfaces, greater pretensioning is required. Turning the adjustment collar to “0” deactivates the mechanical power transmission. The workpieces can then be mechanically pretensioned until the yield in the workpieces is eliminated. The adjustment collar can then be set to the desired clamping force, and the high clamping force introduced.

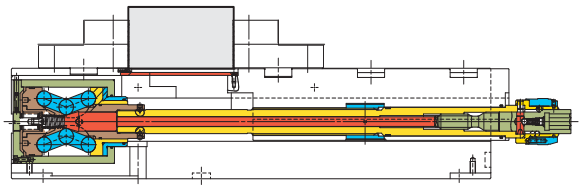
RKK: The power transmission guarantees that the body remains free from deformation; a very high clamping accuracy is achieved.



Type RKK

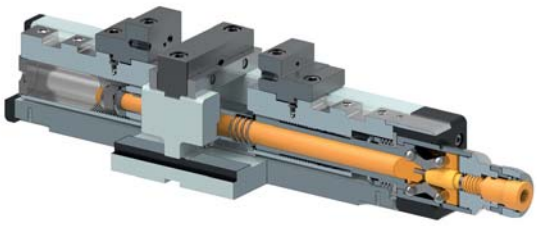


Type RKE

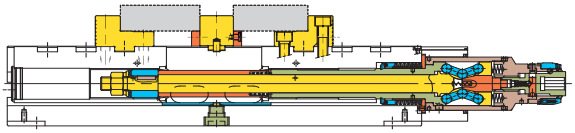


TWIN CLAMPING

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

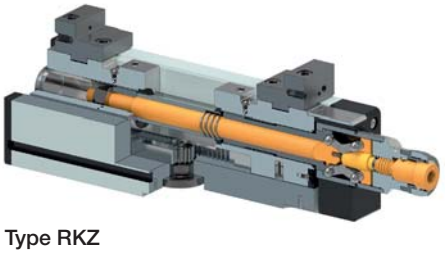


Type RKD

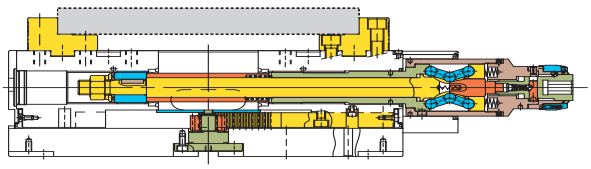


CENTRIC CLAMPING

The two movable clamping jaws are brought to the workpiece by clockwise turning of the spindle with the hand-crank (left-hand/right-hand thread). Turning the hand-crank further in clockwise direction all the way exceeds the release torque of the coupling pin and initiates mechanical power transmission of the toggle lever. The accumulating pressure is distributed evenly over the pushand-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 centrical motion of the movable clamping jaw over the entire clamping stroke, regardless of clamping force and clamping span.



Type RKZ





THE PREMIUM VICE FOR ANY AREA OF APPLICATION



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

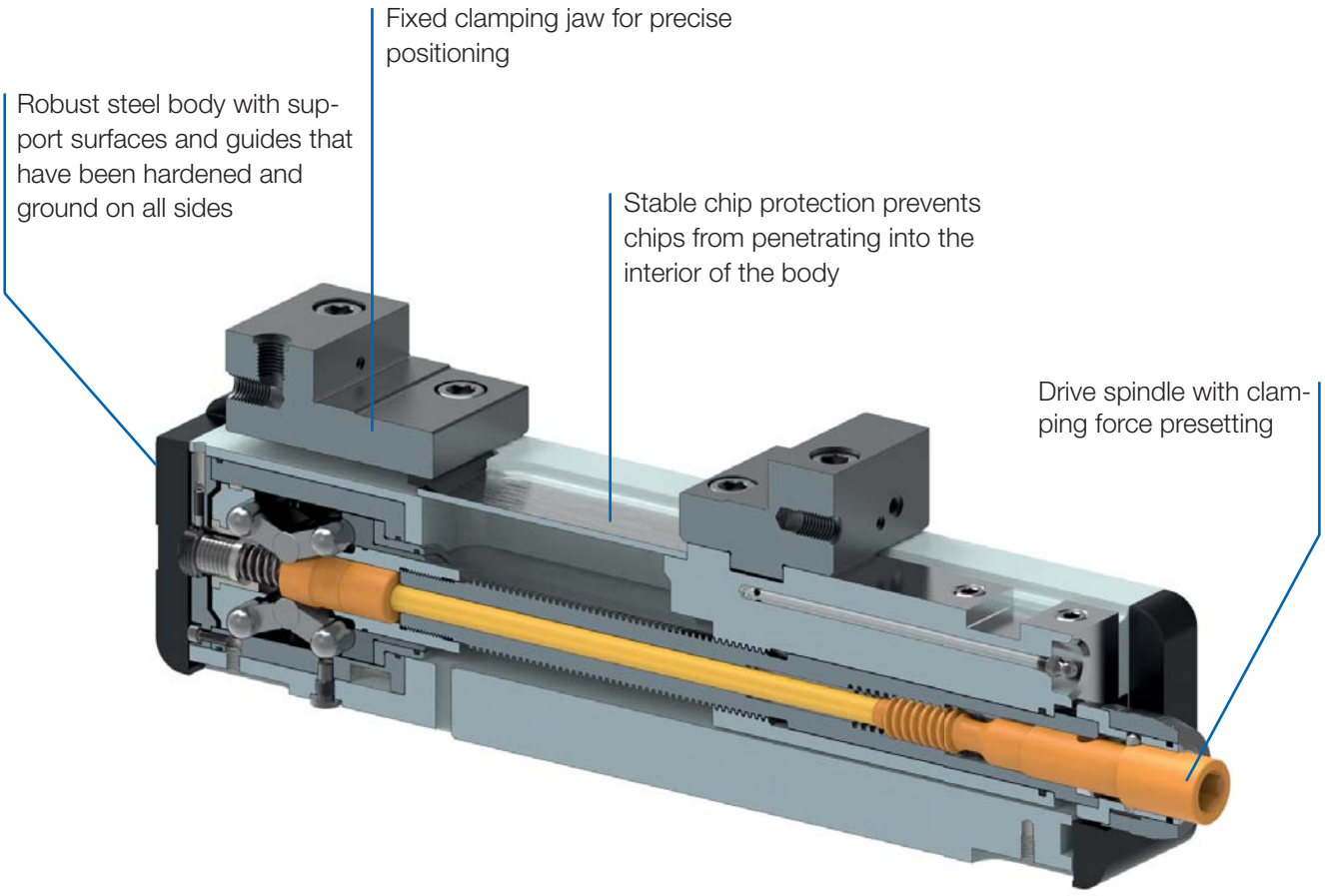
Video RKE

NC-COMPACT VICES

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

ADVANTAGES AT A GLANCE

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



RKE



APPLICATION

Particularly suitable for use on machining centers.

TYPE

Size 92 - clamping system mechanical-hydraulical with power transmitter, manually operated.
Size 125, 160 and 200 - clamping system mechanical-mechanical with power transmitter, manually operated.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

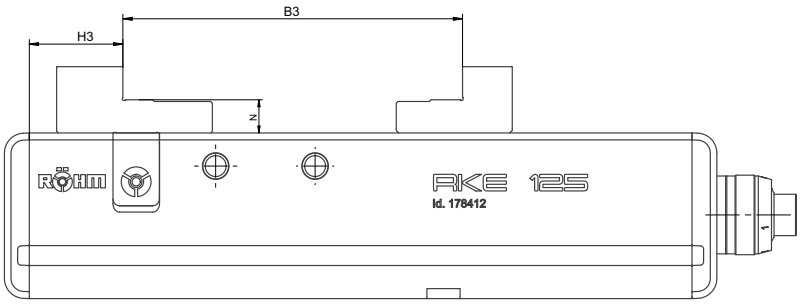
A32
RKE, with stepped jaws

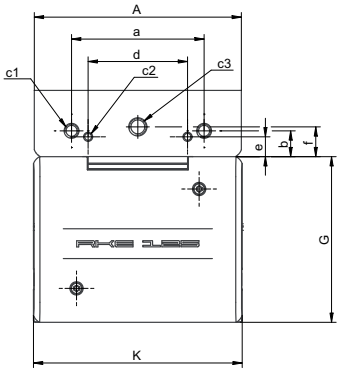
Item no.	178411	178412	178413	178414
Jaw width A mm	92	125	160	200
Jaw design	stepped jaws	stepped jaws	stepped jaws	stepped jaws
B2 mm	0 - 138	0 - 216	0 - 320	0 - 315
B3 mm	71 - 208	97 - 312	131 - 451	131 - 451
C mm	32	40	50	60
D mm	330	463	618	618
F mm	276	400	530	530
G-0,02 mm	80	100	115	115
H2 mm	80	112,5	130	135
H3 mm	41	56,5	64	64
J2 mm	56	70	97	97
K mm	94	126	162	162
L2 mm	64	94	98	103
M mm	25	40	34	39
M* mm	25	30	32,5	32,5
N-0,01 mm	16	20	25	25
U mm	20	20	20	20
V mm	12	12	12	12
W mm	68	1x108	2x102,5	2x102,5
X mm	10	10	10	10
Y mm	15	15	15	15
Z mm	70	109	117	117
a mm	63	80	100	125
b mm	13,6	15,6	19,6	24,6
c1	M 6x14	M 8x14	M 8x14	M 10x15
c2	M 5x9	M 5x10	M 5x9	M 5x10
c3	M 10x16	M 10x18	M 10x18	M 14x20
d mm	48	60	80	110
e mm	8	12	12	12
f mm	14	18	20	25
g mm	70	95	125	125
Ø k	M10x18	M12x22	M16x25	M16x25
l mm	140	240	200	200
m2±0,02 mm	60	127,5	70	65
n±0,02 mm	99	183,5	136	136
y+0,01 mm	40	47,5	57,5	57,5
z mm	72	100	135	135
Clamping force kN	25	40	60	60
Weight kg	15	41	79	85

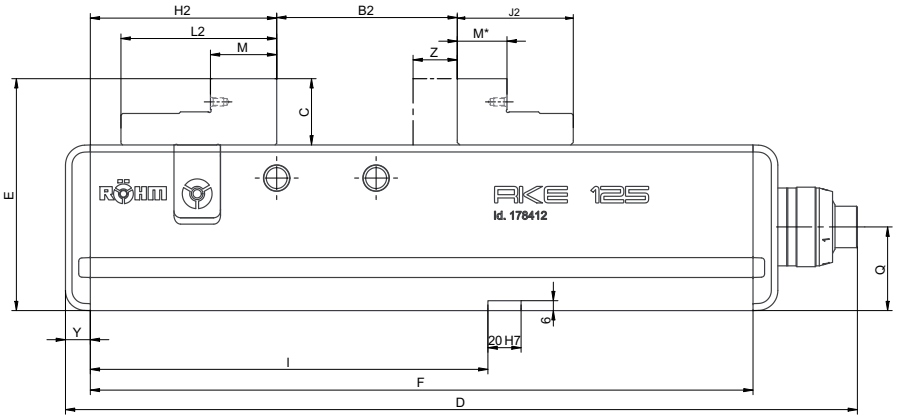
▲ on request

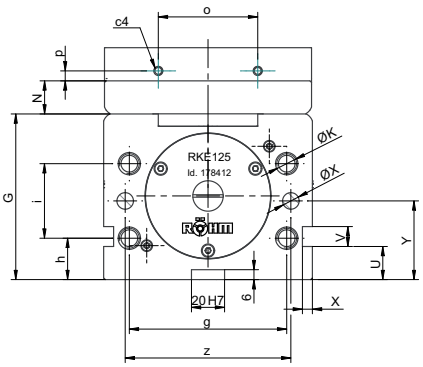
RKE


RKE 125


B3
H3
z
RKE 125
Id. 178412


A
a
d
c1
c2
c3
e
b
f
G
K


H2
B2
J2
L2
M
M*
Z
C
E
RKE 125
Id. 178412
Q
Y
20 H7
6
I
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RKE 125
Id. 178412
ØK
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6
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Accessories RKE

A37
Standard top jaws SA, reversible



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

A37
Stepped jaws SB, reversible



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

A37
Double stepped jaws DSB, “smooth”



Item no.	Contents of delivery	Size	Width mm	Height mm
168698	set	92	50	48
168693	set	125	62	60
175387	set	160	95	75

A37
Carrier jaws TB, without swivelling claw inserts



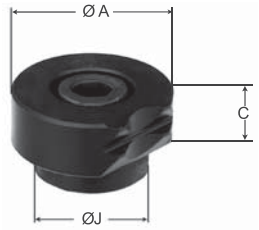
Item no.	Contents of delivery	Size	Width mm	Height mm
165856	set	125	125	20
166218	set	160/200	160	25

A37
Carrier jaws, without claw inserts



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

A37
Swivelling claw inserts, for carrier jaws 743-72

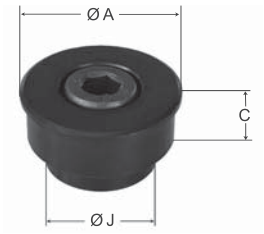


Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	C mm
165854	piece	92/125	28	20	10
166216	piece	160/200	30	22	10

▲ on request

Accessories RKE

A37
Tensioner for carrier jaws 743-72



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

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



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

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



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

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



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

A37
Claw jaws with fine step, 2,5 mm clamping depth



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

Accessories RKE

A37
Claw jaws without step, universal for clamping depth > 2,5 mm



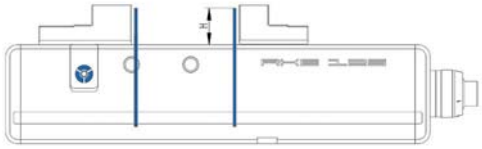
Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661	set	125	92	32	14
166667	set	160	125	40	16
166669	set	200	160	50	18

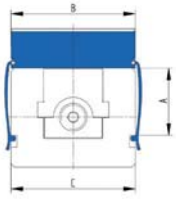
A37
Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box



Item no.	Web height A mm	Jaw width B mm	Rail height H mm	Guiding width C mm	Spare clamp (Set = 4 pieces)
1269621	48	92	10/16/18/20/23/25/26/27/28/29	94	1269624
1269622	68	125	10/15/20/25/28/30/33/35/36/37	126	1269625
1269623	83	160/200	10/15/20/25/30/35/40/43/45/47	162	1269626







A37
V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



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

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



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

A37
Draw-down jaws SNF, with spring plate, hardened and ground



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

A37
V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



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

▲ on request

Accessories RKE

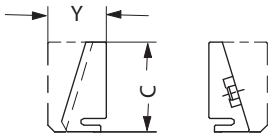
A37
Draw-down jaws RNG, with two permanent magnets



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

A37
Standard insert RNS, held by two permanent magnets

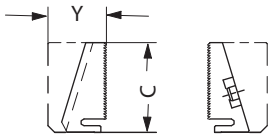




Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242	set	92	92	32	21
159232	set	125	125	40	26
155245	set	160	160	50	30
163783	set	200	200	60	34

A37
Standard insert finely checkered RNSf, held by two permanent magnets

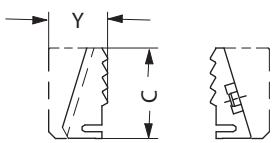




Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163270	set	92	92	32	21
163267	set	125	125	40	26
163273	set	160	160	50	30
163784	set	200	200	60	34

A37
Claw insert RNK, held by two permanent magnets





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

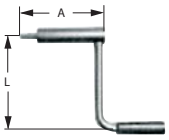
Accessories RKE

A37
Floating jaw horizontal PEB, for clamping non-parallel workpieces



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

A37
Hand crank, turnable handle, hexagon socket



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

A37
90° Angle drive



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

A37
Single clamp SPE, assembly, for mounting vices on end and on the base.



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

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

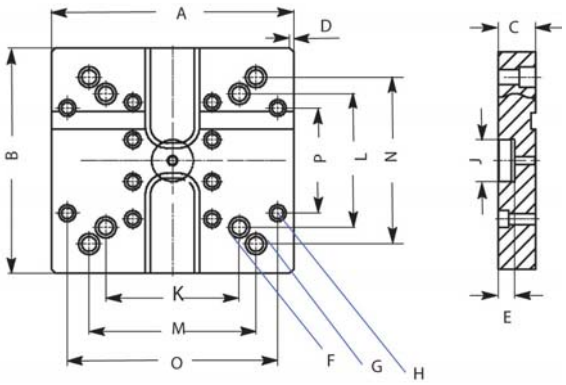


Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

▲ on request

Accessories RKE / RKK





APPLICATION

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

TYPE

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

TECHNICAL FEATURES

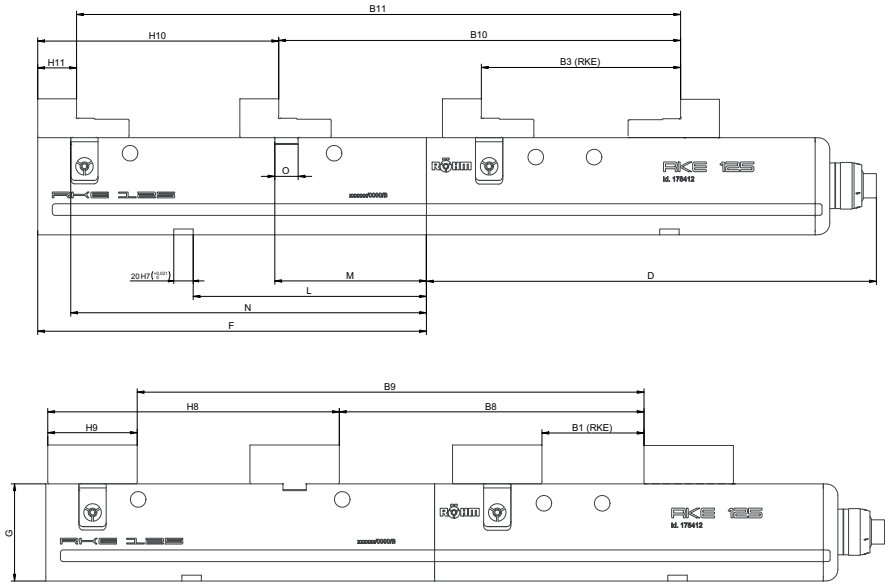
- Bores for modular grid 40/50/63
- Without fixing groove/bore (machine side)

A37
Standard basic plate GP for DUO-Tower, for NC-compact vices

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

Accessories RKE





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

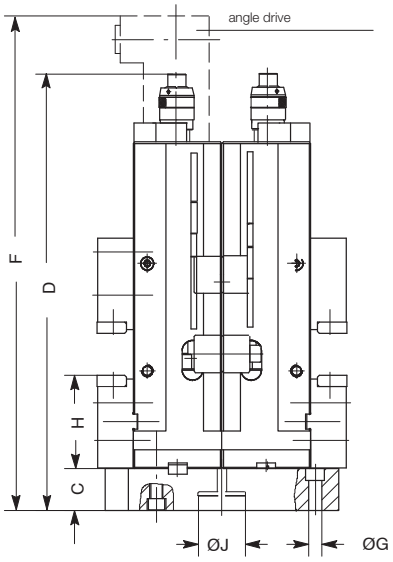
Item no.	178418	178419	178420	178421	178422	178423
For	RKE 125	RKE 125	RKE 125	RKE 160	RKE 160	RKE 160
D	463	463	463	618	618	618
F	105	200	400	190	295	530
G	100	100	100	115	115	115
L	-	-	240	-	-	200
M	-	-	156	-	-	225
N	68	160	364	150	253	493
O	24	24	24	30	30	30
B1	0-215	0-215	0-215	0-320	0-320	0-320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

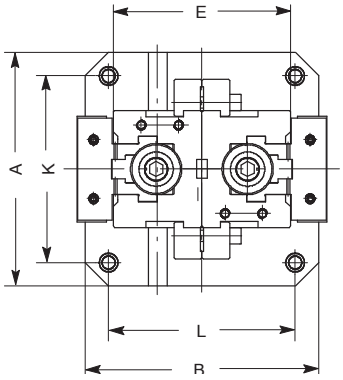
▲ on request

Notes

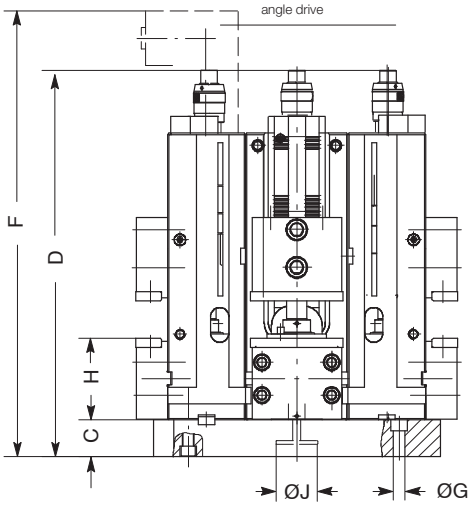
Duo and Quattro clamping towers RKE

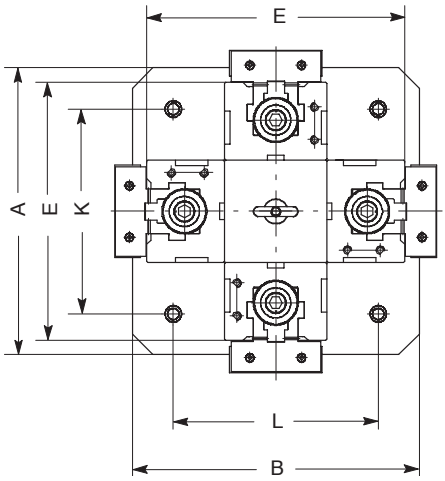
Duo-clamping towers (on request)





Quattro-clamping towers (on request)





Technical data

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

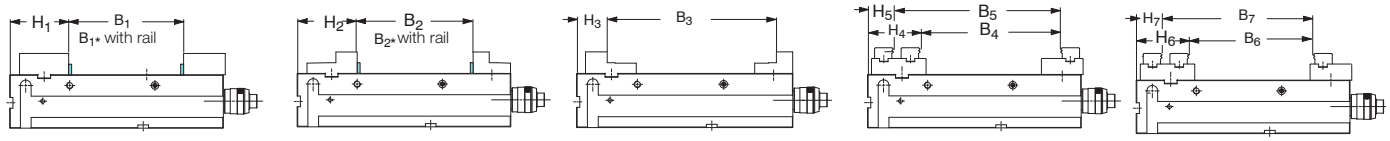
* On inquiry insert dimensions please

Technical data

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

* On inquiry insert dimensions please

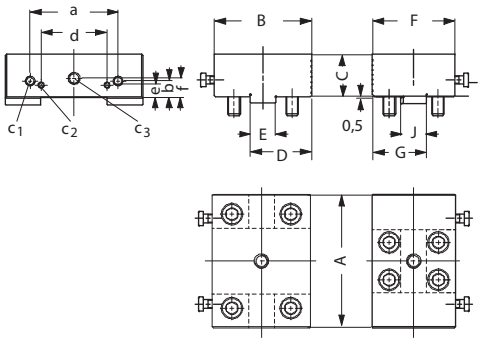
Clamping range RKE



	Standard jaws		Stepped jaws				Carrier jaws with pronged inserts			
	H1	B1 B1* with rail	H2	B2 B2* with rail	H3	B3	H4/H5	B4/B5	H6/H/	B6/B7
RKE 125	110,5	0-215	112,5	0-216	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	130	0-320	130	0-320	64	131-451	H_4: 122	B_4: 67-383	H_6: 122	B_6: 18-334

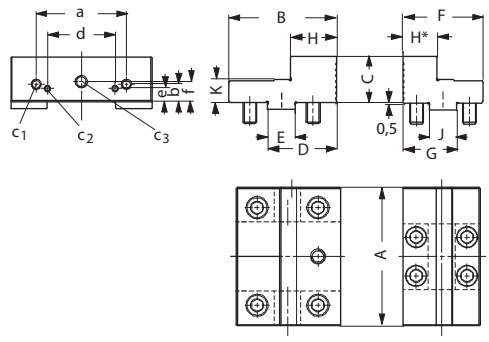
Clamping jaw dimensions for NC-Compact vices

Standard top jaws, reversible



Jaw width	125	160	200
Id.-Nr.	**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

Stepped jaws, reversible



Jaw width	92	125	160	200
Id.-Nr.	**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

RKE-LV



APPLICATION

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

TYPE

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

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

- Sturdy steel basic body and all guides are hardened and ground on all sides
- Compact design
- Carrier jaws, incl. swivelable claw inserts. For round and rectangular workpieces
- Clamping ranges carrier jaws
  rightangular workpieces: 35 - 215 mm
  circular workpieces: 65 - 225 mm

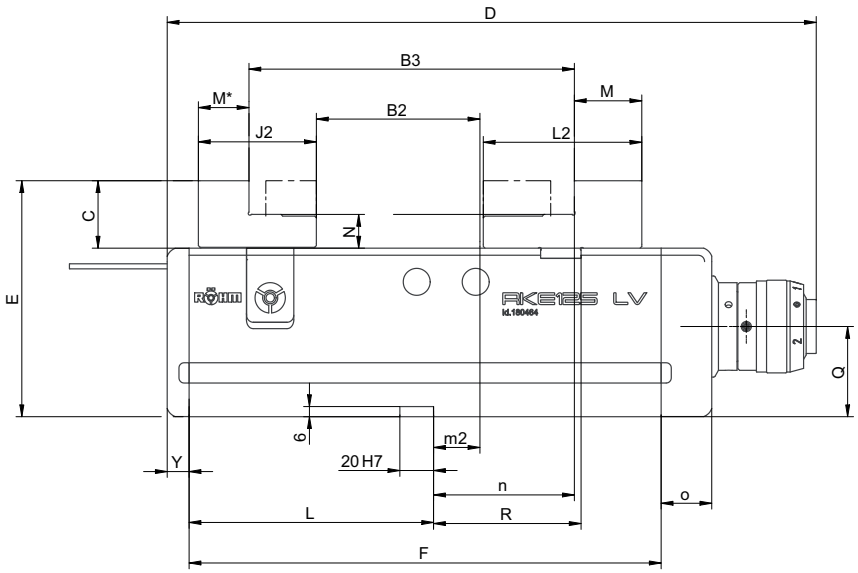
A32
RKE-LV, with reversible stepped jaws or carrier jaws

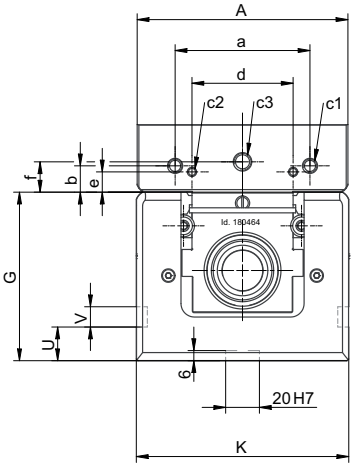
Item no.	180464	180465
Jaw width A mm	125	125
Jaw design	stepped jaws	carrier jaws
B2 mm	0-96	35-215
B3 mm	96-192	65-225
C mm	40	20
D mm	385	385
E mm	140	130
F mm	280	280
G-0,02 mm	100	100
J2 mm	70	78
K mm	126	126
L mm	145	145
L2 mm	94	105
M mm	40	-
M* mm	30	-
N-0,01 mm	20	20
O mm	30	30
Q mm	53,5	53,5
R mm	87,5	87,5
U mm	20	20
V mm	40	40
Y mm	13	13
a mm	60	-
b mm	15,6	-
c1	M10	-
c2	M8	-
c3	M5	-
d mm	80	-
e mm	12	-
f mm	18	-
m2±0,02 mm	27,5	-
n±0,02 mm	83,5	-
o mm	30	30
v mm	120	120
w mm	46	46
x mm	95	95
Øm x depth	M12x20	M12x20
Clamping force kN	40	40
A1 mm	-	28
A2 mm	-	26,5
C1 mm	-	10
W1 mm	-	38
W2 mm	-	17
W3 mm	-	22
W4 mm	-	15
Weight kg	29	29

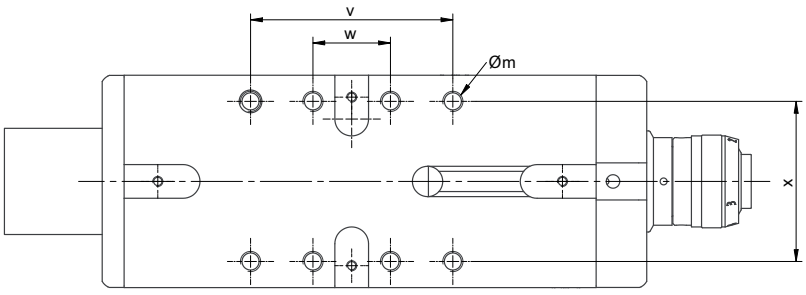
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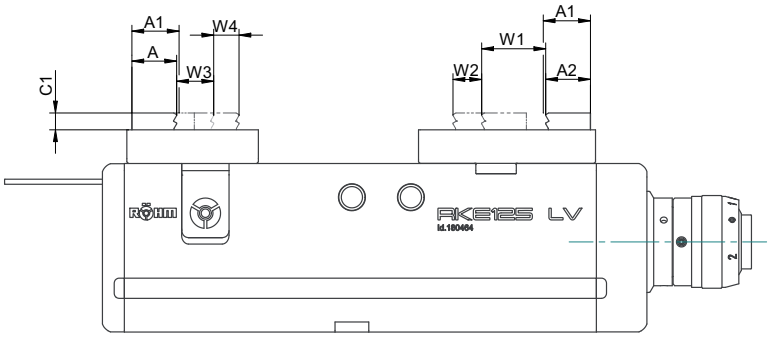
RKE-LV


RKE
125LV


D
B3
M*
M
B2
J2
L2
C
N
E
RKE125 LV
Id.180464
Q
6
m2
20 H7
Y
n
o
L
R
F


A
a
d
c2
c3
c1
f
b
e
Id. 180464
G
V
U
6
20 H7
K

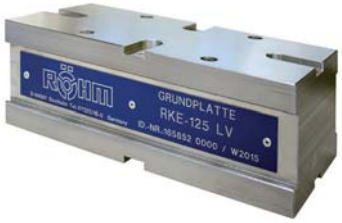

v
w
Øm
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A1
W4
A
W3
C1
W1
A1
W2
A2
RKE125 LV
Id.180464

Accessories RKE-LV

A37
Standard base plate GP

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



A37
Standard top jaws SA, reversible

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



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

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



A37
Stepped jaws SB, reversible

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



A37
Double stepped jaws DSB, “smooth”

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



A37
Carrier jaws TB, without swivelling claw inserts

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



▲ on request

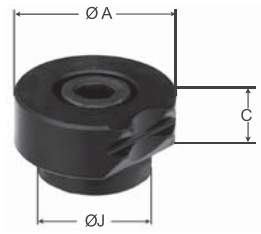
Accessories RKE-LV

A37
Carrier jaws, without claw inserts

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

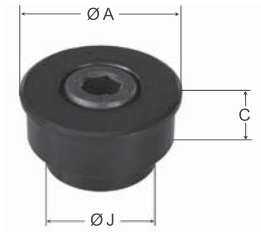


A37
Swivelling claw inserts, for carrier jaws 743-72



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

A37
Tensioner for carrier jaws 743-72



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

A37
Claw jaws with fine step, 2,5 mm clamping depth



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

A37
Claw jaws without step, universal for clamping depth >2,5mm



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

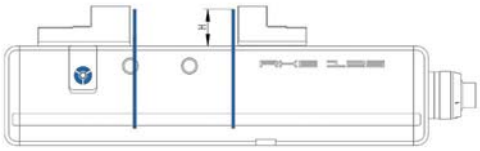
Accessories RKE-LV

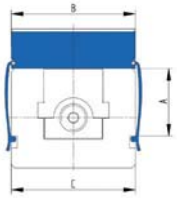
A37
Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box



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







A37
Standard jaws SGN, one side smooth, one side grooved, hardened and ground



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

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



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

A37
V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



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

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



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

A37
Draw-down jaws SNF, with spring plate, hardened and ground



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

▲ on request

Accessories RKE-LV

A37
V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



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

A37
Hand crank, turnable handle, hexagon socket



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

A37
90° Angle drive



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

A37
Single clamp SPE, assembly, for mounting vices on end and on the base.



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

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



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

RKK



APPLICATION

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

TYPE

Size 1: Clamping system, mechanical/hydraulic.
Size 2-5: Clamping system, mechanical/mechanical.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

A32
RKK, with standard jaws SA and SGN normal jaw

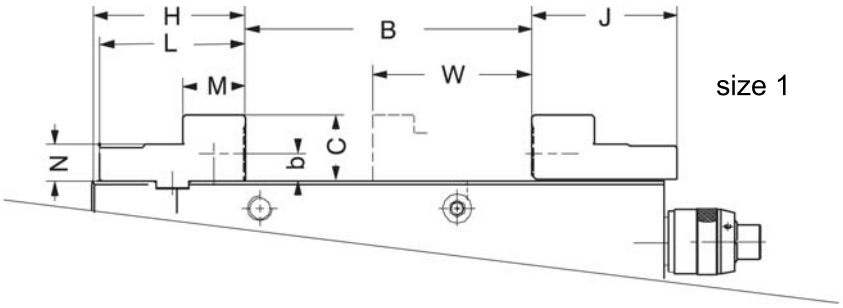
Item no.	162640 [1]	151342	148545	148682	149371
Size	1	2a	3	4	5
Jaw width A mm	92	113	135	160	200
Clamping capacity B mm	0-138	0-170	0-215	0-340	0-340
C mm	32	39	49	60	70
D mm	330	424	483	618	618
E mm	112	133	148	179	189
F mm	276	350	400	525	525
G-0,02 mm	80	95	100	120	120
H-0,05 mm	73	100	110,5	130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

[1] With stepped jaws

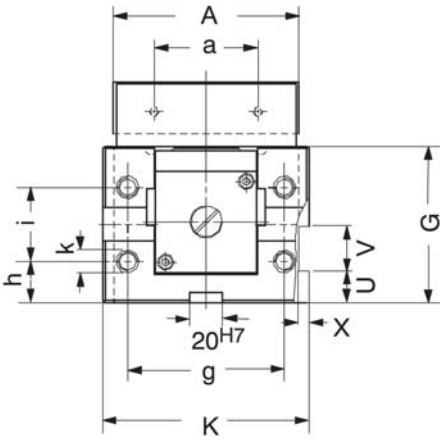
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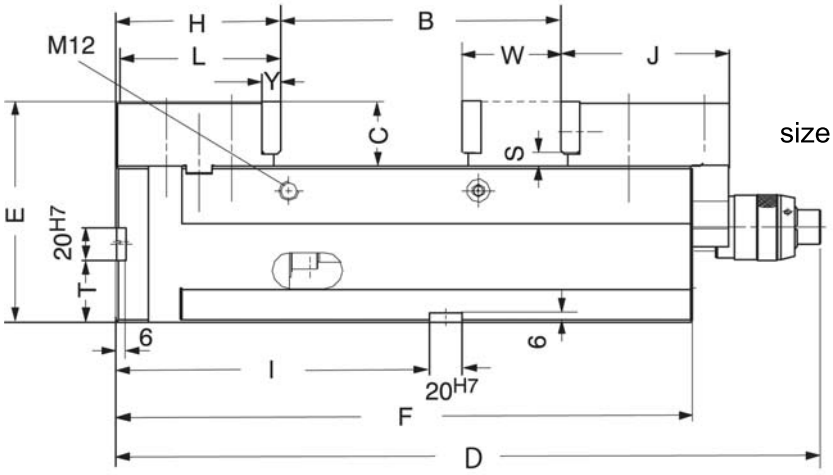
RKK



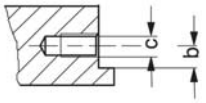


size 1





size 2-5



Accessories RKK

A37
Standard top jaws SA, reversible for screwing on clamping jaws, with fixing screws



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

A37
Top jaws SN, reversible, for hooking in quick-change clamping inserts and for screwing on clamping jaws, with fixing screws



Item no.	Contents of delivery	Size	Width mm	Height mm
149239	set	2a	108	49
149240	set	3	133	53
149375	set	4	158	67
149376	set	5	198	67

A37
Carrier jaws TB, reversible for screwing on claw inserts or special jaws, with fixing screws



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

A37
Claw insert KRE, for carrier jaws 743-70, with fixing screw



Item no.	Contents of delivery	Size	Ø J mm	C mm
146070	piece	3/4/5/2a	30	20

A37
Claw jaws with fine step, 2,5 mm clamping depth



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

▲ on request

Accessories RKK

A37
Claw jaws without step, universal for clamping depth >2,5mm



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

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



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

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



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

A37
V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking capacity mm	
					Horizontal	Vertical
128770	piece	92	92	31,6	3-13	5-32
082362	piece	2a	113	31,6	3-13	5-32
082363	piece	125	135	39,6	4-20	6-40
082364	piece	160	160	49,6	5-29	7-48
082365	piece	200	200	62,6	6-37	8-56

A37
Draw-down jaws SNF, with spring plate, hardened and ground



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

A37
V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



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

Accessories RKK

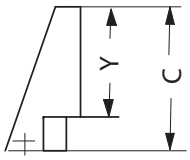
A37
Normal jaw SGNA, with movable workpiece stop, hardened and ground



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

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

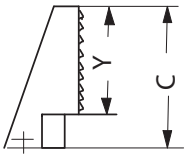




Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
147953	set	2a	110	49	36
147954	set	3	135	53	40
147955	set	4	160	67	50
158823	set	5	200	67	50

A37
Standard inserts finely checkered NCSf, with small surface area to increase the specific surface clamping (higher holding forces)

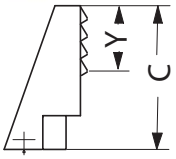




Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163227	set	2a	110	49	36
163228	set	3	135	53	40
163229	set	4	160	67	50
163230	set	5	200	67	50

A37
Claw inserts NCK, hardened and ground, for unmachined workpieces

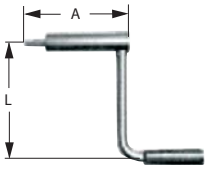




Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
148916	set	2a	110	49	24
148917	set	3	135	53	24
148918	set	4	160	67	45
159447	set	5	200	67	45

Accessories RKK

A37
Hand crank, turnable handle, hexagon socket



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

A37
90° Angle drive, for RKK 92 / RKE-L 92, for fastening NC-compact clamps, advantageous for front-sided set-up or for large machine tables



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

A37
90° **Angle drive,** for RKK 2-5



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

A37
Single clamp SPE, assembly, for mounting vices on end and on the base



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

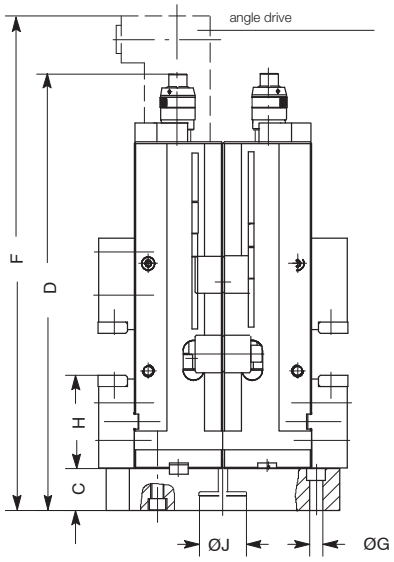
A37
Fixed slot nuts NTS hardened and ground, with fixing screw

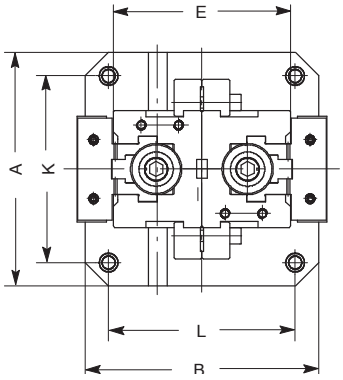


Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

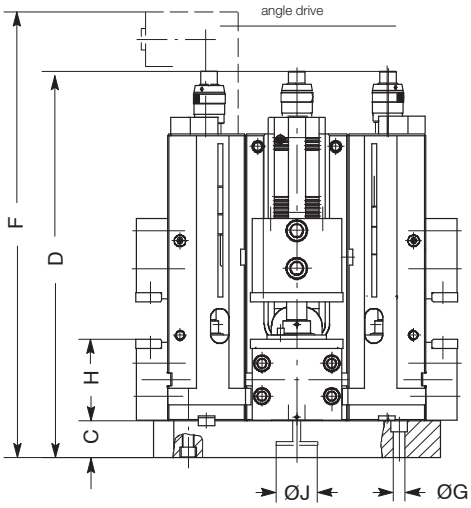
Duo and Quattro clamping towers RKK

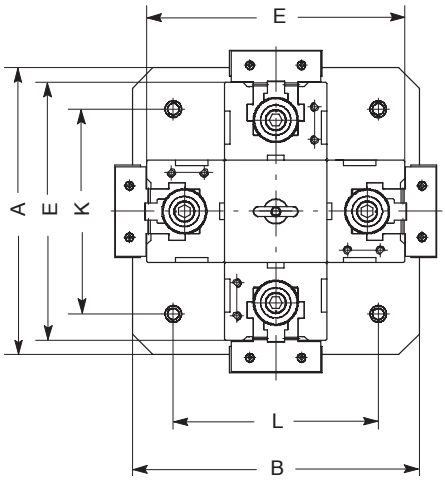
Duo-clamping towers (on request)





Quattro-clamping towers (on request)





Technical data

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

* On inquiry insert dimensions please

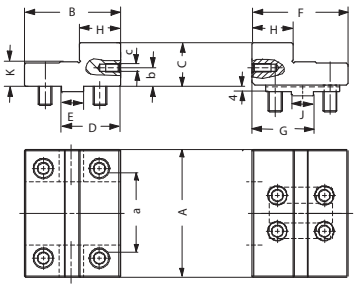
Technical data

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

* On inquiry insert dimensions please

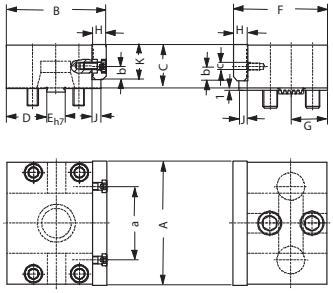
Jaw dimensions and clamping range RKK

With stepped jaws, reversible



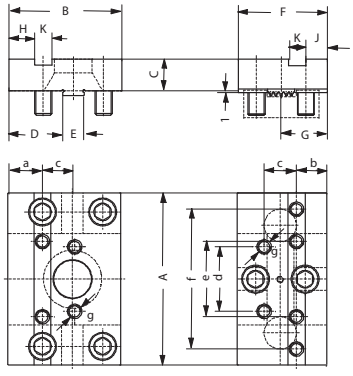
Size	1
A	92
B	70
C	32
D	43
E_{h7}	16
F	70
G	45
H	30
J_{g6}	16
K	18
a	63
b	13,6
c	M6

Standard top jaws SA, reversible



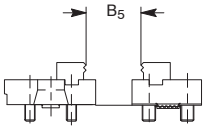
Size	2/2a	3	4	5
A	113	135	160	200
B	99	109	128	128
C	39	49	60	70
D	41,5	44	50	50
E_{h7}	16	20	20	20
F	102	102	110	110
G	38	39	42	42
H	11,6	15,6	15,6	19,6
J	7,6	9,6	9,6	13,6
K	31,6	39,6	49,6	62,6
a	63	80	100	125
b	13,6	15,6	19,6	24,6
c	M6	M8	M8	M10

Carrier jaws, reversible

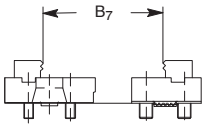


Size	2/2a	3	4	5
A	110	135	160	200
B	90	95	105	105
C	25	30	30	30
D	41	44	50	50
E_{h7}	16	20	20	20
F	83	83	83	83
G	43	43	43	43
H	41	21	24	24
J	20	20	20	20
K_{H7}	16	16	16	16
a	49	29	32	32
b	28	28	28	28
c	25	25	30	30
d	50	60	70	70
e	80	60	70	110
f	-	110	130	160
g	M12	M12	M12	M12

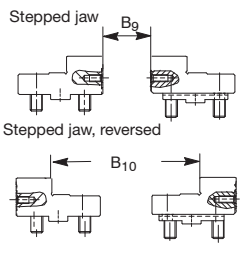
Clamping ranges: External clamping RKK



Carrier jaws with pronged inserts



Carrier jaws with pronged inserts



Size			
1	-	-	B9: 0-138 / B10: 84-222
2+2a	59-233	89-263	
3	30-257	110-337	
4+5	59-395	144-481	



SET-UP AND WORKING TIME REDUCTION BY TWIN CLAMPING



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

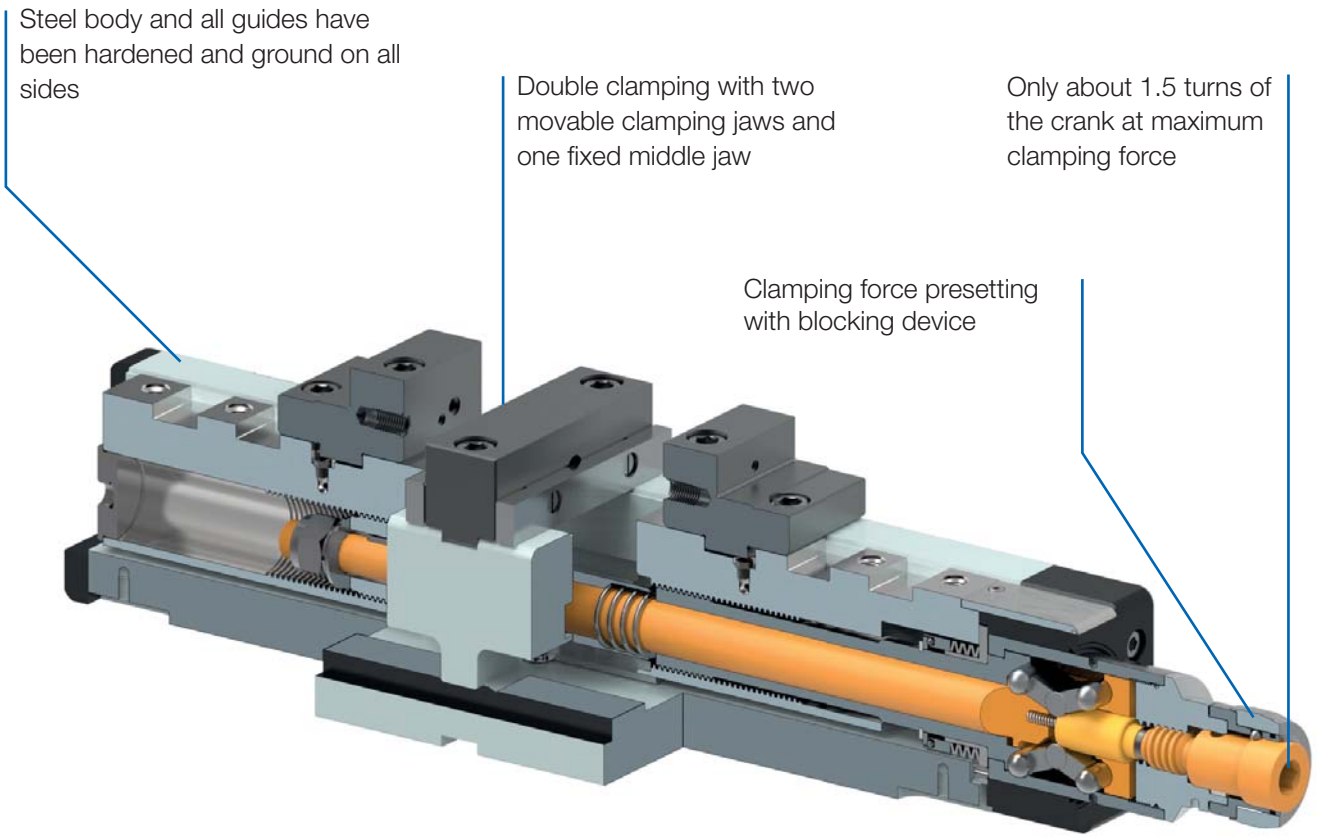
Then the crank is turned further, the other movable clamping jaw is placed against the workpiece, fixed and force is built up via the mechanical spindle.
Balance springs compensate dimensional diescrepancies from up to ±3 mm between workpiece I and workpiece II.

NC-COMPACT TWIN VICES

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

ADVANTAGES AT A GLANCE

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



RKD



APPLICATION

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

TYPE

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

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

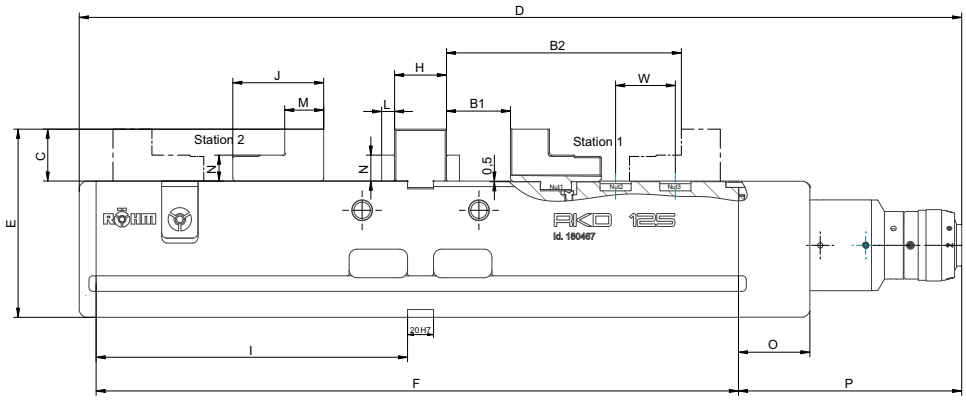
A32
RKD, with reversible stepped jaws and centre jaw

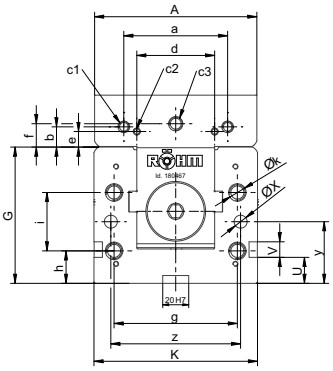
Item no.	180466	180467
Jaw width A mm	92	125
B1 slot 1 mm	0 - 48	0 - 48
B1 slot 2 mm	48 - 96	46 - 94
B1 slot 3 mm	-	92 - 140
B2 slot 1 mm	42 - 79	51 - 88
B2 slot 2 mm	79 - 127	86 - 134
B2 slot 3 mm	-	132 - 180
C mm	32	40
D mm	512	680
E mm	117	145
F mm	356	495
G-0,02 mm	85	105
H-0,02 mm	30	40
J mm	56	70
K mm	94	126
L mm	10	10
M mm	25	30
N-0,01 mm	16	20
O mm	55	55
P mm	144	172
T-0,02 mm	30	37,5
U mm	20	20
V mm	12	12
W mm	1 x 48	2 x 46
X x depth	10H7x 12	10H7 x 12
Y mm	12	13
Z mm	50	50
a mm	63	80
b mm	13,6	15,6
c1	M6x14	M8 x 14
c2	M5 x 9	M5 x 10
c3	M10 x 16	M10 x 18
d mm	48	60
e mm	8	12
f mm	14	18
g mm	70	95
h mm	20	25
i mm	50	45
k x depth	M10 x 18	M12 x 22
l-0,02 mm	170	240
y±0,01 mm	40	47,5
z mm	72	100
Clamping force kN	25	40
Weight kg	24	53

▲ on request

RKD


RKD 125


D
B2
H
J
M
L
B1
W
Station 2
Station 1
C
E
N
0.5
RKD 125
id. 180467
20 H7
I
F
O
P


A
a
d
c1
c2
c3
f
b
e
G
i
h
g
z
K
20 H7

Accessories RKD

A37
Stepped jaws SB, reversible, with fixing screws



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

A37
Standard jaws SGN, one side smooth, one side grooved, hardened and ground



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

A37
Standard jaws finely checkered SGNf, one side finely checkered, one side grooved, hardened and ground



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

A37
Claw jaws with fine step, 2,5 mm clamping depth



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

A37
Claw jaws without step, universal for clamping depth >2,5mm



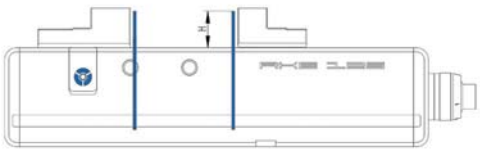
Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661	set	92	92	32	14
166667	set	125	125	40	16

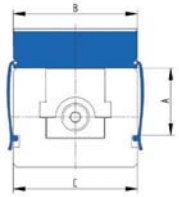
A37
Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box



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







▲ on request

Accessories RKD

A37
Center jaws MBA



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

A37
Work support WAM, for center jaws



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

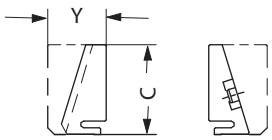
A37
Draw-down jaws RNG, with two permanent magnets



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

A37
Standard insert RNS, held by two permanent magnets

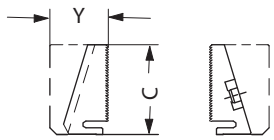




Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242	set	92	92	32	21
159232	set	125	125	40	26

A37
Standard insert finely checkered RNSf, held by two permanent magnets



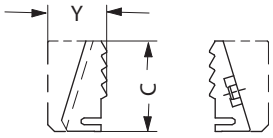


Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163270	set	92	92	32	21
163267	set	125	125	40	26

Accessories RKD

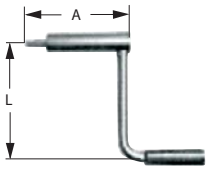
A37
Claw insert RNK, held by two permanent magnets





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

A37
Hand crank, turnable handle, hexagon socket



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

A37
Angle drive



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

A37
Single clamp SPE, assembly, for mounting vices on end and on the base



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

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



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

Notes

RKD-M



APPLICATION

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

TYPE

Clamping system mechanical without power transmitter, manually operated.
With one-sided drive spindle.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

A32

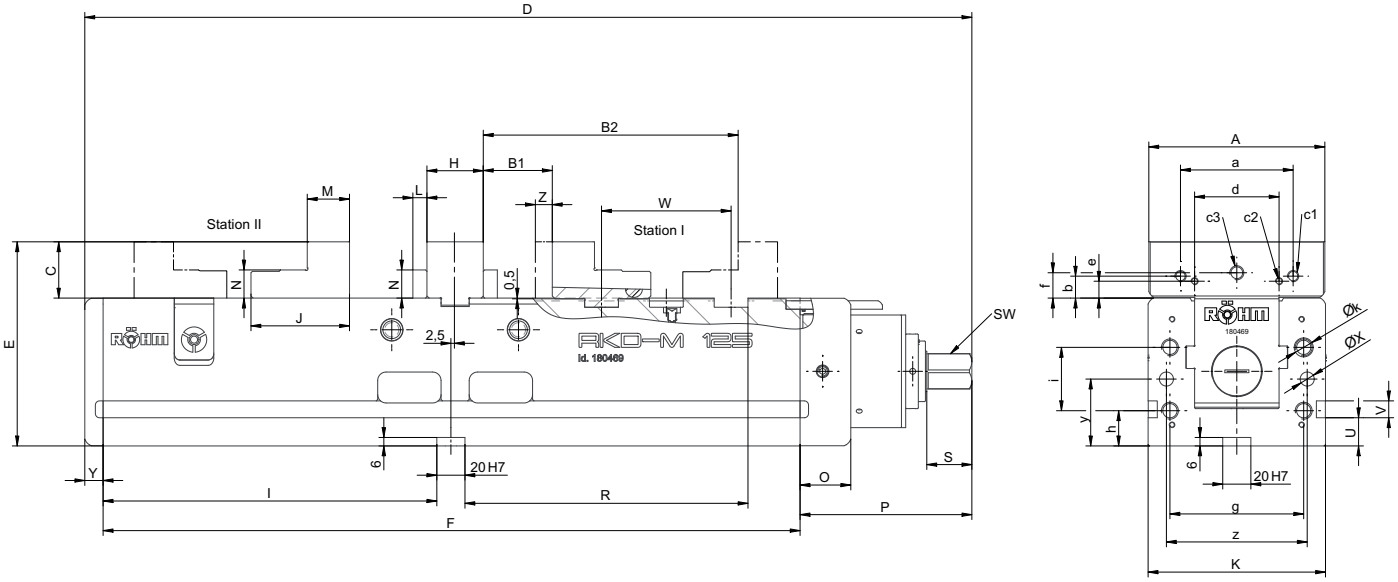
RKD-M, with reversible stepped jaws and centre jaw

Item no.	180468	180469
Jaw width A mm	92	125
B1 slot 1 mm	0-48	0-48
B1 slot 2 mm	48-96	46-94
B1 slot 3 mm	-	92-140
B2 slot 1 mm	42-79	51-88
B2 slot 2 mm	79-127	86-134
B2 slot 3 mm	-	132-180
C mm	32	40
D mm	512	680
E mm	117	145
F mm	366	495
G-0,02 mm	85	105
H-0,02 mm	30	40
J mm	56	70
K mm	94	126
L mm	10	10
M mm	25	30
N-0,01 mm	16	20
O mm	36	36
P mm	114	122
R mm	143	201
S mm	31	32
T-0,02 mm	30	37,5
U mm	20	20
V mm	12	12
W mm	1 x 48	2 x 46
Y mm	12	13
Z mm	50/53	50/53
Key-width SW	17	19
a mm	63	80
b mm	13,6	15,6
c1	M6 x 14	M8 x 14
c2	M5 x 9	M5 x 10
c3	M10 x 16	M10 x 18
d mm	48	60
e mm	8	12
f mm	14	18
g mm	70	95
h mm	20	25
i mm	50	45
k x depth	M10 x 18	M12 x 22
l-0,02 mm	177	237
y±0,01 mm	40	47,5
z mm	72	100
Clamping force kN	25	40
Weight kg	24	52

▲ on request

RKD-M


RKD-M 125


D
B2
H
B1
M
L
Z
W
Station II
Station I
C
N
J
2,5
0,5
E
SW
RKD-M 125
Id. 180469
6
20 H7
Y
I
R
O
P
S
F
A
a
d
c3
c2
c1
e
f
b
ØK
ØL
i
v
h
U
V
g
z
K

Accessories RKD-M

A37
Stepped jaws SB, reversible, with fixing screws



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

A37
Standard jaws SGN, one side smooth, one side grooved, hardened and ground



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

A37
Standard jaws finely checkered SGNf, one side finely checkered, one side grooved, hardened and ground



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

A37
V-jaw PB, horizontal and vertical



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

A37
Claw jaws with fine step, 2,5 mm clamping depth



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

▲ on request

Accessories RKD-M

A37
Claw jaws without step, universal for clamping depth >2,5mm



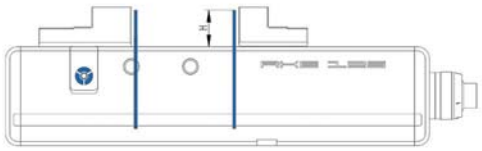
Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661	set	92	92	32	14
166667	set	125	125	40	16

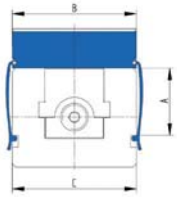
A37
Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box



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







A37
Draw-down jaws RNG, with two permanent magnets

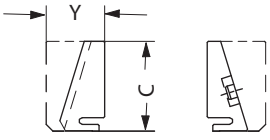


Item no.	Contents of delivery	Size	Width mm	Height mm
155237	set	92	92	32
159227	set	125	125	39,5

A37
Standard insert RNS, held by two permanent magnets



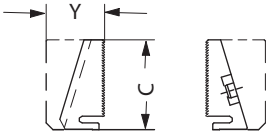
Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242	set	92	92	32	21
159232	set	125	125	40	26



Accessories RKD-M

A37
Standard insert finely checkered RNSf, held by two permanent magnets

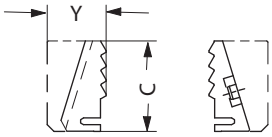




Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163270	set	92	92	32	21
163267	set	125	125	40	26

A37
Claw insert RNK, held by two permanent magnets





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

A37
Drive adapter ATA



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

A37
Fixed stepped jaw FSB, for single clamping, reversible



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

A37
Center jaws MBA



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

▲ on request

Accessories RKD-M

C15
Hand crank HKU, with octagon socket



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

A37
Single clamp SPE assembly, for mounting vices on end and on the base.



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

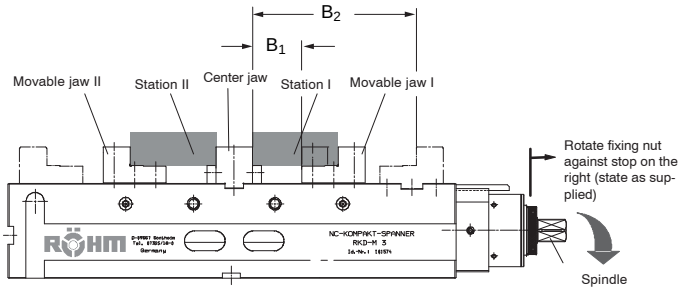
A37
Fixed slot nuts NTS, hardened and ground, with fixing screw



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

Clamping range RKD-M

Clamping ranges: Twin clamping



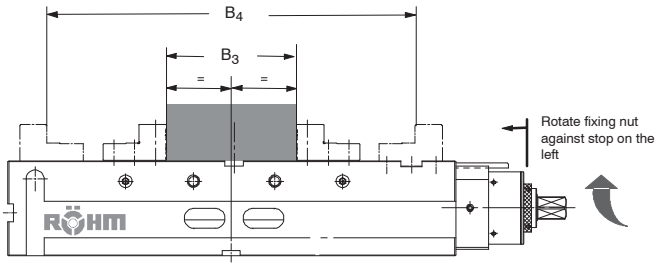
Function:
To adjust mobile jaw I with regard to the workpiece of station I turn the spindle to the right by means of the handle (left-right handed thread). About 1 kN are applied to keep the jaw in the adjusted position (third-hand function).
By further turning the lever, mobile jaw II is adjusted with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

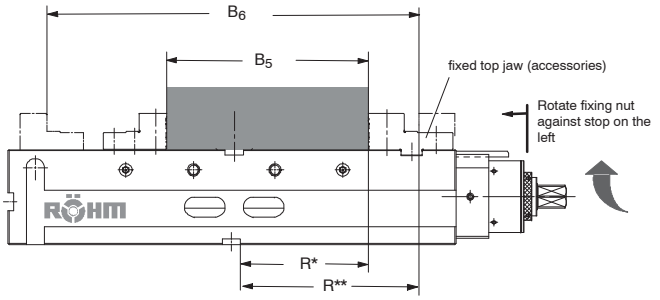
Clamping ranges: Centric clamping



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

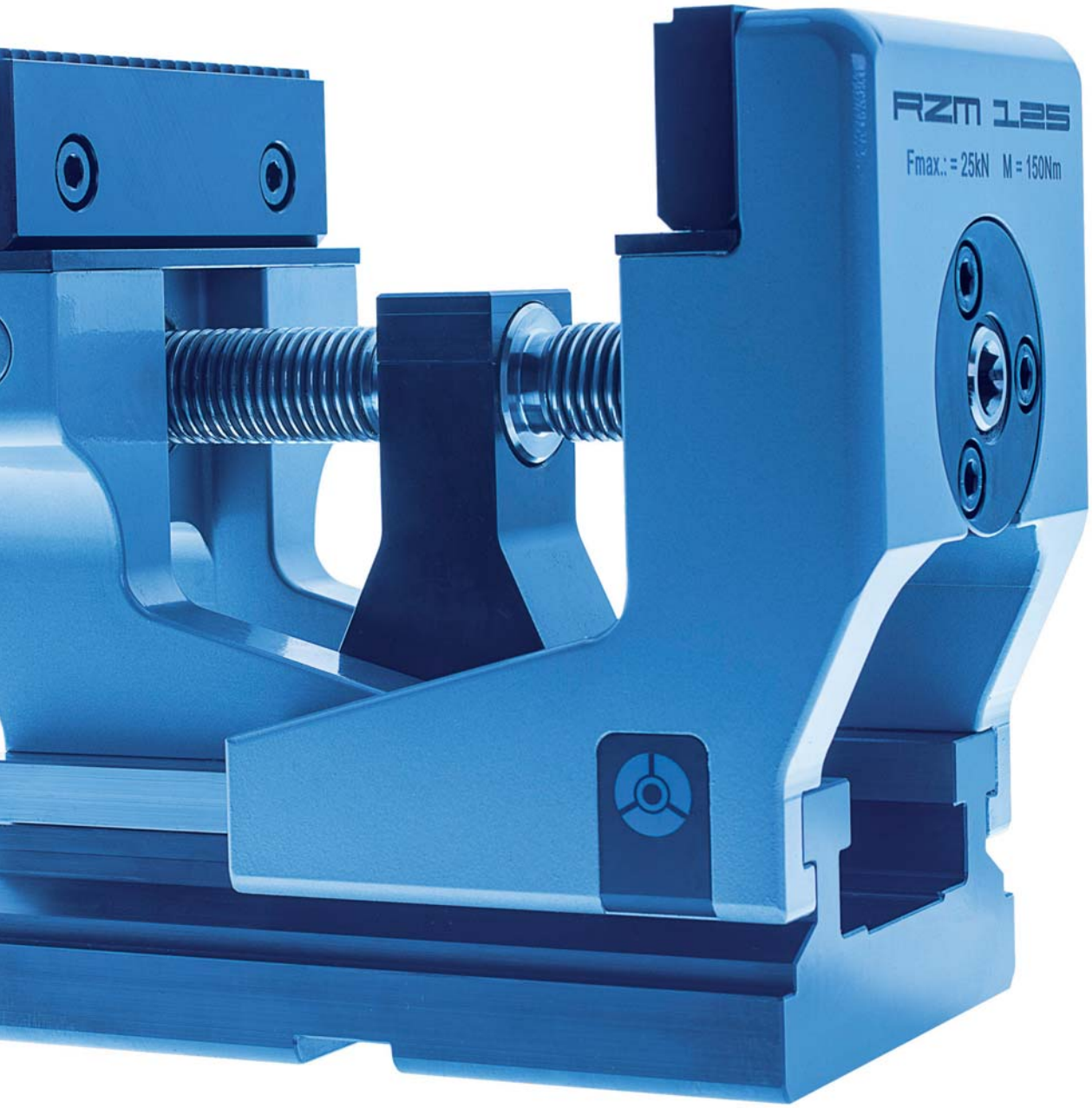
Clamping ranges: Single clamping



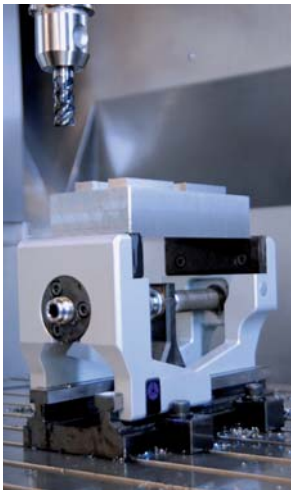
Remove central jaw and movable mounting jaw I.
Install fixed mounting jaw (accessory - not in scope of delivery).
Fixing nut - stop on the left (spindle rigid)
Stroke of moving jaw: "Z" 53mm

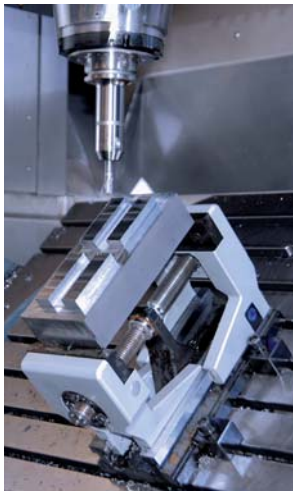
Size		92	125
B_5	Groove 1	126 - 177	171 - 222
	Groove 2	174 - 225	217 - 268
	Groove 3	-	263 - 314
B_6	Groove 1	196 - 247	267 - 318
	Groove 2	244 - 295	313- 364
	Groove 3	-	360 - 410
	R*	101	141
	R**	140	197

Notes



IDEAL FOR 5-AXIS MACHINING





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

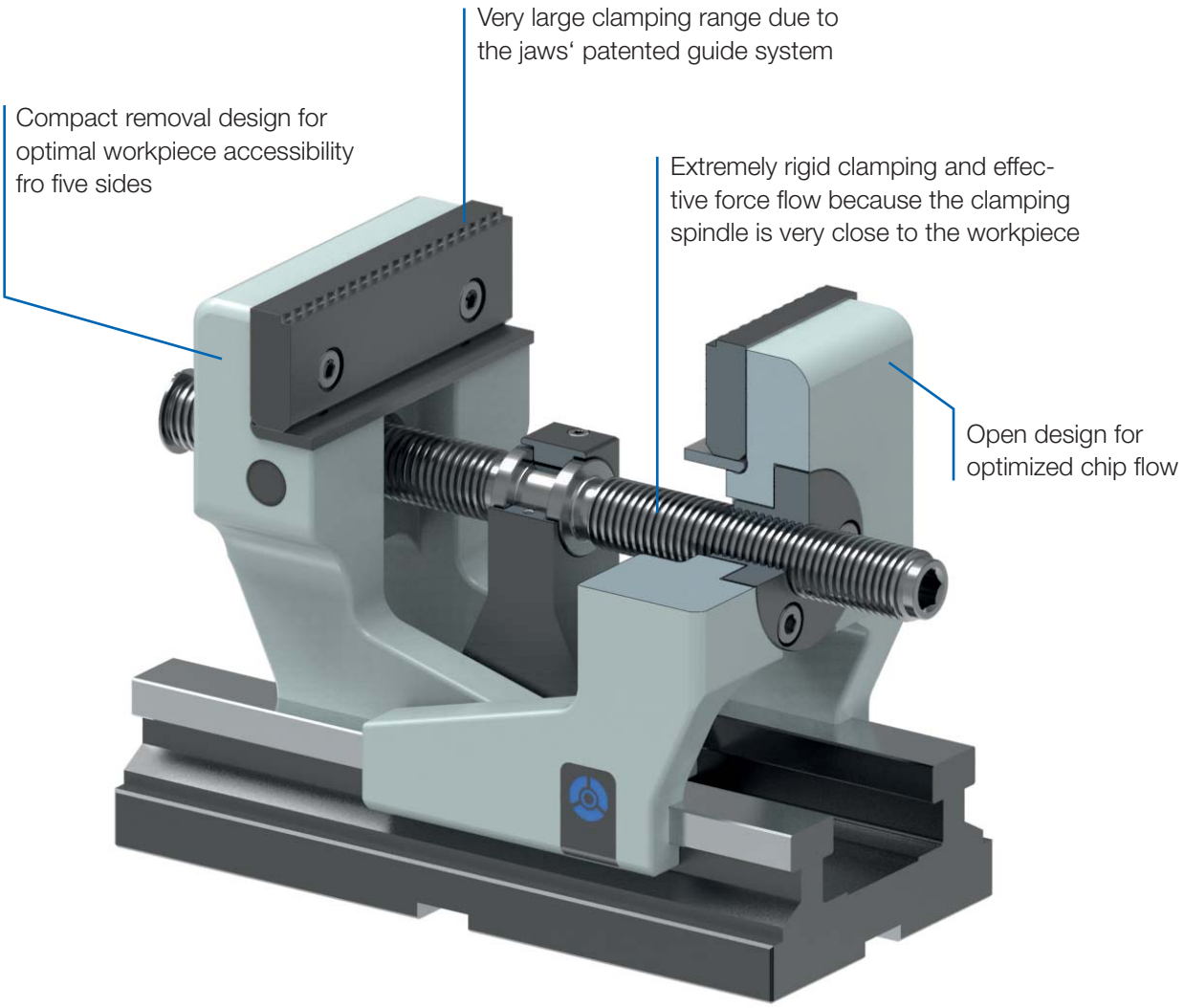
Video RZM

NC-COMPACT SELF CENTERING VICES

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

ADVANTAGES AT A GLANCE

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



RZM



APPLICATION

Optimized for 5-axis machining.

TYPE

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

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

- Steel body hardened and ground
- Highly positioned clamping jaw
- Top spindle lying near the clamping jaws for optimal force transfer
- Long jaw guide and compact design
- Including SKB clawed jaws
- Clamping repeatability 0,02 mm

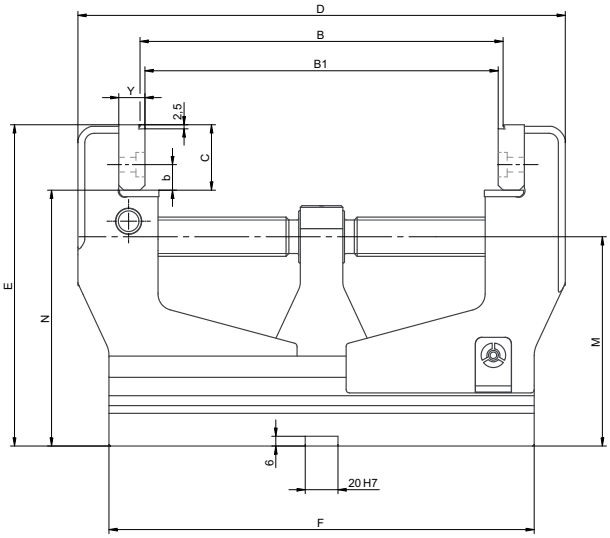
A32
RZM

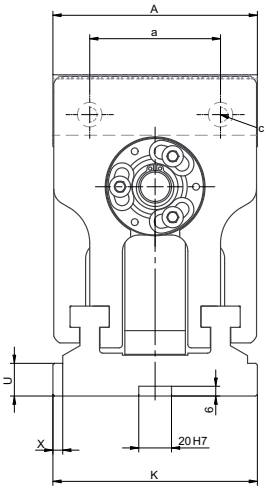
Item no.	178910	178911
Jaw width A mm	125	125
Design	long design	short design
B min.	23	23
B max.	222	142
B1 mm	17-216	17-136
C mm	128	128
D mm	298	218
E mm	196,5	196,5
F mm	260	180
N mm	156,5	156,5
U mm	20	20
X mm	6	6
Clamping force kN	25	25
Tightening torque Nm	150	150
Weight kg	20,3	17,4

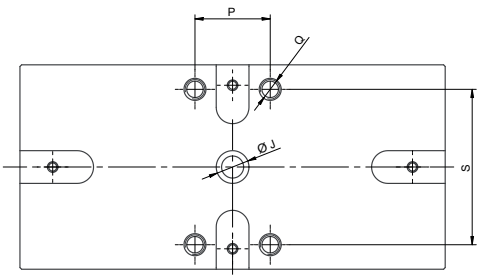
▲ on request

RZM









Accessories RZM

A37
Claw jaws without step, universal for clamping depth >2,5mm



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

A37
Claw jaws with fine step, 2,5 mm clamping depth



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

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



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

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



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

A37
V-jaw PB, horizontal and vertical



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

▲ on request

Accessories RZM

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



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

A37
V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



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

A37
Spindle, for shortening the clamping range of the long RZM version

Item no.	Contents of delivery	Length mm	Diameter mm
178958	piece	218	24



A37
Single clamp SPE, for mounting vices on end and on the base



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

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



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

RKZ



APPLICATION

Optimized for 5-axis machining.

TYPE

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

CUSTOMER BENEFITS

- Horizontal, vertical or side mounting
- High repeatability and constant clamping force
- Clamping accuracy at the centre: ± 0,01 - clamping repeatability: 0,01
- The clamping thread of the spindle is protected from dirt and chips in every basic jaw position
- With grease nipples installed on both sides, that all guides and the spindle thread can be lubricated quickly and easily

TECHNICAL FEATURES

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

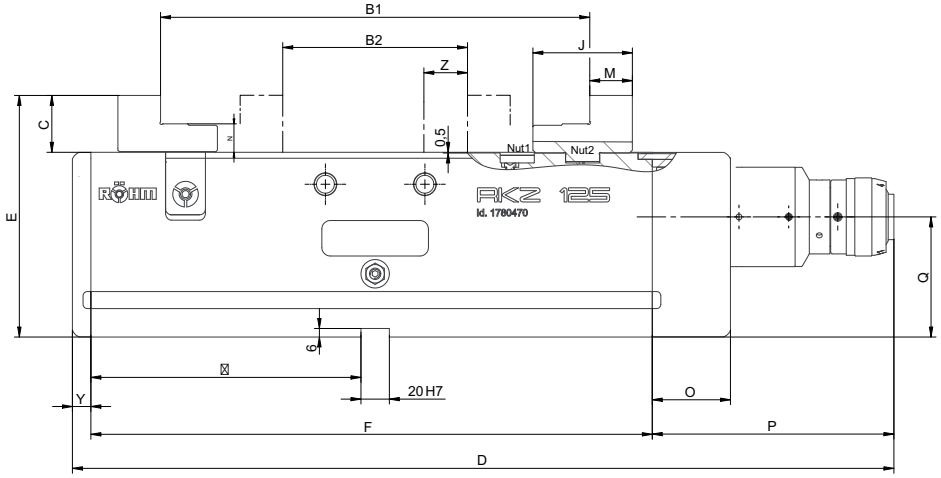
A32
RKZ, with stepped jaws

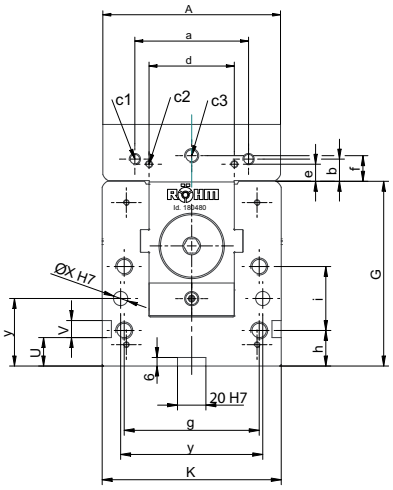
Item no.	180470
Jaw width A mm	125
B1 slot 1 mm	112-206
B1 slot 2 mm	204-298
B2 slot 1 mm	32-126
B2 slot 2 mm	124-218
C mm	40
D mm	578
E mm	170
F mm	395
G-0,02 mm	130
J mm	70
K mm	126
M mm	30
N-0,01 mm	20
O mm	55
P mm	170
Q mm	84,5
T-0,02 mm	37,5
U mm	20
V mm	12
W mm	46
X x depth	10 H7 x 12
Y mm	12
Stroke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

▲ on request

RKZ


RKZ 125


B1
B2
Z
J
M
C
E
0,5
Nut1
Nut2
RKZ 125
Id. 1780470
6
X
Y
20 H7
F
D
O
P
Q


A
a
d
c1
c2
c3
e
b
f
ØX H7
G
i
h
y
V
U
6
20 H7
g
y
K

Accessories RKZ

A37
Stepped jaws SB, reversible

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



A37
Raised stepped jaws ESB

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



A37
Double V-jaw, reversible, with fine step, for jaw dimensions of the double V-jaws please see page 4065!

Item no.	Contents of delivery	Size	Width mm	Height mm	Length mm	Size prism mm	Clamping dia. D1 mm		Clamping dia. D2 mm	
							slot 1	slot 2	slot 1	slot 2
169756	set	125	125	84,5	86	56	15-40	-	30-92**	89-105



A37
Standard jaws SGN, one side smooth, one side grooved, hardened and ground

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



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

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



▲ on request

Accessories RKZ

A37
V-jaw PB, horizontal and vertical



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

A37
Claw jaws with fine step, 2,5 mm clamping depth



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

A37
Claw jaws without step, universal for clamping depth >2,5mm



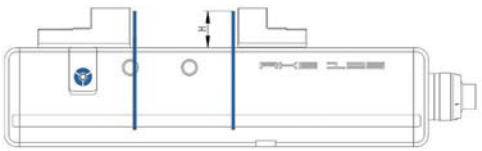
Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166667	set	125	125	40	16

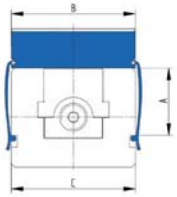
A37
Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box



Item no.	Web height A	Jaw width B mm	Rail height H	Spare clamp (Set = 4 pieces)
1295915	98	125	10/15/20/25/28/30/33/35/36/37	1295918







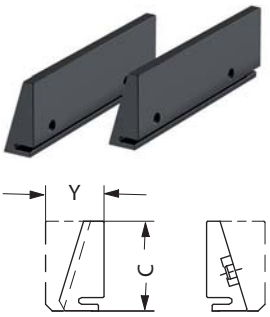
A37
Draw-down jaws RNG, with two permanent magnets



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

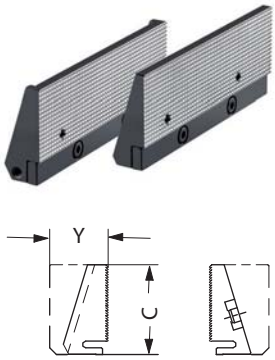
Accessories RKZ

A37
Standard insert RNS, held by two permanent magnets



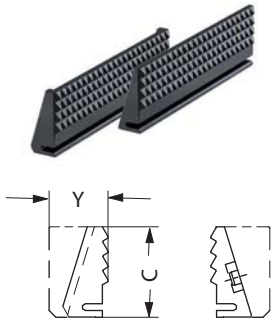
Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
159232	set	125	125	40	26

A37
Standard insert finely checkered RNSf, held by two permanent magnets



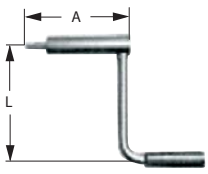
Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163267	set	125	125	40	26

A37
Claw insert RNK, held by two permanent magnets



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

A37
Hand crank, turnable handle, hexagon socket



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

▲ on request

Accessories RKZ

A37
Angle drive



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

A37
Single clamp SPE, assembly, for mounting vices on end and on the base



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

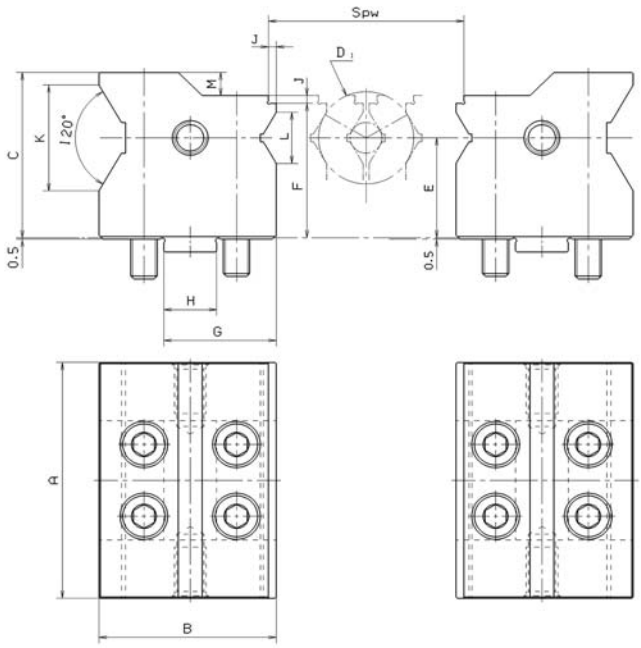
A37
Fixed slot nuts NTS, hardened and ground, with fixing screw



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

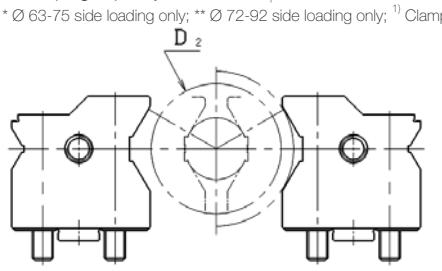
Jaw dimensions

Double V-jaw, reversible, with fine step



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

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



RKZ-M



APPLICATION

Optimized for 5-axis machining.

TYPE

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

CUSTOMER BENEFITS

- Short, compact design
- Large clamping stroke
- Constant clamping force for every clamping operation and high clamping repeatability when a torque wrench is used
- clamping accuracy at the centre: ± 0,02 - clamping repeatability: 0,01

TECHNICAL FEATURES

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

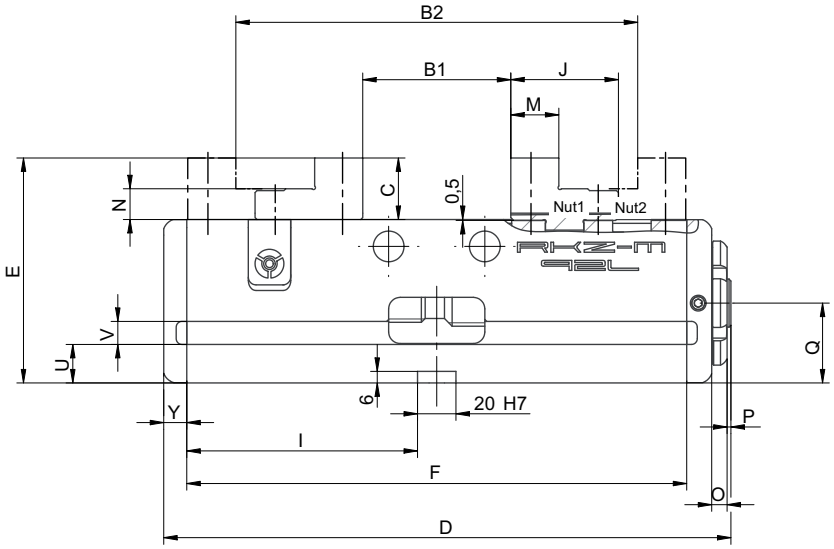
A32
RKZ-M, with stepped jaws

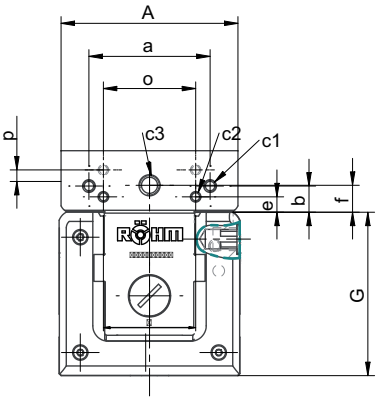
Item no.	180190	180191	180192	180193
Jaw width A mm	50	70	92	125
B1 slot 1 mm	0-39	0 - 58	0 - 76	0 - 97
B1 slot 2 mm	36-75	48-106	70-146	92-189
B2 slot 1 mm	37-75	48-105	78-138	81-177
B2 slot 2 mm	72-111	95-153	132-208	172-269
C mm	20	25	32	40
Dmax mm	167	219	295	366
E mm	75	95	117	145
F mm	140	190	260	330
G-0,02 mm	55	70	85	105
J mm	32	41	56	70
K mm	52	72	94	126
M mm	14	17,5	25	30
N-0,01 mm	10	12	16	20
O mm	10	10	13	13
P mm	1	1	2	2
Q mm	31	40	41,5	53
U mm	15	20	20	20
V mm	12	12	12	12
W mm	18	24	35	46
Y mm	10	10	12	13
Z mm	20,5	30	39	49,5
a mm	-	-	63	80
b mm	-	-	13,6	15,6
c1	-	-	M6x10	M8x14
c2	M 4 x 8	M 5 x 8	M5x8	M5x8
c3	-	-	M10x16	M10x18
c4	M3x6	M4x8	M5x8	M5x8
d mm	26	37	48	60
e mm	5	6	8	12
f mm	-	-	14	18
l mm	60	85	120	155
o mm	32	52	55	55
p mm	3,5	4,5	6	6
q mm	38	52	55	55
r mm	20	30	32	32
s mm	15	19	20	20
t mm	6 kt-SW 8	6 kt-SW 10	6 kt-SW 14	6 kt-SW 14
u mm	4 kt-SW 12	4 kt-SW 14	4 kt-SW 19	4 kt-SW 19
Clamping force kN	10	15	20	25
Weight kg	3,5	7	18	32,5

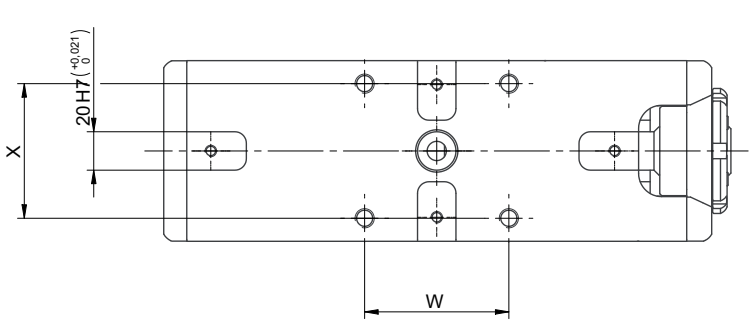
▲ on request

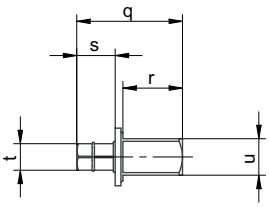
RKZ-M


RKZ-M
125L


B2
B1
J
M
N
C
0,5
Nut1
Nut2
E
V
U
Q
6
20 H7
Y
I
F
P
O
D


A
a
o
p
c3
c2
c1
e
b
f
G


20H7 (+0,021 0)
X
W


q
s
r
t
u

Accessories RKZ-M

A37
Stepped jaws SB, reversible, with fixing screws

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



A37
Raised stepped jaws ESB

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



A37
Double V-jaw, reversible, with fine step, for jaw dimensions of the double V-jaws please see page 4070!

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



A37
Standard jaws SGN, one side smooth, one side grooved, hardened and ground



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

A37
Standard jaws finely checkered SGNf, one side finely checkered, one side grooved, hardened and ground



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

A37
V-jaw PB, horizontal and vertical



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

▲ on request

Accessories RKZ-M

A37
Claw jaws with fine step 2,5 mm clamping depth



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

A37
Claw jaws without step, universal for clamping depth > 2,5 mm



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

C15
Hand crank HKU, with octagon socket



Item no.	Contents of delivery	Size	Octagon	L
009150	piece	50	12	80
009152	piece	70	14	125
382112	piece	92	19	160
009154	piece	125	19	200

A37
Drive adapter ATA



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

A37
Single clamp SPE, assembly, for mounting vices on end and on the base



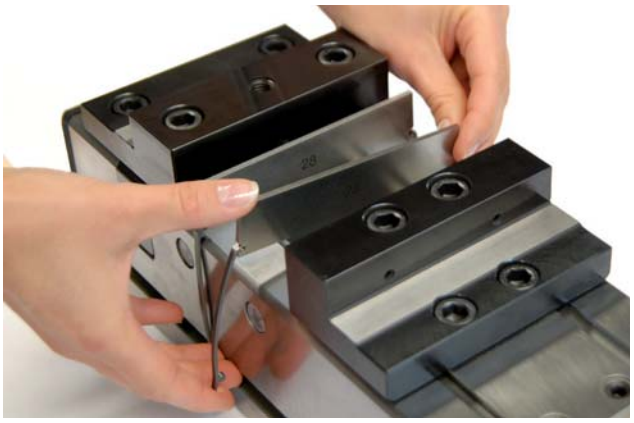
Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

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



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

General accessories - Cliparc



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

Technical features:

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

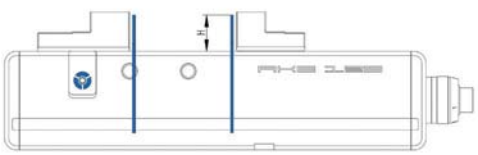
Contents of delivery: Set with 10 different pair of rails and 4 clamps in wooden box

Support rails Cliparc



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

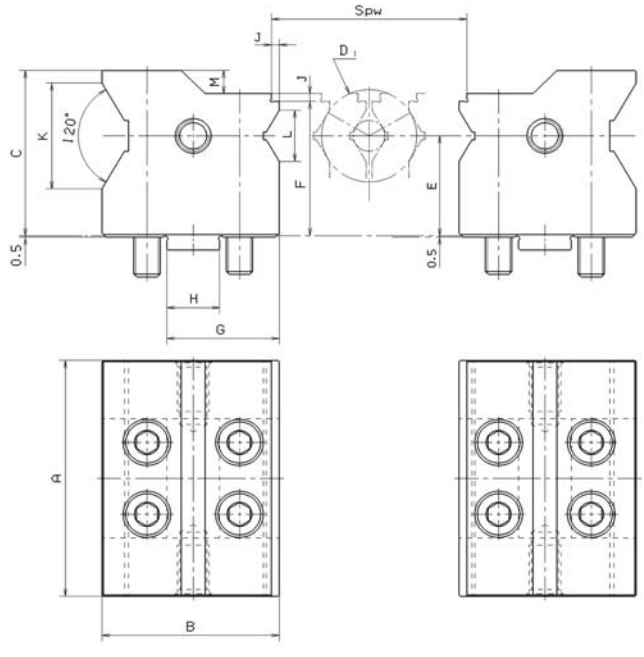






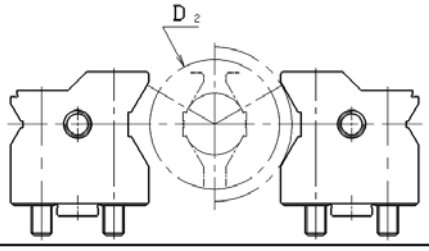
Jaw dimensions

Double V-jaw, reversible, with fine step



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

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



General accessories

A37
Dual clamp DSP, complete, for mutual support in the case of front-sided set-up in pairs



Item no.	Contents of delivery
149125	piece

A37
Single clamp SPE, assembly, for mounting vices on end and on the base



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

A37
Work locator WSA, universally adjustable, for screwing onto the NC-compact clamp or machine vice, connecting thread M12



Item no.	Contents of delivery
320400	piece

A37
Work locator WSA, universally adjustable, for fastening to the machine table (size 14 T-slot) or for screwing onto the NC-compact clamp / machine vice (M12)



Item no.	Contents of delivery
320401	piece

A37
Precision vice locator PSA, universally adjustable, for screwing onto the NC-compact clamp or machine vice, connecting thread M12



Item no.	Contents of delivery
681192	piece

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



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

Clamping jaws

Clamping jaws to screw onto stepped jaws and standard top jaw
Clamping jaws compatible with NC-compact clamps, NC power clamps and machine vices with the same jaw width.

APPLICATION

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

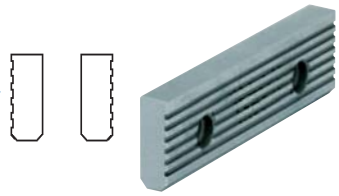


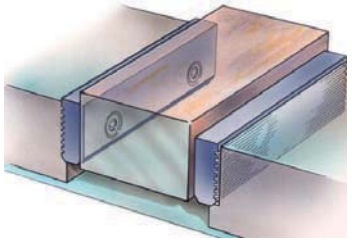
With stepped jaws[1)]



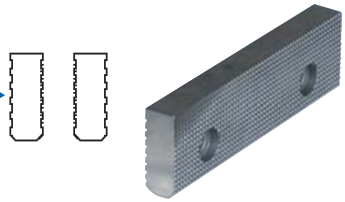
Standard top jaws[1)]

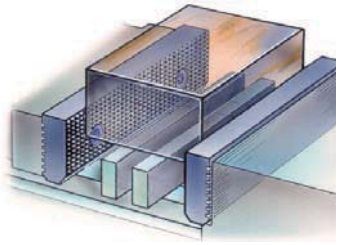
SGN normal jaw – reversible, one side smooth, one side longitudinally
serrated for precise clamping of parallel parts with delicate clamping surfaces.



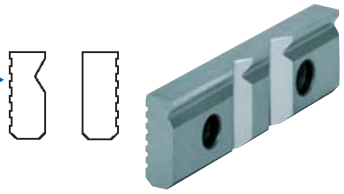


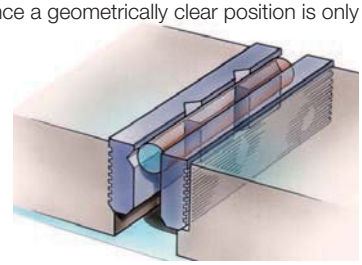
SGN normal jaw, finely checkered– reversible, one side finely checkered, one side longitudinally
serrated to increase the specific surface pressure (high holding force).



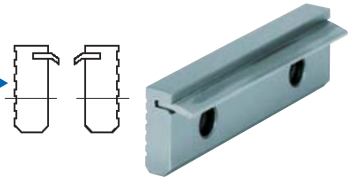


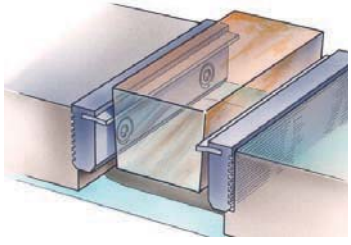
SPR prism jaw
for precise clamping of round material in vertical and horizontal position
The jaws are to be used in combination with a normal jaw, since a geometrically clear position is only achieved with a three-point clamping.



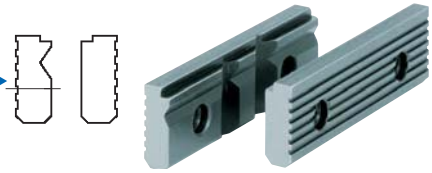


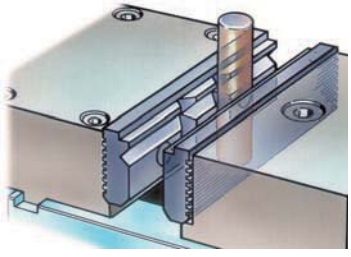
Pull-down jaws with SNF
spring leaf are especially suitable for clamping raw parts
The leaf springs are pressed by the clamping force downwards, thereby causing pull-down force.





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





[1)] not suitable for RZM

Quick change clamping inserts

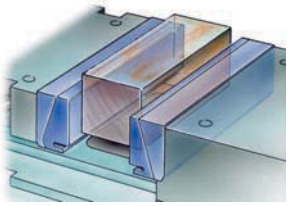
Draw-down base jaws with permanent magnet and quick changeable clamping inserts
Clamping jaw comparable to the NC-compact clamp and machine vices with the same jaw width.



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

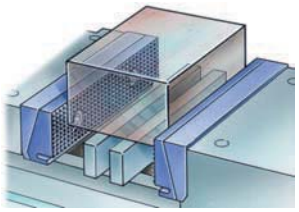
RNS standard insert
for machined workpieces without angle error



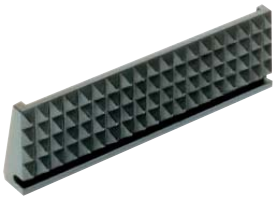


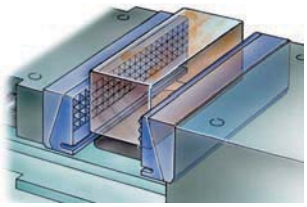
RNS standard insert, finely checkered
to increase the specific surface pressure (higher holding force)





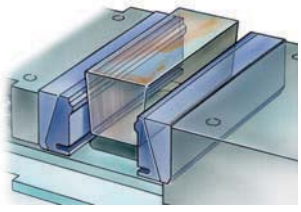
RNK claw insert
to increase the specific surface pressure (higher holding force)





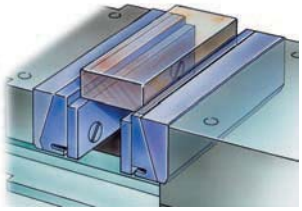
Insert with round RNR clamping base – line-shaped clamping base
for machined workpieces with and without angle error



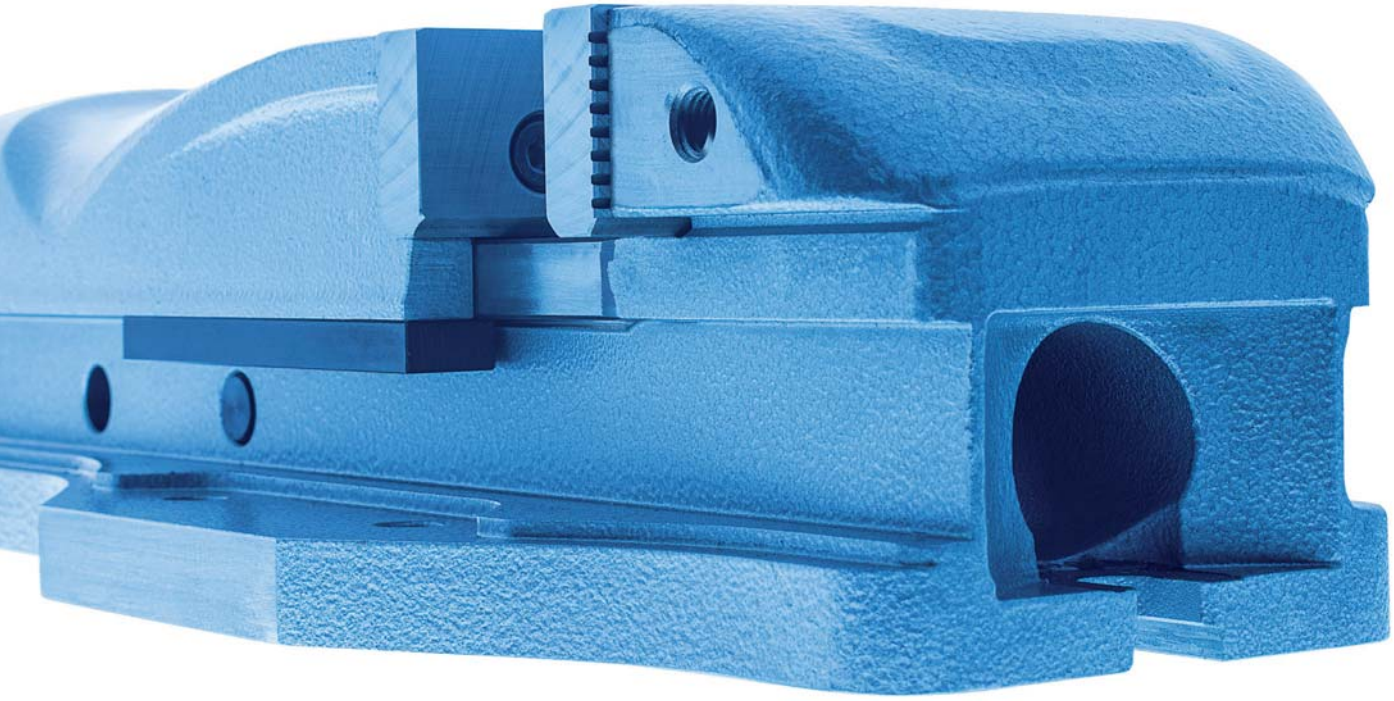


RWA workpiece support
for fastening to the standard inserts. For raising the height of the workpieces during the clamping process.





Other sizes and versions available upon request.



UNIVERSALLY USABLE AND PROVEN MANY TIMES OVER



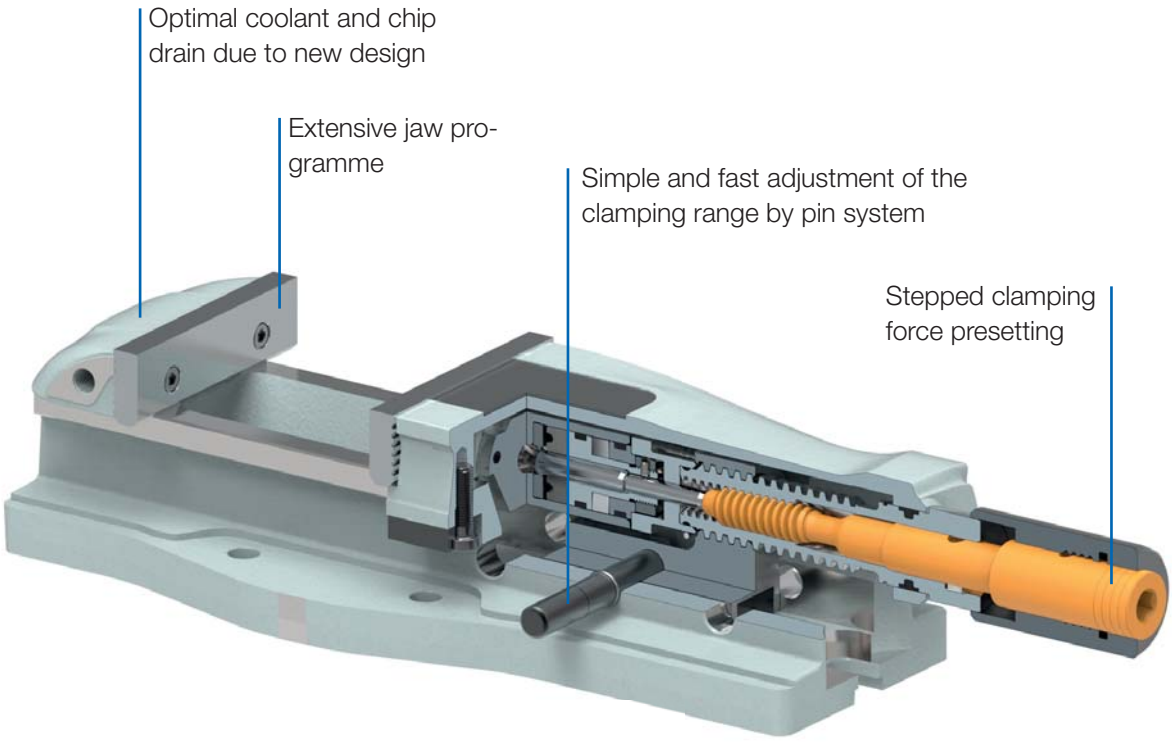
The RÖHM machine vice is suitable for universal application on milling machines and machining centers. The base is equipped with grooves to ensure a precise fastening on the machine table.

MACHINE VICES

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

ADVANTAGES AT A GLANCE

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



RB-K

ORANGE LINE



APPLICATION

For universal use on milling machines and machining centers.

TYPE

Manual clamping system with power amplifier.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

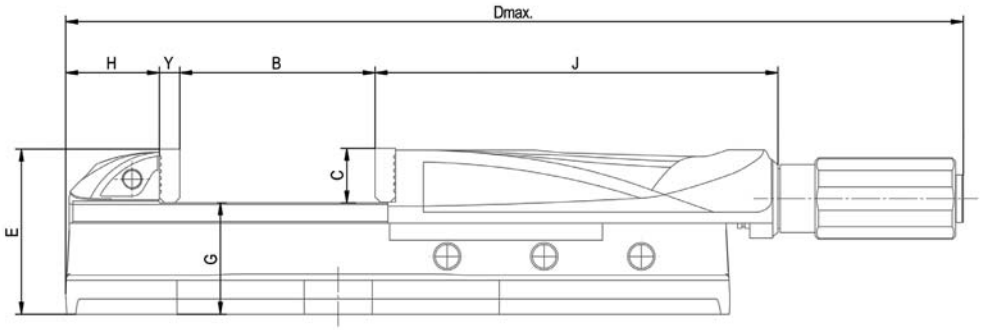
A10
RB-K, with SGN **normal** jaws and hand crank

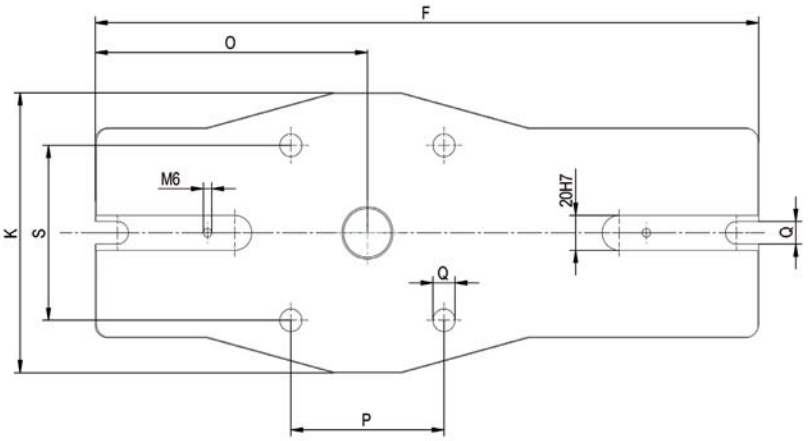
Item no.	179075	179076	179077	179078	179079
Size	1	2	3	4	5
Jaw width A mm	92	113	135	160	200
Clamping capacity B mm	100	170	220	310	350
C mm	31,6	31,6	39,6	49,6	66,6
D mm	490	583	679	817	1022
E mm	91	97	112	133	171
F mm	310	390	468	574	685
G±0,02 mm	59	65,5	72,5	83,5	104,5
H mm	50	55	70	80	90
J mm	218	236,5	262	298	375
K mm	160	160	200	240	280
O mm	115	160	180	220	230
P mm	90	90	90	90	160
Q mm	13	13	13	17	21
S mm	100	100	135	180	180
Y mm	12	12	16	16	20
a mm	63	63	80	100	140
b mm	13,6	13,6	15,6	19,6	23
c	M6	M6	M8	M8	M10
d mm	12	12	13	13	16
Clamping force kN	25	30	40	50	100
Weight kg	15,5	24	39	60	112

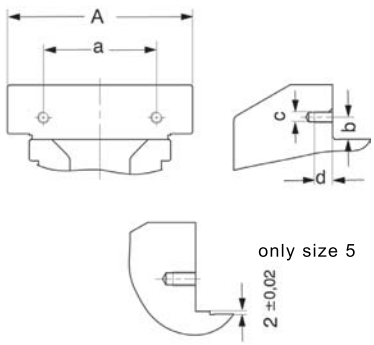
▲ on request

RB-K









Accessories RB-K

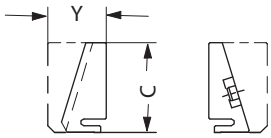
A37
Draw-down jaws RNG, with two permanent magnets



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

A37
Standard insert RNS, held by two permanent magnets

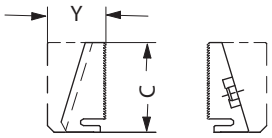




Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242	set	1	92	32	21
155243	set	2	110	32	21
155244	set	3	135	40	26
155245	set	4	160	50	30
155246	set	5	200	67	36

A37
Standard insert, finely checkered RNSf, held by two permanent magnets

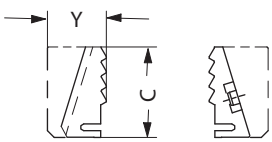




Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163270	set	1	92	32	21
163271	set	2	110	32	21
163272	set	3	135	40	26
163273	set	4	160	50	30
163274	set	5	200	67	36

A37
Claw insert RNK, held by two permanent magnets





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

▲ on request

Accessories RB-K

A37
Insert with round clamping shoulder RNR, held by two permanent magnets



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

A37
Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground



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

A37
Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors



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

A37
Draw-down jaws SNF, with spring plate, hardened and ground



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

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



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

Accessories RB-K

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



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

A37
V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



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

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



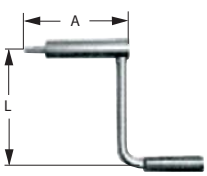
Item no.	Contents of delivery	Size	Width mm	Height mm
150739	piece	2	113	31,6
150740	piece	3	135	39,6
150741	piece	4	160	49,6

A37
Floating jaw horizontal PEB, for clamping non-parallel workpieces



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

A37
Hand crank, turnable handle, hexagon socket

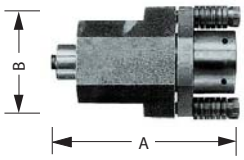


Item no.	Contents of delivery	Size	Hexagon	A	L
134593	piece	1/2	12	48	80
134198	piece	3	12	60	90
134499	piece	4	12	117	90
134600	piece	5	14	104	160

▲ on request

Accessories RB-K

A37
Hydraulic unit HDE



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

A37
Spindle, complete



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

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



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

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



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

RB-M

ORANGE LINE



APPLICATION

For universal use on milling machines and machining centers.

TYPE

Clamping system mechanical without power transmitter, manually operated.

CUSTOMER BENEFITS

- High precision thanks to precise jaw guides
- Fast clamping range adjustment via bolt system
- Optimal coolant and chip drain
- High wear-resistance thanks to hardened jaw guides

TECHNICAL FEATURES

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

A10

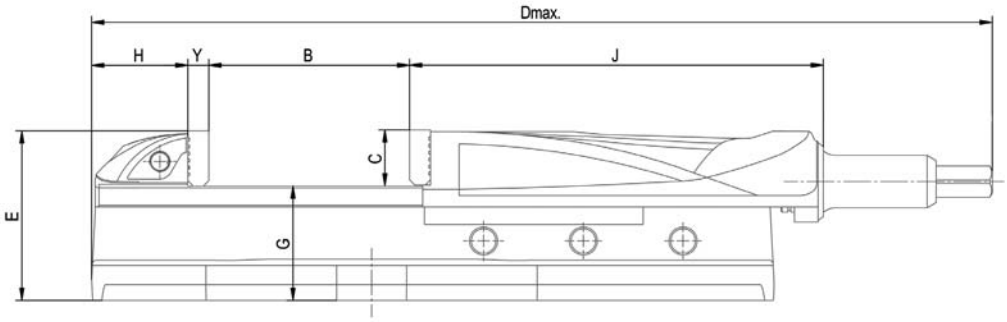
RB-M, with SGN normal jaws and hand crank

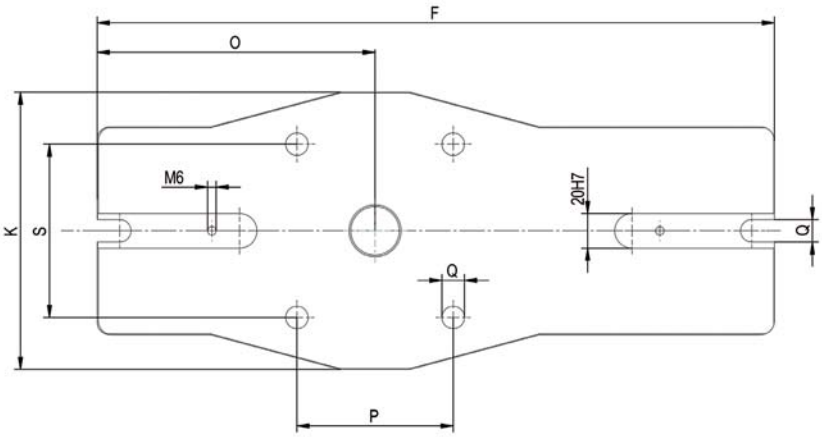
Item no.	179080	179081	179082	179083	179084
Size	1	2	3	4	5
Jaw width A mm	92	113	135	160	200
Clamping capacity B mm	100	185	240	330	370
C mm	31,6	31,6	39,6	49,6	66,6
D mm	420	586	686	860	1015
E mm	91	97	112	133	171
F mm	310	390	468	574	685
G±0,02 mm	59	65,5	72,5	83,5	104,5
H mm	50	55	70	80	90
J mm	218	236,5	262	298	375
K mm	160	160	200	240	280
O mm	115	160	180	220	230
P mm	90	90	90	90	160
Q mm	13	13	13	17	21
S mm	100	100	135	180	180
Y mm	12	12	16	16	20
a mm	63	63	80	100	140
b mm	13,6	13,5	15,6	19,6	23
c	M6	M6	M8	M8	M10
d mm	23	12	13	13	16
Clamping force kN	20	25	35	45	55
Weight kg	15,5	24	39	60	112

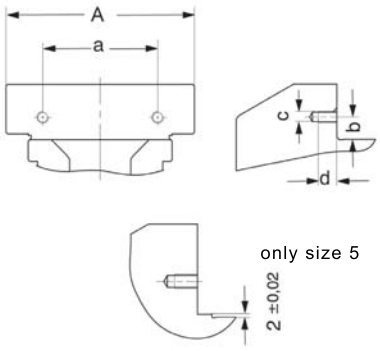
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RB-M









Accessories RB-M

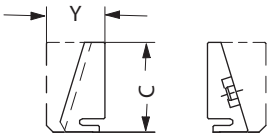
A37
Draw-down jaws RNG, with two permanent magnets



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

A37
Standard insert RNS, held by two permanent magnets

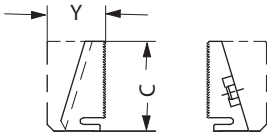




Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242	set	1	92	32	21
155243	set	2	110	32	21
155244	set	3	135	40	26
155245	set	4	160	50	30
155246	set	5	200	67	36

A37
Standard insert finely checkered RNSf, held by two permanent magnets

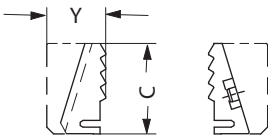




Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163270	set	1	92	32	21
163271	set	2	110	32	21
163272	set	3	135	40	26
163273	set	4	160	50	30
163274	set	5	200	67	36

A37
Claw insert RNK, held by two permanent magnets





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

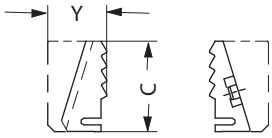
▲ on request

Accessories RB-M

A37
Insert with round clamping shoulder RNR, held by two permanent magnets



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



A37
Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground



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

A37
Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors



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

A37
Draw-down jaws SNF, with spring plate, hardened and ground



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

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



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

Accessories RB-M

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



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

A37
V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



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

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



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

C15
Hand crank HKU, with octagon socket



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

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



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

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



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

▲ on request

Notes

RBA



APPLICATION

For universal use on milling machines and machining centers.

TYPE

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

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

- Sturdy, maintenance-free spindle
- Quickly exchangeable hydraulic unit
- With normal jaws and hand crank
- Locking pin is protected against dirt and chips
- Steel body with stationary clamping jaw
- Blocking mechanism for pre-clamping workpieces
- Automatic reclamping in the hydraulic unit by means of built-in disc springs
- All wear parts, especially the jaw guides, are hardened and ground
- Robust flat-trajectory guide of moving jaw

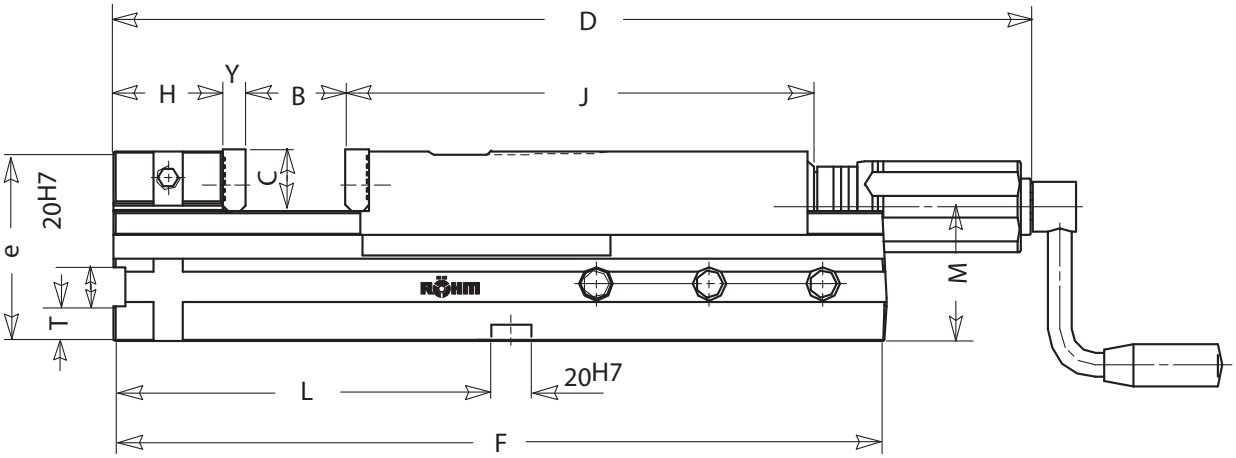
A27
RBA, standard version, with normal jaws SGN and hand crank

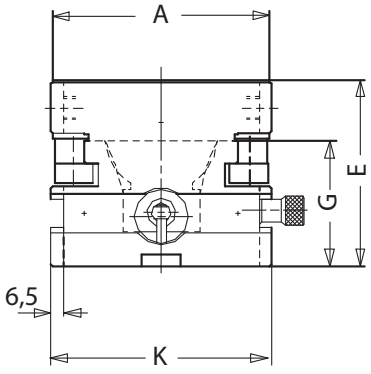
Item no.	153394	153395	153396	153397
Size	1	2	3	4
Jaw width A mm	92	113	135	160
B mm	0-100	0-170	0-220	0-310
B1 mm		0-175	0-225	0-310
B2 mm		125-300	138-363	146-454
B3 mm		199-374	220-445	248-556
C mm	31,6	31,6	39,6	49,6
Dmax mm	490	583	681	817
E±0,02 mm	91,2	97,7	112,7	133,7
F mm	310	390	468	574
G±0,02 mm	59	65,5	72,5	83,5
H±0,02 mm	50	55	70	80
J mm	218	236,5	262	298
K±0,02 mm	94	115	137	162
L±0,02 mm	130	190	190	240
M mm	61,5	68	78	93
T±0,02 mm	12,5	17,5	17,5	22,5
Y-0,01 mm	11,6	11,6	15,6	15,6
a mm	63	63	80	100
b mm	13,6	13,6	15,6	19,6
c mm	M6	M6	M8	M8
d mm	12	12	13	13
e±0,02 mm	89,5	96	111	132
Clamping force kN	25	30	40	50
Weight kg	15,5	24	39	60

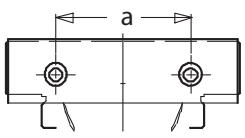
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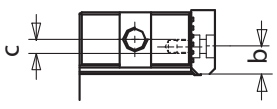
RBA











Accessories RBA

A37
Draw-down jaws SNF, with spring plate, hardened and ground



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

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



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

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



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

A37
V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking capacity mm	
					Horizontal	Vertical
128770	piece	92	92	31,6	3-13	5-32
082362	piece	2a	113	31,6	3-13	5-32
082363	piece	125	135	39,6	4-20	6-40
082364	piece	160	160	49,6	5-29	7-48

A37
V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



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

▲ on request

Accessories RBA

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



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

A37
Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground



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

A37
Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors



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

A37
Stepped top jaw ASB, for stationary jaw



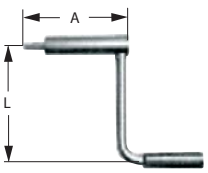
Item no.	Contents of delivery	Size	Width mm	Height mm
153403	piece	2	113	19
153405	piece	3	135	22
153407	piece	4	160	25

A37
Stepped top jaw ASB, for movable jaw



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

A37
Hand crank, turnable handle, hexagon socket



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

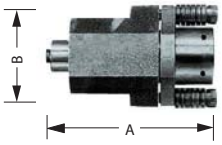
Accessories RBA

A37
Angle drive, for screwing on the moving jaw (the moving jaw must be reworked), for actuating the vice spindle from above (90°)



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

A37
Hydraulic unit HDE



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

A37
Spindle, complete



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

A37
Single clamp SPE, for mounting vices on end and on the base.



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

Notes

RBAW



APPLICATION

For universal use on milling machines and machining centers.

TYPE

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

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

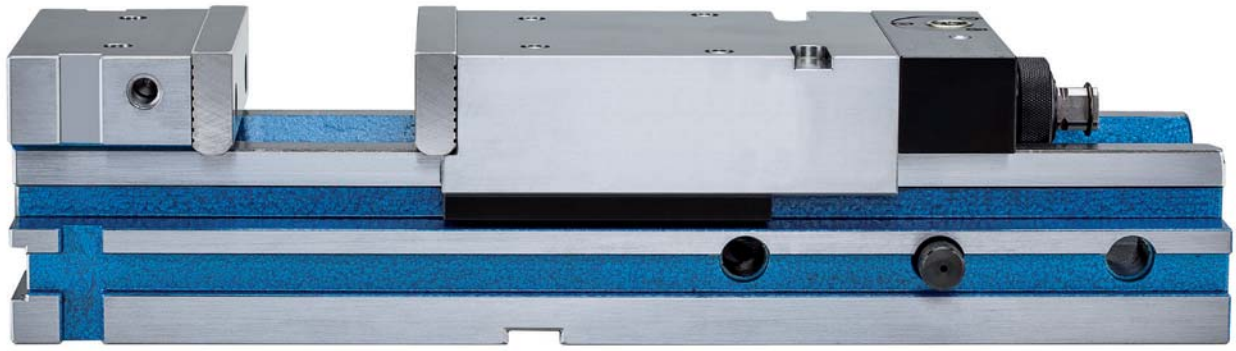
A27

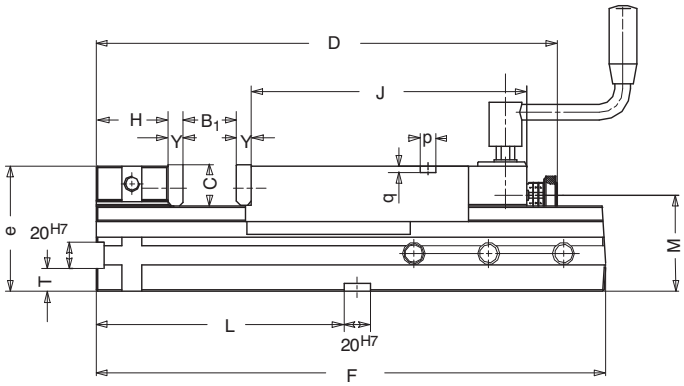
RBAW, with SGN normal jaws, hand crank and angle drive

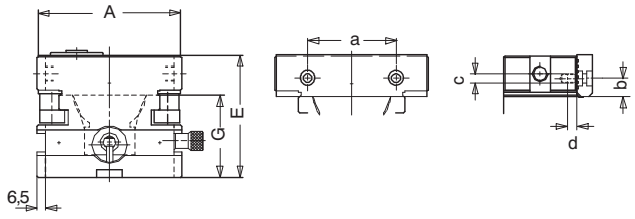
Item no.	154763	154764	154765
Size	2	3	4
Jaw width A mm	113	135	160
B1 mm	0-175	0-225	0-310
B2 mm	125-300	138-363	146-454
B3 mm	199-374	220-445	248-556
C mm	31,6	39,6	49,6
Dmax mm	500	578	702
E±0,02 mm	97,7	112,7	133,7
F mm	390	468	574
G±0,02 mm	65,5	72,5	83,5
H±0,02 mm	55	70	80
J mm	211	213	240
K±0,02 mm	115	137	162
L±0,02 mm	190	190	240
M mm	73,5	80,5	96
T±0,02 mm	17,5	17,5	22,5
Y-0,01 mm	11,6	15,6	15,6
a mm	63	80	100
b mm	13,6	15,6	19,6
c mm	M6	M8	M8
d mm	12	13	13
e±0,02 mm	96	111	132
f mm	82	80	100
g mm	16	30	30
h mm	M 8 x 14	M10x16	M12x20
i mm	63	80	100
k mm	30	30	30
l mm	85	105	120
m mm	30	35	35
n mm	52	70	96
o mm	135	135	142
pH7 mm	12	14	14
q mm	5	5	5
Clamping force kN	30	40	50
Weight kg	22	36	62

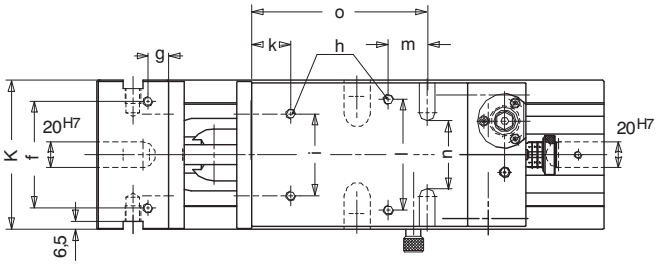
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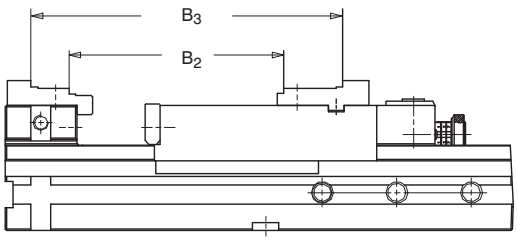
RBAW




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20H7
6,5


B3
B2

Accessories RBAW

A37
Draw-down jaws SNF, with spring plate, hardened and ground



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

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



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

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



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

A37
V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking capacity mm	
					Horizontal	Vertical
082362	piece	2a	113	31,6	3-13	5-32
082363	piece	125	135	39,6	4-20	6-40
082364	piece	160	160	49,6	5-29	7-48

A37
V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



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

▲ on request

Accessories RBAW

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



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

A37
Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground



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

A37
Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors



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

A37
Stepped top jaw ASB, for stationary jaw



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

A37
Stepped top jaw ASB, for movable jaw



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

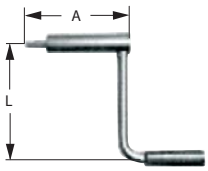
A37
Floating jaw horizontal PEB, for clamping non-parallel workpieces



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

Accessories RBAW

A37
Hand crank, turnable handle, hexagon socket



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

A37
Single clamp SPE, for mounting vices on end and on the base



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

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



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

General accessories

A37
Dual clamp DSP, for mutual support in the case of front-sided set-up in pairs



Item no.	Contents of delivery
149125	piece

A37
Single clamp SPE, assembly, for mounting vices on end and on the base



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

A37
Work locator WSA, universally adjustable, for screwing onto the NC-compact clamp or machine vice, connecting thread M12



Item no.	Contents of delivery
320400	piece

A37
Work locator WSA, universally adjustable, for fastening to the machine table (size 14 T-slot) or for screwing onto the NC-compact clamp / machine vice (M12)



Item no.	Contents of delivery
320401	piece

A37
Precision vice locator PSA, universally adjustable, for screwing onto the NC-compact clamp or machine vice, connecting thread M12



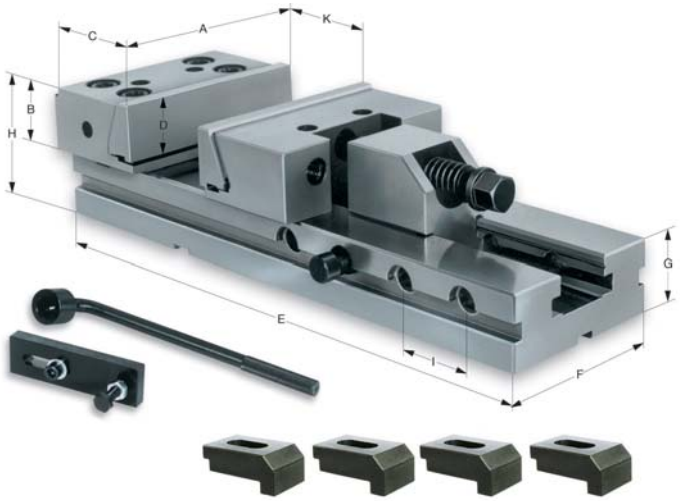
Item no.	Contents of delivery
681192	piece

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



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

MSR



APPLICATION

For universal use on milling machines and machining centers.

TYPE

Clamping system mechanical without power transmitter, manually operated.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

A11
MSR, with draw-down jaws

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

▲ on request

Accessories MSR

A37
Step jaw SB, for stationary jaw



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

A37
Step jaw SB, for movable jaw



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

A37
V-jaw PB with jaw steps, for movable jaw



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

A37
Inclinde jaw WB (for circular parts), for movable jaw



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

A37
Single clamp SPE



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

A37
Rotation plate DP



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

RS



APPLICATION

For conventional machine tools.

TYPE

Clamping system mechanical without power transmitter, manually operated.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

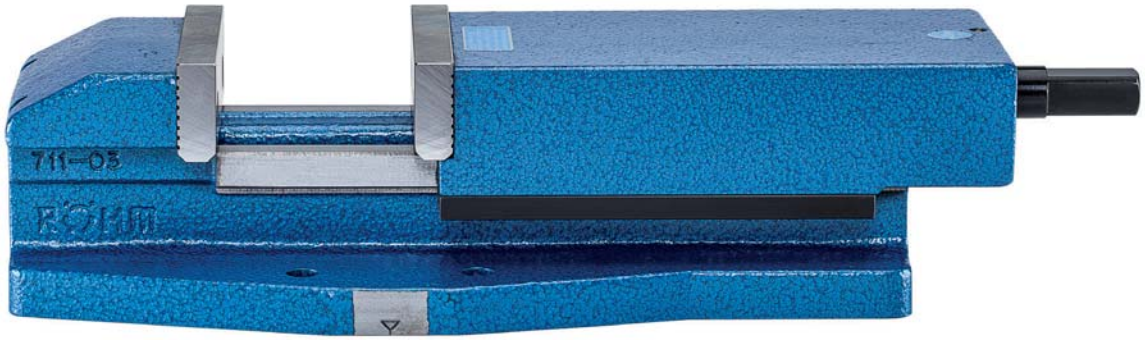
- Made of special cast iron for versatile use
- Long guidance of moving jaw
- Force transfer by means of threaded spindle
- With normal jaws SGN and handcrank
- Use on rotary plate with graduation

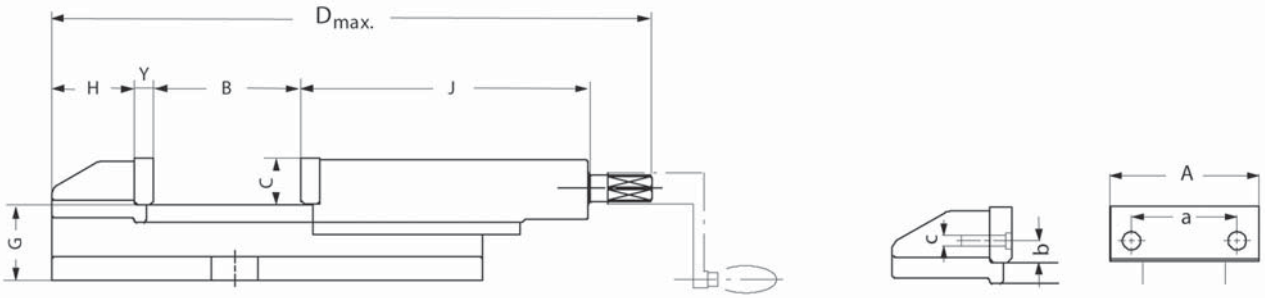
A11

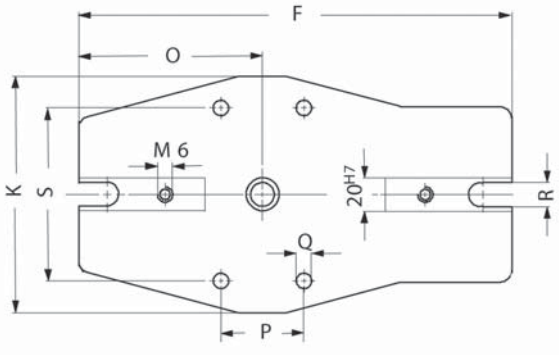
RS, with SGN normal jaws and hand crank

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

RS







Accessories RS

A37
Draw-down jaws SNF, with spring plate, hardened and ground



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

A37
Standard jaws SGN, one side smooth, one side grooved, hardened and ground



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

[1] both sides ground

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



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

A37
V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking capacity mm	
					Horizontal	Vertical
128770	piece	92	92	31,6	3-13	5-32
082362	piece	2a	113	31,6	3-13	5-32
082363	piece	125	135	39,6	4-20	6-40
082364	piece	160	160	49,6	5-29	7-48
082365	piece	200	200	62,6	6-37	8-56

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



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

▲ on request

Accessories RS

C15
Hand crank HKU, with octagon socket



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

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



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

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



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

UZ



APPLICATION

For conventional machine tools.

TYPE

Centric clamping system mechanical without power transmitter, manually operated.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

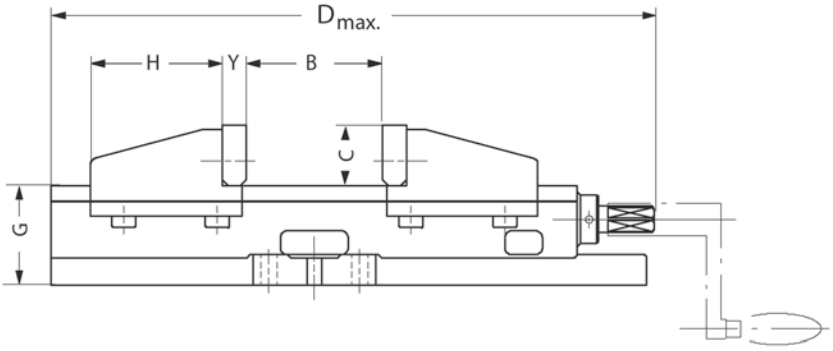
A11
UZ, self-centering vice

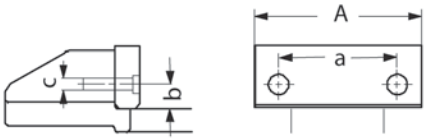
Item no.	014523	014740	014752	014802	014807
Size	2	3	4	5	6
Jaw width A mm	113	135	160	200	250
B mm	110	140	180	300	400
C mm	31,6	39,6	49,6	62,6	62,6
D mm	358	408	495	655	767
F mm	344	394	480	640	751
G mm	61	65,5	74	79	85
J mm	81	87	107	123	123
K mm	132	152	180	200	220
O mm	149	174	214	294	344
P mm	50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

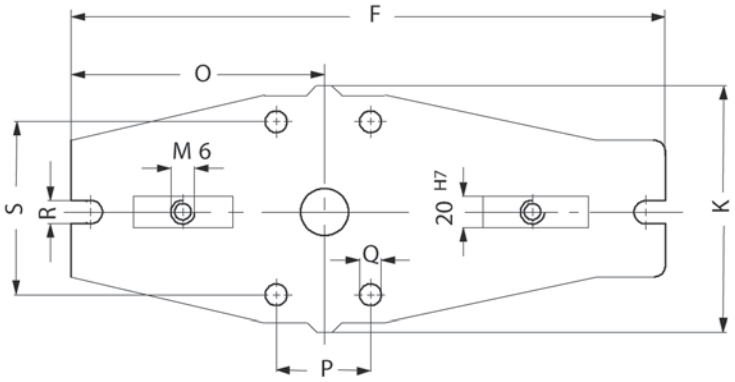
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UZ









Accessories UZ

A37
Draw-down jaws SNF, with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
077103	set	2	90	24,6
077104	set	2a	113	31,6
077105	set	125	135	39,6
077106	set	160	160	49,6
077107	set	200	200	62,6

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



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

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



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

A37
V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking capacity mm	
					Horizontal	Vertical
082361	piece	2	90	24,6	3-13	5-32
082362	piece	2a	113	31,6	3-13	5-32
082363	piece	125	135	39,6	4-20	6-40
082364	piece	160	160	49,6	5-29	7-48
082365	piece	200	200	62,6	6-37	8-56
082366	piece	6	250	62,6	7-45	9-65

A37
V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



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

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



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

▲ on request

Accessories UZ

C15
Hand crank HKU, with octagon socket



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

General accessories

A37
Work locator WSA, universally adjustable, for fastening to the machine table (size 14 T-slot) or for screwing onto the NC-compact clamp / machine vice (M12)

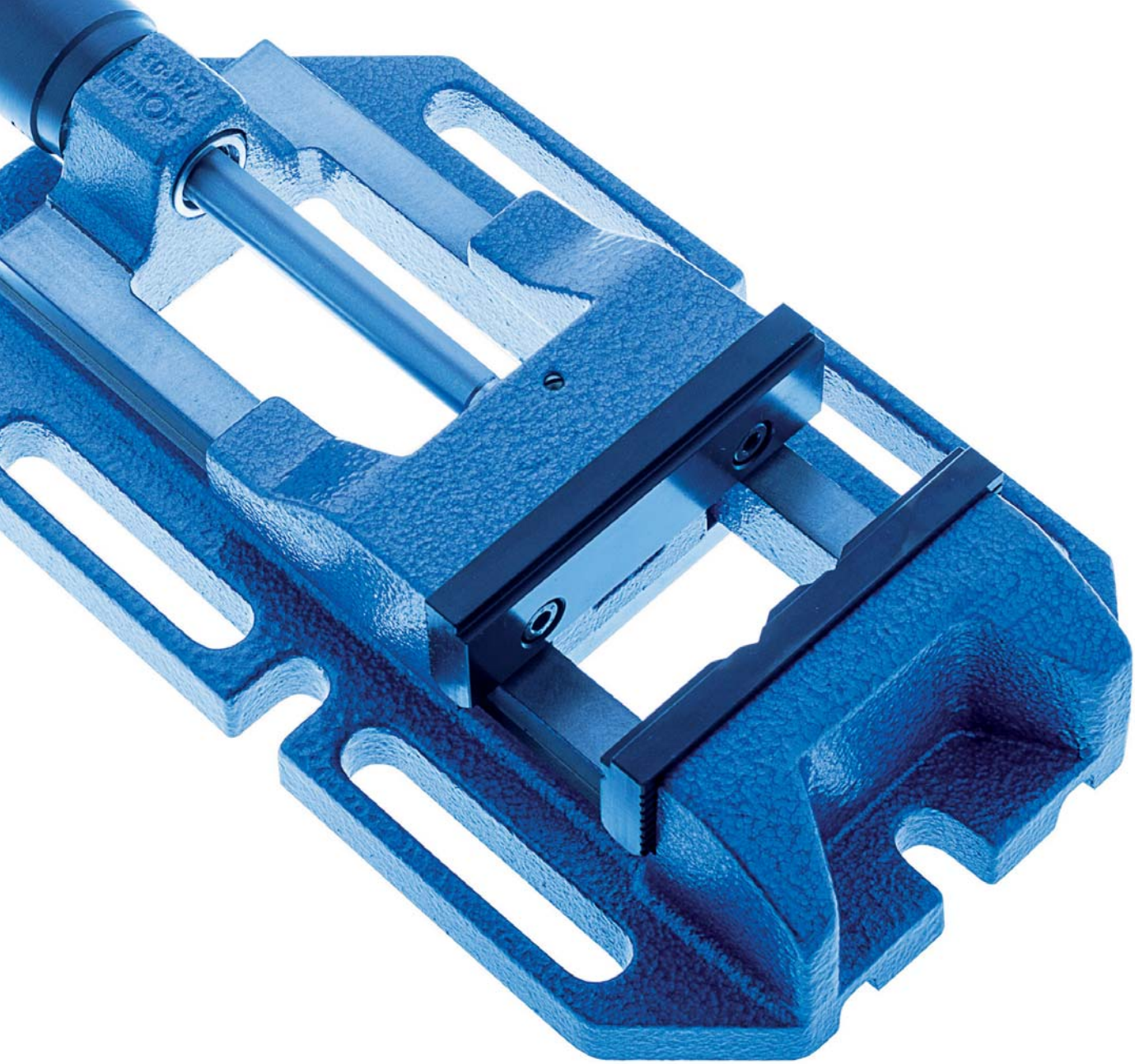


Item no.	Contents of delivery
320401	piece

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



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



IDEAL FOR DRILLING AND MEASURING MACHINES



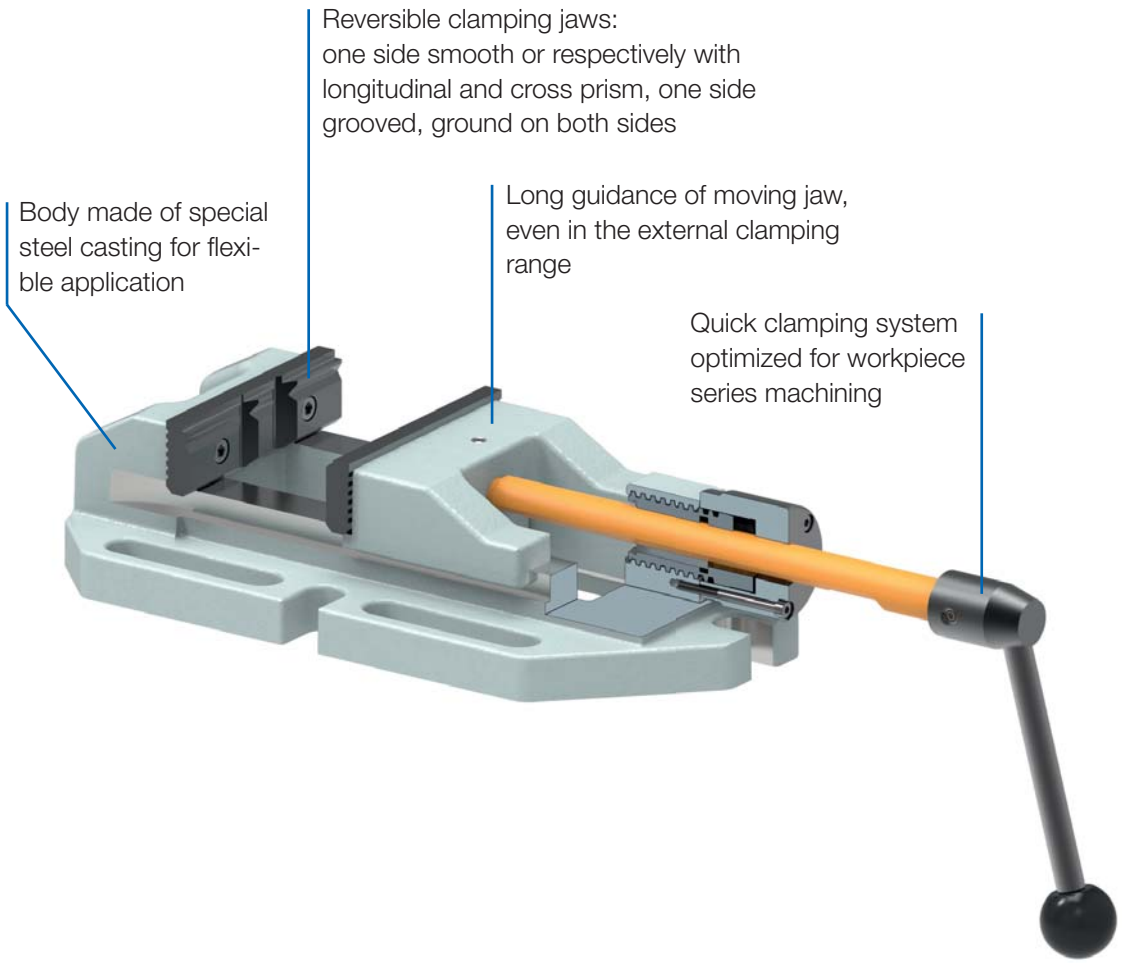
For decades, RÖHM drilling machine vices have been enabling reliable and quick clamping of workpieces on drilling and measuring machines. The entire clamping range can be set by one-handed turning.

DRILLING MACHINE VICES

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

ADVANTAGES AT A GLANCE

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



BMS



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

Clamping system mechanical, manually operated.
Standard version.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

- Body made out of special steel casting
- Positive locking

A12
BSS, with V-jaw and normal jaw SBO

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



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

Clamping system mechanical, manually operated.
Standard version.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

- Body made out of special steel casting
- Low, stable design with thread spindle
- Both jaws with support surface for clamping flat workpieces

A12
BOF, with V-jaw and normal jaw SBO

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

▲ on request

BMS



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

D. I. Y. design for small drill stands.
Clamping system mechanical, manually operated.

CUSTOMER BENEFITS

- Lever movable
- Both jaws with support surface for clamping flat workpieces

TECHNICAL FEATURES

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

A12
BSH, small, light D.I.Y. design

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



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

Sturdy version for drill stands, table drills and box column drills.
Clamping system mechanical, manually operated.

CUSTOMER BENEFITS

- Long lever for maximal clamping force
- Both jaws with support surface for clamping flat workpieces

TECHNICAL FEATURES

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

A12
BSH, sturdy craftsman design

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

BMS



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

Clamping system mechanical, manually operated.
Standard version.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

A12
DPV, with V-jaw and normal jaw SBO

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



APPLICATION

For securely clamping workpieces on drills and measuring machines.

TYPE

Clamping system mechanical, manually operated.
Standard version.
3 set-up options thanks to two additional, perpendicularly machined support surfaces: bottom, right and front.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

A12
DPV 3-W, with V-jaw and normal jaw SBO

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

▲ on request

Accessories BMS

A37
V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



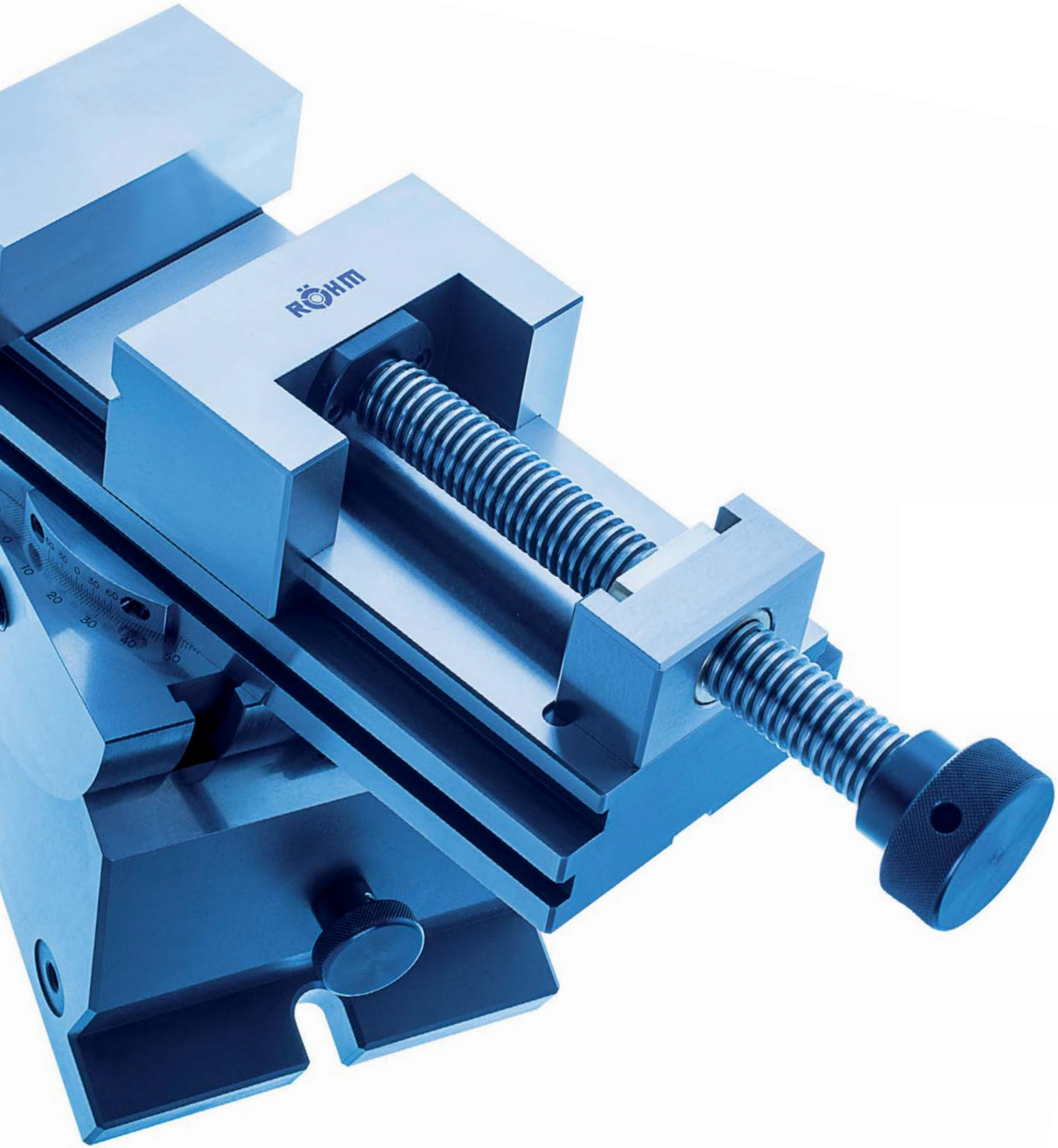
Item no.	Contents of delivery	Size	Width mm	Height mm	Chucking capacity mm	
					Horizontal	Vertical
332714	set	1	90	24,8	4-17	4-25
317259	set	2	110	31,8	3-12	5-32
317260	set	3	135	39,8	3-13	6-40
317261	set	4	160	49,8	5-22	7-48

A37
V-jaw and standard jaw SBO, soft and gunmetal-finished, with work support, for DPV



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

[1] only for DPV 3-W

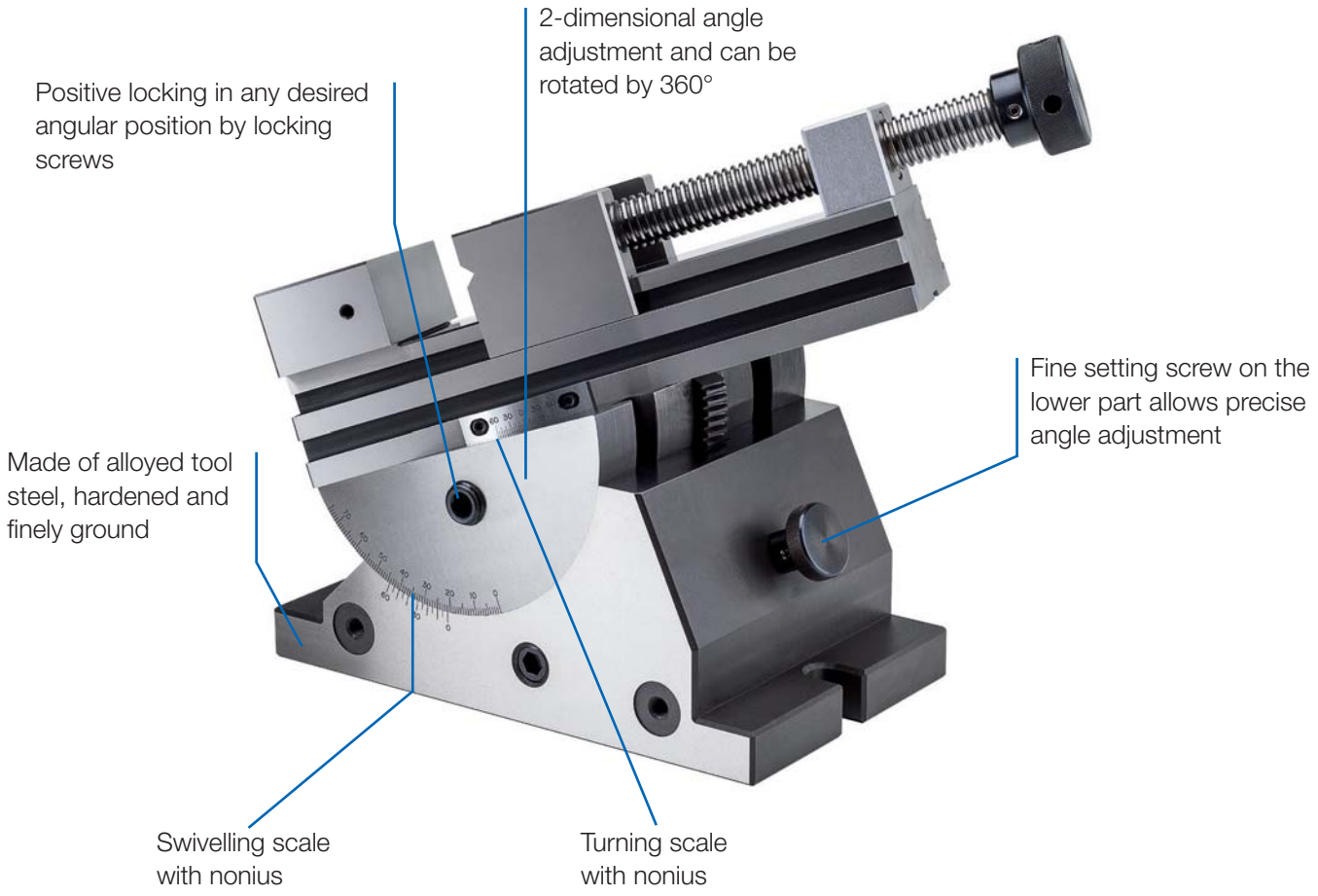

ROHM

GRINDING AND INSPECTION VICES

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

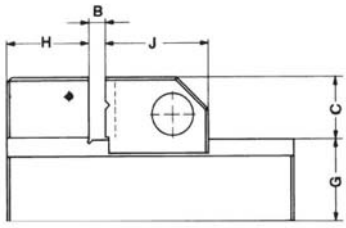
ADVANTAGES AT A GLANCE

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



Grinding and inspection vice





APPLICATION

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

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

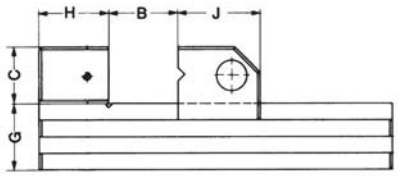
A29

PL-S micro, with quick adjustment

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

[1] Base to stationary jaw clamping surface
[2] Base to upper guide edge





APPLICATION

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

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

A29

PL-S, with quick adjustment

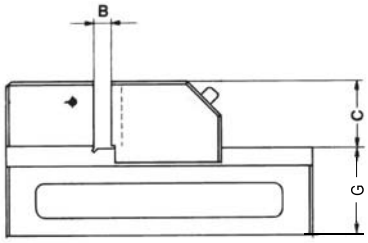
Item no.	Size	Squareness [1] / 100 mm	Parallelism [2] / 100 mm	Jaw width mm	B mm	Total heigth mm	C mm	Length body mm	G mm	H mm	J mm	Work locator	Weight kg
1179516	1	0,005	0,002	70	80	62	30	160	32	33	45	M6	3
1179517	2	0,005	0,002	90	120	80	40	210	40	40	50	M5	5,8
1179518	3	0,005	0,002	120	150	90	40	280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

[1] Base to stationary jaw clamping surface
[2] Base to upper guide edge

▲ on request

Grinding and inspection vice





APPLICATION

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

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

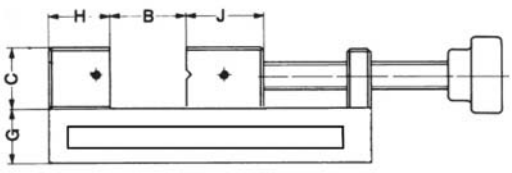
- With draw-down effect
- Made of alloyed tool steel, hardened and very finely ground
- Horizontally and vertically ground prism
- No spindle which could cause contamination during electric discharge machining, for example

A29
PLF, with quick adjustment in gauge accuracy

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

[1] Base to stationary jaw clamping surface
[2] Base to upper guide edge





APPLICATION

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

CUSTOMER BENEFITS

- Clamping and unclamping with threaded spindle

TECHNICAL FEATURES

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

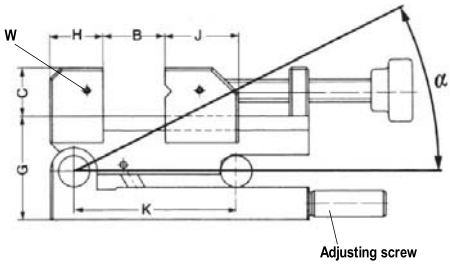
A29
PL-G

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

[1] Base for stationary jaw clamping surface
[2] Base for upper guide edge

Grinding and inspection vice





APPLICATION

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

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

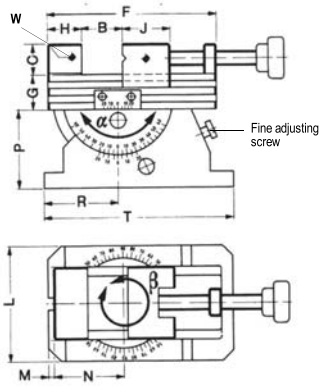
- Made of alloyed tool steel, hardened and very finely ground
- Horizontally and vertically ground prism

A29

PS-SV, front swivelling axis

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





APPLICATION

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

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

A29

PS-ZD, 2-dimensional

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

Stationary power clamping devices



KZS-P

APPLICATION
Optimally suitable for rational clamping in automated work procedures.

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

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



KZS-PG

APPLICATION
Optimally suitable for rational clamping in automated work procedures.

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

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



SSP

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

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

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

Power-Grip zero-point clamping system





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

ADVANTAGES AT A GLANCE

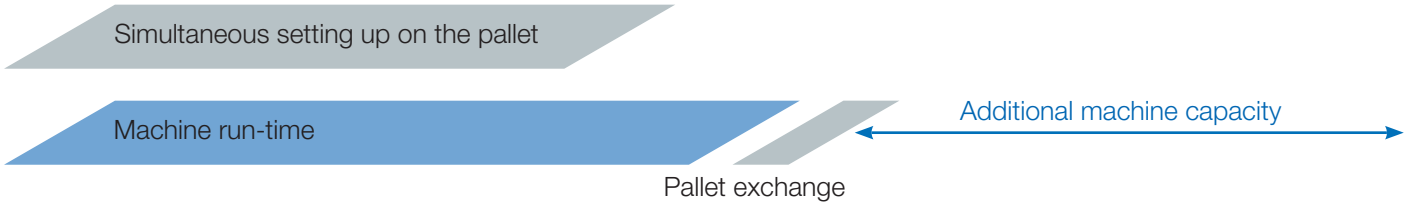
- Increase in productivity thanks to set-up time reduction up to 90%
- Maximum precision and repeatability of 0.002 mm
- Palletizing and clamping device from one source

SET-UP TIME REDUCTION BY UP TO 90%

Without palletising system



With Power-Grip zero point clamping system



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driven by technology

Id.-Nr. 1178264 / 0915 AU



AUTOMATION TECHNOLOGY

2015/2016

RÖHM
driven by technology

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

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

Dynamism
Variety
Security
Partnership
Globality
Innovation

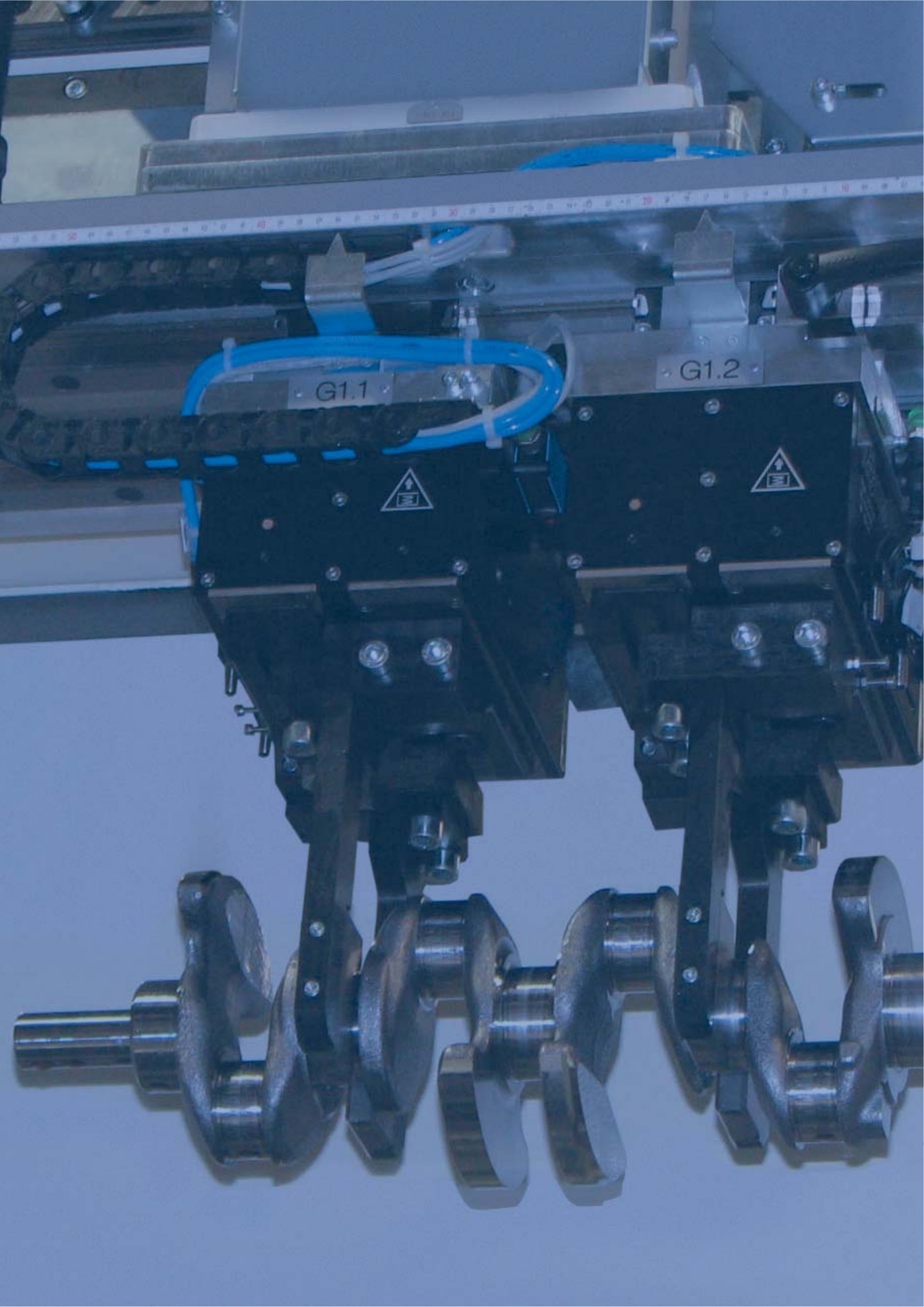

G1.1
G1.2



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AUTOMATION TECHNOLOGY

2-jaw parallel grippers

RPP 5006
RPP-A 5028

3-jaw centric grippers

RZP 5046
RZP-A 5064

2-jaw long stroke grippers

RGP 5080
RGPO 5090

Application-specific grippers

RDPP - Sealed parallel grippers 5098
RPR - Compact long stroke grippers 5098

Synthetic grippers

RRMG 5102

Swivel Units

RSP-Flex 5108

Errors and corrections are reserved!

Operation guide






TYPE	RPP	RPP-A	RZP	RZP-A
	2-jaw parallel gripper		3-jaw centric gripper	
Gripping force	208 - 21900 N	240 - 3450 N	650 - 38000 N	700 - 16500 N
Stroke per jaw	2 - 45 mm	2 - 16 mm	3 - 35 mm	3 - 16 mm
Gripping type				
Clamping type				
Gripping force safety device				
Actuation	optional	optional		
Page	5006	5028	5046	5064

hydraulical actuated

pneumatical actuated

external gripping

internal gripping

parallel gripping

centric gripping

Operation guide

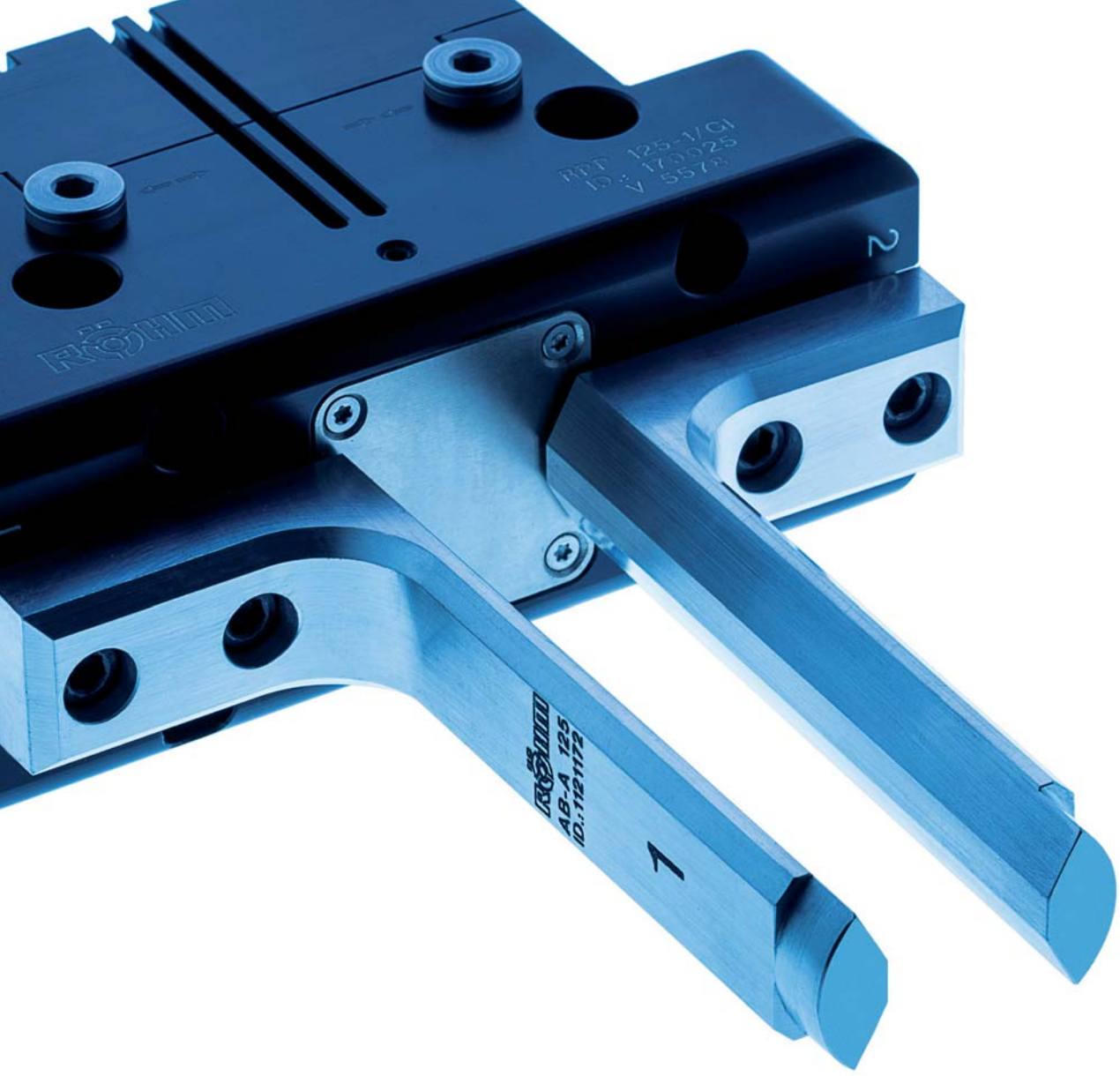





TYPE	RGP	RGPO	RPR	RRMG
	2-jaw long stroke gripper			Synthetic gripper
Gripping force	630 - 2950 N	1250 - 3000 N	260 - 1100 N	80 - 150 N
Stroke per jaw	30 - 50 mm	60 - 100 mm	14 - 28 mm	2,6 - 4,3 mm
Gripping type				
Clamping type				
Gripping force safety device			-	Optional
Actuation		 optional		
Page	5080	5090	5098	5102

 gripping force safety device external gripping

 gripping force safety device internal gripping



NOMENCLATURE

RPP	-A	- 100	-1	/ GA	/ V
RÖHM **P**arallel gripper **P**neumatic	**A =** Alternative jaw fixture by tongue and groove	**Sizes** 50 - 380	Jaw stroke variant **1** = long stroke **2** = short stroke	Optional: Spring safety **GA** = outside grip **GI** = inside grip	Optional: **V** = Viton FKM-sealing for temperatures up to 150 °C

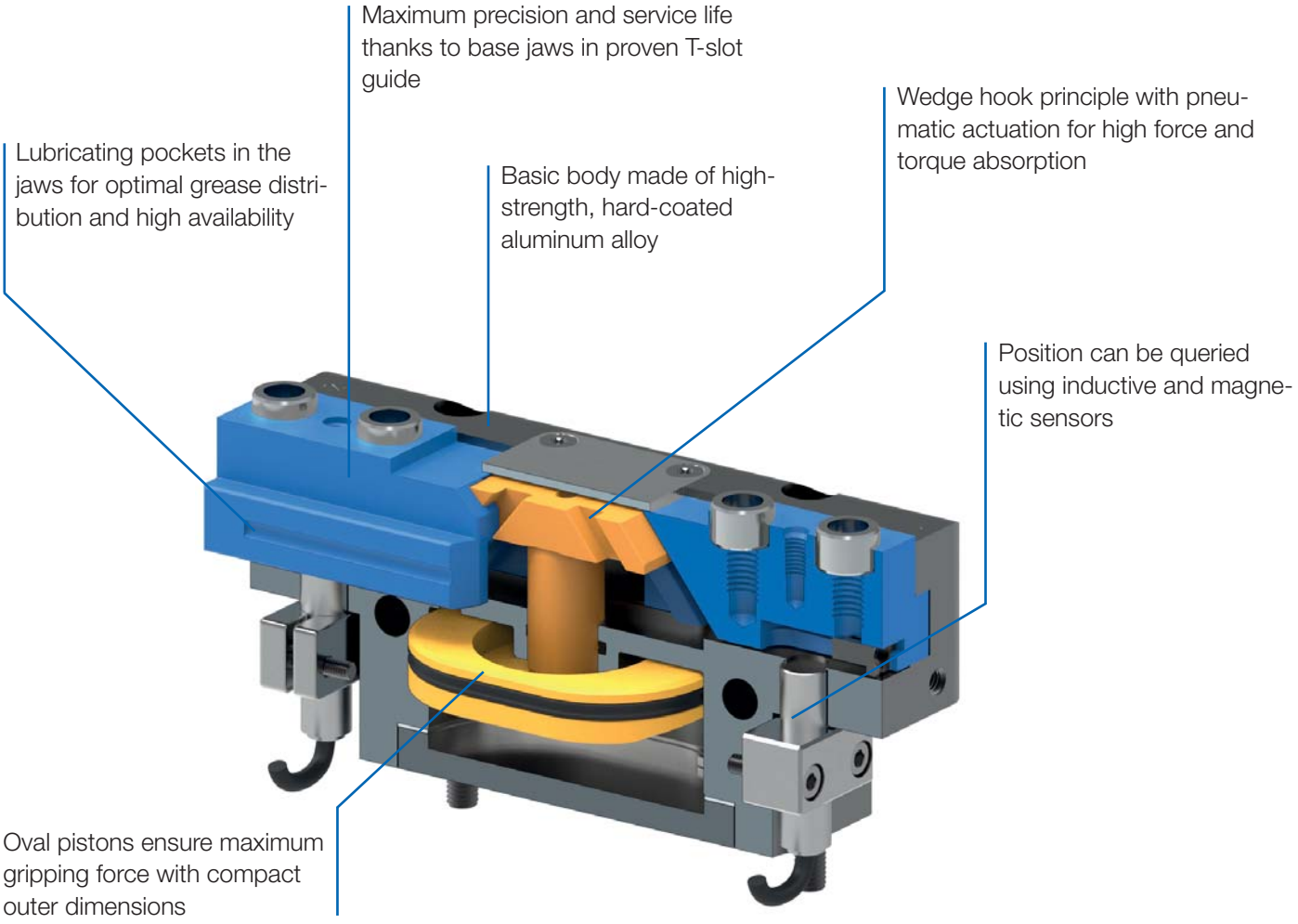
Video RPP

2-JAW PARALLEL GRIPPER

Equipped with two parallel gripper fingers, RÖHM grippers are optimally suited for universal gripping of round and angular workpieces. Especially on robots or portals, the 2-jaw parallel grippers will convince you with their compact design, low own weight and high gripping force.

ADVANTAGES AT A GLANCE

- High gripping force with low own weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide



RPP-50



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 380, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-50 - 2-jaw parallel gripper air operated

Item no.	170119	170120 ▲	170121	170122 ▲	170123 ▲	170124 ▲
Design	RPP-50-1	RPP-50-2	RPP-50-1/GA	RPP-50-2/GA	RPP-50-1/GI	RPP-50-2/GI
Gripping force at 6 bar N	208	398	242	462	264	505
Stroke per jaw mm	4	2	4	2	4	2
Gripping force maintained N	-	-	35	65	35	65
Recommended workpiece weight kg	0,7	1,45	0,7	1,45	0,7	1,45
Weight kg	0,19	0,19	0,23	0,23	0,23	0,23
Width mm	65	65	65	65	65	65
Height mm	31	31	47	47	47	47
Depth mm	30	30	30	30	30	30
Mx Nm	20	20	20	20	20	20
My Nm	25	25	25	25	25	25
Mz Nm	10	10	10	10	10	10
Fz N	500	500	500	500	500	500
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,02	0,02	0,02	0,02	0,03	0,03
Opening time s	0,02	0,02	0,03	0,03	0,02	0,02
Air consumption per cycle cm^3	5	5	5	5	5	5
Max. allowable length of jaw mm	64	64	64	64	64	64

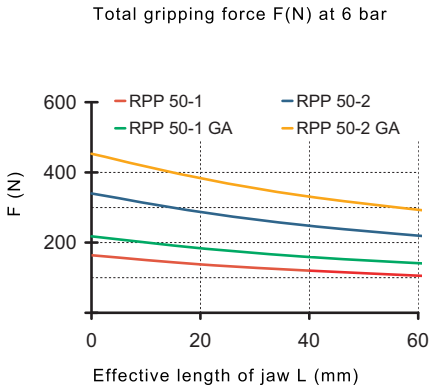
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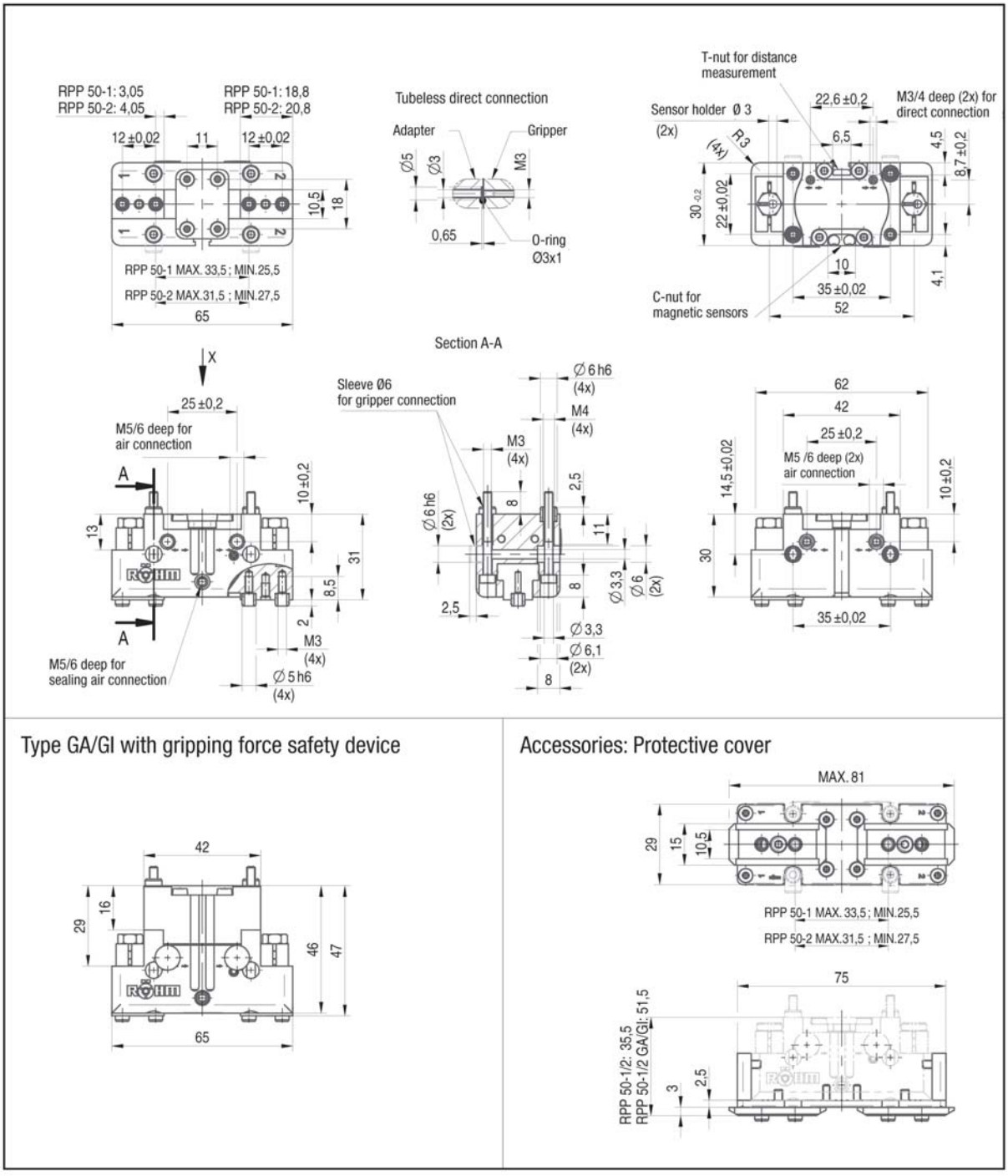
RPP-50

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Type GA/GI with gripping force safety device

Accessories: Protective cover

RPP-64



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 380, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-64 - 2-jaw parallel gripper air operated

Item no.	170001	170002 ▲	170003	170004 ▲	170005 ▲	170006 ▲
Design	RPP-64-1	RPP-64-2	RPP-64-1/GA	RPP-64-2/GA	RPP-64-1/GI	RPP-64-2/GI
Gripping force at 6 bar N	316	605	458	876	487	932
Stroke per jaw mm	6	3	6	3	6	3
Gripping force maintained N	-	-	100	200	100	200
Recommended workpiece weight kg	1,5	3	1,5	3	1,5	3
Weight kg	0,3	0,3	0,4	0,4	0,4	0,4
Width mm	76	76	76	76	76	76
Height mm	39	39	57	57	57	57
Depth mm	36	36	36	36	36	36
Mx Nm	40	40	40	40	40	40
My Nm	60	60	60	60	60	60
Mz Nm	40	40	40	40	40	40
Fz N	1100	1100	1100	1100	1100	1100
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,03	0,03	0,02	0,02	0,04	0,04
Opening time s	0,03	0,03	0,04	0,04	0,02	0,02
Air consumption per cycle cm^3	10	10	10	10	10	10
Max. allowable length of jaw mm	90	85	85	80	85	80

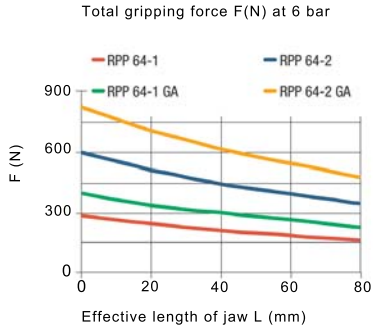
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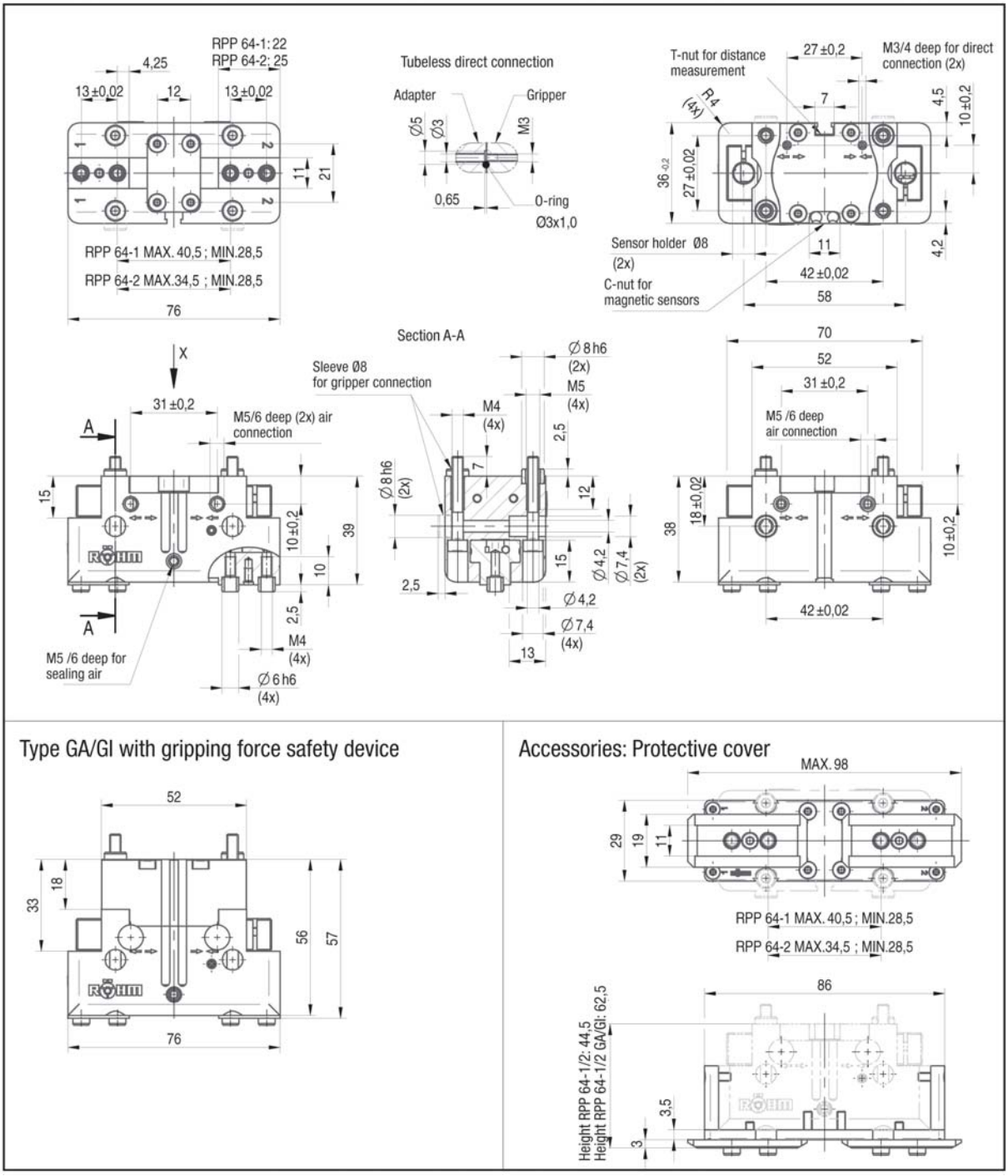
RPP-64

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Type GA/GI with gripping force safety device

Accessories: Protective cover

RPP-80



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 380, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-80 - 2-jaw parallel gripper air operated

Item no.	170007	170008 ▲	170009	170010 ▲	170011 ▲	170012 ▲
Design	RPP-80-1	RPP-80-2	RPP-80-1/GA	RPP-80-2/GA	RPP-80-1/GI	RPP-80-2/GA
Gripping force at 6 bar N	470	886	615	1156	657	1236
Stroke per jaw mm	8	4	8	4	8	4
Gripping force maintained N	-	-	160	300	160	300
Recommended workpiece weight kg	2,2	4,3	2,2	4,3	2,2	4,3
Weight kg	0,5	0,5	0,6	0,6	0,6	0,6
Width mm	96	96	96	96	96	96
Height mm	49	49	67	67	67	67
Depth mm	42	42	42	42	42	42
Mx Nm	60	60	60	60	60	60
My Nm	95	95	95	95	95	95
Mz Nm	55	55	55	55	55	55
Fz N	1500	1500	1500	1500	1500	1500
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,04	0,04	0,03	0,03	0,05	0,05
Opening time s	0,04	0,04	0,05	0,05	0,03	0,03
Air consumption per cycle cm^3	21	21	21	21	21	21
Max. allowable length of jaw mm	110	105	105	100	105	100

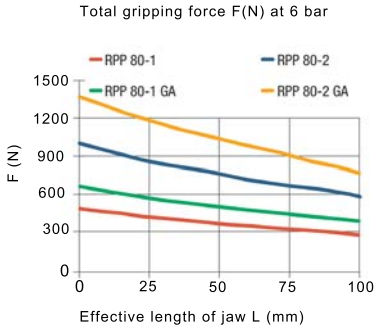
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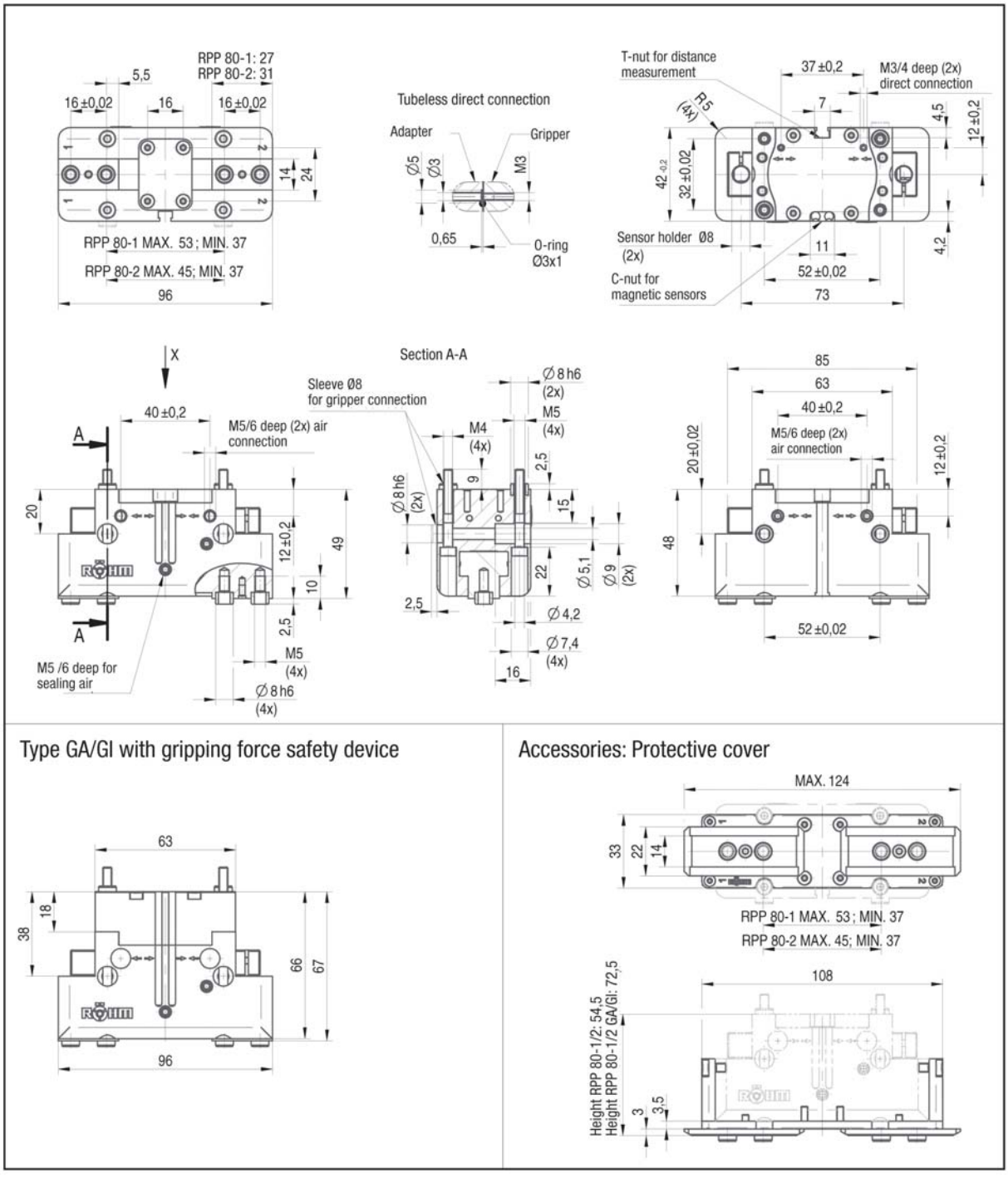
RPP-80

Max. load on gripper and jaw



Clamping force diagram exterior gripping





RPP-100



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 380, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-100 - 2-jaw parallel gripper air operated

Item no.	170013	170014	170015	170016	170018 ▲	170019 ▲
Design	RPP-100-1	RPP-100-2	RPP-100-1/GA	RPP-100-2/GA	RPP-100-1/GI	RPP-100-2/GI
Gripping force at 6 bar N	830	1570	981	1857	1044	1977
Stroke per jaw mm	10	5	10	5	10	5
Gripping force maintained N	-	-	260	500	260	450
Recommended workpiece weight kg	3,5	7	3,5	7	3,5	7
Weight kg	0,8	0,8	1	1	1	1
Width mm	120	120	120	120	120	120
Height mm	55	55	81	81	81	81
Depth mm	50	50	50	50	50	50
Mx Nm	80	80	80	80	80	80
My Nm	115	115	115	115	115	115
Mz Nm	70	70	70	70	70	70
Fz N	2000	2000	2000	2000	2000	2000
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,07	0,07	0,05	0,05	0,09	0,09
Opening time s	0,07	0,07	0,09	0,09	0,05	0,05
Air consumption per cycle cm^3	40	40	40	40	40	40
Max. allowable length of jaw mm	145	135	135	125	135	125

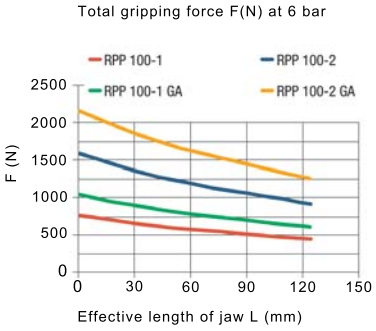
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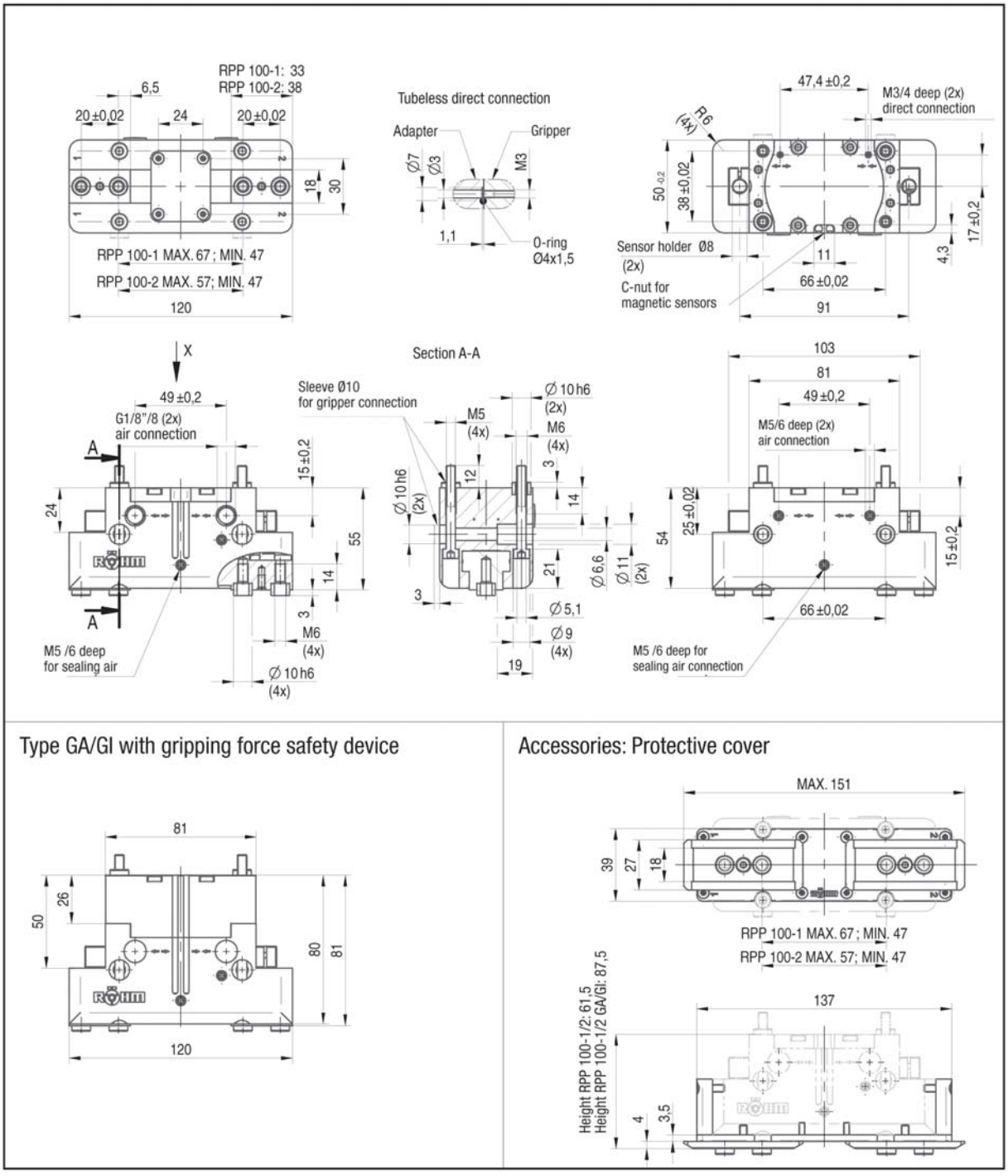
RPP-100

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Type GA/GI with gripping force safety device

Accessories: Protective cover

RPP-125



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 380, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-125 - 2-jaw parallel gripper air operated

Item no.	170020	170021	170022	170023	170025	170026
Design	RPP-125-1	RPP-125-2	RPP-125-1/GA	RPP-125-2/GA	RPP-125-1/GI	RPP-125-2/GI
Gripping force at 6 bar N	1243	2500	1568	3162	1625	3277
Stroke per jaw mm	13	6	13	6	13	6
Gripping force maintained N	-	-	350	750	350	750
Recommended workpiece weight kg	6,2	12,5	6,2	12,5	6,2	12,5
Weight kg	1,5	1,5	1,9	1,9	1,9	1,9
Width mm	151	151	151	151	151	151
Height mm	63	63	93	93	93	93
Depth mm	60	60	60	60	60	60
Mx Nm	120	120	120	120	120	120
My Nm	145	145	145	145	145	145
Mz Nm	100	100	100	100	100	100
Fz N	2800	2800	2800	2800	2800	2800
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,1	0,1	0,08	0,08	0,12	0,12
Opening time s	0,1	0,1	0,12	0,12	0,08	0,08
Air consumption per cycle cm^3	80	80	80	80	80	80
Max. allowable length of jaw mm	180	170	170	160	170	160

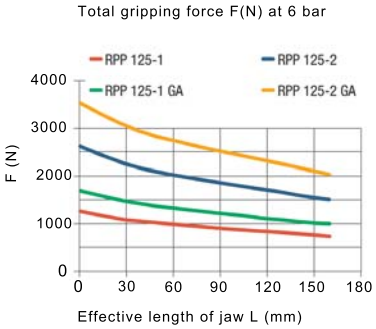
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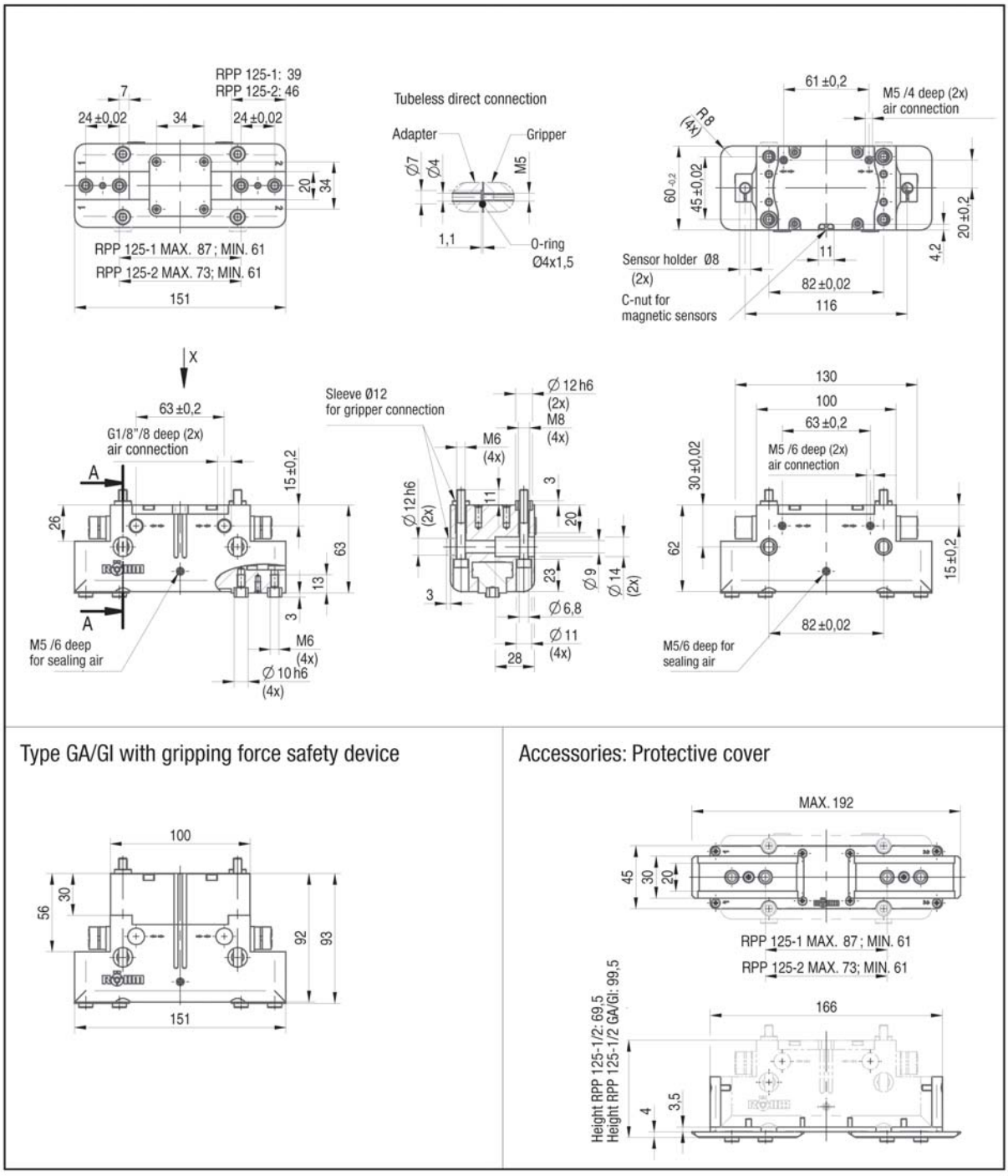
RPP-125

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Type GA/GI with gripping force safety device

Accessories: Protective cover

RPP-160



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 380, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-160 - 2-jaw parallel gripper air operated

Item no.	170029	170030	170031	170032	170033	170034
Design	RPP-160-1	RPP-160-2	RPP-160-1/GA	RPP-160-2/GA	RPP-160-1/GI	RPP-160-2/GI
Gripping force at 6 bar N	2000	3775	2555	4805	2664	5010
Stroke per jaw mm	16	8	16	8	16	8
Gripping force maintained N	-	-	550	1100	550	1100
Recommended workpiece weight kg	9	17	9	17	9	17
Weight kg	2,8	2,8	3,6	3,6	3,6	3,6
Width mm	192	192	192	192	192	192
Height mm	77	77	117	117	117	117
Depth mm	72	72	72	72	72	72
Mx Nm	170	170	170	170	170	170
My Nm	180	180	180	180	180	180
Mz Nm	130	130	130	130	130	130
Fz N	4300	4300	4300	4300	4300	4300
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,15	0,15	0,25	0,25	0,12	0,12
Opening time s	0,15	0,15	0,25	0,25	0,12	0,12
Air consumption per cycle cm^3	160	160	160	160	160	160
Max. allowable length of jaw mm	220	210	210	200	210	200

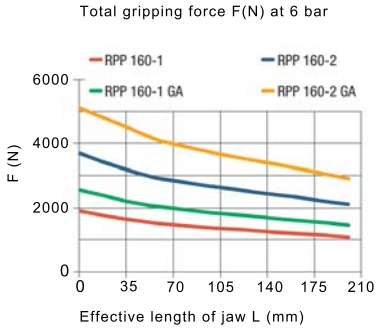
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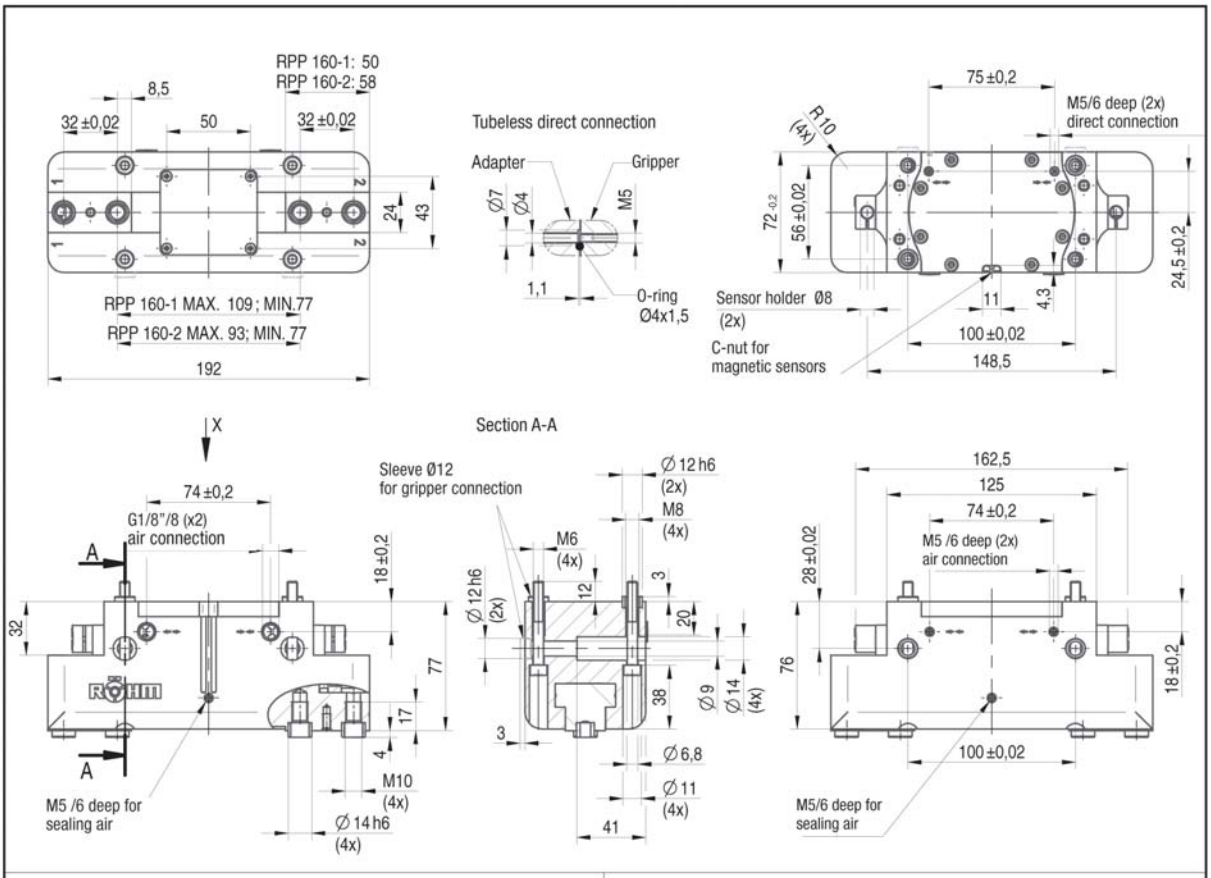
RPP-160

Max. load on gripper and jaw

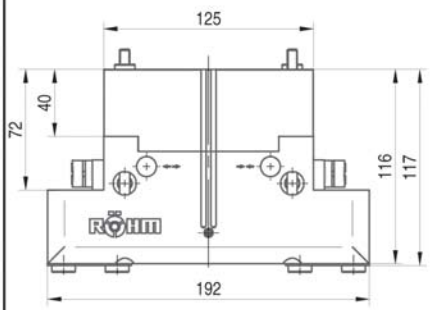


Clamping force diagram exterior gripping

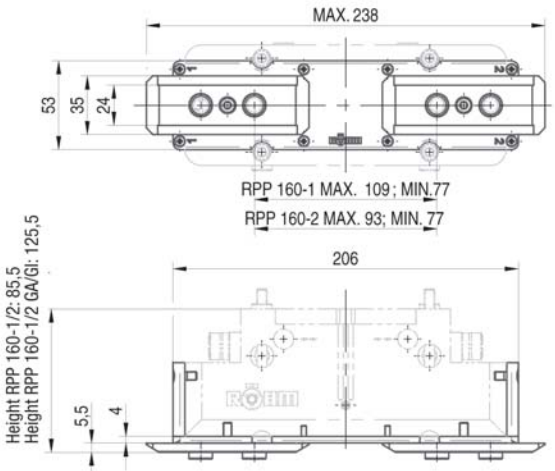




Type GA/GI with gripping force safety device



Accessories: Protective cover



RPP-200



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 380, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-200 - 2-jaw parallel gripper air operated

Item no.	170035	170036	170037	170038	170039 ▲	170040 ▲
Design	RPP-200-1	RPP-200-2	RPP-200-1/GA	RPP-200-2/GA	RPP-200-1/GI	RPP-200-2/GI
Gripping force at 6 bar N	3080	5240	3940	6700	4090	6950
Stroke per jaw mm	25	14	25	14	25	14
Gripping force maintained N	-	-	900	1500	900	1500
Recommended workpiece weight kg	14	24	14	24	14	24
Weight kg	5,5	5,5	7,5	7,5	7,5	7,5
Width mm	234	234	234	234	234	234
Height mm	91	91	141	141	141	141
Depth mm	100	100	100	100	100	100
Mx Nm	180	180	180	180	180	180
My Nm	200	200	200	200	200	200
Mz Nm	140	140	140	140	140	140
Fz N	5000	5000	5000	5000	5000	5000
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,35	0,35	0,3	0,3	0,6	0,6
Opening time s	0,35	0,35	0,6	0,6	0,3	0,3
Air consumption per cycle cm^3	390	390	390	390	390	390
Max. allowable length of jaw mm	280	240	240	200	240	200

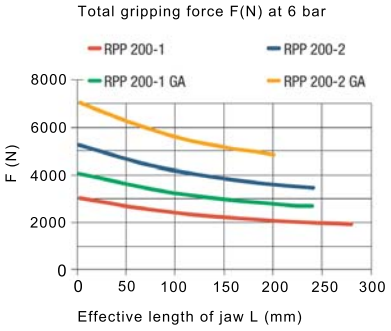
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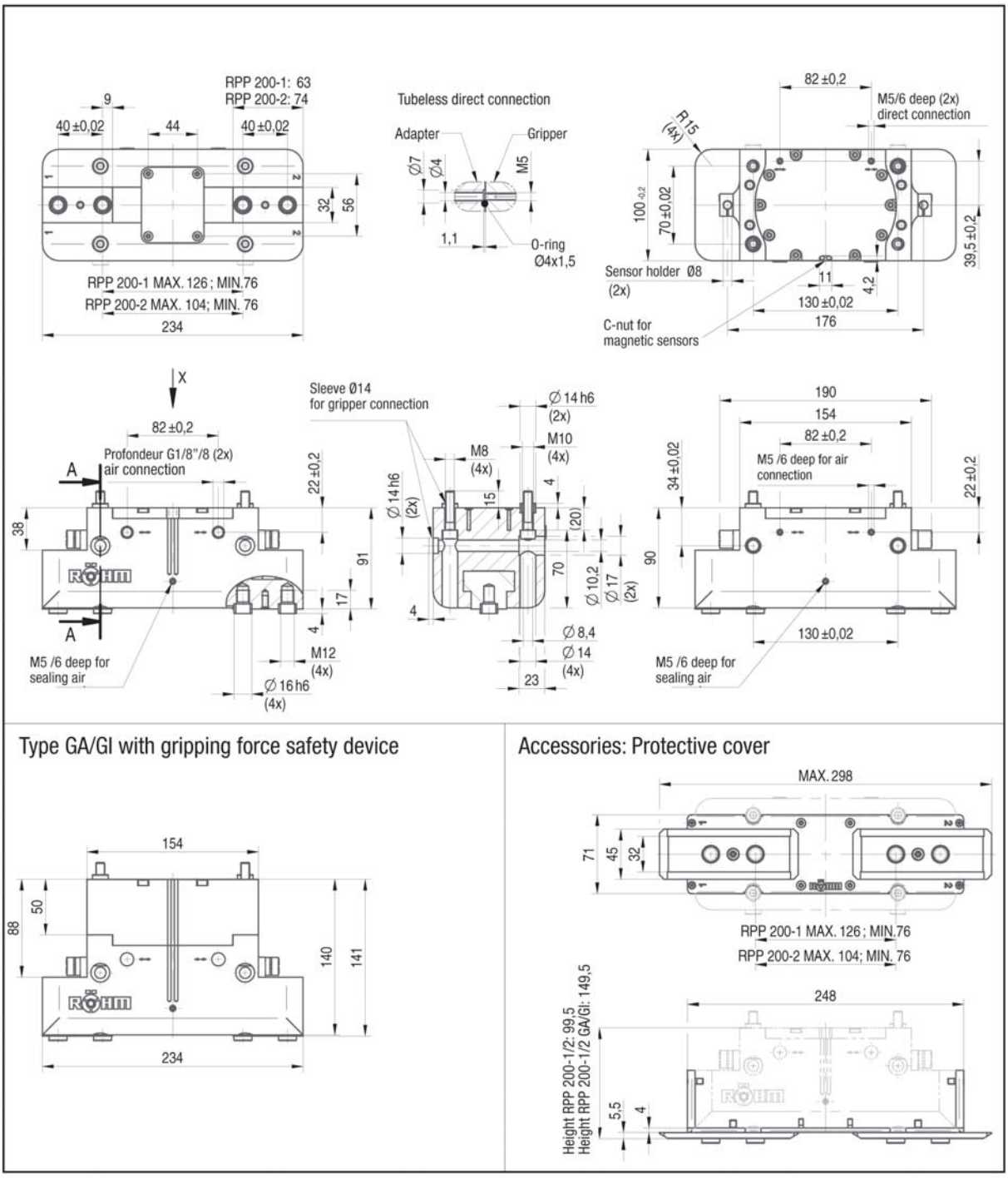
RPP-200

Max. load on gripper and jaw



Clamping force diagram exterior gripping





RPP-240



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 380, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-240 - 2-jaw parallel gripper air operated

Item no.	170100	170101	170102	170103	170104	170105
Design	RPP-240-1	RPP-240-2	RPP-240-1/GA	RPP-240-2/GA	RPP-240-1/GI	RPP-240-2/GA
Gripping force at 6 bar N	4309	7324	5256	8934	5526	9392
Stroke per jaw mm	30	17	30	17	30	17
Gripping force maintained N	-	-	1000	1600	1000	1600
Recommended workpiece weight kg	21	35	21	35	21	35
Weight kg	8,8	9,2	12	12	12	12
Width mm	270	270	270	270	270	270
Height mm	107	107	163,5	163,5	163,5	163,5
Depth mm	115	115	115	115	115	115
Mx Nm	260	260	260	260	260	260
My Nm	250	250	250	250	250	250
Mz Nm	160	160	160	160	160	160
Fz N	6200	6200	6200	6200	6200	6200
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,45	0,45	0,35	0,35	0,65	0,65
Opening time s	0,45	0,45	0,65	0,65	0,35	0,35
Air consumption per cycle cm^3	650	650	650	650	650	650
Max. allowable length of jaw mm	320	280	280	240	280	240

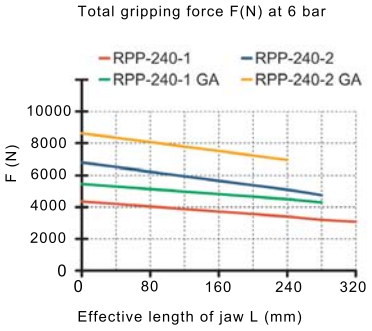
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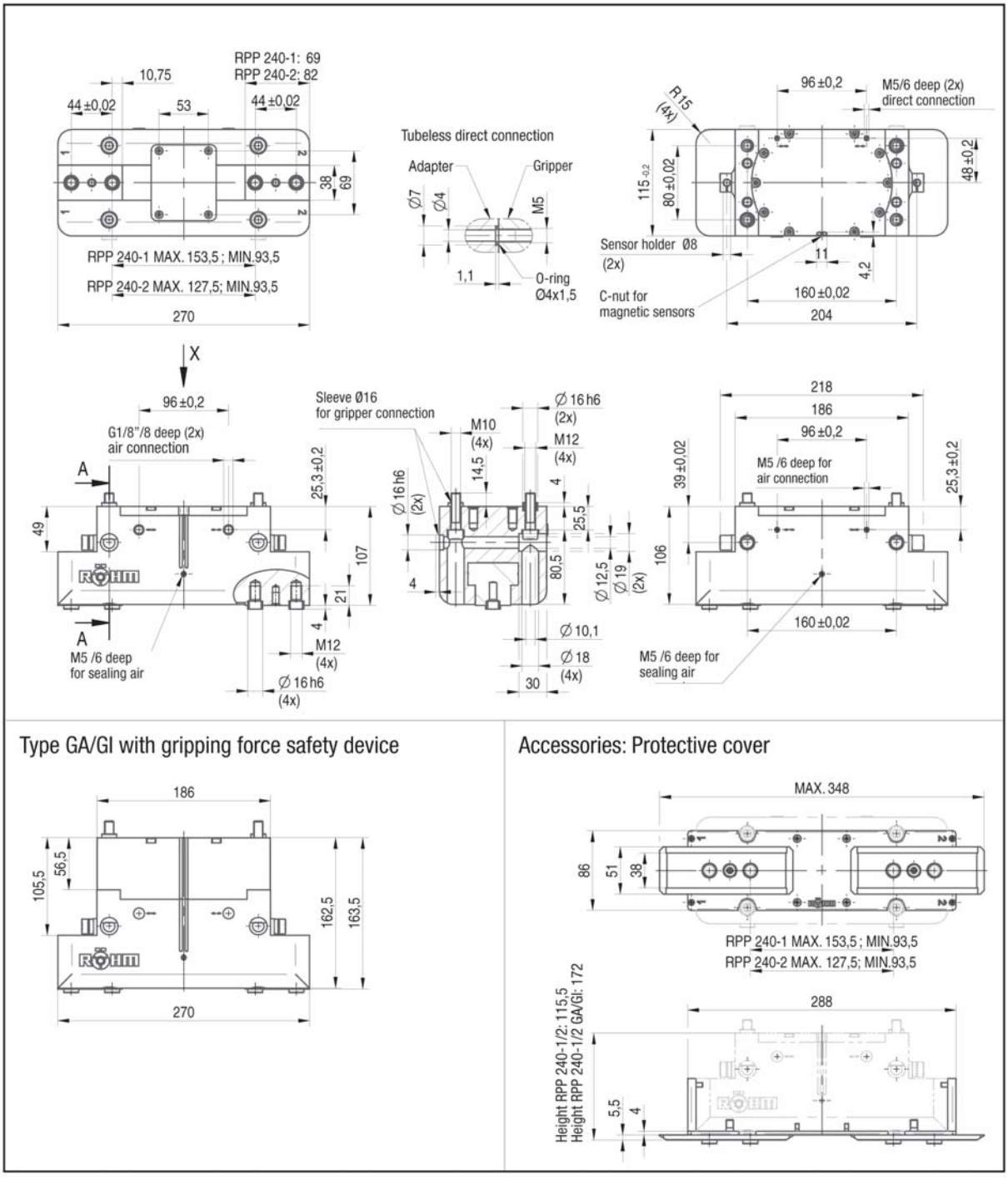
RPP-240

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Type GA/GI with gripping force safety device

Accessories: Protective cover

RPP-300



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 380, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-300 - 2-jaw parallel gripper air operated

Item no.	170041	170042	170043	170044	170045 ▲	170046 ▲
Design	RPP-300-1	RPP-300-2	RPP-300-1/GA	RPP-300-2/GA	RPP-300-1/GI	RPP-300-2/GI
Gripping force at 6 bar N	6400	11000	7590	12910	7860	13360
Stroke per jaw mm	35	20	35	20	35	20
Gripping force maintained N	-	-	1300	2200	1300	2200
Recommended workpiece weight kg	31	52	31	52	31	52
Weight kg	14	14	17	17	17	17
Width mm	320	320	320	320	320	320
Height mm	122	122	172	172	172	172
Depth mm	140	140	140	140	140	140
Mx Nm	400	400	400	400	400	400
My Nm	400	400	400	400	400	400
Mz Nm	250	250	250	250	250	250
Fz N	8000	8000	8000	8000	8000	8000
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,5	0,5	0,4	0,4	0,7	0,7
Opening time s	0,5	0,5	0,7	0,7	0,4	0,4
Air consumption per cycle cm^3	1040	1040	1040	1040	1040	1040
Max. allowable length of jaw mm	350	300	300	250	300	250

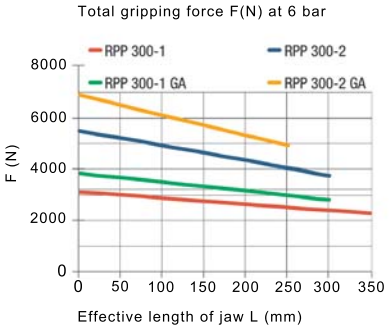
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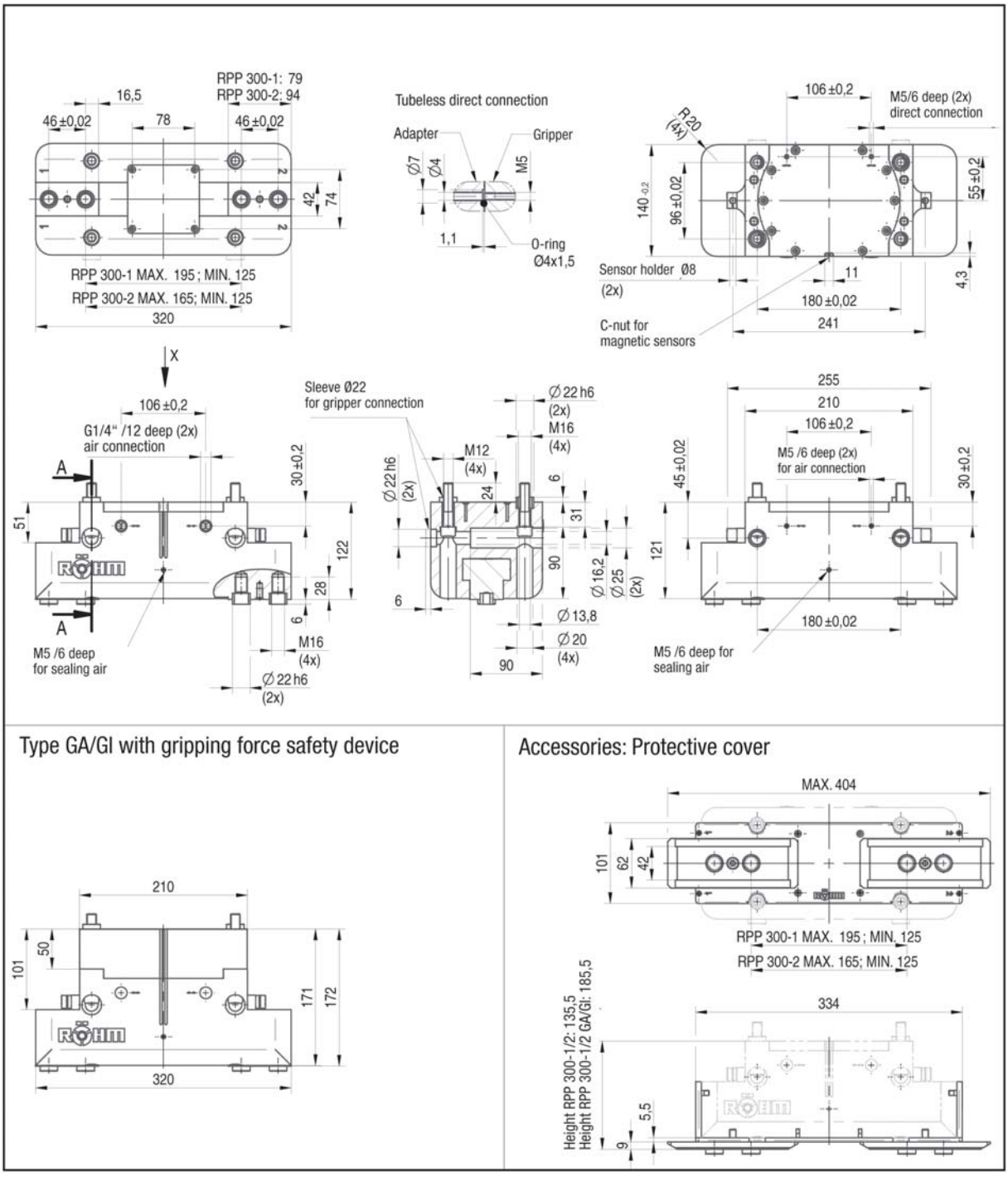
RPP-300

Max. load on gripper and jaw



Clamping force diagram exterior gripping





RPP-380



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 380, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-380 - 2-jaw parallel gripper air operated

Item no.	172113	172114	172115	172116	172117 ▲	172118 ▲
Design	RPP-380-1	RPP-380-2	RPP-380-1/GA	RPP-380-2/GA	RPP-380-1/GI	RPP-380-2/GI
Gripping force at 6 bar N	9620	16350	12470	21200	12900	21900
Stroke per jaw mm	45	26	45	26	45	26
Gripping force maintained N	-	-	2850	4850	2850	4850
Recommended workpiece weight kg	48	82	35,5	82	48	82
Weight kg	28	28	35,5	35,5	35,5	35,5
Width mm	310	410	410	410	410	410
Height mm	226,5	155	226,5	226,5	226,5	226,5
Depth mm	170	170	170	170	170	170
Mx Nm	560	560	560	560	560	560
My Nm	560	560	560	560	560	560
Mz Nm	370	370	370	370	370	370
Fz N	10000	10000	10000	10000	10000	10000
Operating pressure min./ max. without GA/GI bar	2,5-8	2,5-8				
Operating pressure min./ max. with GA/GI bar			4-6,5	4-6,5	4-6,5	4-6,5
Clamping time s	0,6	0,6	0,45	0,45	0,8	0,8
Opening time s	0,6	0,6	0,8	0,8	0,5	0,5
Max. allowable length of jaw mm	400	350	350	300	350	300

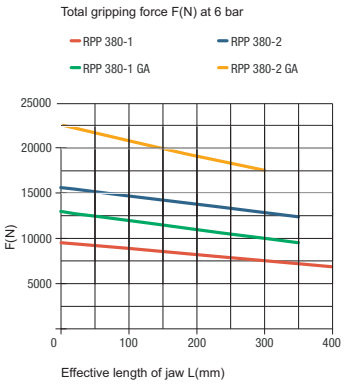
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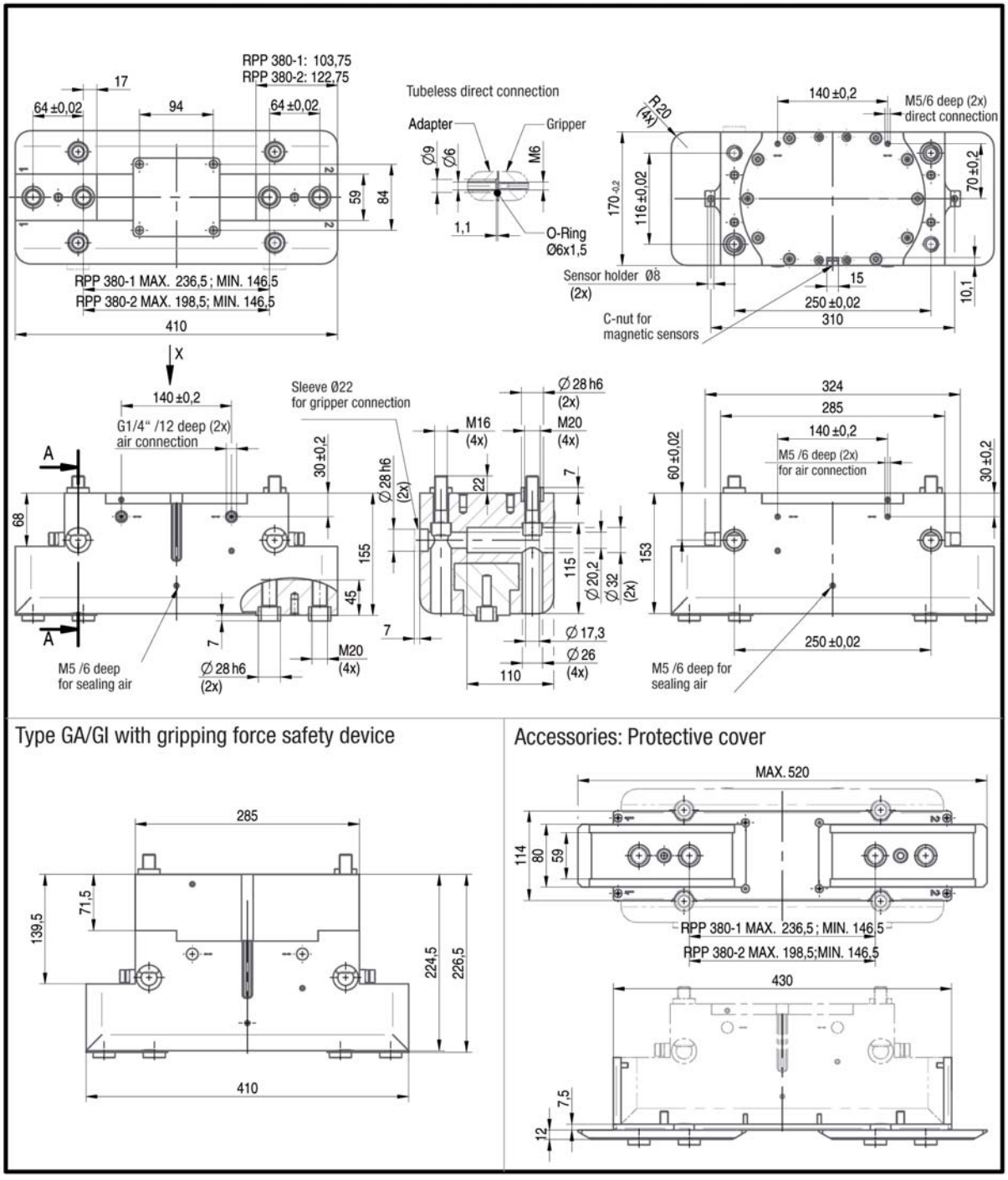
RPP-380

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Type GA/GI with gripping force safety device

Accessories: Protective cover

Accessories RPP



Jaw blank - steel (including fixing screws)
2-jaw set

Item no.	Number of jaws	Design	For
170574 ▲	2	steel	RPP-50
170575 ▲	2	steel	RPP-64
170576 ▲	2	steel	RPP-80
170577 ▲	2	steel	RPP-100
170578 ▲	2	steel	RPP-125
170579 ▲	2	steel	RPP-160
170580 ▲	2	steel	RPP-200
170581 ▲	2	steel	RPP-240
170582 ▲	2	steel	RPP-300
170583 ▲	2	steel	RPP-380



Jaw blank - aluminium (including fixing screws)
2-jaw set

Item no.	Number of jaws	Design	For
170584 ▲	2	aluminium	RPP-50
170585 ▲	2	aluminium	RPP-64
170586 ▲	2	aluminium	RPP-80
170587 ▲	2	aluminium	RPP-100
170588 ▲	2	aluminium	RPP-125
170589 ▲	2	aluminium	RPP-160
170590 ▲	2	aluminium	RPP-200
170591 ▲	2	aluminium	RPP-240
170592 ▲	2	aluminium	RPP-300
170593 ▲	2	aluminium	RPP-380



Protective cover

Item no.	For
170594	RPP-50
170540	RPP-64
170541	RPP-80
170542	RPP-100
170543	RPP-125
170544	RPP-160
170545	RPP-200
170546	RPP-240
170547	RPP-300
170548	RPP-380



Compressed air connection

Item no.	Design	For
802539	L-Plug connector M5 - 6 mm	RPP-50 / RPP-64 / RPP-80
477025	L-Plug connector 1/8 - 6 mm	RPP-100 - RPP-240
477024	L-Plug connector 1/4 - 6 mm	RPP-300 / RPP-380



Pressure maintenance
for double acting gripper (G1/8)

Item no.
1078823



Proximity switch

Item no.	Size (diameter/ length)	Design	For
1149503	3x27	30 cm cable, plug M8x1-S49	RPP-50
229114	M8x1x30,5	5 m cable, open leads	RPP-64 / RPP-80 / RPP-100
389661	M8x1x46,5	3 m cable, open leads	RPP-125 - RPP-380



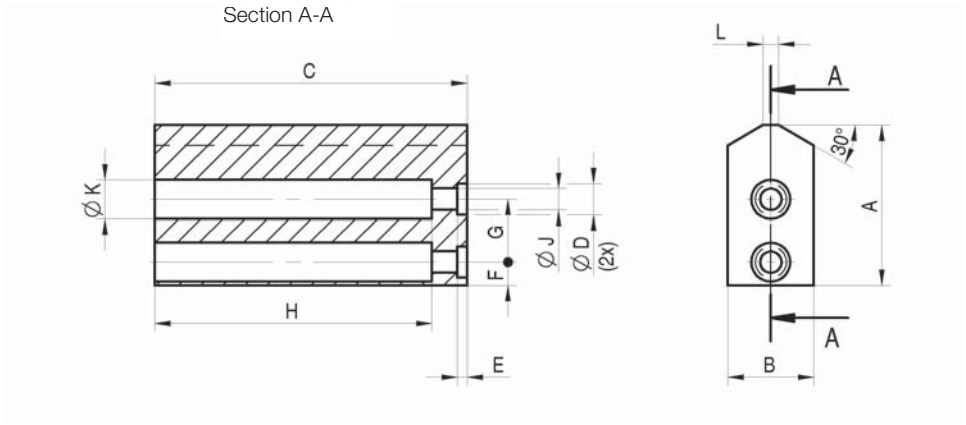
Magnetic field sensors

Item no.	Size (diameter/length)	Design	For
1306268	C-Nut	2 m cable, open leads	RPP-50
1276722	C-Nut	3 m cable, 3 open leads	all sizes, all types

▲ on request

Accessories RPP

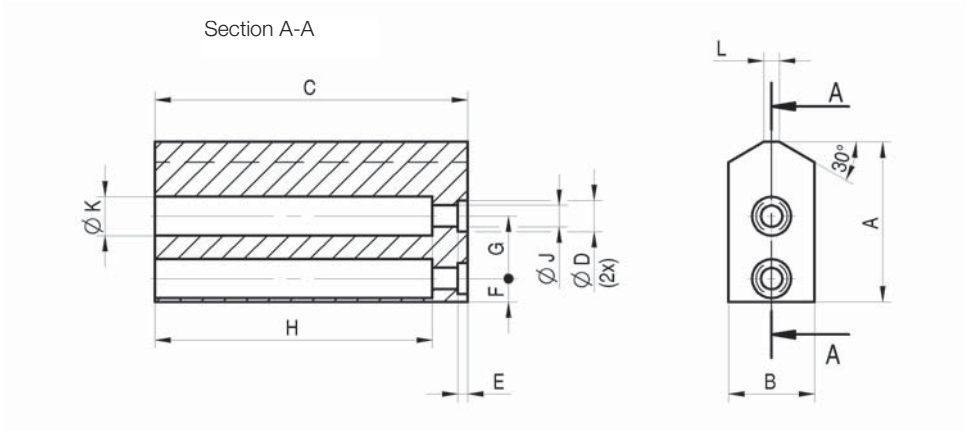




Jaw blank - steel (including fixing screws), 2-jaw set

RPP / RZP	50	64	80	100	125	160	200	240	300
RPP - 2-jaw set	**170574**	**170575**	**170576**	**170577**	**170578**	**170579**	**170580**	**170581**	**170582**
RZP - 3-jaw set	**170596**	**170500**	**170502**	**170504**	**170506**	**170508**	**170510**	**170512**	**170514**
A	30	32	41	51	60	80	96	109	130
B	15	20	22	30	35	40	40	50	60
C	50	64	80	100	125	160	200	220	200
D +0,04/+0,02	5	6	8	10	10	14	16	16	22
E±0,2	2	2,5	2,5	3	3	4	4	4	6
F±0,1	5	5	6	7	9,5	10	15	15,5	20
G±0,1	12	13	16	20	24	32	40	44	46
H	45	57	71	91	115	146	181	204	177
J	3,4	4,5	5,5	6,6	6,6	11	13,5	13,5	17,5
K	6	8	10	11	11	18	20	20	26
L	2	3	4	5	6	8	13	10	16
Weight per jaw Kg	0,15	0,25	0,45	1,0	1,75	3,2	5,0	8,0	10,2





Jaw blank - aluminium (including fixing screws), 2-jaw set

RPP / RZP	50	64	80	100	125	160	200	240	300
RPP - 2-jaw set	**170584**	**170585**	**170586**	**170587**	**170588**	**170589**	**170590**	**170591**	**170592**
RZP - 3-jaw set	**170597**	**170550**	**170552**	**170554**	**170556**	**170558**	**170560**	**170562**	**170564**
A	30	32	41	51	60	80	96	109	130
B	15	20	25	30	35	40	45	50	60
C	50	64	80	100	125	160	200	220	200
D +0,04/+0,02	5	6	8	10	10	14	16	16	22
E±0,2	2	2,5	2,5	3	3	4	4	4	6
F±0,1	5	5	6	7	9,5	10	15	15,5	20
G±0,1	12	13	16	20	24	32	40	44	46
H	43	55	69	88	112	141	176	200	170
J	3,4	4,5	5,5	6,6	6,6	11	13,5	13,5	17,5
K	6	8	10	11	11	18	20	20	26
L	2	3	4	5	6	8	9	10	16
Weight per jaw Kg	0,05	0,1	0,18	0,35	0,6	1,2	2,0	2,8	3,4

RPP-A 50



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 160, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via tongue and groove.

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-A 50 - 2-jaw parallel gripper air operated with tongue and groove

Item no.	438040 ▲	438041 ▲	438042 ▲	438043 ▲	438044 ▲	438045 ▲
Design	RPP-A 50-1	RPP-A 50-2	RPP-A 50-2/GA	RPP-A 50-2/GA	RPP-A 50-1/GI	RPP-A 50-2/GI
Gripping force at 6 bar N	170	320	210	380	220	410
Stroke per jaw mm	4	2	4	2	4	2
Gripping force maintained N	-	-	30	60	30	60
Recommended workpiece weight kg	0,85	1,6	0,85	1,6	0,85	1,6
Weight kg	0,13	0,16	0,17	0,17	0,17	0,17
Width mm	50	50	50	50	50	50
Height mm	47	47	47	47	47	47
Depth mm	28	28	28	28	28	28
Mx Nm	12	12	12	12	12	12
My Nm	10	10	10	10	10	10
Mz Nm	10	10	10	10	10	10
Fz N	250	250	250	250	250	250
Operating pressure min./ max. without GA/GI bar	2-8	2-8				
Operating pressure min./ max. with GA/GI bar			4-6,5	4-6,5	4-6,5	4-6,5
Clamping time s	0,02	0,02	0,01	0,01	0,02	0,02
Opening time s	0,02	0,02	0,02	0,02	0,01	0,01
Air consumption per cycle cm^3	5	5	5	5	5	5
Max. allowable length of jaw mm	50	50	50	50	50	50

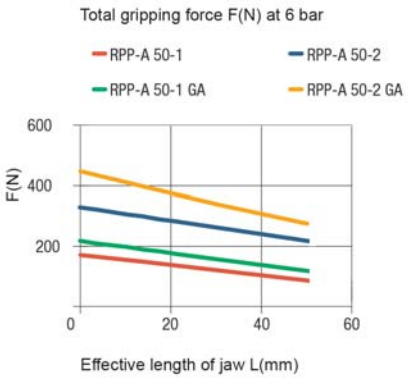
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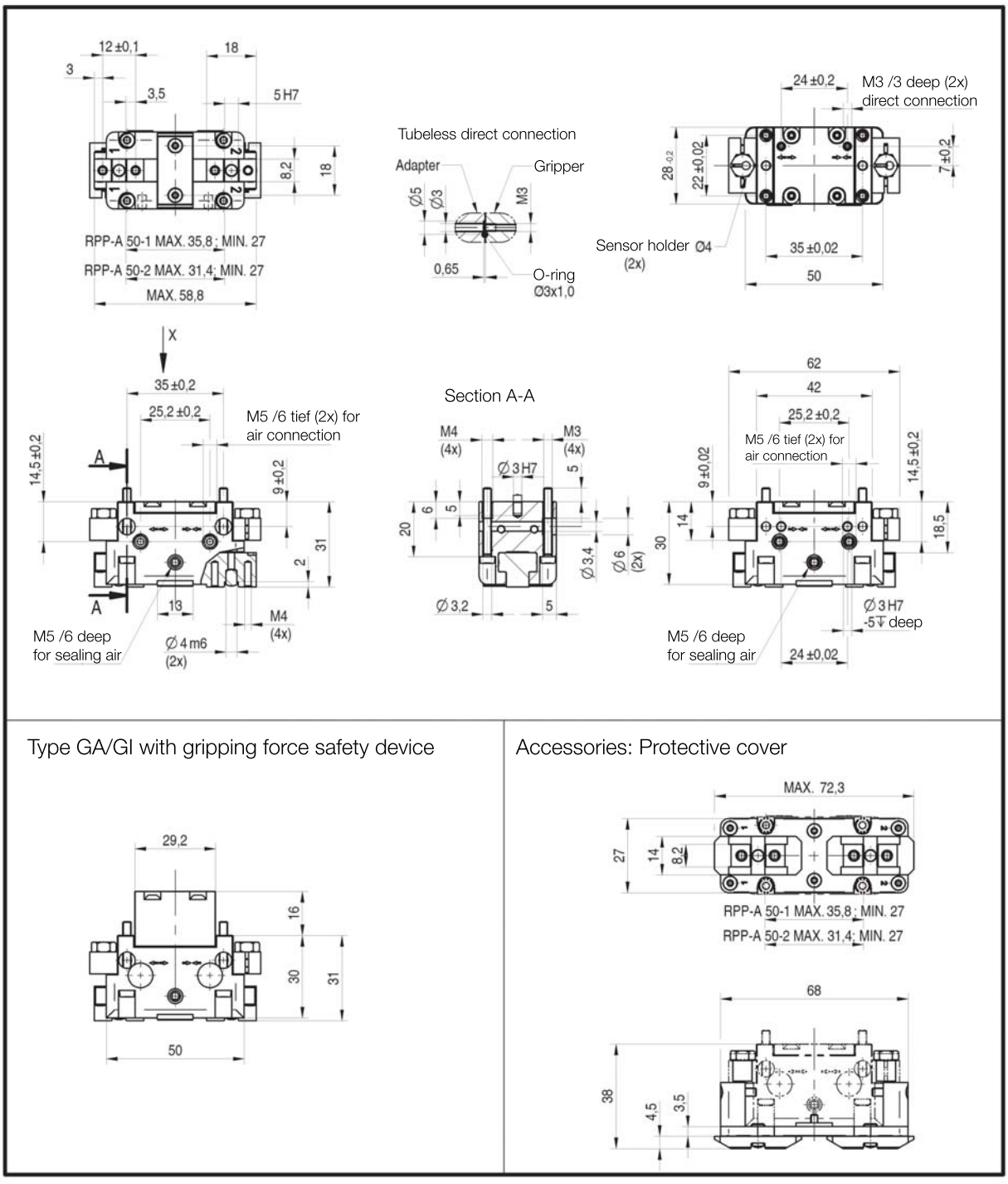
RPP-A 50

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Type GA/GI with gripping force safety device

Accessories: Protective cover

RPP-A 64



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 160, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via tongue and groove.

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-A 64 - 2-jaw parallel gripper air operated with tongue and groove

Item no.	436763	436764	436765 ▲	436766 ▲	436767 ▲	436768 ▲
Design	RPP-A 64-1	RPP-A 64-2	RPP-A 64-1/GA	RPP-A 64-2/GA	RPP-A 64-1/GI	RPP-A 64-2/GI
Gripping force at 6 bar N	240	450	320	600	350	650
Stroke per jaw mm	6	3	6	3	6	3
Gripping force maintained N	-	-	80	150	80	150
Recommended workpiece weight kg	1,2	2,2	1,2	2,2	1,2	2,2
Weight kg	0,3	0,3	0,42	0,42	0,42	0,42
Width mm	64	64	64	64	64	64
Height mm	40	40	58	58	58	58
Depth mm	36	36	36	36	36	36
Mx Nm	15	15	15	15	15	15
My Nm	30	30	30	30	30	30
Mz Nm	25	25	25	25	25	25
Fz N	450	450	450	450	450	450
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,02	0,02	0,01	0,01	0,02	0,02
Opening time s	0,02	0,02	0,02	0,02	0,1	0,1
Air consumption per cycle cm^3	10	10	10	10	10	10
Max. allowable length of jaw mm	64	64	64	64	64	64

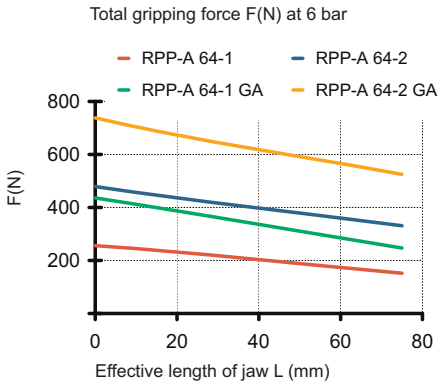
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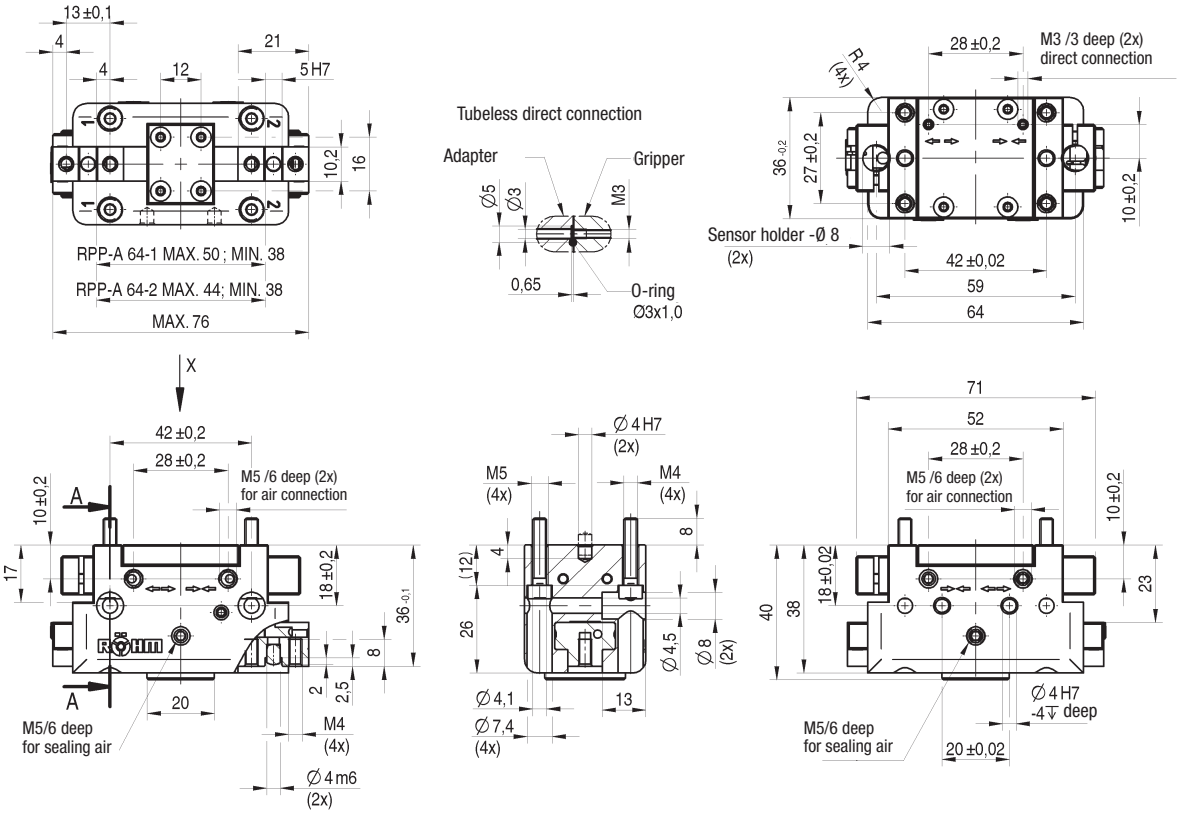
RPP-A 64

Max. load on gripper and jaw

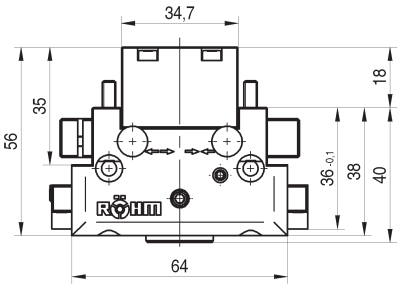


Clamping force diagram exterior gripping

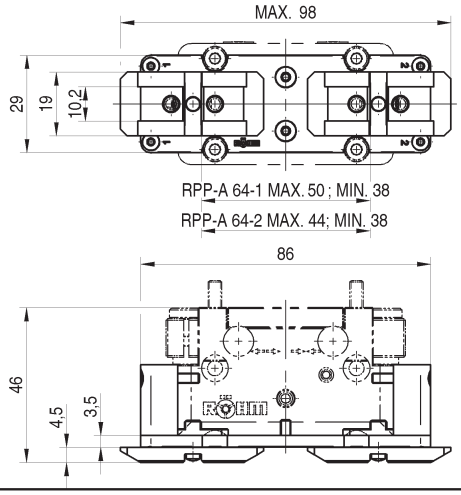




Type GA/GI with gripping force safety device



Accessories: Protective cover



RPP-A 80



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 160, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via tongue and groove.

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-A 80 - 2-jaw parallel gripper air operated with tongue and groove

Item no.	434844 ▲	435027 ▲	435028 ▲	435029 ▲	435030 ▲	435031 ▲
Design	RPP-A 80-1	RPP-A 80-2	RPP-A 80-1/GA	RPP-A 80-2/GA	RPP-A 80-1/GI	RPP-A 80-2/GI
Gripping force at 6 bar N	380	700	520	970	550	1000
Stroke per jaw mm	8	4	8	4	8	4
Gripping force maintained N	-	-	140	270	140	270
Recommended workpiece weight kg	1,9	3,5	1,9	3,5	1,9	3,5
Weight kg	0,45	0,45	0,6	0,6	0,6	0,6
Width mm	80	80	80	80	80	80
Height mm	50	50	71	71	71	71
Depth mm	42	42	42	42	42	42
Mx Nm	30	30	30	30	30	30
My Nm	90	90	90	90	90	90
Mz Nm	35	35	35	35	35	35
Fz N	600	600	600	600	600	600
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,03	0,03	0,02	0,02	0,03	0,03
Opening time s	0,03	0,03	0,03	0,03	0,02	0,02
Air consumption per cycle cm^3	20	20	20	20	20	20
Max. allowable length of jaw mm	80	80	80	80	80	80

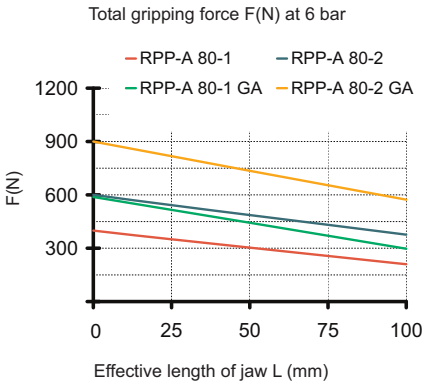
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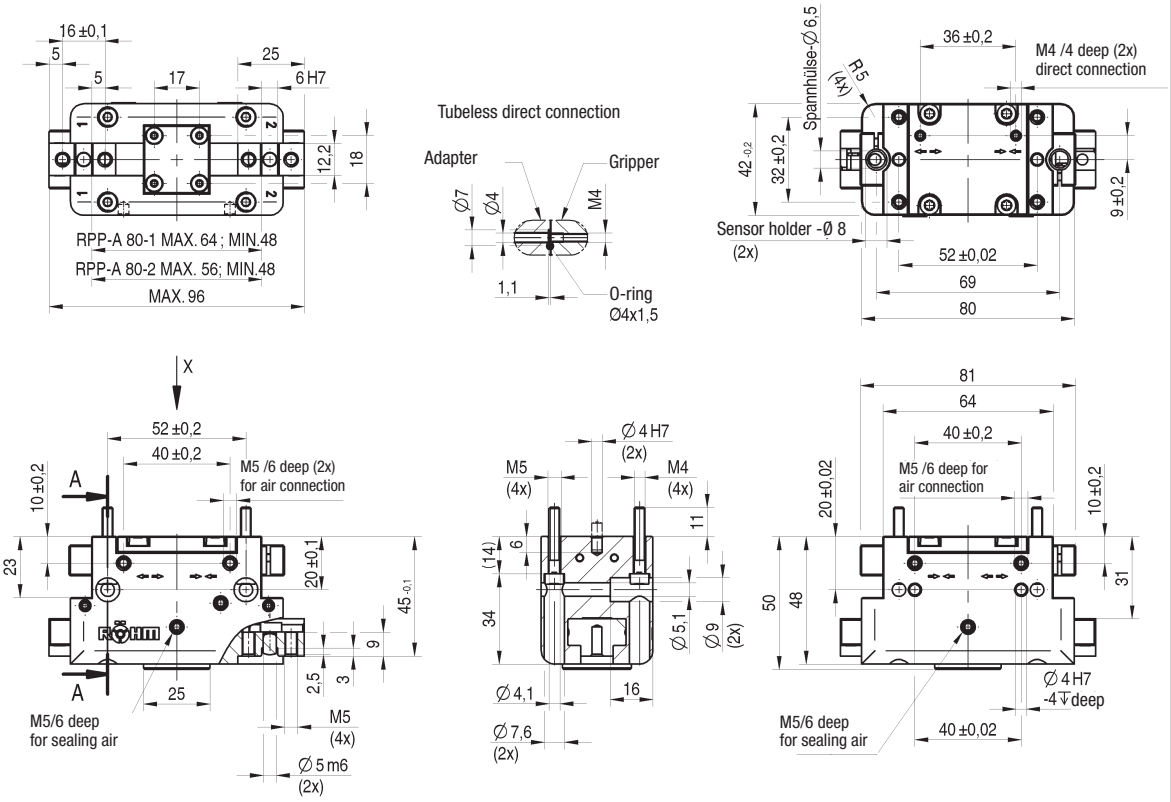
RPP-A 80

Max. load on gripper and jaw

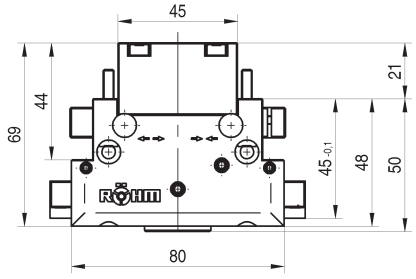


Clamping force diagram exterior gripping

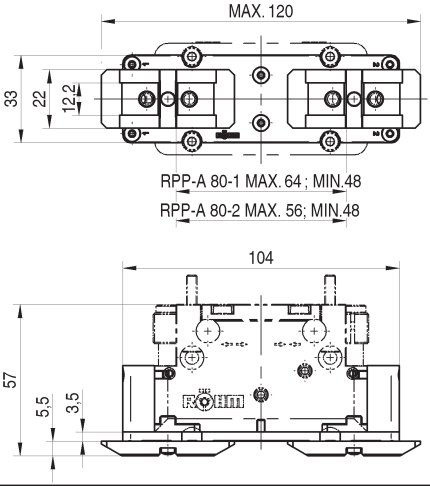




Type GA/GI with gripping force safety device



Accessories: Protective cover



RPP-A 100



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 160, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via tongue and groove.

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-A 100 - 2-jaw parallel gripper air operated with tongue and groove

Item no.	434845 ▲	435032 ▲	435033 ▲	434846 ▲	435034 ▲	435035 ▲
Design	RPP-A 100-1	RPP-A 100-2	RPP-A 100-1/GA	RPP-A 100-2/GA	RPP-A 100-1/GI	RPP-A 100-2/GI
Gripping force at 6 bar N	600	1160	750	1450	800	1550
Stroke per jaw mm	10	5	10	5	10	5
Gripping force maintained N	-	-	150	290	150	290
Recommended workpiece weight kg	3	5,5	3	5,5	3	5,5
Weight kg	0,75	0,75	0,95	0,95	0,95	0,95
Width mm	100	100	100	100	100	100
Height mm	56	56	82,5	82,5	82,5	82,5
Depth mm	50	50	50	50	50	50
Mx Nm	45	45	45	45	45	45
My Nm	95	95	95	95	95	95
Mz Nm	45	45	45	45	45	45
Fz N	800	800	800	800	800	800
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,05	0,05	0,03	0,03	0,05	0,05
Opening time s	0,05	0,05	0,05	0,05	0,03	0,03
Air consumption per cycle cm^3	40	40	40	40	40	40
Max. allowable length of jaw mm	100	100	100	100	100	100

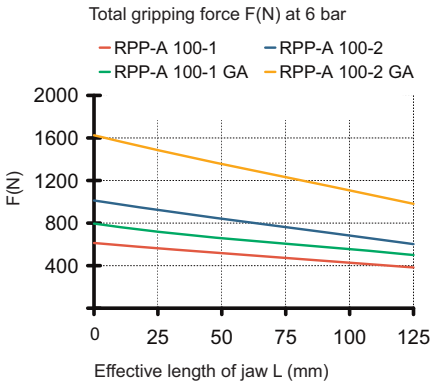
▲ on request

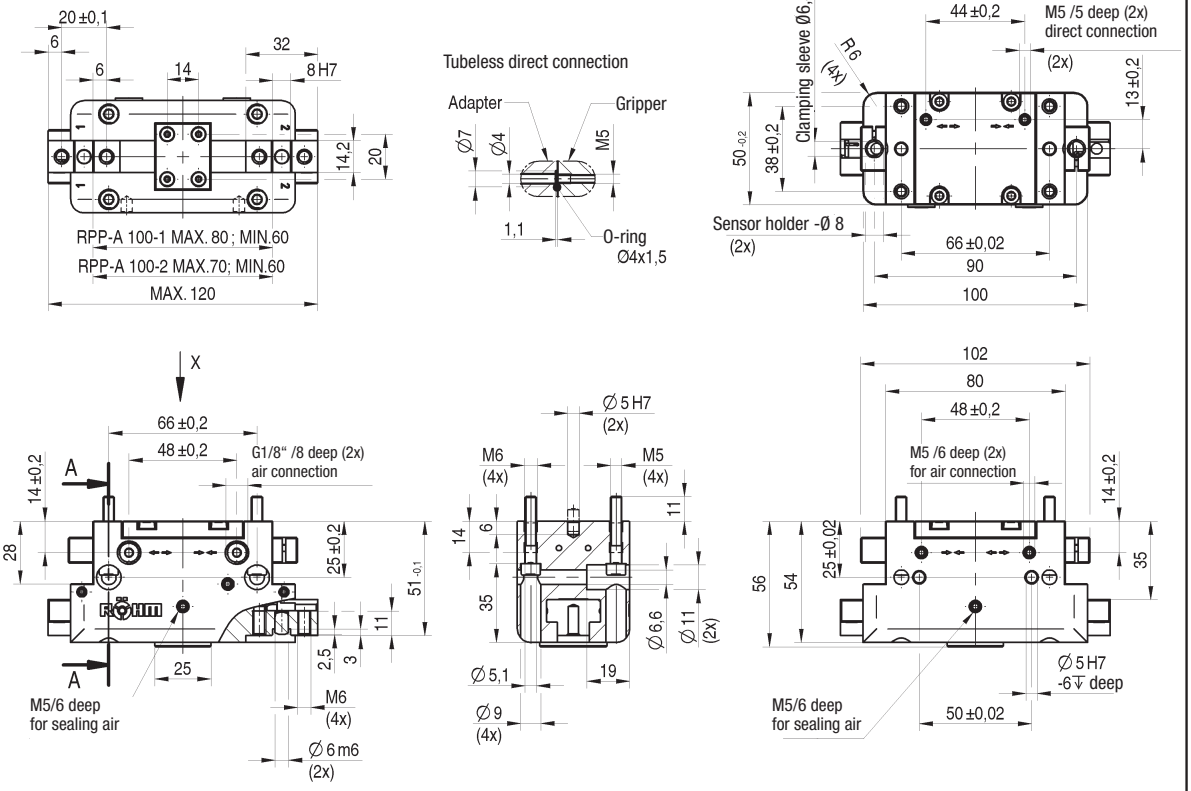
RPP-A 100

Max. load on gripper and jaw

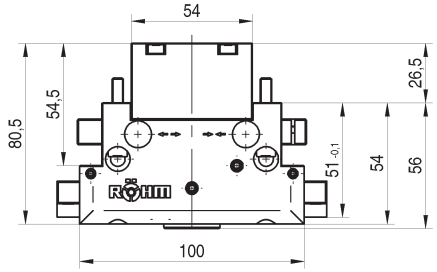


Clamping force diagram exterior gripping

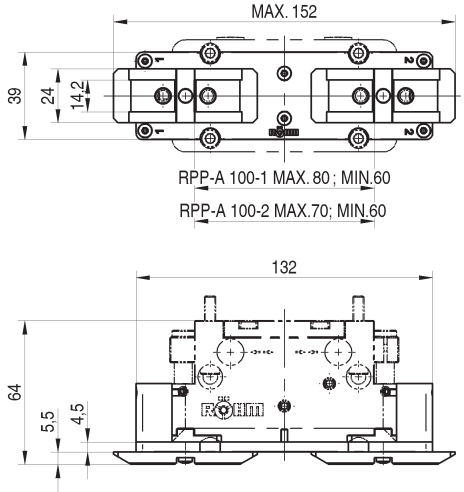




Type GA/GI with gripping force safety device



Accessories: Protective cover



RPP-A 125



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 160, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via tongue and groove.

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-A 125 - 2-jaw parallel gripper air operated with tongue and groove

Item no.	435036 ▲	435037 ▲	435038 ▲	434847 ▲	435039 ▲	435040 ▲
Design	RPP-A 125-1	RPP-A 125-2	RPP-A 125-1/GA	RPP-A 125-2/GA	RPP-A 125-1/GI	RPP-A 125-2/GI
Gripping force at 6 bar N	950	1900	1230	2450	1300	2520
Stroke per jaw mm	13	6	13	6	13	6
Gripping force maintained N	-	-	280	550	280	550
Recommended workpiece weight kg	4,5	9,5	4,5	9,5	4,5	9,5
Weight kg	1,3	1,3	1,65	1,65	1,65	1,65
Width mm	125	125	125	125	125	125
Height mm	64	64	104	104	104	104
Depth mm	60	60	60	60	60	60
Mx Nm	60	60	60	60	60	60
My Nm	100	100	100	100	100	100
Mz Nm	70	70	70	70	70	70
Fz N	900	900	900	900	900	900
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,08	0,08	0,07	0,07	0,1	0,1
Opening time s	0,08	0,08	0,1	0,1	0,07	0,07
Air consumption per cycle cm^3	70	70	70	70	70	70
Max. allowable length of jaw mm	125	125	125	125	125	125

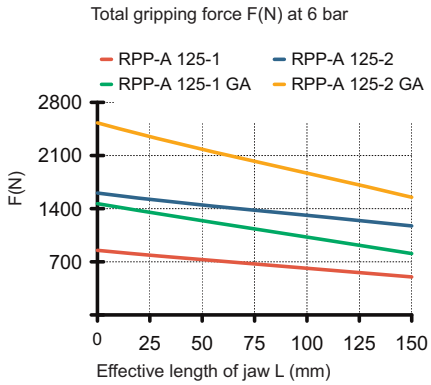
▲ on request

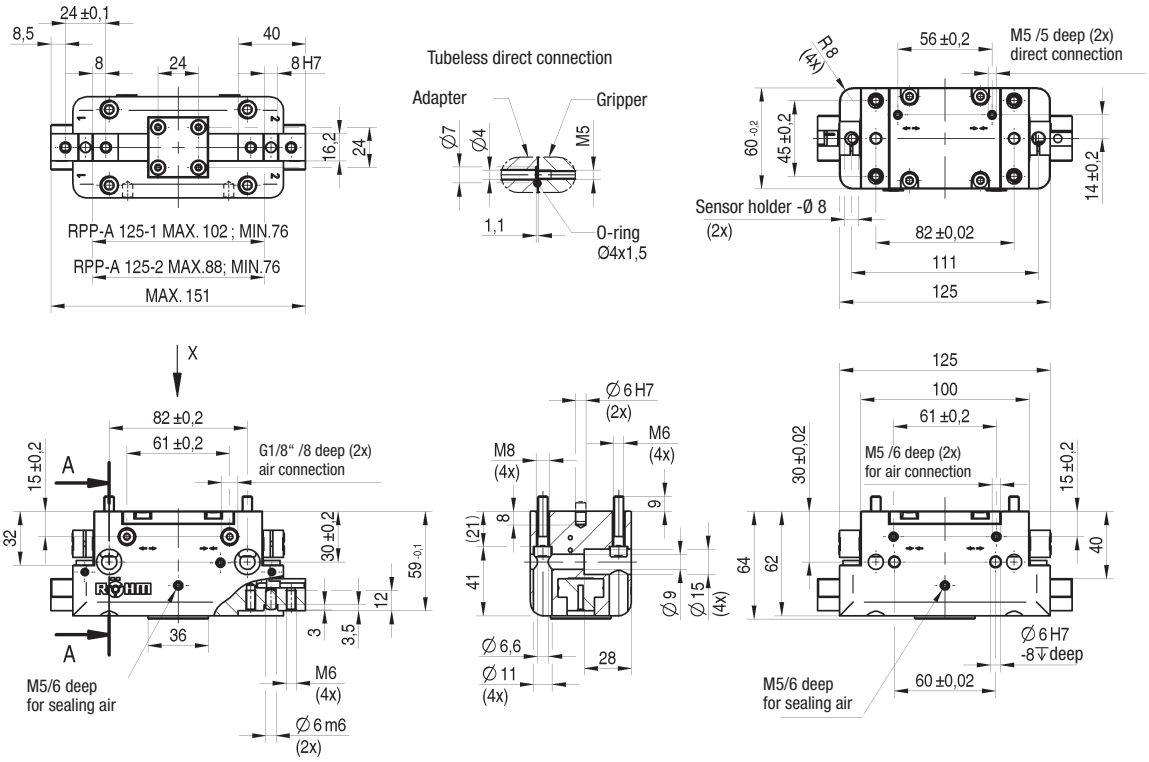
RPP-A 125

Max. load on gripper and jaw

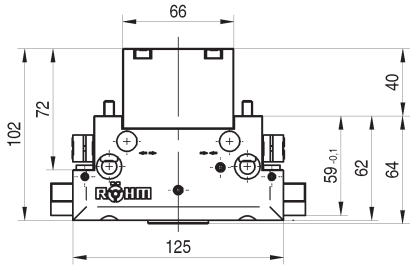


Clamping force diagram exterior gripping

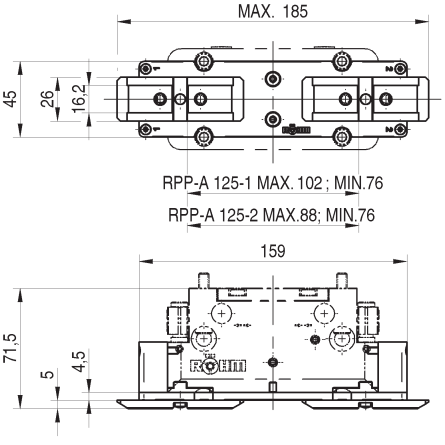




Type GA/GI with gripping force safety device



Accessories: Protective cover



RPP-A 160



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 50 to 160, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via tongue and groove.

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation (hydraulic actuation available on request)
- Position Monitoring with inductive or magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RPP-A 160 - 2-jaw parallel gripper air operated with tongue and groove

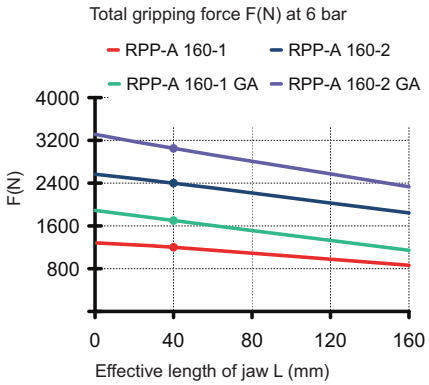
Item no.	434848 ▲	435041 ▲	436525 ▲	436526 ▲	436527 ▲	436528 ▲
Design	RPP-A 160-1	RPP-A 160-2	RPP-A 160-1/GA	RPP-A 160-2/GA	RPP-A 160-1/GI	RPP-A 160-2/GI
Gripping force at 6 bar N	1300	2500	1700	3300	1850	3450
Stroke per jaw mm	16	8	16	8	16	8
Gripping force maintained N	-	-	400	800	400	800
Recommended workpiece weight kg	6,5	12,5	6,5	12,5	6,5	12,5
Weight kg	2,5	2,5	3,1	3,1	3,1	3,1
Width mm	160	160	160	160	160	160
Height mm	78	78	126	126	126	126
Depth mm	72	72	72	72	72	72
Mx Nm	80	80	80	80	80	80
My Nm	100	100	100	100	100	100
Mz Nm	80	80	80	80	80	80
Fz N	1100	1100	1100	1100	1100	1100
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,1	0,1	0,12	0,12	0,3	0,3
Opening time s	0,1	0,1	0,3	0,3	0,12	0,12
Air consumption per cycle cm^3	130	130	130	130	130	130
Max. allowable length of jaw mm	160	160	160	160	160	160

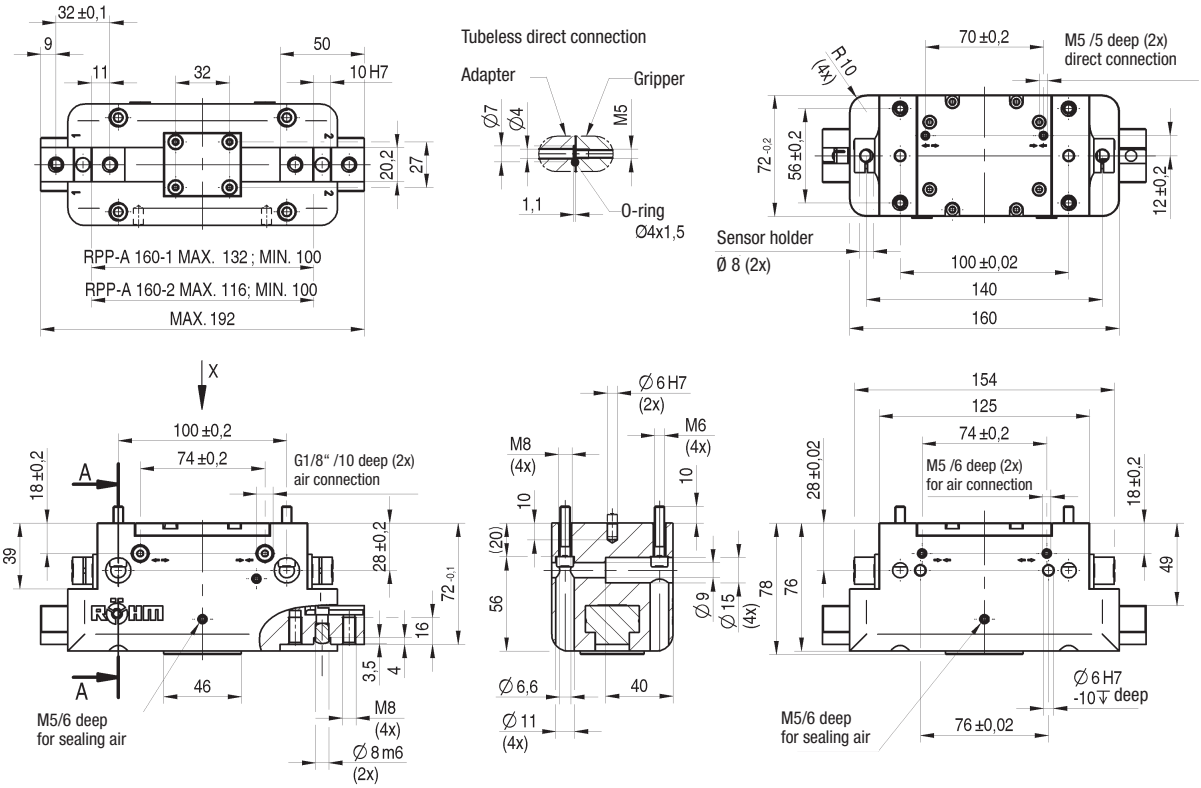
RPP-A 160

Max. load on gripper and jaw

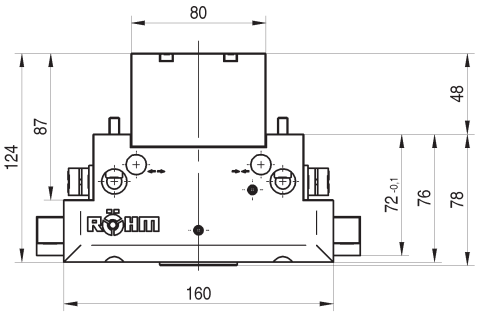


Clamping force diagram exterior gripping

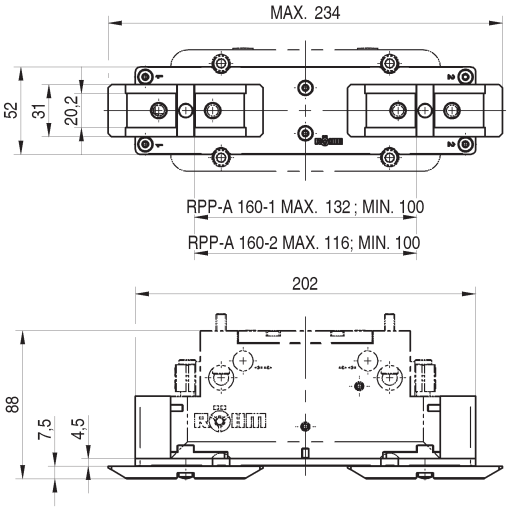




Type GA/GI with gripping force safety device



Accessories: Protective cover



Accessories RPP-A



Jaw blank - steel (including fixing screws), 2-jaw set

Item no.	Number of jaws	Design	For
170683 ▲	2	steel	RPP-A 50
170675 ▲	2	steel	RPP-A 64
170676 ▲	2	steel	RPP-A 80
170677 ▲	2	steel	RPP-A 100
170678 ▲	2	steel	RPP-A 125
170679 ▲	2	steel	RPP-A 160



Jaw blank - aluminium (including fixing screws) 2-jaw set

Item no.	Number of jaws	Design	For
170693 ▲	2	aluminium	RPP-A 50
170685 ▲	2	aluminium	RPP-A 64
170686 ▲	2	aluminium	RPP-A 80
170687 ▲	2	aluminium	RPP-A 100
170688 ▲	2	aluminium	RPP-A 125
170689 ▲	2	aluminium	RPP-A 160



Protective cover

Item no.	For
170708 ▲	RPP-A 50
170700 ▲	RPP-A 64
170701 ▲	RPP-A 80
170702 ▲	RPP-A 100
170703 ▲	RPP-A 125
170704 ▲	RPP-A 160



Compressed air connection

Item no.	Design	For
802539	L-Plug connector M5 - 6 mm	RPP-A 50 / RPP-A 64 / RPP-A 80
477025	L-Plug connector 1/8 - 6 mm	RPP-A 100 - RPP-A 160



Pressure maintenance for double acting gripper (G1/8)

Item no.
1078823



Proximity switch

Item no.	Size (diameter/ length)	Design	For
1149503	3x27	30 cm cable, plug M8x1-S49	RPP-50
229114	M8x1x30,5	5 m cable, open leads	RPP-A 64 / RPP-A 80 / RPP-A 100
389661	M8x1x46,5	3 m cable, open leads	RPP-A 125 - RPP-A 160

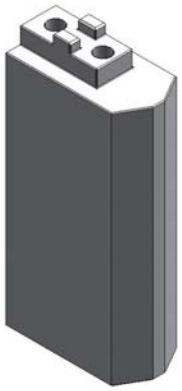


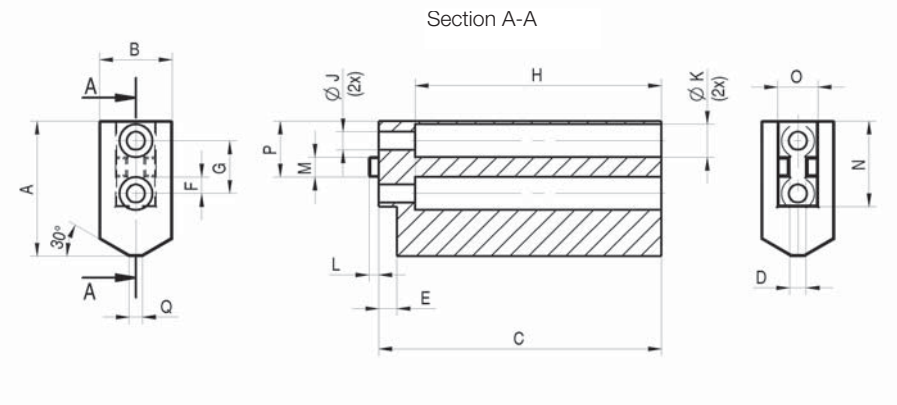
Magnetic field sensors

Item no.	Size (diameter/ length)	Design	For
1306268	C-Nut	2 m cable, open leads	RPP-A 50
1276722	C-Nut	3 m cable, open leads	RPP-A 64 - RPP-A 160

▲ on request

Accessories RPP-A

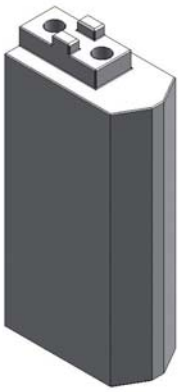


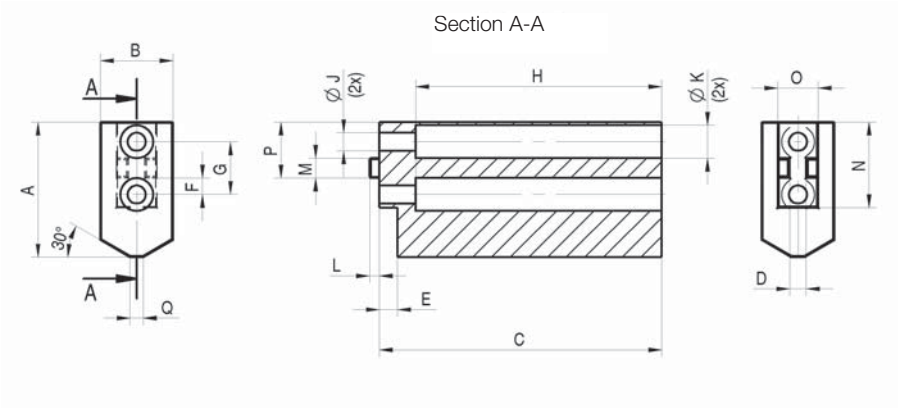


Jaw blank - steel (including fixing screws

RPP-A / RZP-A Jaw blank - steel	**50**	**64**	**80**	**100**	**125**	**160**
RPP-A - 2-jaw set	**170683**	**170675**	**170676**	**170677**	**170678**	**170679**
RZP-A - 3-jaw set	**-**	**170825**	**170826**	**170827**	**170828**	**170829**
A	26	32	41	51	60	80
B	15	20	22	30	35	40
C	50	68,5	85,5	105,5	130,5	166,5
D +0,01/+0,03	4	4	5	6	6	8
E+0,2	2	4,5	5,5	5,5	5,5	6,5
F±0,1	3,5	4	5	6	8	11
G±0,1	12	13	16	20	24	32
H	45,5	59,5	74,5	94,5	119,5	153,5
J	3,4	4,5	5,5	6,6	6,6	9
K	6	8	10	11	11	15
L	2	2,5	3	3	3,5	4
Mf7	5	5	6	8	8	10
N-0,3/-0,5	22,825	21	26	33	41	51
O-0,3/-0,5	8	10,2	12,2	14,2	16,2	20,2
P+0,1	12,5	14	17	21	25,5	31
Q	4	3	4	5	6	8
Weight per jaw Kg	0,13	0,26	0,46	1,0	1,8	3,5

Accessories RPP-A





Jaw blank - aluminium (including fixing screws)

RPP-A / RZP-A Jaw blank - aluminium	50	64	80	100	125	160
RPP-A - 2-jaw set	**170693**	**170685**	**170686**	**170687**	**170688**	**170689**
RZP-A - 3-jaw set	**-**	**170835**	**170836**	**170837**	**170838**	**170839**
A	26	32	41	51	60	80
B	15	20	22	30	35	40
C	50	68,5	85,5	105,5	130,5	166,5
D +0,01/+0,03	4	4	5	6	6	8
E+0,2	2	4,5	5,5	5,5	5,5	6,5
F±0,1	3,5	4	5	6	8	11
G±0,1	12	13	16	20	24	32
H	45,5	59,5	74,5	94,5	119,5	153,5
J	3,4	4,5	5,5	6,6	6,6	9
K	6	8	10	11	11	15
L	2	2,5	3	3	3,5	4
Mf7	5	5	6	8	8	10
N-0,3/-0,5	22,825	21	26	33	41	51
O-0,3/-0,5	8	10,2	12,2	14,2	16,2	20,2
P+0,1	12,5	14	17	21	25,5	31
Q	4	3	4	5	6	8
Weight per jaw Kg	0,13	0,1	0,16	0,35	0,62	1,2

Notes



NOMENCLATURE

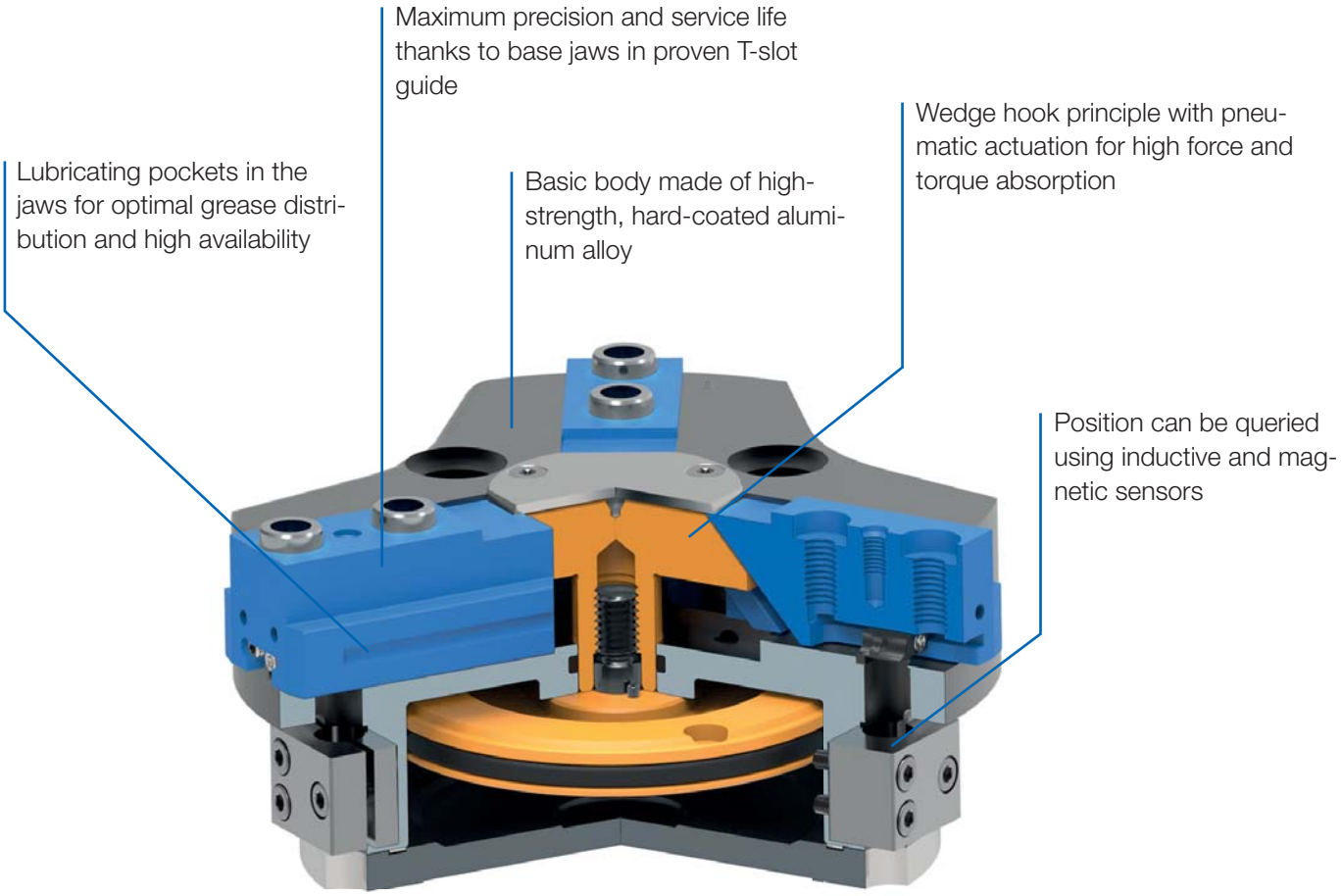
RZP	-A	- 100	-1	/ GA	/ V
RÖHM **Z** centric gripper **P**neumatic	**A =** Alternative jaw fixture by tongue and groove	**Sizes** 64 - 300	Jaw stroke variant **1** = long stroke **2** = short stroke	Optional: spring safety **GA** = outside grip **GI** = inside grip	Optional: **V** = Viton FKM-sealing for temperatures up to 150 °C

3-JAW CENTRIC GRIPPER

Equipped with three centrically arranged gripper fingers, RÖHM RZP grippers are optimally suited for universal and self-centering gripping of round workpieces. Especially on robots or portals, the 3-jaw centric grippers will convince you with their compact design, low dead weight and high gripping force.

ADVANTAGES AT A GLANCE

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide



RZP-64



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 300, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

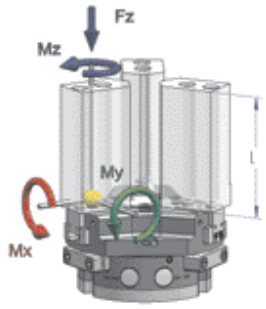
C40
RZP-64 - 3-jaw centric gripper air operated

Item no.	170050	170051 ▲	170052	170053 ▲	170054	170055 ▲
Design	RZP-64/3-1	RZP-64/3-2	RZP-64/3-1 GA	RZP-64/3-2 GA	RZP-64/3-1 GI	RZP-64/3-2 GI
Gripping force at 6 bar N	650	1200	850	1600	900	1700
Stroke per jaw mm	6	3	6	3	6	3
Gripping force maintained N	-	-	200	400	200	400
Recommended workpiece weight kg	3,2	6	3,2	6	3,2	6
Weight kg	0,45	0,45	0,55	0,55	0,55	0,55
Height mm	43,3	43,3	56,8	56,8	56,8	56,8
Ø mm	76	76	76	76	76	76
Mx Nm	40	40	40	40	40	40
My Nm	60	60	60	60	60	60
Mz Nm	40	40	40	40	40	40
Fz N	1100	1100	1100	1100	1100	1100
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,03	0,03	0,02	0,02	0,04	0,04
Opening time s	0,03	0,03	0,04	0,04	0,02	0,02
Air consumption per cycle cm^3	25	25	25	25	25	25
Max. allowable length of jaw mm	90	85	85	80	85	80

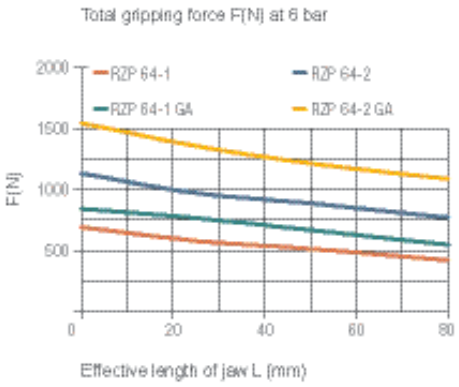
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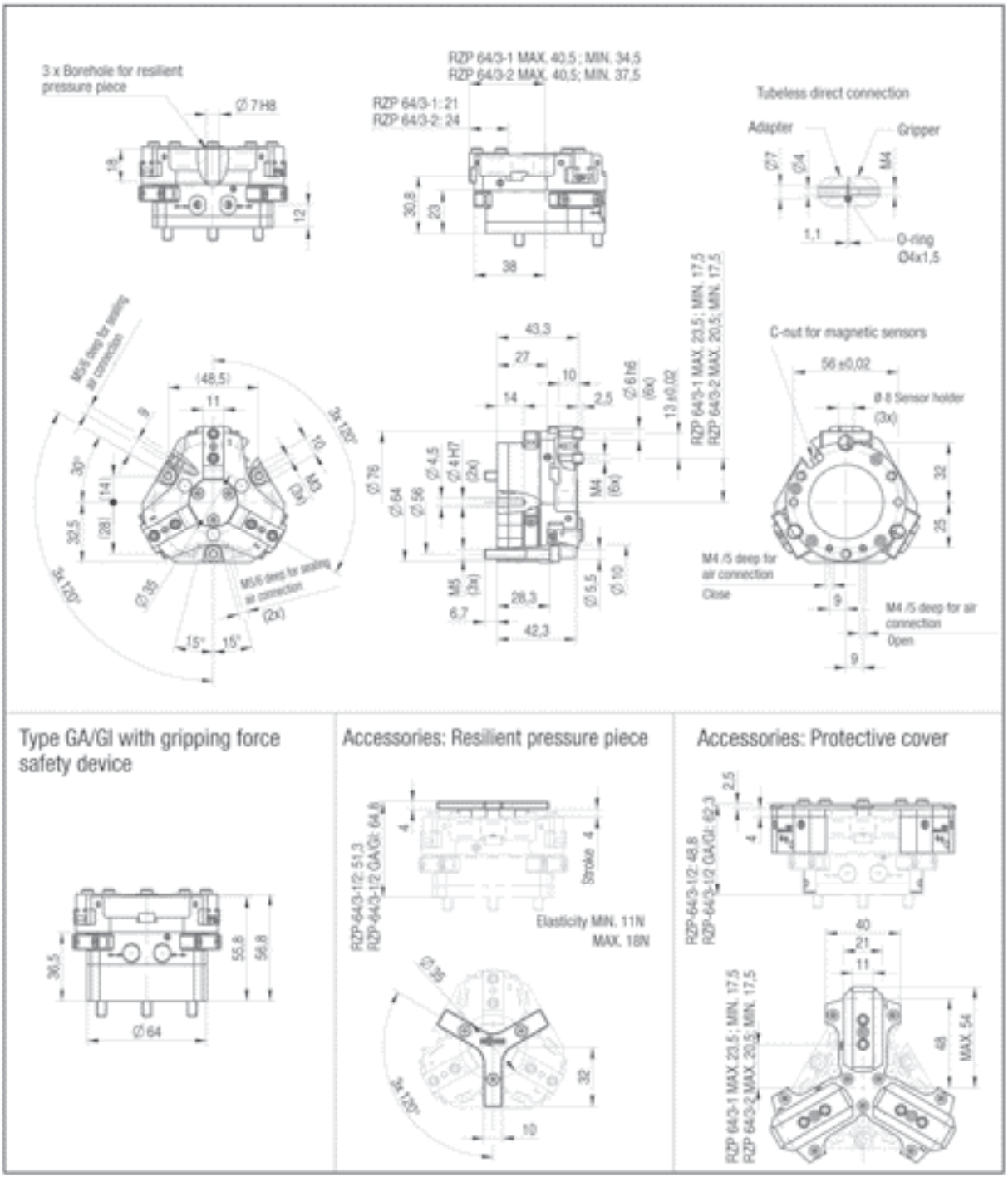
RZP-64

Max. load on gripper and jaw



Clamping force diagram exterior gripping





RZP-80



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 300, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

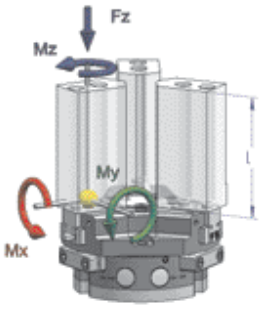
C40
RZP-80 - 3-jaw centric gripper air operated

Item no.	170056	170057 ▲	170058	170059 ▲	170060	170061 ▲
Design	RZP-80/3-1	RZP-80/3-2	RZP-80/3-1 GA	RZP-80/3-2 GA	RZP-80/3-1 GI	RZP-80/3-2 GI
Gripping force at 6 bar N	1200	2400	1550	3100	1700	3250
Stroke per jaw mm	8	4	8	4	8	4
Gripping force maintained N	-	-	350	700	350	700
Recommended workpiece weight kg	6	12	6	12	6	12
Weight kg	0,8	0,8	1	1	1	1
Height mm	49,3	49,3	64,3	64,3	64,3	64,3
Ø mm	96	96	96	96	96	96
Mx Nm	60	60	60	60	60	60
My Nm	95	95	95	95	95	95
Mz Nm	55	55	55	55	55	55
Fz N	1500	1500	1500	1500	1500	1500
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,05	0,05	0,03	0,03	0,06	0,06
Opening time s	0,05	0,05	0,05	0,05	0,04	0,04
Air consumption per cycle cm^3	60	60	60	60	60	60
Max. allowable length of jaw mm	110	105	100	100	105	100

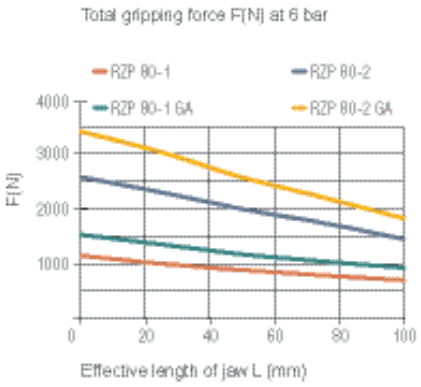
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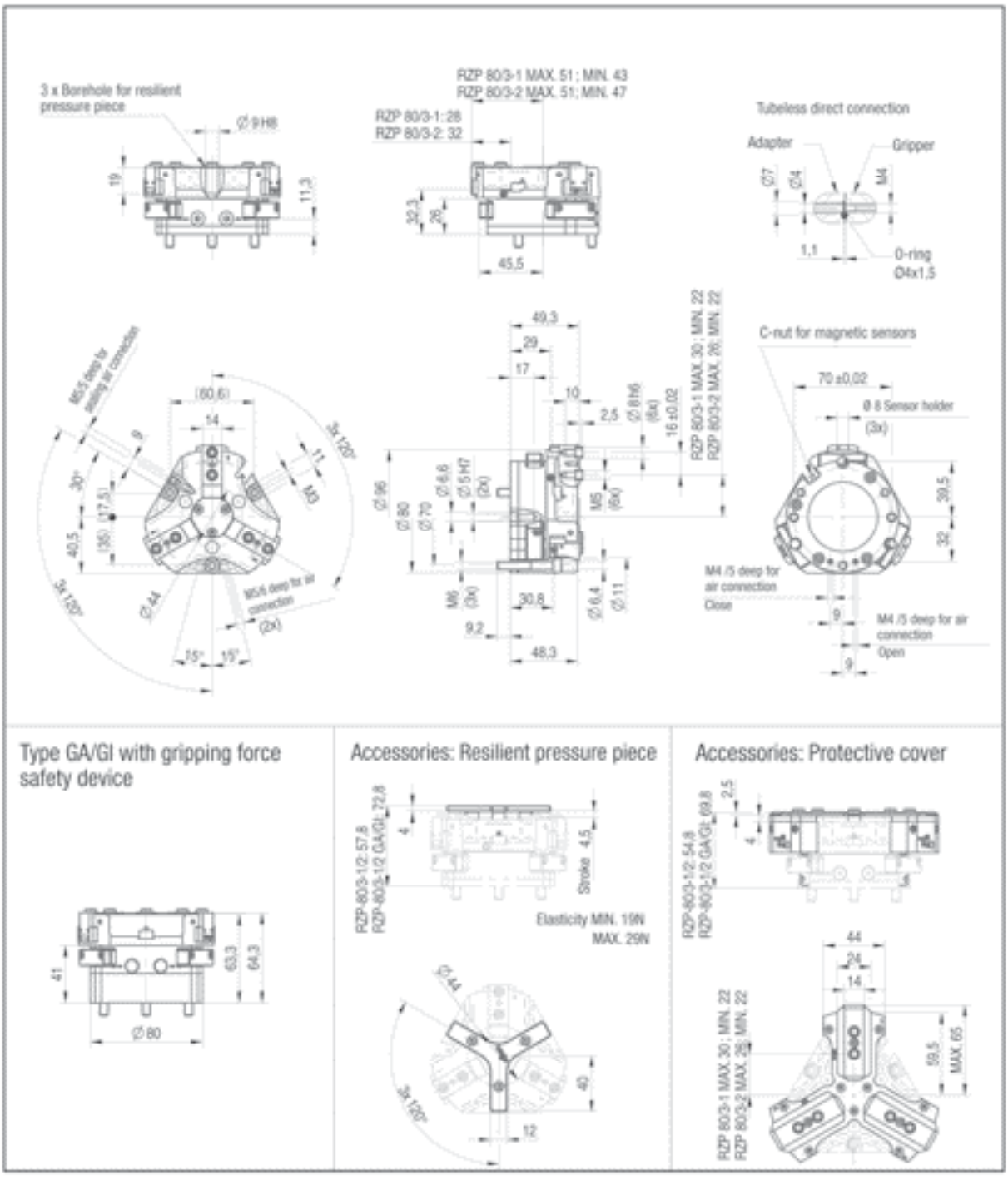
RZP-80

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Centric gripper RZP

RZP-100



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 300, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

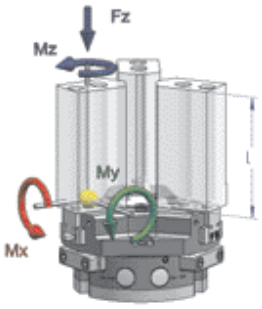
C40
RZP-100 - 3-jaw centric gripper air operated

Item no.	170062	170063 ▲	170064	170065 ▲	170066	170067 ▲
Design	RZP-100/3-1	RZP-100/3-2	RZP-100/3-1 GA	RZP-100/3-2 GA	RZP-100/3-1 GI	RZP-100/3-2 GI
Gripping force at 6 bar N	2000	4000	2650	5300	2800	5620
Stroke per jaw mm	10	5	10	5	10	5
Gripping force maintained N	-	-	650	1300	650	1300
Recommended workpiece weight kg	10	20	10	20	10	20
Weight kg	1,4	1,4	2	2	2	2
Height mm	59,3	59,3	79,3	79,3	79,3	79,3
Ø mm	120	120	120	120	120	120
Mx Nm	80	80	80	80	80	80
My Nm	115	115	115	115	115	115
Mz Nm	70	70	70	70	70	70
Fz N	2000	2000	2000	2000	2000	2000
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,1	0,1	0,1	0,1	0,2	0,2
Opening time s	0,1	0,1	0,2	0,2	0,1	0,1
Air consumption per cycle cm^3	120	120	120	120	120	120
Max. allowable length of jaw mm	145	135	135	125	135	125

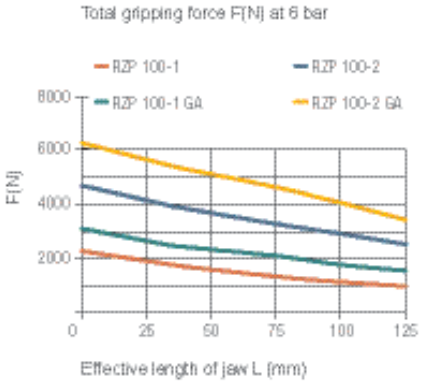
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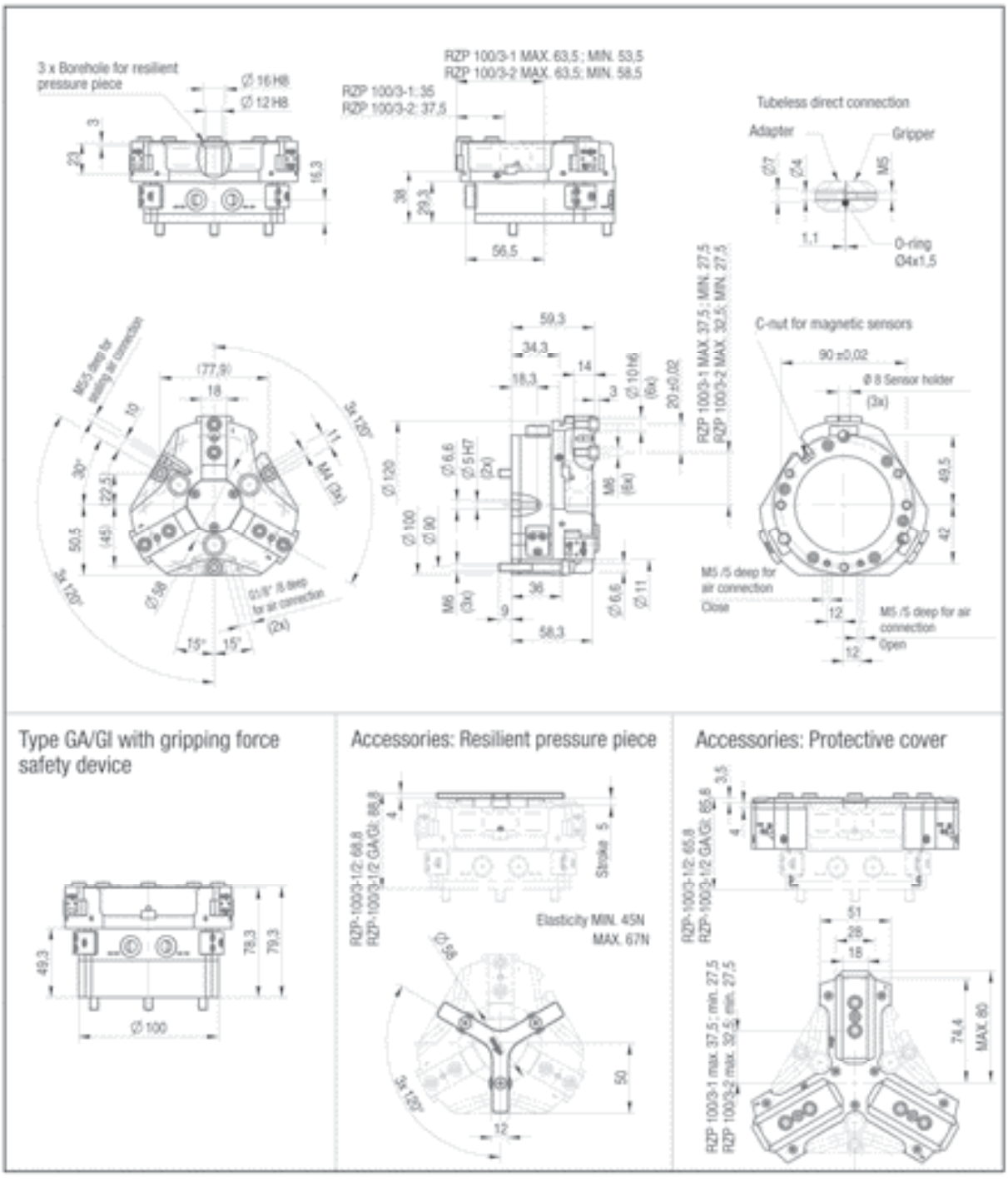
RZP-100

Max. load on gripper and jaw



Clamping force diagram exterior gripping





RZP-125



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 300, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

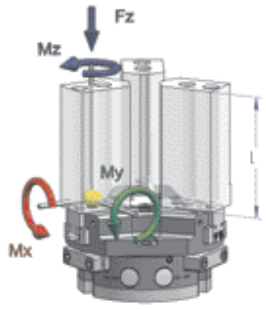
C40
RZP-125 - 3-jaw centric gripper air operated

Item no.	170068	170069 ▲	170070	170071 ▲	170072	170073 ▲
Design	RZP-125/3-1	RZP-125/3-2	RZP-125/3-1 GA	RZP-125/3-2 GA	RZP-125/3-1 GI	RZP-125/3-2 GI
Gripping force at 6 bar N	3200	6000	4200	7800	4400	8000
Stroke per jaw mm	13	6	13	6	13	6
Gripping force maintained N	-	-	1000	1800	1000	1800
Recommended workpiece weight kg	16	30	16	30	16	30
Weight kg	2,4	2,4	3,2	3,2	3,2	3,2
Height mm	67	67	91,5	91,5	91,5	91,5
Ø mm	150	150	150	150	150	150
Mx Nm	120	120	120	120	120	120
My Nm	145	145	145	145	145	145
Mz Nm	100	100	100	100	100	100
Fz N	2800	2800	2800	2800	2800	2800
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,2	0,2	0,17	0,17	0,35	0,35
Opening time s	0,2	0,2	0,35	0,35	0,17	0,17
Air consumption per cycle cm^3	230	230	230	230	230	230
Max. allowable length of jaw mm	180	170	170	160	170	160

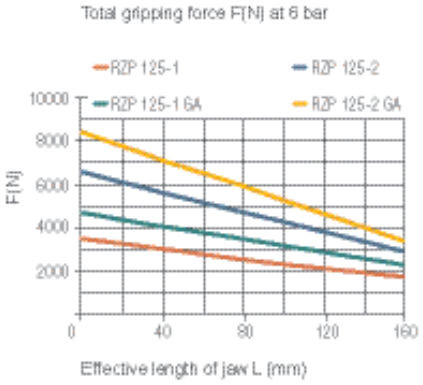
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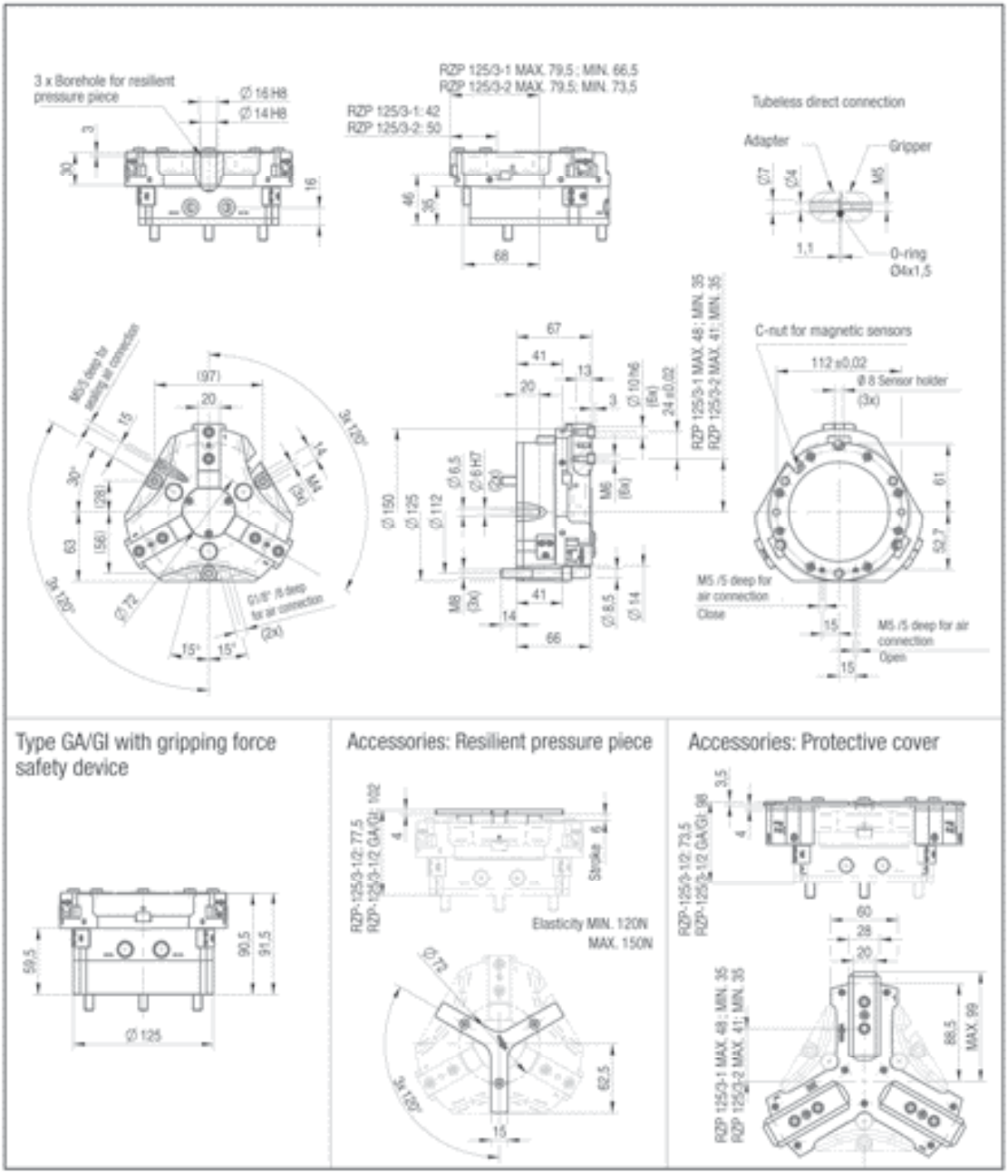
RZP-125

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Centric gripper RZP

RZP-160



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 300, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

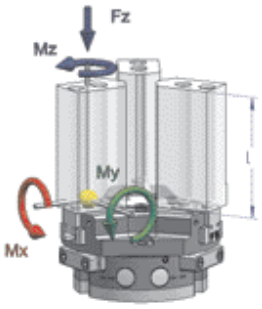
C40
RZP-160 - 3-jaw centric gripper air operated

Item no.	170074	170075 ▲	170076	170077 ▲	170078	170079 ▲
Design	RZP-160/3-1	RZP-160/3-2	RZP-160/3-1 GA	RZP-160/3-2 GA	RZP-160/3-1 GI	RZP-160/3-2 GI
Gripping force at 6 bar N	6000	11000	8000	15000	8500	16000
Stroke per jaw mm	16	8	16	8	16	8
Gripping force maintained N	-	-	2000	4000	2000	4000
Recommended workpiece weight kg	30	55	30	55	30	55
Weight kg	5,5	5,5	8	8	8	8
Height mm	81	81	111	111	111	111
Ø mm	190	190	190	190	190	190
Mx Nm	170	170	170	170	170	170
My Nm	180	180	180	180	180	180
Mz Nm	130	130	130	130	130	130
Fz N	4300	4300	4300	4300	4300	4300
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,5	0,5	0,4	0,4	0,8	0,8
Opening time s	0,5	0,5	0,8	0,8	0,4	0,4
Air consumption per cycle cm^3	520	520	520	520	520	520
Max. allowable length of jaw mm	220	210	210	200	200	200

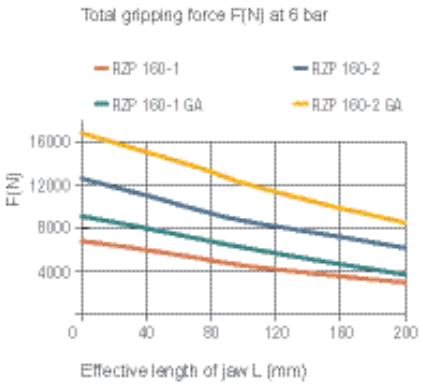
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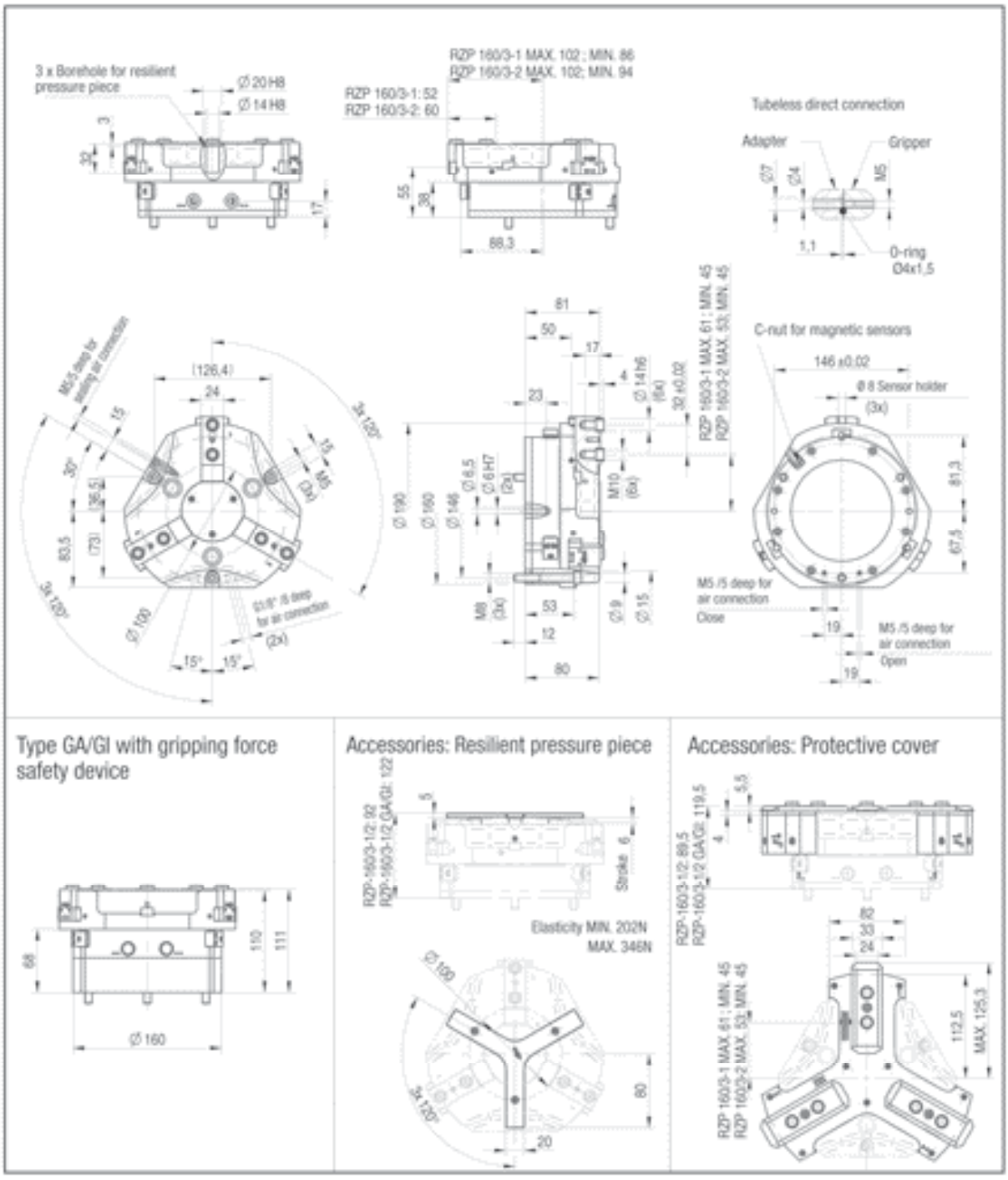
RZP-160

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Centric gripper RZP

RZP-200



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 300, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

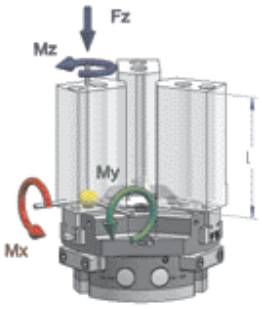
C40
RZP-200 - 3-jaw centric gripper air operated

Item no.	170080	170081 ▲	170082	170083 ▲	170084	170085 ▲
Design	RZP-200/3-1	RZP-200/3-2	RZP-200/3-1 GA	RZP-200/3-2 GA	RZP-200/3-1 GI	RZP-200/3-2 GI
Gripping force at 6 bar N	7500	12500	9300	15500	9500	16200
Stroke per jaw mm	25	14	25	14	25	14
Gripping force maintained N	-	-	1800	3000	1800	3000
Recommended workpiece weight kg	37	62	37	62	37	62
Weight kg	10	10	13	13	13	13
Height mm	96	96	132	132	132	132
Ø mm	250	250	250	250	250	250
Mx Nm	180	180	180	180	180	180
My Nm	200	200	200	200	200	200
Mz Nm	100	100	100	100	100	100
Fz N	5000	5000	5000	5000	5000	5000
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	1,2	1,2	1	1	1,5	1,5
Opening time s	1,2	1,2	1,5	1,5	1	1
Air consumption per cycle cm^3	1000	1000	1000	1000	1000	1000
Max. allowable length of jaw mm	280	250	250	200	250	200

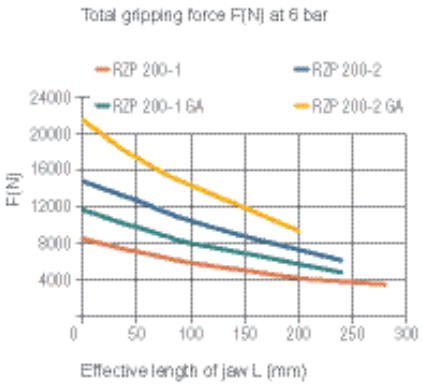
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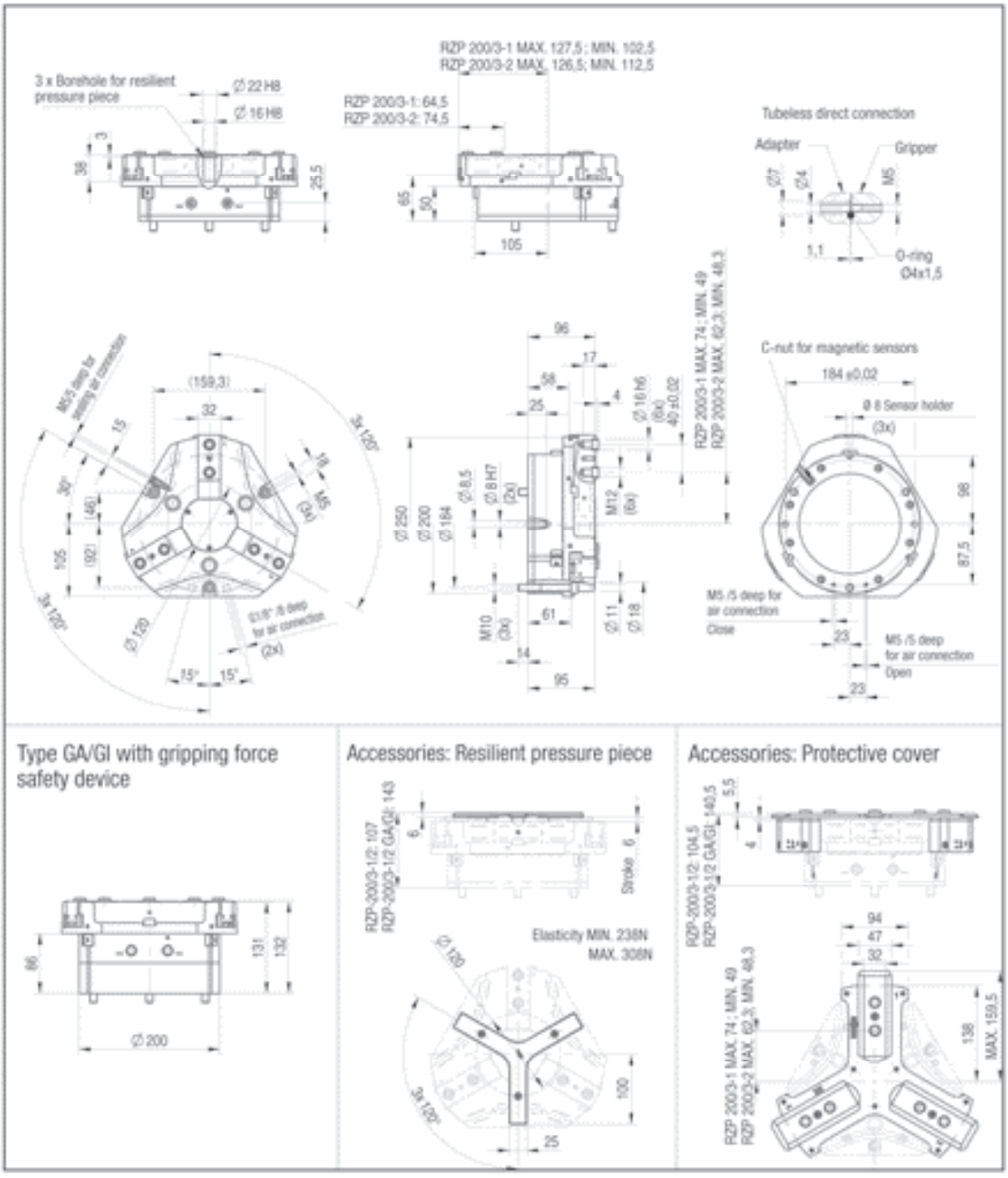
RZP-200

Max. load on gripper and jaw



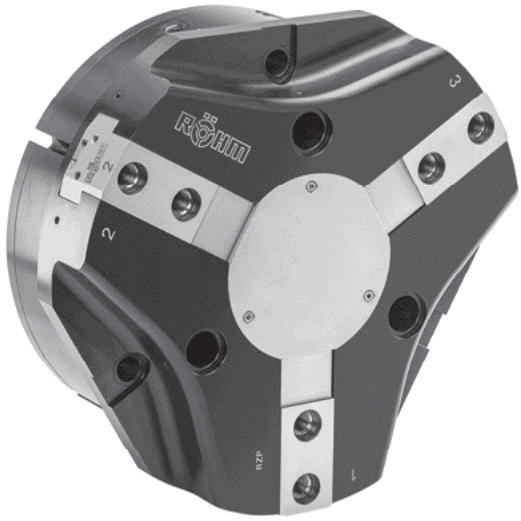
Clamping force diagram exterior gripping





Centric gripper RZP

RZP-240



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 300, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

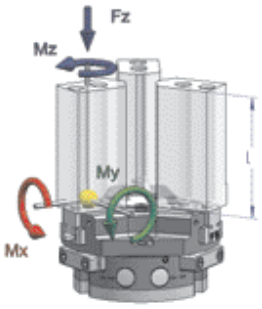
C40
RZP-240 - 3-jaw centric gripper air operated

Item no.	170086	170087 ▲	170088	170089 ▲	170090	170091 ▲
Design	RZP-240/3-1	RZP-240/3-2	RZP-240/3-1 GA	RZP-240/3-2 GA	RZP-240/3-1 GI	RZP-240/3-2 GI
Gripping force at 6 bar N	10500	18000	14000	24000	15000	25000
Stroke per jaw mm	30	17	30	17	30	17
Gripping force maintained N	-	-	3500	6000	3500	6000
Recommended workpiece weight kg	53	90	53	90	53	90
Weight kg	20	20	24	24	24	24
Height mm	128,1	128,1	171,5	171,5	171,5	171,5
Ø mm	290	290	290	290	290	290
Mx Nm	265	265	265	265	265	265
My Nm	250	250	250	250	250	250
Mz Nm	160	160	160	160	160	160
Fz N	6200	6200	6200	6200	6200	6200
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	1,3	1,3	1,1	1,1	1,7	1,7
Opening time s	1,3	1,3	2,1	2,1	1,1	1,1
Air consumption per cycle cm^3	1700	1700	1700	1700	1700	1700
Max. allowable length of jaw mm	300	250	250	200	250	200

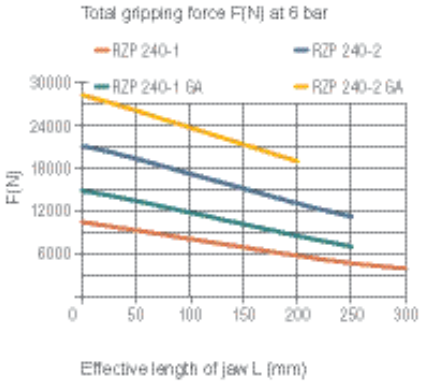
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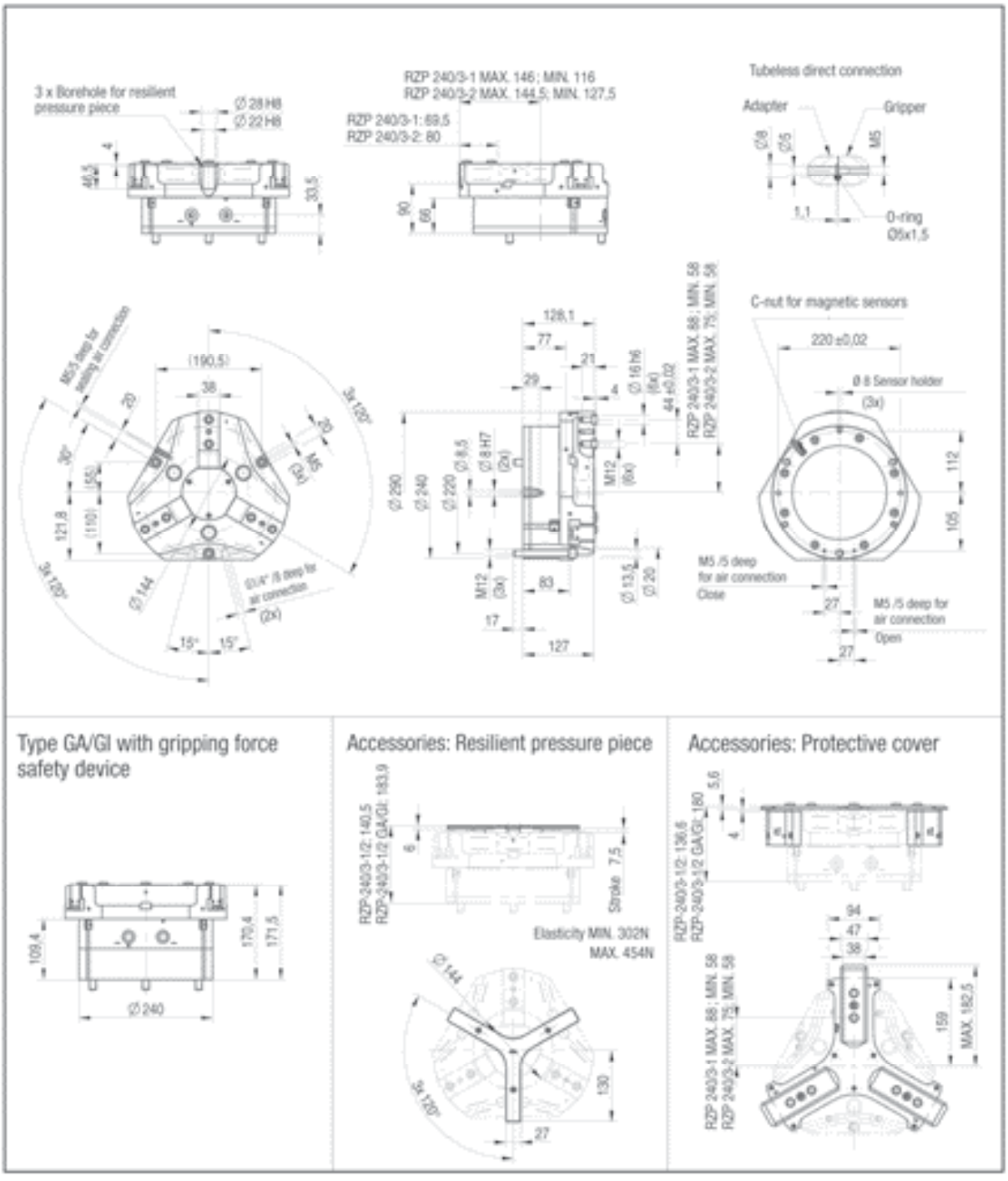
RZP-240

Max. load on gripper and jaw

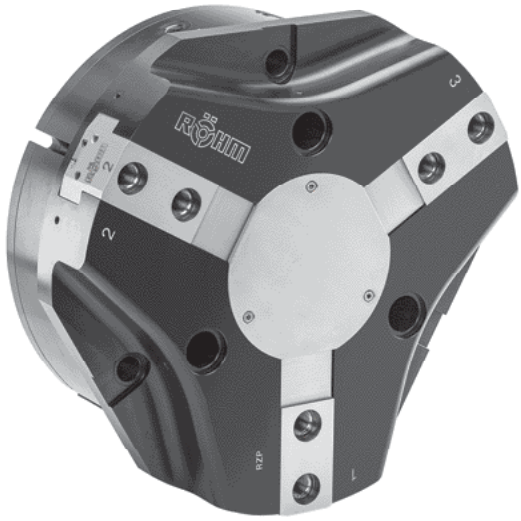


Clamping force diagram exterior gripping





RZP-300



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 300, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

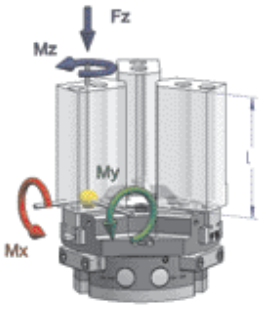
C40
RZP-300 - 3-jaw centric gripper air operated

Item no.	170092	170093 ▲	170094	170095 ▲	170096	170097 ▲
Design	RZP-300/3-1	RZP-300/3-2	RZP-300/3-1 GA	RZP-300/3-2 GA	RZP-300/3-1 GI	RZP-300/3-2 GI
Gripping force at 6 bar N	16000	28000	20000	37500	22500	38000
Stroke per jaw mm	35	20	35	20	35	20
Gripping force maintained N	-	-	6000	9500	6000	9500
Recommended workpiece weight kg	80	140	80	110	80	140
Weight kg	30	30	40	40	40	40
Height mm	146	146	196	196	196	196
Ø mm	345	345	345	345	345	345
Mx Nm	400	400	400	400	400	400
My Nm	400	400	400	400	400	400
Mz Nm	250	250	250	250	250	250
Fz N	8000	8000	8000	8000	8000	8000
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	1,3	1,3	1,2	1,2	2	2
Opening time s	1,3	1,3	2,5	2,5	1,2	1,2
Air consumption per cycle cm^3	2700	2700	2700	2700	2700	2700
Max. allowable length of jaw mm	250	225	225	200	225	200

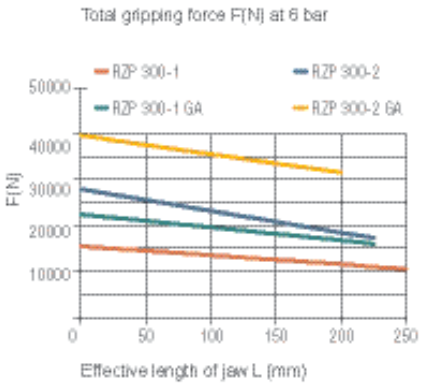
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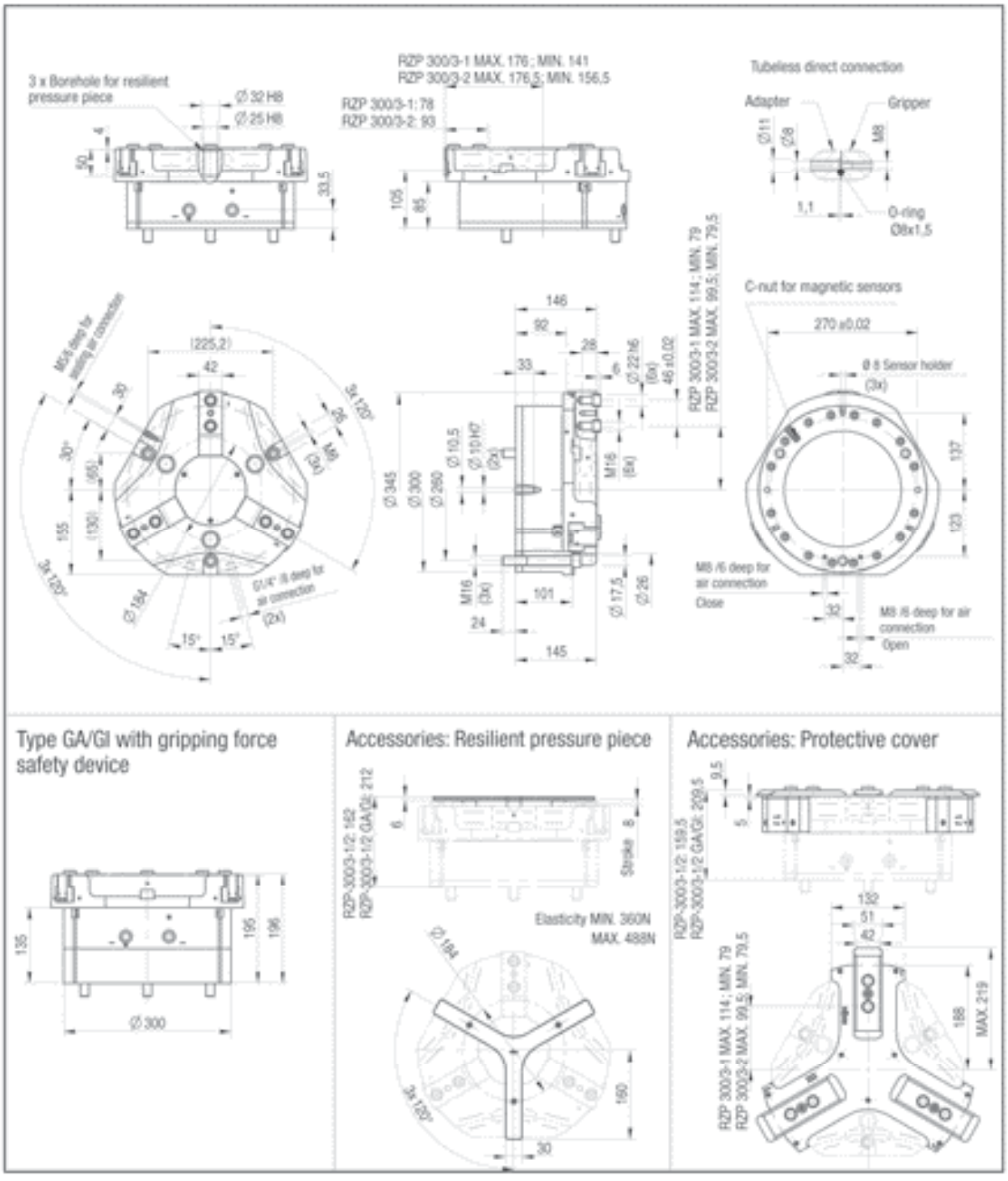
RZP-300

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Centric gripper RZP

Accessories RZP



Jaw blank - steel (including fixing screws)
3-jaw set

Item no.	Number of jaws	Design	For
170500 ▲	3	steel	RZP-64
170502 ▲	3	steel	RZP-80
170504 ▲	3	steel	RZP-100
170506 ▲	3	steel	RZP-125
170508 ▲	3	steel	RZP-160
170510 ▲	3	steel	RZP-200
170512 ▲	3	steel	RZP-240
170514 ▲	3	steel	RZP-300



Jaw blank - aluminium (including fixing screws)
3-jaw set

Item no.	Number of jaws	Design	For
170550 ▲	3	aluminium	RZP-64
170552 ▲	3	aluminium	RZP-80
170554 ▲	3	aluminium	RZP-100
170556 ▲	3	aluminium	RZP-125
170558 ▲	3	aluminium	RZP-160
170560 ▲	3	aluminium	RZP-200
170562 ▲	3	aluminium	RZP-240
170564 ▲	3	aluminium	RZP-300



Protective cover

Item no.	For
170810 ▲	RZP-64
170811 ▲	RZP-80
170812 ▲	RZP-100
170813 ▲	RZP-125
170814 ▲	RZP-160
170815 ▲	RZP-200
170816 ▲	RZP-240
170817 ▲	RZP-300



Resilient pressure piece

Item no.	For
170516 ▲	RZP-64
170517 ▲	RZP-80
170518 ▲	RZP-100
170519 ▲	RZP-125
170520 ▲	RZP-160
170521 ▲	RZP-200
170522 ▲	RZP-240
170523 ▲	RZP-300



Pressure maintenance
for double acting gripper (G1/8)

Item no.
1078823



Compressed air connection

Item no.	Design	For
802539	L-Plug connector M5 - 6 mm	RZP-50 / RZP-64 / RZP-80
477025	L-Plug connector 1/8 - 6 mm	RZP-100 - RZP-240
477024	L-Plug connector 1/4 - 6 mm	RZP-300



Proximity switch

Item no.	Size (diameter/ length)	Design	For
229114	M8x1x30,5	5 m cable, open leads	RZP-64 / RZP-80 / RZP-100 / RZP-125 / RZP-160
389661	M8x1x46,5	3 m cable, open leads	RZP-200 / RZP-240 / RZP-300



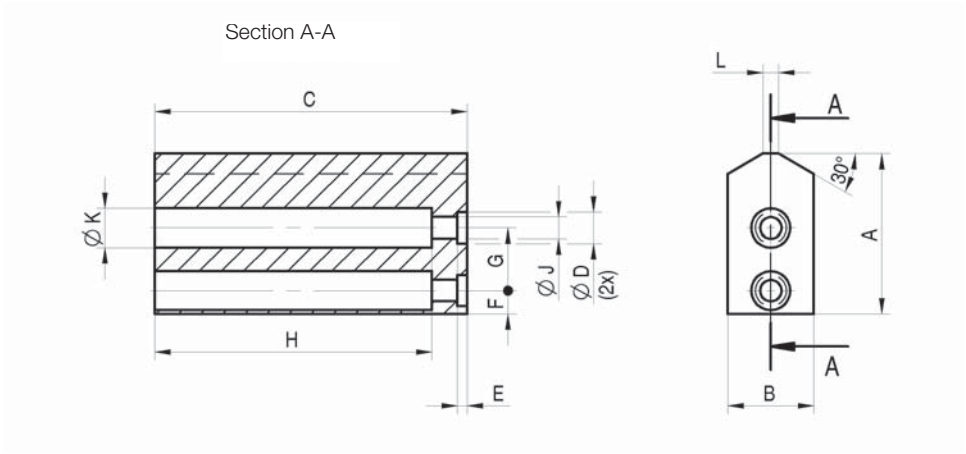
Magnetic field sensors

Item no.	Size (diameter/ length)	Design	For
1276722	C-Nut	3m cable, 3 open leads	all sizes, all types

▲ on request

Accessories RZP

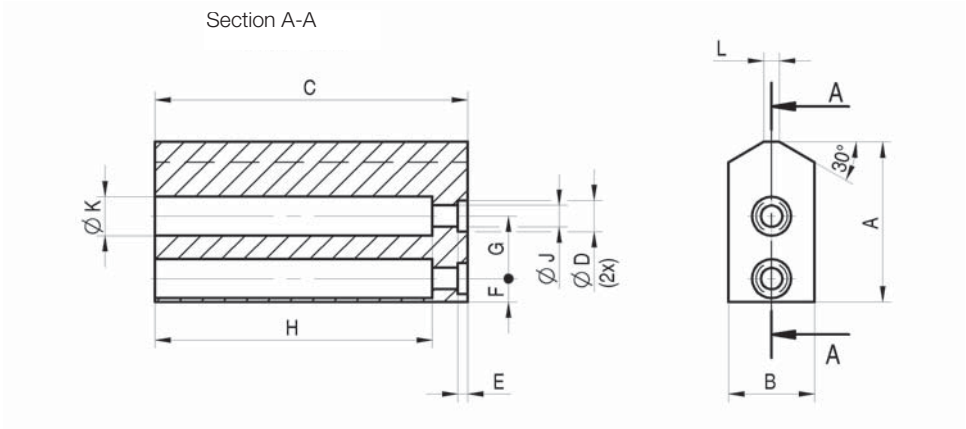




Jaw blank - steel (including fixing screws)

RPP / RZP	64	80	100	125	160	200	240	300
RPP - 2-jaw set	**170575**	**170576**	**170577**	**170578**	**170579**	**170580**	**170581**	**170582**
RZP - 3-jaw set	**170500**	**170502**	**170504**	**170506**	**170508**	**170510**	**170512**	**170514**
A	32	41	51	60	80	96	109	130
B	20	22	30	35	40	40	50	60
C	64	80	100	125	160	200	220	200
D +0,04/+0,02	6	8	10	10	14	16	16	22
E±0,2	2,5	2,5	3	3	4	4	4	6
F±0,1	5	6	7	9,5	10	15	15,5	20
G±0,1	13	16	20	24	32	40	44	46
H	57	71	91	115	146	181	204	177
J	4,5	5,5	6,6	6,6	11	13,5	13,5	17,5
K	8	10	11	11	18	20	20	26
L	3	4	5	6	8	13	10	16
Weight per jaw Kg	0,25	0,45	1,0	1,75	3,2	5,0	8,0	10,2





Jaw blank - aluminium (including fixing screws)

RPP / RZP	64	80	100	125	160	200	240	300
RPP - 2-jaw set	**170585**	**170586**	**170587**	**170588**	**170589**	**170590**	**170591**	**170592**
RZP - 3-jaw set	**170550**	**170552**	**170554**	**170556**	**170558**	**170560**	**170562**	**170564**
A	32	41	51	60	80	96	109	130
B	20	25	30	35	40	45	50	60
C	64	80	100	125	160	200	220	200
D +0,04/+0,02	6	8	10	10	14	16	16	22
E±0,2	2,5	2,5	3	3	4	4	4	6
F±0,1	5	6	7	9,5	10	15	15,5	20
G±0,1	13	16	20	24	32	40	44	46
H	55	69	88	112	141	176	200	170
J	4,5	5,5	6,6	6,6	11	13,5	13,5	17,5
K	8	10	11	11	18	20	20	26
L	3	4	5	6	8	9	10	16
Weight per jaw Kg	0,1	0,18	0,35	0,6	1,2	2,0	2,8	3,4

RZP-A 64



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 160, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

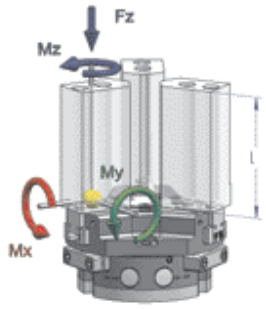
- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RZP-A 64 - 3-jaw centric gripper air operated with tongue and groove

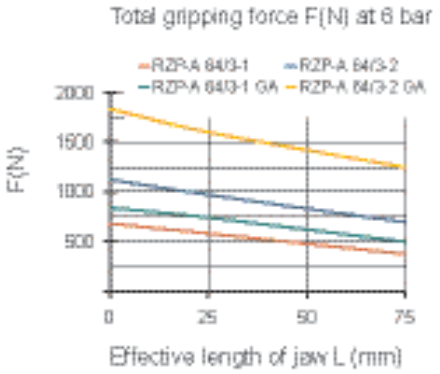
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Design	RZP-A 64/3-1	RZP-A 64/3-2	RZP-A 64/3-1 GA	RZP-A 64/3-2 GA	RZP-A 64/3-1 GI	RZP-A 64/3-2 GI
Gripping force at 6 bar N	700	1350	880	1700	1000	1900
Stroke per jaw mm	6	3	6	3	6	3
Gripping force maintained N	-	-	180	350	180	350
Recommended workpiece weight kg	3,5	6,5	3,5	6,5	3,5	6,5
Weight kg	0,4	0,4	0,5	0,5	0,5	0,5
Height mm	42	42	55,5	55,5	55,5	55,5
Ø mm	64	64	64	64	64	64
Mx Nm	15	15	15	15	15	15
My Nm	30	30	30	30	30	30
Mz Nm	25	25	25	25	25	25
Fz N	1400	1400	1400	1400	1400	1400
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,01	0,01	0,03	0,03	0,04	0,04
Opening time s	0,01	0,01	0,04	0,04	0,03	0,03
Air consumption per cycle cm^3	25	25	25	25	25	25
Max. allowable length of jaw mm	64	64	64	64	64	64

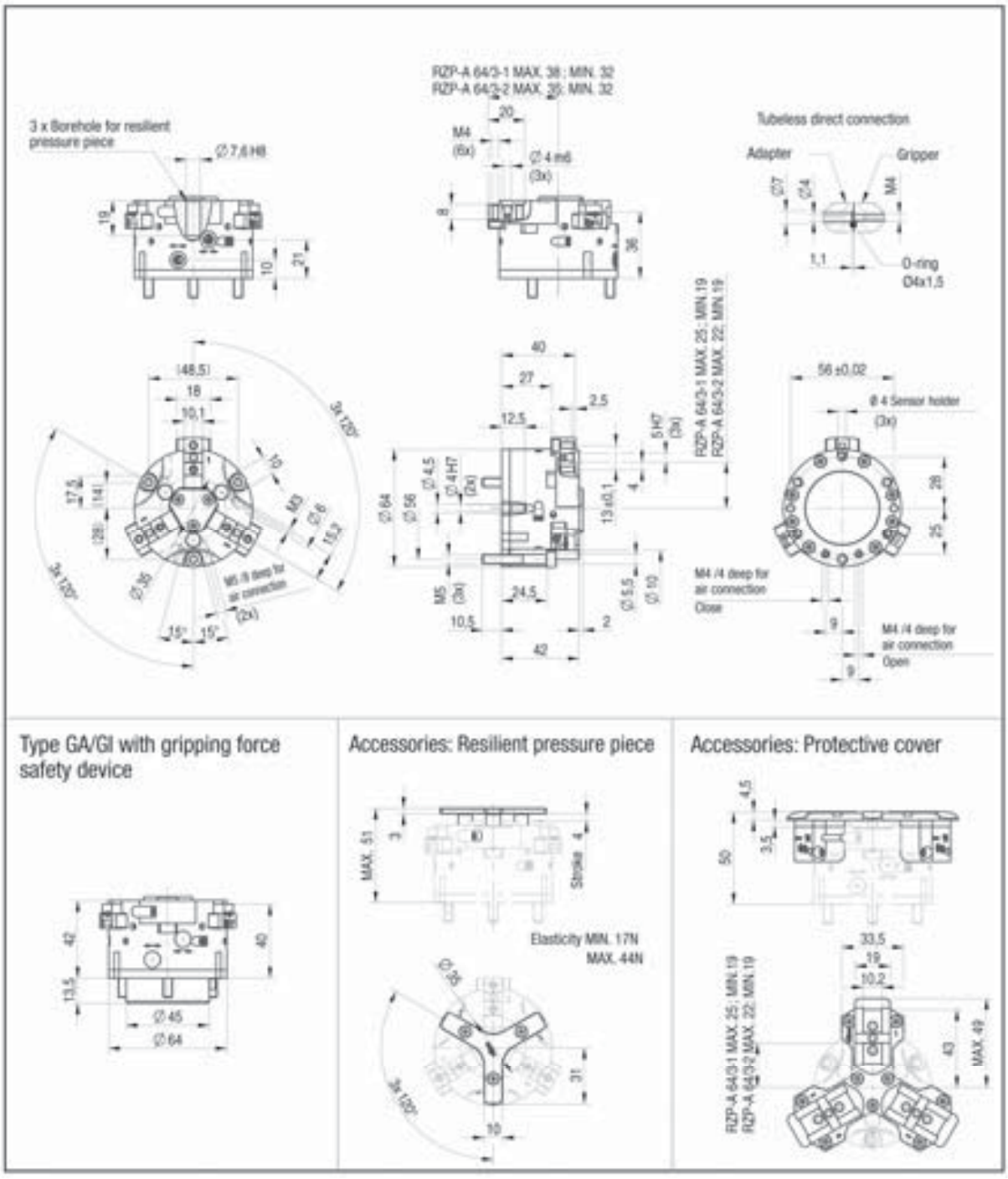
RZP-A 64

Max. load on gripper and jaw



Clamping force diagram exterior gripping





RZP-A 80



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 160, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

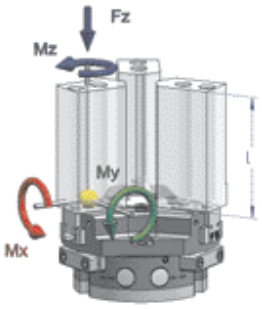
- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RZP-A 80 - 3-jaw centric gripper air operated with tongue and groove

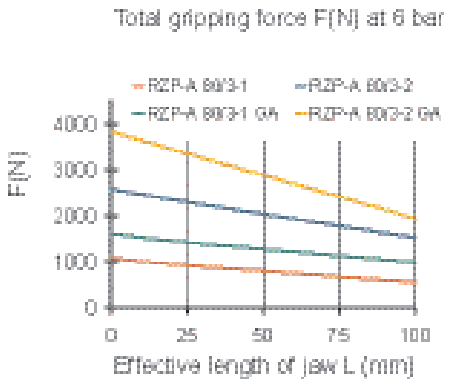
Item no.	434833 ▲	435042 ▲	434837 ▲	435043 ▲	434838 ▲	435044 ▲
Design	RZP-A 80/3-1	RZP-A 80/3-2	RZP-A 80/3-1 GA	RZP-A 80/3-2 GA	RZP-A 80/3-1 GI	RZP-A 80/3-2 GI
Gripping force at 6 bar N	1000	2500	1600	3400	1700	3500
Stroke per jaw mm	8	4	8	4	8	4
Gripping force maintained N	-	-	350	700	350	700
Recommended workpiece weight kg	5	12	5	12	5	12
Weight kg	0,75	0,75	0,95	0,95	0,95	0,95
Height mm	48	48	63	63	63	63
Ø mm	80	80	80	80	80	80
Mx Nm	30	30	30	30	30	30
My Nm	90	90	90	90	90	90
Mz Nm	35	35	35	35	35	35
Fz N	1800	1800	1800	1800	1800	1800
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,06	0,06	0,05	0,05	0,08	0,08
Opening time s	0,05	0,05	0,08	0,08	0,05	0,05
Air consumption per cycle cm^3	60	60	60	60	60	60
Max. allowable length of jaw mm	80	80	80	80	80	80

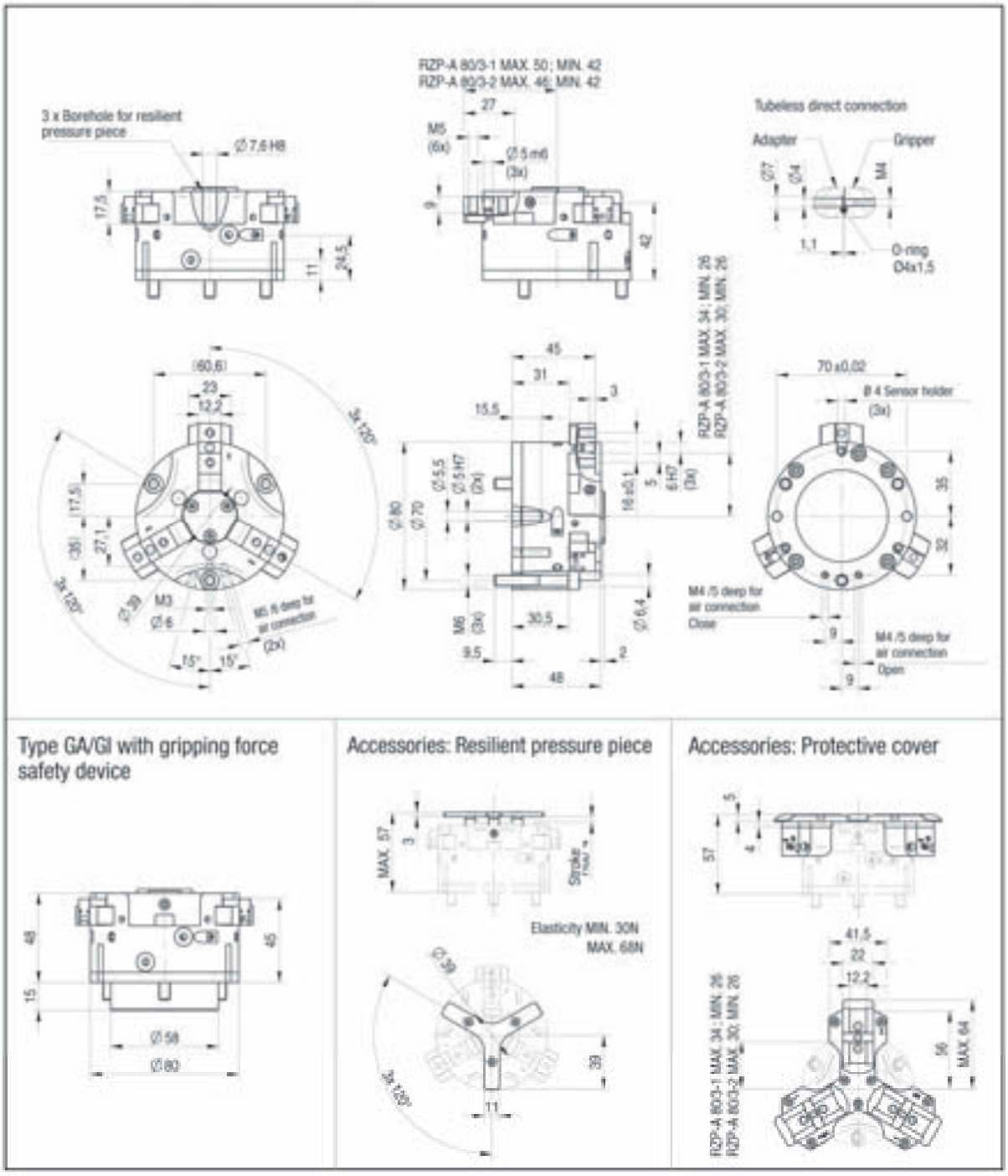
RZP-A 80

Max. load on gripper and jaw



Clamping force diagram exterior gripping





RZP-A 100



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 160, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

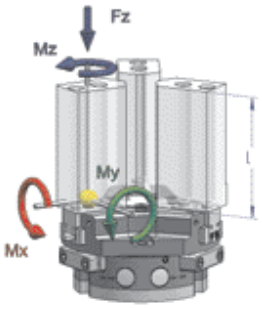
- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RZP-A 100 - 3-jaw centric gripper air operated with tongue and groove

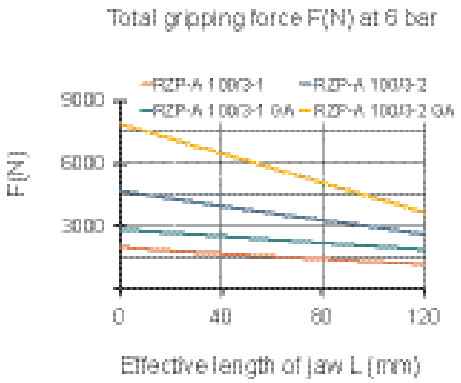
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Design	RZP-A 100/3-1	RZP-A 100/3-2	RZP-A 100/3-1 GA	RZP-A 100/3-2 GA	RZP-A 100/3-1 GI	RZP-A 100/3-2 GI
Gripping force at 6 bar N	2000	4000	2500	5000	2650	5100
Stroke per jaw mm	10	5	10	5	10	5
Gripping force maintained N	-	-	500	1000	500	1000
Recommended workpiece weight kg	10	20	10	20	10	20
Weight kg	1,3	1,3	1,9	1,9	1,9	1,9
Height mm	58	58	78	78	78	78
Ø mm	100	100	100	100	100	100
Mx Nm	45	45	45	45	45	45
My Nm	95	95	95	95	95	95
Mz Nm	45	45	45	45	45	45
Fz N	2300	2300	2300	2300	2300	2300
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,1	0,1	0,1	0,1	0,2	0,2
Opening time s	0,1	0,1	0,2	0,2	0,1	0,1
Air consumption per cycle cm^3	120	120	120	120	120	120
Max. allowable length of jaw mm	100	100	100	100	100	100

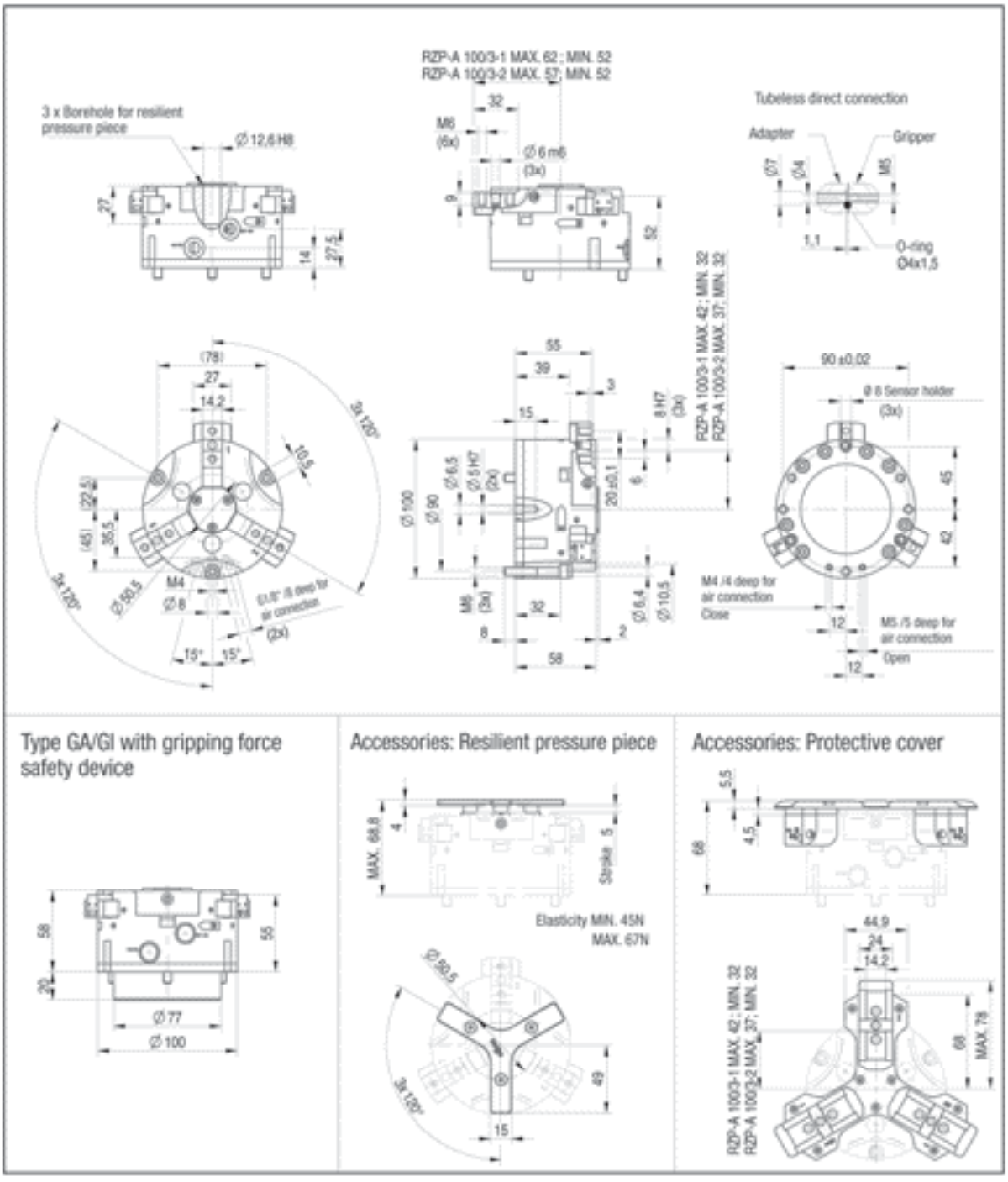
RZP-A 100

Max. load on gripper and jaw



Clamping force diagram exterior gripping





RZP-A 125



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 160, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

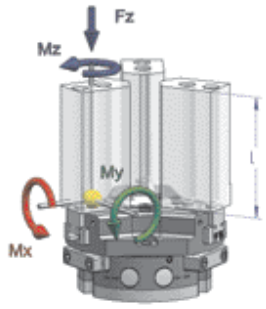
C40
RZP-A 125 - 3-jaw centric gripper air operated with tongue and groove

Item no.	434841 ▲	434902 ▲	434842 ▲	434914 ▲	434843 ▲	434915 ▲
Design	RZP-A 125/3-1	RZP-A 125/3-2	RZP-A 125/3-1 GA	RZP-A 125/3-2 GA	RZP-A 125/3-1 GI	RZP-A 125/3-2 GI
Gripping force at 6 bar N	3300	6500	4200	8100	4300	8300
Stroke per jaw mm	13	6	13	6	13	6
Gripping force maintained N	-	-	900	1600	800	1600
Recommended workpiece weight kg	16	32	16	32	16	32
Weight kg	2,3	2,3	3,4	3,4	3,4	3,4
Height mm	66	66	80,5	80,5	80,5	80,5
Ø mm	125	125	125	125	125	125
Mx Nm	60	60	60	60	60	60
My Nm	100	100	100	100	100	100
Mz Nm	70	70	70	70	70	70
Fz N	2500	2500	2500	2500	2500	2500
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,2	0,2	0,15	0,15	0,35	0,35
Opening time s	0,2	0,2	0,35	0,35	0,15	0,15
Air consumption per cycle cm^3	230	230	230	230	230	230
Max. allowable length of jaw mm	125	125	125	125	125	125

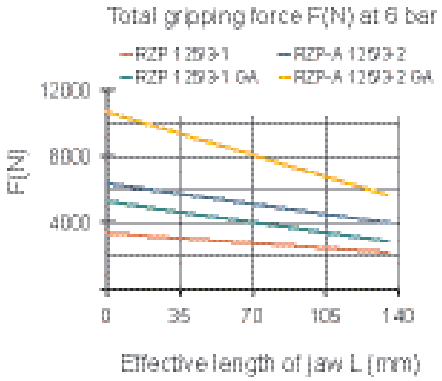
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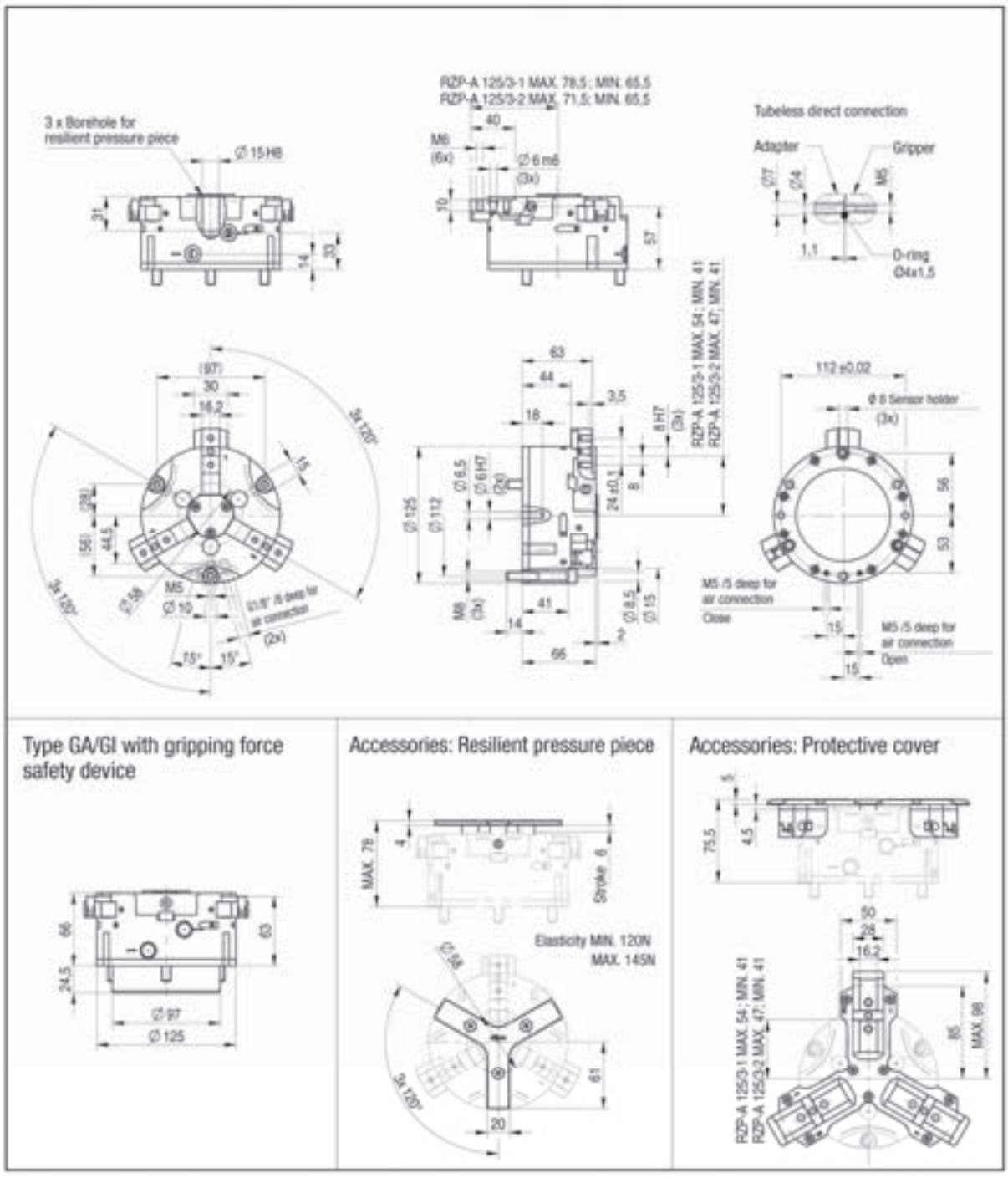
RZP-A 125

Max. load on gripper and jaw



Clamping force diagram exterior gripping





RZP-A 160



APPLICATION

Universal gripping of round and angular workpieces with two parallel gripper fingers for handling with robots or portals.

TYPE

Available from sizes 64 to 160, each in two stroke variants. Optionally with gripping force safety device and/or dirt cover.
Fastening of the gripper fingers via centering sleeves (included in the scope of delivery).

CUSTOMER BENEFITS

- High gripping force with low dead weight and compact design
- Maximum flexibility thanks to versatile connection and fastening options
- Long service life and high reliability thanks to specially ground base jaws in proven T-slot guide

TECHNICAL FEATURES

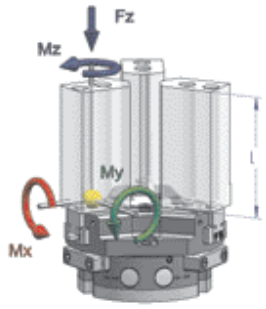
- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Wedge hook principle with pneumatic actuation
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

C40
RZP-A 160 - 3-jaw centric gripper air operated with tongue and groove

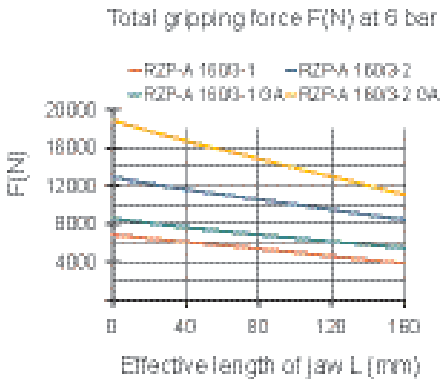
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Design	RZP-A 160/3-1	RZP-A 160/3-2	RZP-A 160/3-1 GA	RZP-A 160/3-2 GA	RZP-A 160/3-1 GI	RZP-A 160/3-2 GI
Gripping force at 6 bar N	6000	12000	8000	16000	8500	16500
Stroke per jaw mm	16	8	16	8	16	8
Gripping force maintained N	-	-	2000	4000	2000	4000
Recommended workpiece weight kg	30	60	30	60	30	60
Weight kg	4,5	4,5	6,6	6,6	6,6	6,6
Height mm	78	78	108	108	108	108
Ø mm	160	160	160	160	160	160
Mx Nm	80	80	80	80	80	80
My Nm	100	100	100	100	100	100
Mz Nm	80	80	80	80	80	80
Fz N	2800	2800	2800	2800	2800	2800
Operating pressure min./ max. without GA/GI bar	2-8	2-8	-	-	-	-
Operating pressure min./ max. with GA/GI bar	-	-	4-7	4-7	4-7	4-7
Clamping time s	0,4	0,4	0,4	0,4	0,8	0,8
Opening time s	0,4	0,4	0,8	0,8	0,4	0,4
Air consumption per cycle cm^3	520	520	520	520	520	520
Max. allowable length of jaw mm	160	160	160	160	160	160

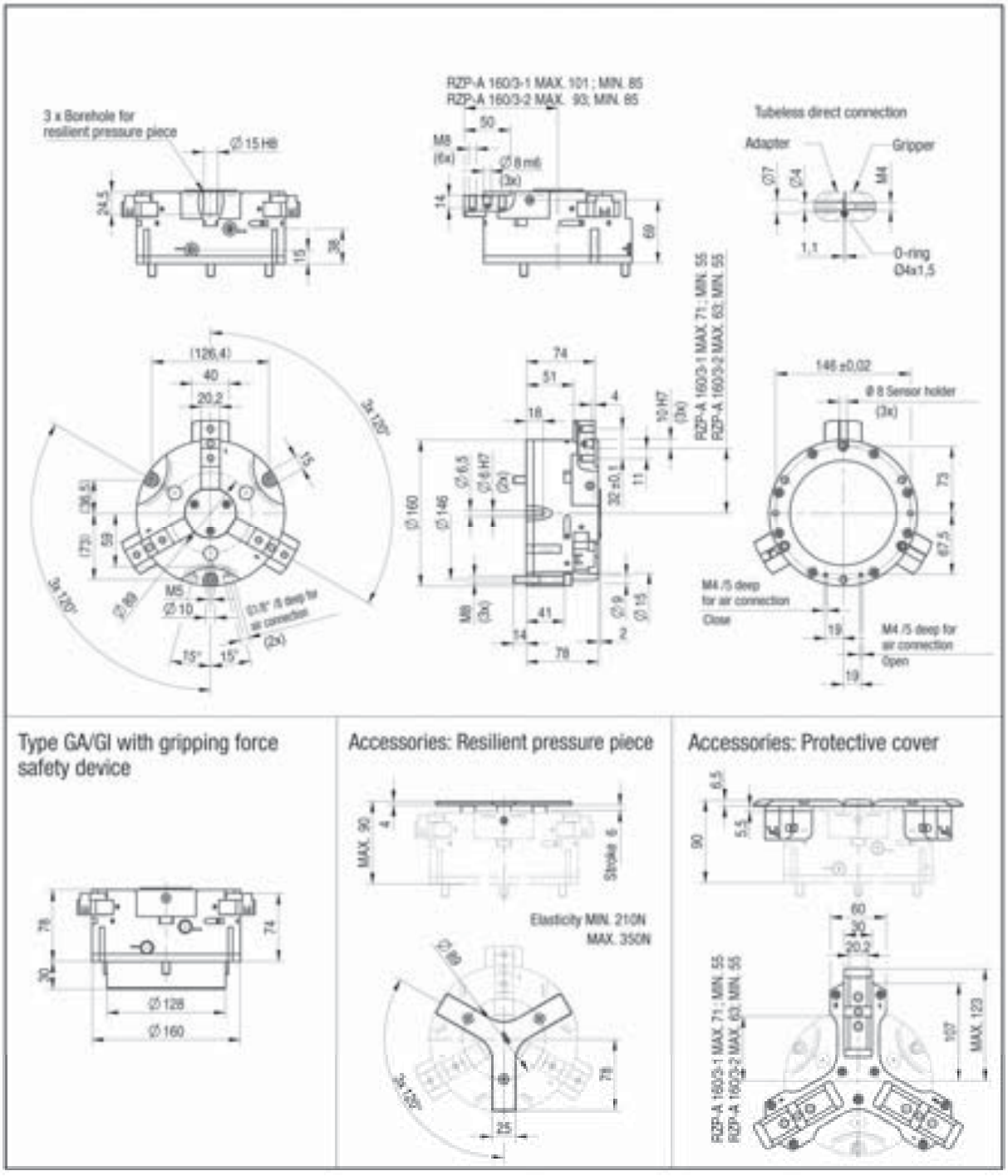
RZP-A 160

Max. load on gripper and jaw



Clamping force diagram exterior gripping





Accessories RZP-A



Jaw blank - steel (including fixing screws)
3-jaw set

Item no.	Number of jaws	Design	For
170825 ▲	3	steel	RZP-A 64
170826 ▲	3	steel	RZP-A 80
170827 ▲	3	steel	RZP-A 100
170828 ▲	3	steel	RZP-A 125
170829 ▲	3	steel	RZP-A 160



Jaw blank - aluminium (including fixing screws)
3-jaw set

Item no.	Number of jaws	Design	For
170835 ▲	3	aluminium	RZP-A 64
170836 ▲	3	aluminium	RZP-A 80
170837 ▲	3	aluminium	RZP-A 100
170838 ▲	3	aluminium	RZP-A 125
170839 ▲	3	aluminium	RZP-A 160



Resilient pressure piece

Item no.	For
165573 ▲	RZP-A 64
170868 ▲	RZP-A 80
170870 ▲	RZP-A 100
170871 ▲	RZP-A 125
170872 ▲	RZP-A 160



Pressure maintenance
for double acting gripper (G1/8)

Item no.
1078823



Compressed air connection

Item no.	Design	For
802539	L-Plug connector M5 - 6 mm	RZP-A 64 / RZP-A 80
477025	L-Plug connector 1/8 - 6 mm	RZP-A 100 / RZP-A 125 RZP-A160

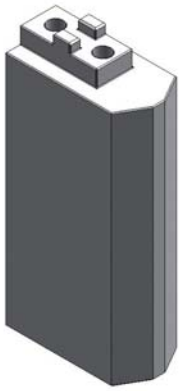


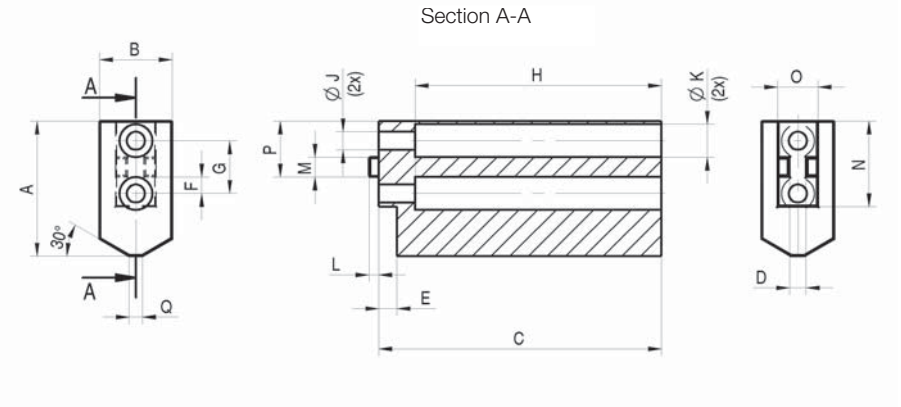
Proximity switch

Item no.	Size (diameter/length)	Design	For
229114	M8x1x30,5	5 m cable, open leads	RZP-A 64 - RZP-A 160

▲ on request

Accessories RZP-A

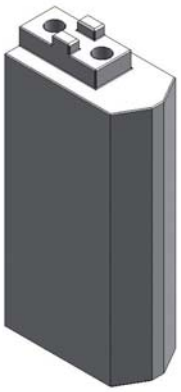


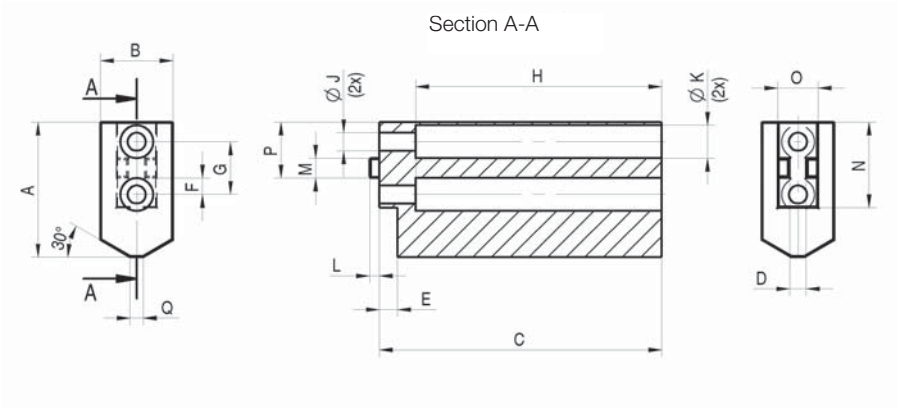


Jaw blank - steel (including fixing screws)

RPP-A / RZP-A Jaw blank - steel	64	80	100	125	160
RPP-A - 2-jaw set	**170675**	**170676**	**170677**	**170678**	**170679**
RZP-A - 3-jaw set	**170825**	**170826**	**170827**	**170828**	**170829**
A	32	41	51	60	80
B	20	22	30	35	40
C	68,5	85,5	105,5	130,5	166,5
D +0,01/+0,03	4	5	6	6	8
E+0,2	4,5	5,5	5,5	5,5	6,5
F±0,1	4	5	6	8	11
G±0,1	13	16	20	24	32
H	59,5	74,5	94,5	119,5	153,5
J	4,5	5,5	6,6	6,6	9
K	8	10	11	11	15
L	2,5	3	3	3,5	4
Mf7	5	6	8	8	10
N-0,3/-0,5	21	26	33	41	51
O-0,3/-0,5	10,2	12,2	14,2	16,2	20,2
P+0,1	14	17	21	25,5	31
Q	3	4	5	6	8
Weight per jaw Kg	0,26	0,46	1,0	1,8	3,5

Accessories RZP-A



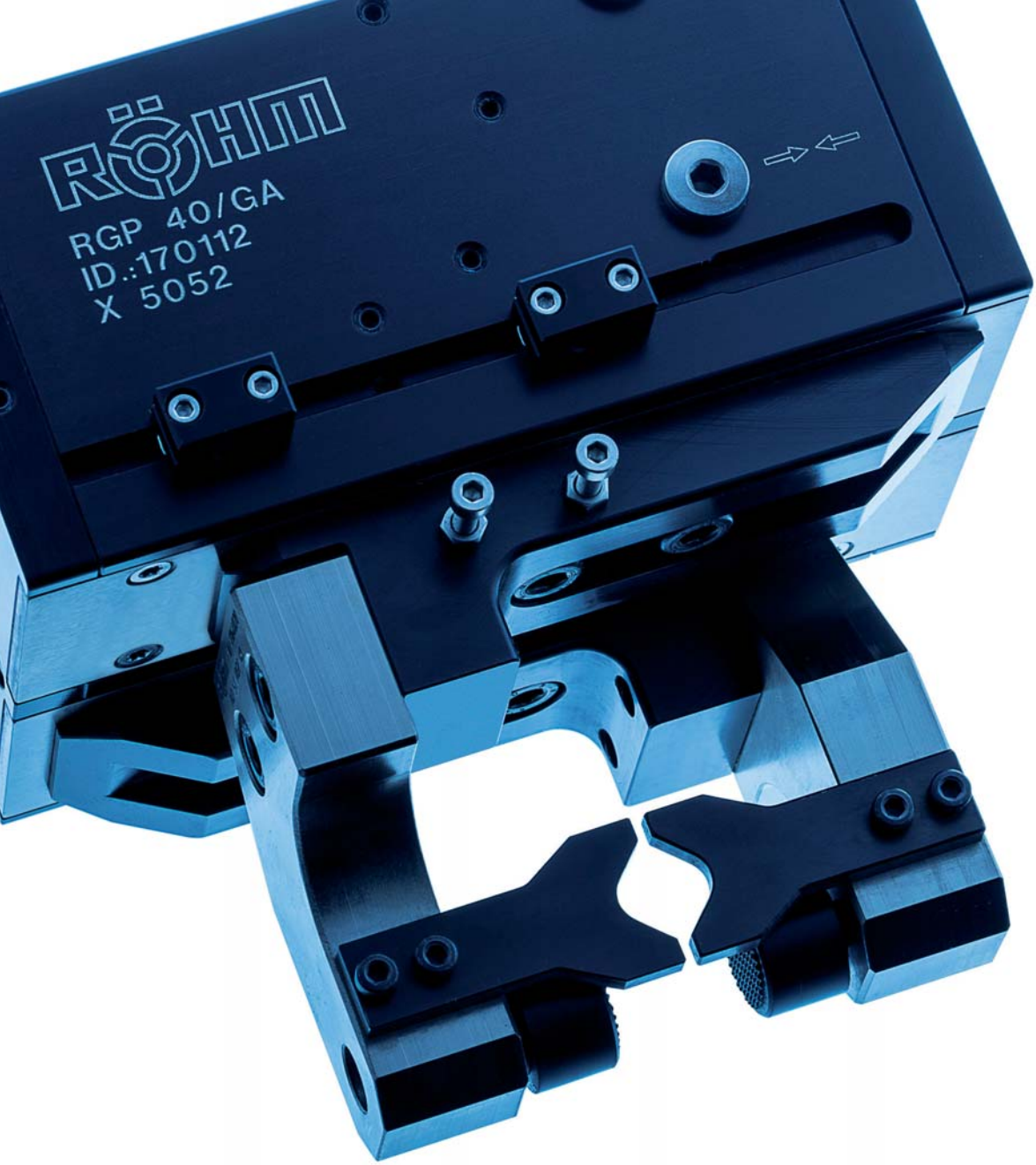


Jaw blank - aluminium (including fixing screws)

RPP-A / RZP-A Jaw blank - aluminium	64	80	100	125	160
RPP-A - 2-jaw set	**170685**	**170686**	**170687**	**170688**	**170689**
RZP-A - 3-jaw set	**170835**	**170836**	**170837**	**170838**	**170839**
A	32	41	51	60	80
B	20	22	30	35	40
C	68,5	85,5	105,5	130,5	166,5
D +0,01/+0,03	4	5	6	6	8
E+0,2	4,5	5,5	5,5	5,5	6,5
F±0,1	4	5	6	8	11
G±0,1	13	16	20	24	32
H	59,5	74,5	94,5	119,5	153,5
J	4,5	5,5	6,6	6,6	9
K	8	10	11	11	15
L	2,5	3	3	3,5	4
Mf7	5	6	8	8	10
N-0,3/-0,5	21	26	33	41	51
O-0,3/-0,5	10,2	12,2	14,2	16,2	20,2
P+0,1	14	17	21	25,5	31
Q	3	4	5	6	8
Weight per jaw Kg	0,1	0,16	0,35	0,62	1,2

▲ on request

Notes



NOMENCLATURE

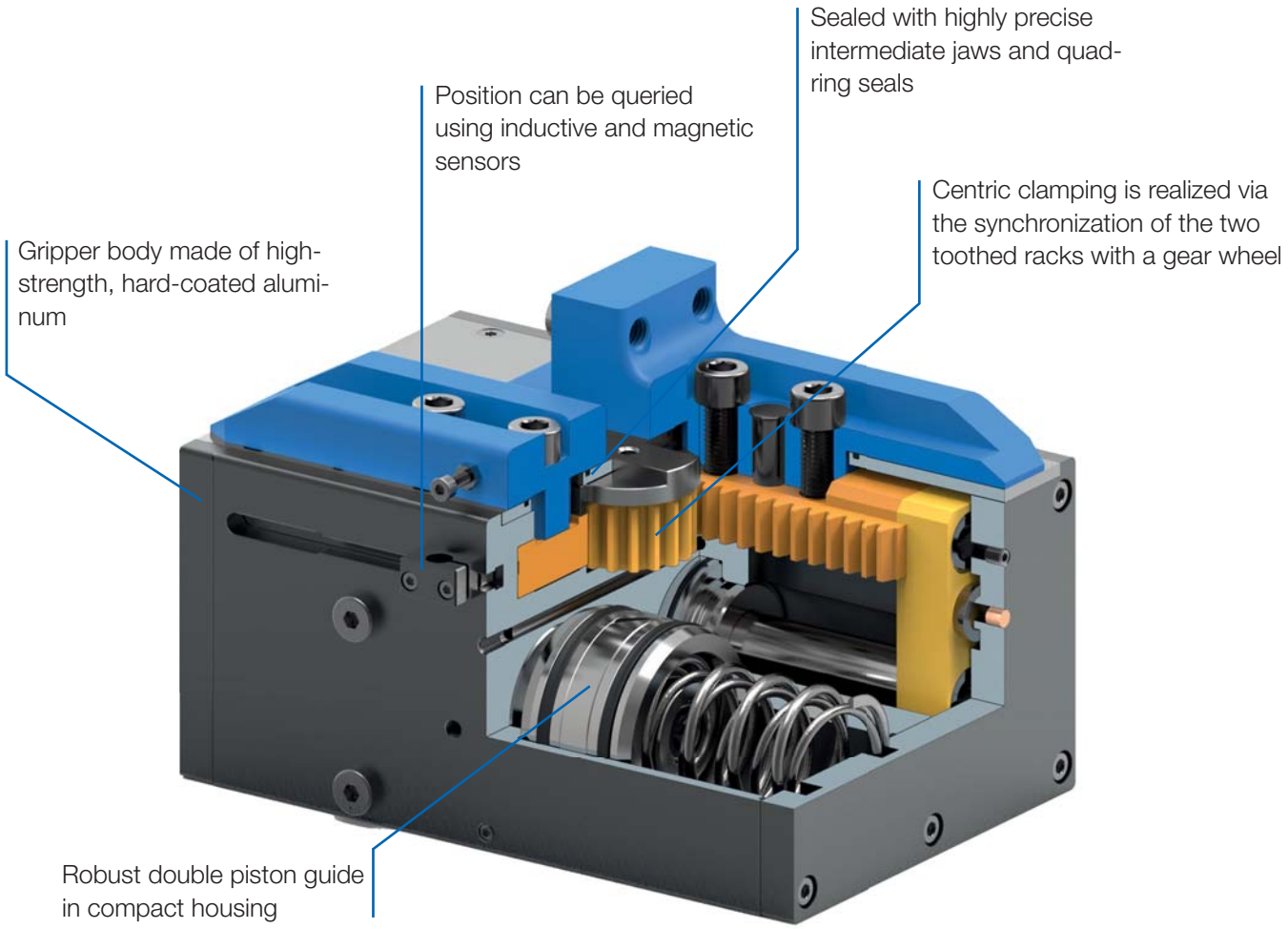
RGP	O	- 100	/ GA	/ V
RÖHM **G** long stroke gripper **P**neumatic (sealed version)	**O =** Open version for longer jaw stroke	**Sizes** RGP: 30-50 RGPO: 40-60	Optional: spring safety **GA** = outside grip	Optional: **V** = Viton FKM-sealing for temperatures up to 150 °C

2-JAW LONG STROKE GRIPPER

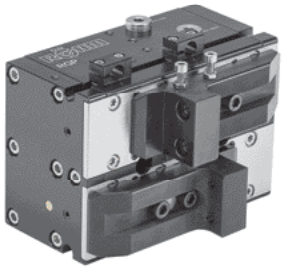
The 2-jaw long stroke gripper allows for large jaw strokes, thanks to its design, and is therefore optimally suited for handling large parts and a high part diversity. Due to the sealed guide, it is often used in rough environments. The centric clamping is realized via the synchronization of the two toothed racks with a gear wheel.

ADVANTAGES AT A GLANCE

- High gripping force with simultaneously high jaw stroke by means of double-acting pressure pistons
- High torque support for using long gripper fingers by means of robust flat guide
- Sealed for rough ambient conditions with quad-ring seal and highly precise intermediate jaws



RGP-30



APPLICATION

Sealed large-stroke gripper for handling large parts and high part variety.

TYPE

Available in sizes 30, 40 and 50 with integrated seal - optionally with gripping force securing device.
High precision thanks to double-piston drive synchronized via gear wheel.

CUSTOMER BENEFITS

- High gripping force with simultaneously high jaw stroke by means of double-acting pressure pistons
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Sealed for rough ambient conditions with quad-ring seal and highly precise intermediate jaws
- Maximum flexibility thanks to versatile connection and fastening options

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

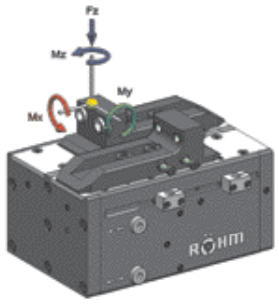
C40
RGP-30 - 2-jaw long stroke gripper air operated

Item no.	170109	170110
Design	RGP 30	RGP 30 GA
Gripping force at 6 bar N	630	720
Stroke per jaw mm	30	30
Gripping force maintained N	-	90
Recommended workpiece weight kg	3	3
Weight kg	3,2	3,2
Width mm	134	134
Height mm	66	66
Depth mm	94	94
Mx Nm	30	30
My Nm	95	95
Mz Nm	45	45
Fz N	1000	1000
Operating pressure min./max. without GA/GI bar	2-8	-
Operating pressure min./max. with GA/GI bar	-	5-6,5
Clamping time s	0,3	0,35
Opening time s	0,3	0,35
Air consumption per cycle cm^3	92	92
Max. allowable length of jaw mm	150	100

▲ on request

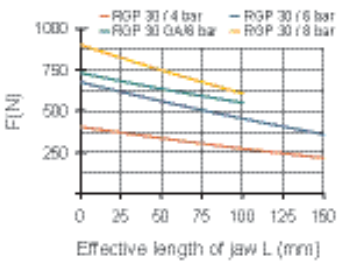
RGP-30

Max. load on gripper and jaw

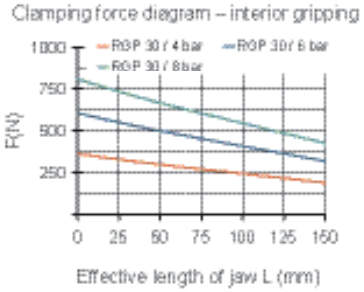


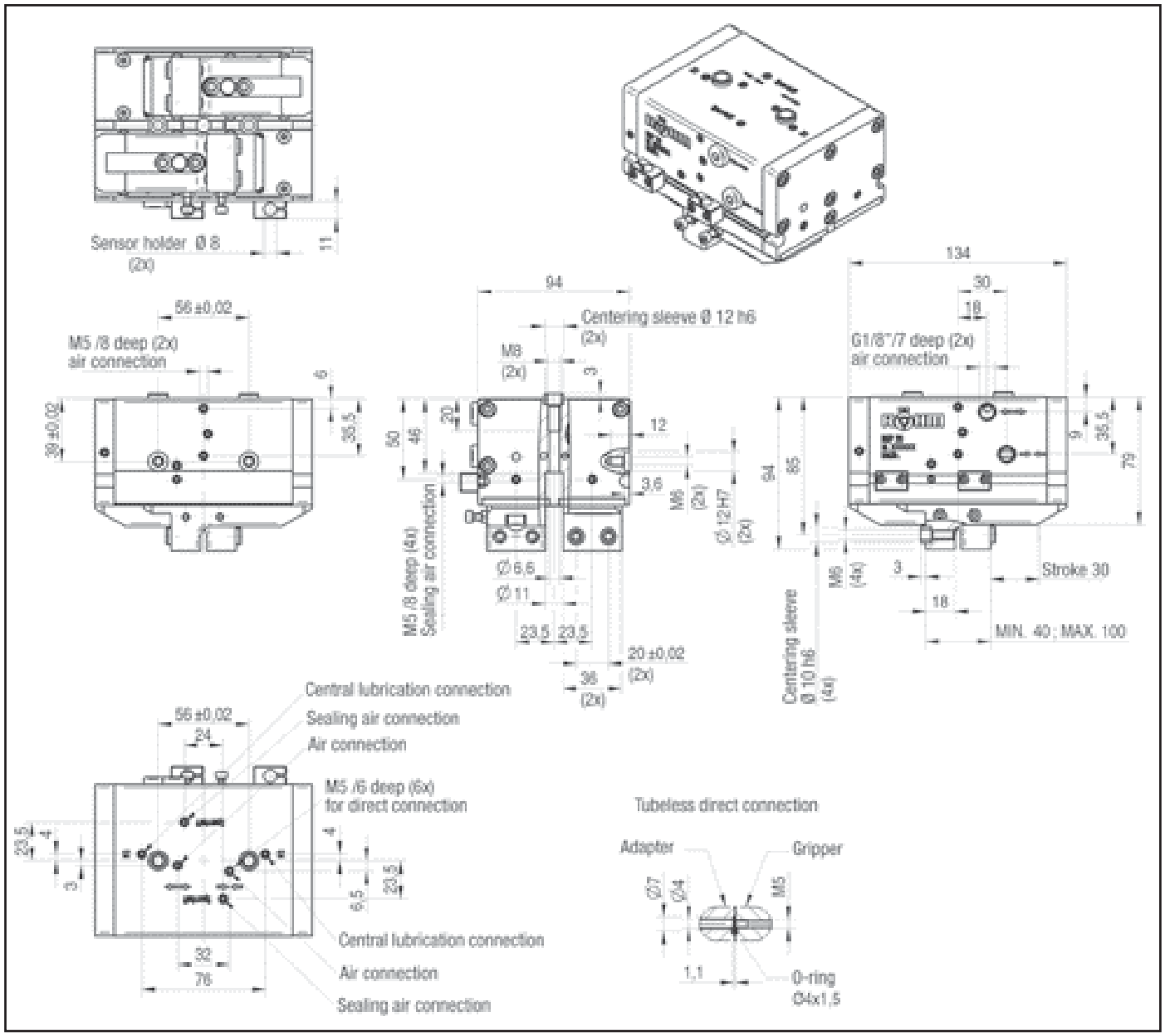
Clamping force diagram

Clamping force diagram – exterior gripping

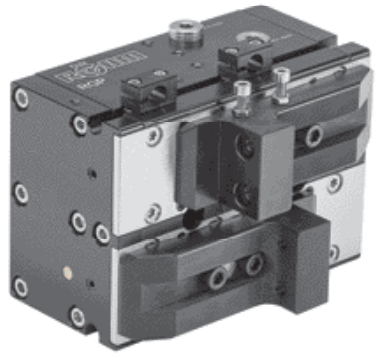


Clamping force diagram – interior gripping





RGP-40



APPLICATION

Sealed large-stroke gripper for handling large parts and high part variety.

TYPE

Available in sizes 30, 40 and 50 with integrated seal - optionally with gripping force securing device.
High precision thanks to double-piston drive synchronized via gear wheel.

CUSTOMER BENEFITS

- High gripping force with simultaneously high jaw stroke by means of double-acting pressure pistons
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Sealed for rough ambient conditions with quad-ring seal and highly precise intermediate jaws
- Maximum flexibility thanks to versatile connection and fastening options

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

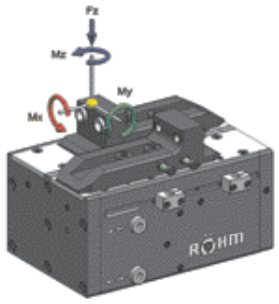
C40
RGP-40 - 2-jaw long stroke gripper air operated

Item no.	170111	170112	170113
Design	RGP 40	RGP 40-GA	RGP 40-GI
Gripping force at 6 bar N	1260	1540	1380
Stroke per jaw mm	40	40	40
Gripping force maintained N	-	150	150
Recommended workpiece weight kg	6,3	6,3	5,5
Weight kg	5,6	5,6	5,6
Width mm	171	171	171
Height mm	83	83	83
Depth mm	115	115	115
Mx Nm	50	50	50
My Nm	100	100	100
Mz Nm	70	70	70
Fz N	1100	1100	1100
Operating pressure min./max. without GA/GI bar	2-8	-	-
Operating pressure min./max. with GA/GI bar	-	5-6,5	5-6,5
Clamping time s	0,3	0,3	0,4
Opening time s	0,3	0,4	0,3
Air consumption per cycle cm^3	240	240	240
Max. allowable length of jaw mm	200	150	150

▲ on request

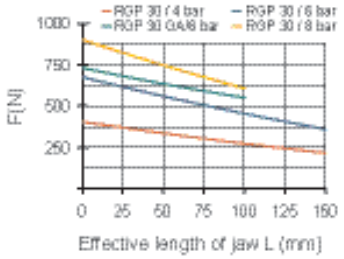
RGP-40

Max. load on gripper and jaw

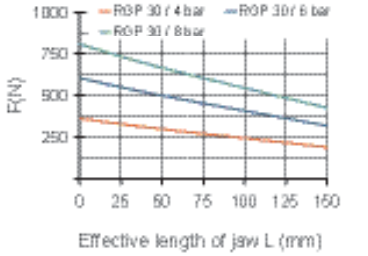


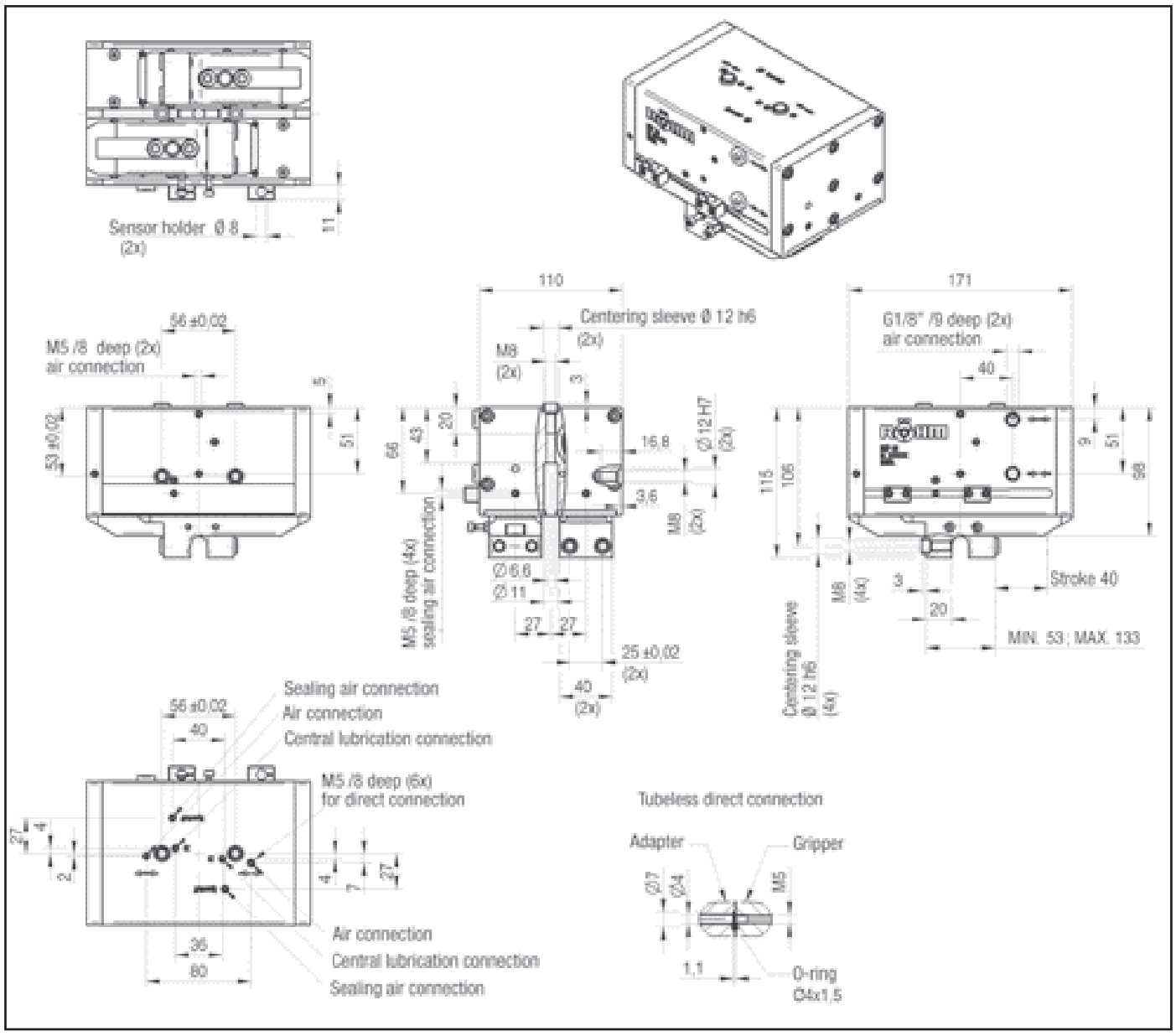
Clamping force diagram

Clamping force diagram – exterior gripping

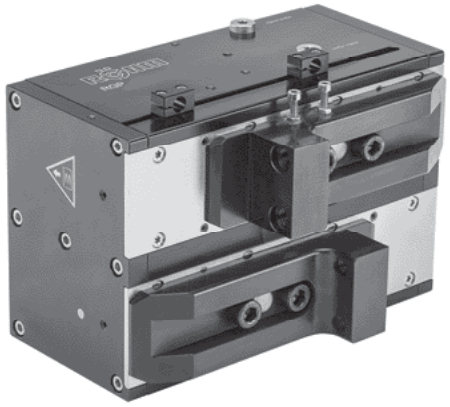


Clamping force diagram – interior gripping





RGP-50



APPLICATION

Sealed large-stroke gripper for handling large parts and high part variety.

TYPE

Available in sizes 30, 40 and 50 with integrated seal - optionally with gripping force securing device.
High precision thanks to double-piston drive synchronized via gear wheel.

CUSTOMER BENEFITS

- High gripping force with simultaneously high jaw stroke by means of double-acting pressure pistons
- High torque support for using long gripper fingers thanks to elongated jaw guide
- Sealed for rough ambient conditions with quad-ring seal and highly precise intermediate jaws
- Maximum flexibility thanks to versatile connection and fastening options

TECHNICAL FEATURES

- Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy.
- All functional parts made of hardened steel for maximum service life
- Optional inductive and magnetic position sensors
- Optionally available with FKM seals for higher temperatures up to 150°C (on request)
- Integrated purge air connection to prevent contamination

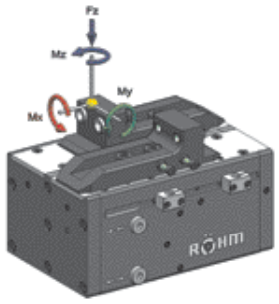
C40
RGP-50 - 2-jaw long stroke gripper air operated

Item no.	170114	170115	170116
Design	RGP 50	RGP 50-GA	RGP 50-GI
Gripping force at 6 bar N	2600	2950	2680
Stroke per jaw mm	50	50	50
Gripping force maintained N	-	450	450
Recommended workpiece weight kg	13	13	11,5
Weight kg	11	11	11
Width mm	218	218	218
Height mm	103	103	103
Depth mm	141	141	141
Mx Nm	60	60	60
My Nm	100	100	100
Mz Nm	80	80	80
Fz N	1300	1300	1300
Operating pressure min./max. without GA/GI bar	2-8	-	-
Operating pressure min./max. with GA/GI bar	-	5-6,5	5-6,5
Clamping time s	0,6	0,5	0,7
Opening time s	0,7	0,8	0,6
Air consumption per cycle cm^3	600	600	600
Max. allowable length of jaw mm	250	200	200

▲ on request

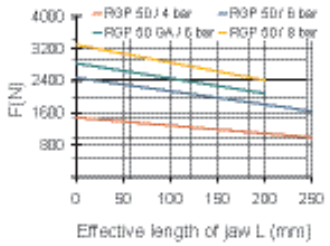
RGP-50

Max. load on gripper and jaw

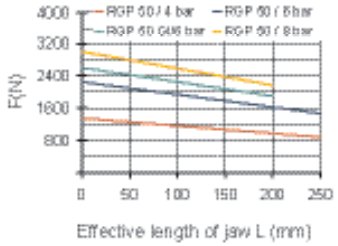


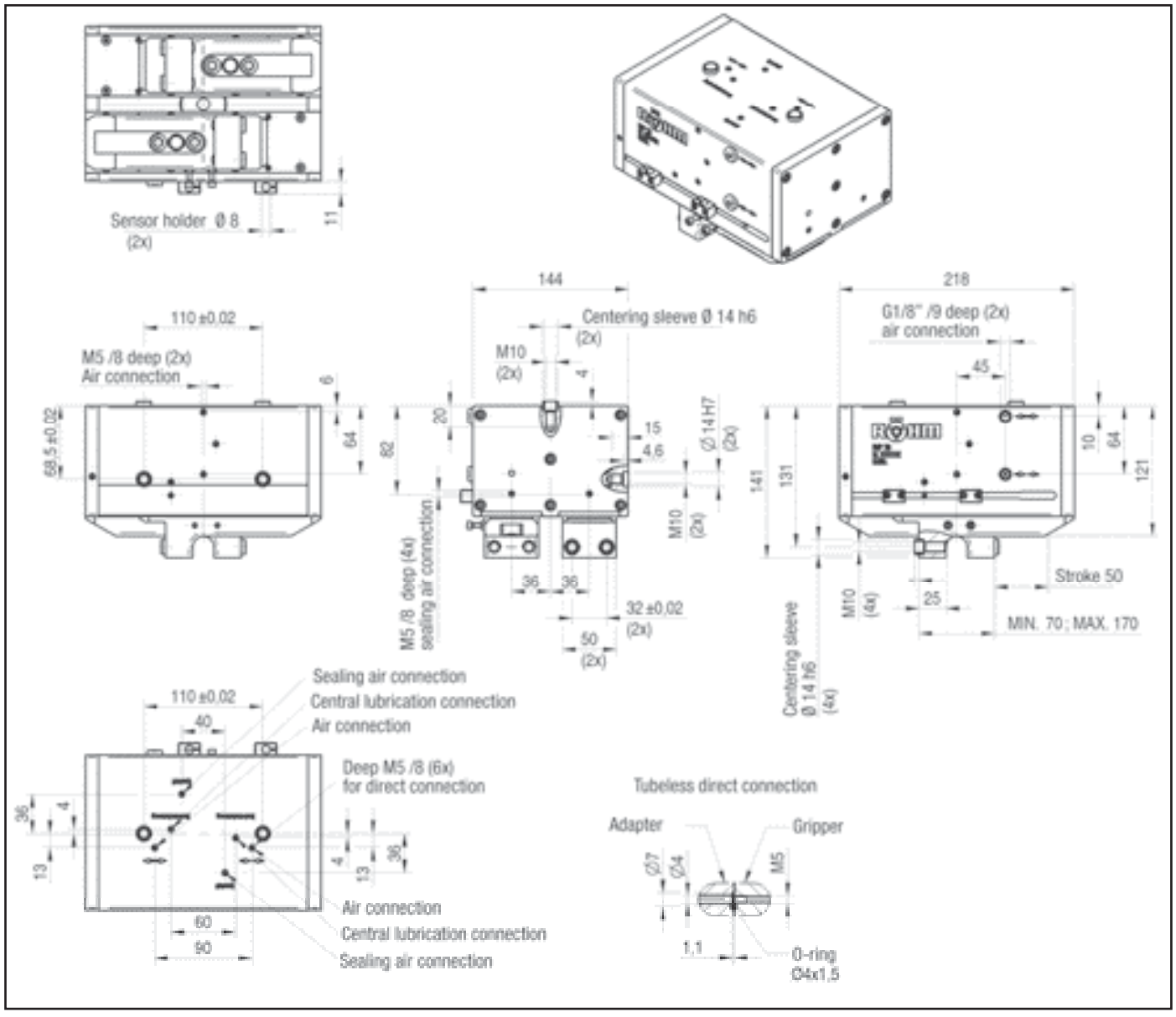
Clamping force diagram

Clamping force diagram – exterior gripping



Clamping force diagram – interior gripping





Accessories RGP



Intermediate jaw - steel (including fixing screws)
2-jaw set

Item no.	Number of jaws	Design	For
170993 ▲	2	steel	RGP-30
170995 ▲	2	steel	RGP-40
170997 ▲	2	steel	RGP-50



Jaw blank - steel (including fixing screws)
2-jaw set

Item no.	Number of jaws	Design	For
1146146 ▲	2	aluminium	RGP-30
1146144 ▲	2	aluminium	RGP-40
1131198 ▲	2	aluminium	RGP-50



Pressure maintenance
for double acting gripper (G1/8)

Item no.
1078823



Compressed air connection

Item no.	Design	For
477025	L-Plug connector 1/8 - 6 mm	all sizes, all types



Proximity switch

Item no.	Size (diameter/ length)	Design	For
229114	M8x1x30,5	5 m cable, open leads	all sizes, all types



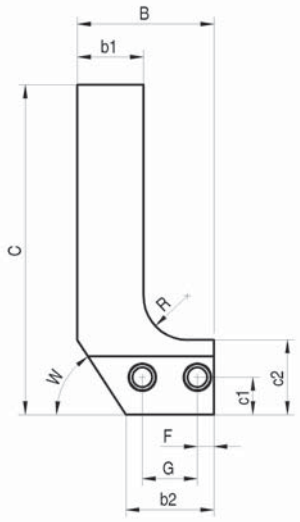
Magnetic field sensors

Item no.	Size (diameter/ length)	Design	For
1276722	C-Nut	3m cable, 3 open leads	all sizes, all types

▲ on request

Accessories RGP



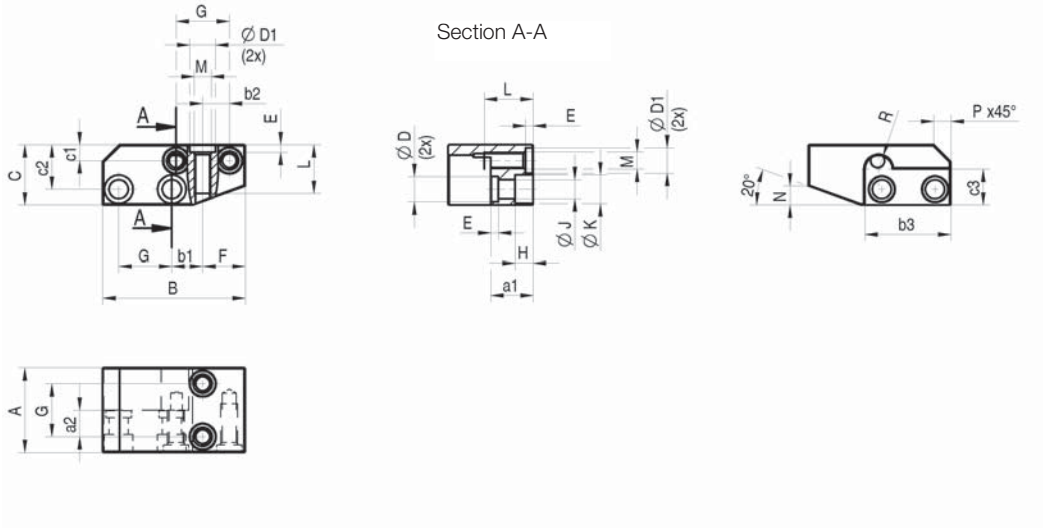


Jaw blank - steel (including fixing screws)

RGP Jaw blank - steel	30	40	50
RGP - 2-jaw set	**1146146**	**1146144**	**1131198**
A	**28**	**32**	**42**
a1	18	20	25
B	54	62	80
b1	25	30	38
b2	36	40	50
C	100	150	200
c1	13	17	22
c2	30	34	40
c3	22,5	26,5	32,5
D+0,02/+0,04	10	12	14
E+0,02	3,6	3,6	4,6
F±0,1	8	7,5	9
G±0,02	20	25	32
H	6,8	8,5	11
J	6,6	9	11
K	11	13,5	16,5
R	15	20	25
W	57°	57°	57°
Weight per jaw Kg	0,6	1,2	2,6

Accessories RGP





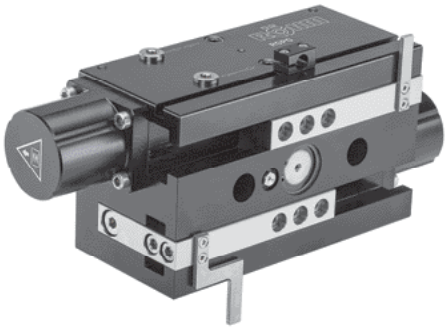
Intermediate jaw - steel (including fixing screws)

RGP Intermediate jaw - steel	**30**	**40**	**50**
RGP - 2-jaw set	**170993**	**170995**	**170997**
A	**36**	**40**	**50**
a1	18	20	25
a2	10	12,5	16
B	59,5	67	86
b1	13,5	14,5	20
b2	10	12,5	16
b3	36,5	40,5	50,5
C	26,5	28,5	35
c1	8	7,5	9
c2	20	21	25
c3	16	17	20,5
D+0,02/+0,04	10	12	14
E+0,02	3,5	3,5	4,6
F±0,1	18	20	25
G±0,02	20	25	32
H	6,8	8,5	11
J	6,6	9	11
K	11	13,5	16,5
L	18	23	28
M	M6	M8	M10
Nx20°	8	9	12
Px45°	7	8	10
R	5,5	6,5	6,5
Weight per jaw Kg	0,6	1,2	2,6
Centering sleeve	**170264**	**170265**	**170266**
Size	Ø10	Ø12	Ø14

▲ on request

Notes

RGPO-4060



APPLICATION

Premium large stroke gripper with large stroke and ground jaw guides.

CUSTOMER BENEFITS

- Up to 5 million cycles maintenance-free
- Available on request: Temperature-resistant version (up to approx. 150° C)

TECHNICAL FEATURES

- Gripper body made of high-strength, hard-coated aluminum.
- Toothed racks, intermediate jaws and gear wheel made of hardened steel
- High torque absorption of the intermediate jaws due to the robust flat guide of the toothed racks
- Suitable for the use of long top jaws.
- Centric clamping is realized via the synchronization of the two toothed racks with one gear wheel
- Special gripper type available with additional spring set to prevent loss of gripping force during external or internal gripping
- Energy supply possible by means of screw connection or via hoseless direct connection

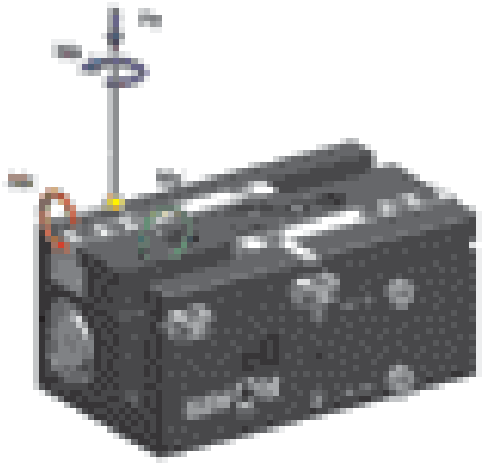
RGPO 4060 - 2-jaw large stroke gripper air operated

Item no.	172774	172775
Design	RGPO 4060	RGPO 4060-GA
Gripping force at 6 bar N	1250	1920
Stroke per jaw mm	60	60
Recommended workpiece weight kg	5,5	5,5
Weight kg	3,8	4,2
Width mm	170	170
Height mm	80	80
Depth mm	100	100
Mx Nm	80	80
My Nm	125	125
Mz Nm	100	100
Fz N	3000	3000
Operating pressure min./max. without GA/GI bar	3-8	
Operating pressure min./max. with GA/GI bar		4-8
Clamping time s	0,35	0,4
Opening time s	0,35	0,35
Air consumption per cycle cm^3	278	278
Max. allowable length of jaw mm	150	150

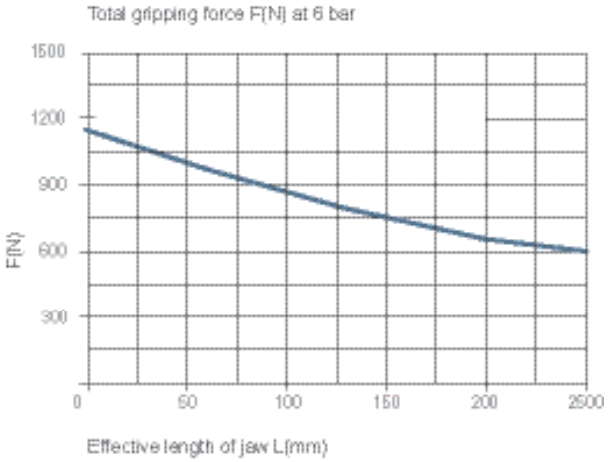
▲ on request

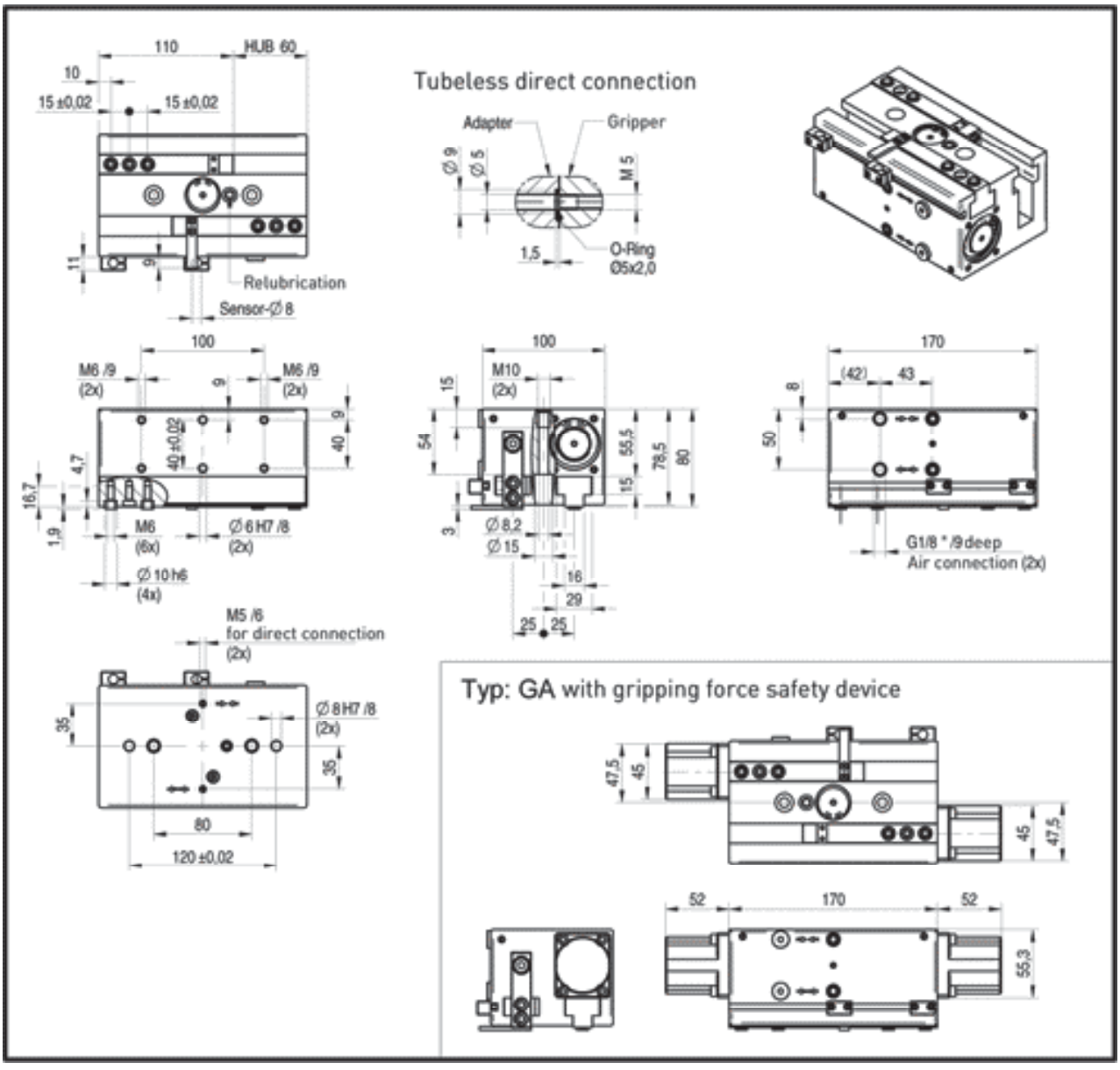
RGPO-4060

Max. load on gripper and jaw



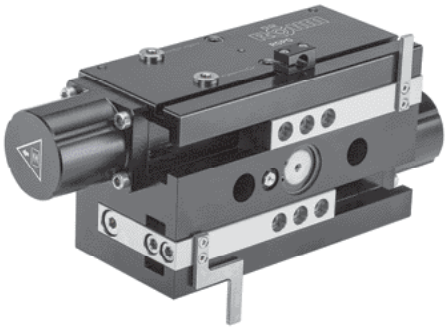
Clamping force diagram exterior gripping





2-jaw long stroke gripper

RGPO-40100



APPLICATION

Premium large stroke gripper with large stroke and ground jaw guides.

CUSTOMER BENEFITS

- Up to 5 million cycles maintenance-free
- Available on request: Temperature-resistant version (up to approx. 150° C)

TECHNICAL FEATURES

- Gripper body made of high-strength, hard-coated aluminum.
- Toothed racks, intermediate jaws and gear wheel made of hardened steel
- High torque absorption of the intermediate jaws due to the robust flat guide of the toothed racks
- Suitable for the use of long top jaws.
- Centric clamping is realized via the synchronization of the two toothed racks with one gear wheel
- Special gripper type available with additional spring set to prevent loss of gripping force during external or internal gripping on request
- Energy supply possible by means of screw connection or via hoseless direct connection

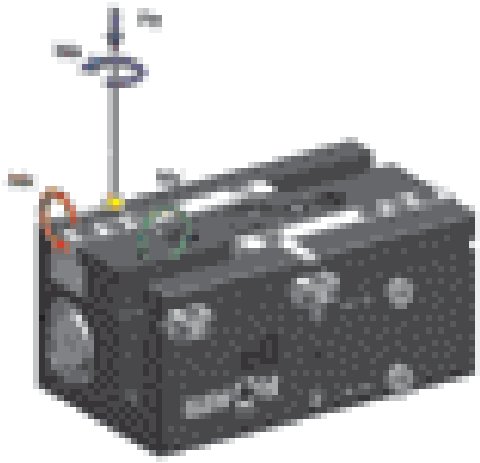
RGPO 40100 - 2-jaw large stroke gripper air operated

Item no.	172777
Design	RGPO 40100
Gripping force at 6 bar N	1250
Stroke per jaw mm	100
Recommended workpiece weight kg	5,5
Weight kg	5,3
Width mm	170
Height mm	80
Depth mm	100
Mx Nm	80
My Nm	125
Mz Nm	100
Fz N	3000
Operating pressure min./max. without GA/GI bar	3-8
Clamping time s	0,35
Opening time s	0,35
Air consumption per cycle cm^3	278
Max. allowable length of jaw mm	150

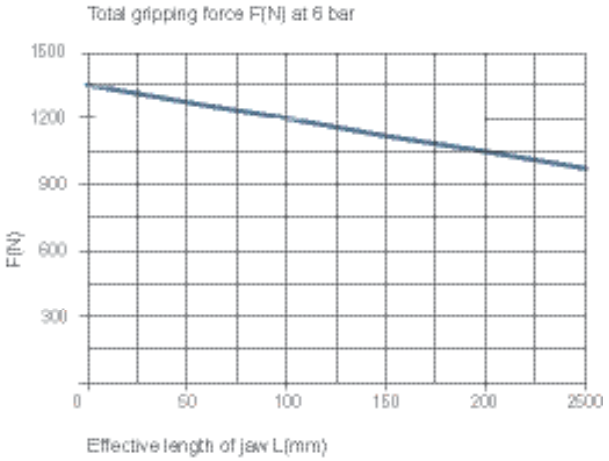
▲ on request

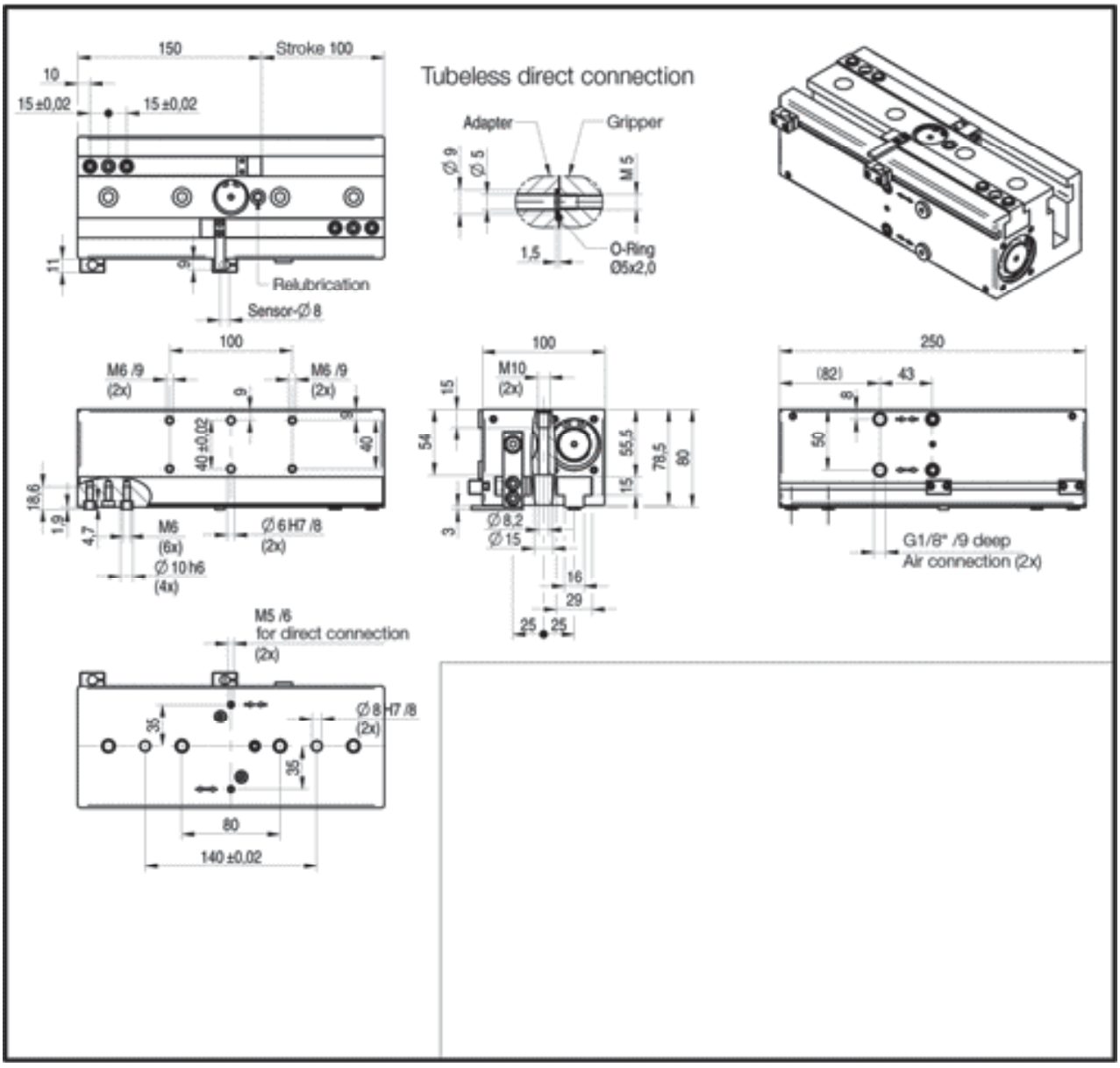
RGPO-40100

Max. load on gripper and jaw



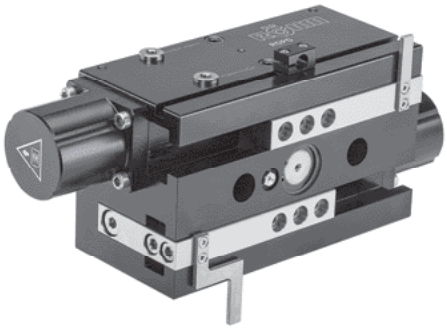
Clamping force diagram exterior gripping





2-jaw long stroke gripper

RGPO-6360



APPLICATION

Premium large stroke gripper with large stroke and ground jaw guides.

CUSTOMER BENEFITS

- Up to 5 million cycles maintenance-free
- Available on request: Temperature-resistant version (up to approx. 150° C)

TECHNICAL FEATURES

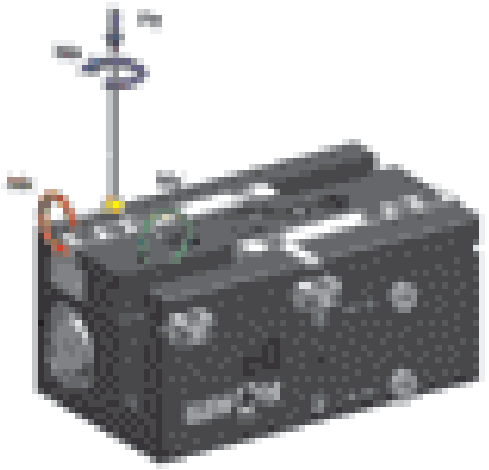
- Gripper body made of high-strength, hard-coated aluminum.
- Toothed racks, intermediate jaws and gear wheel made of hardened steel
- High torque absorption of the intermediate jaws due to the robust flat guide of the toothed racks
- Suitable for the use of long top jaws.
- Centric clamping is realized via the synchronization of the two toothed racks with one gear wheel
- Special gripper type available with additional spring set to prevent loss of gripping force during external or internal gripping
- Energy supply possible by means of screw connection or via hoseless direct connection

RGPO 6360 - 2-jaw large stroke gripper air operated

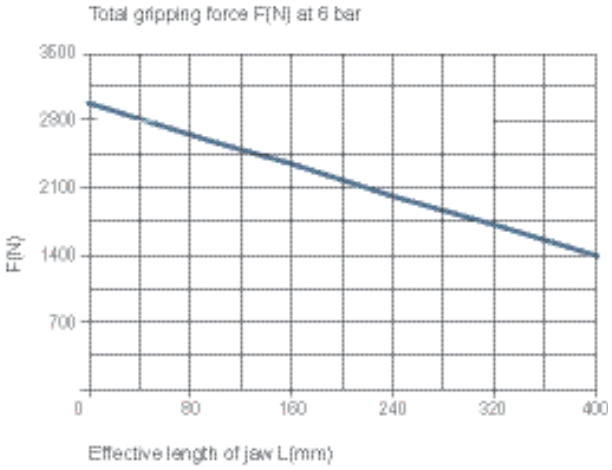
Item no.	172794	172795
Design	RGPO 6360	RGPO 6360-GA
Gripping force at 6 bar N	3000	4000
Stroke per jaw mm	60	60
Recommended workpiece weight kg	15	15
Weight kg	10	11
Width mm	185	185
Height mm	121,5	121,5
Depth mm	154	154
Mx Nm	200	200
My Nm	300	300
Mz Nm	250	250
Fz N	9000	9000
Operating pressure min./max. without GA/GI bar	3-8	
Operating pressure min./max. with GA/GI bar		4-8
Clamping time s	0,4	0,4
Opening time s	0,4	0,5
Air consumption per cycle cm^3	710	710
Max. allowable length of jaw mm	200	200

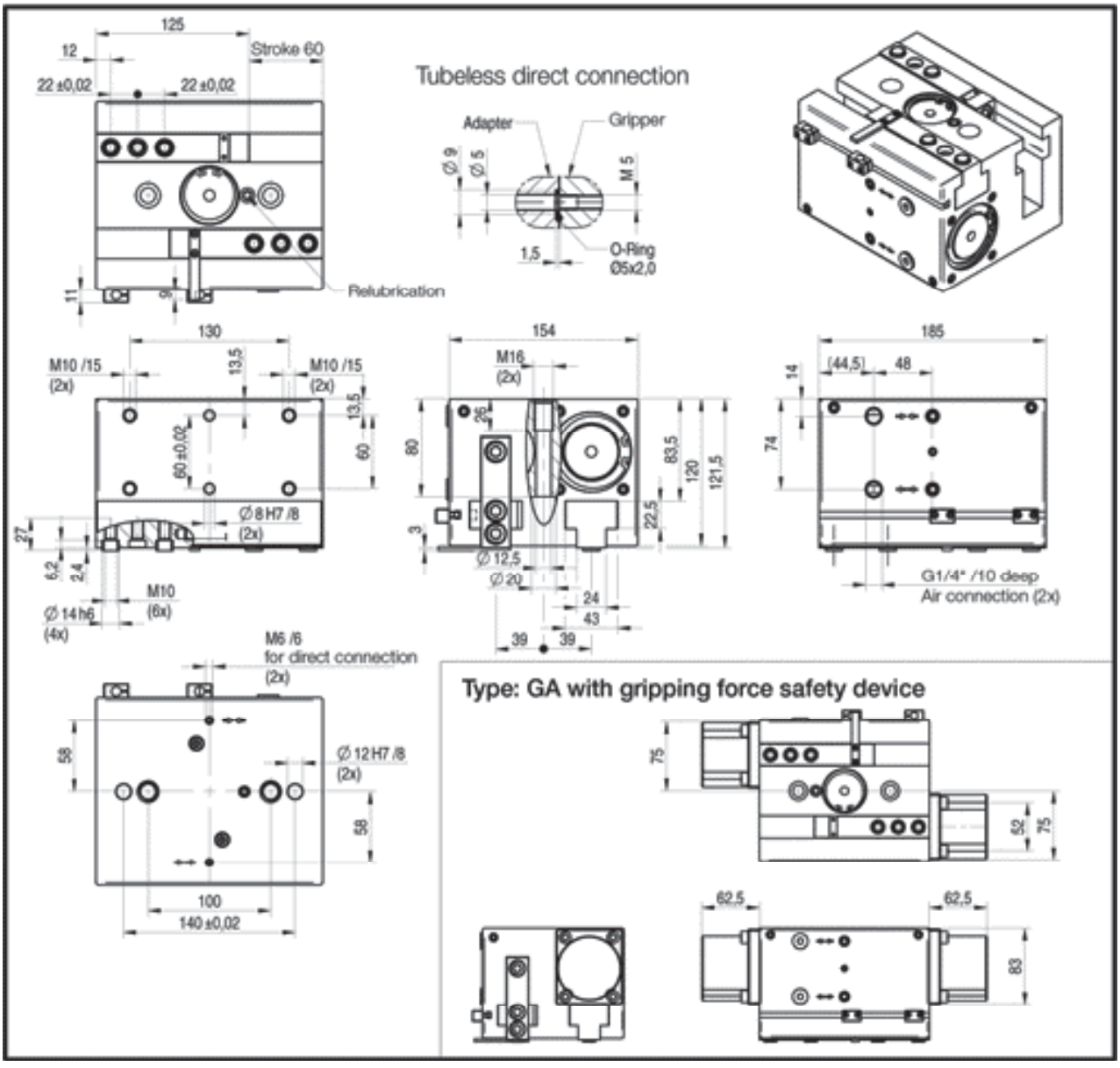
RGPO-6360

Max. load on gripper and jaw



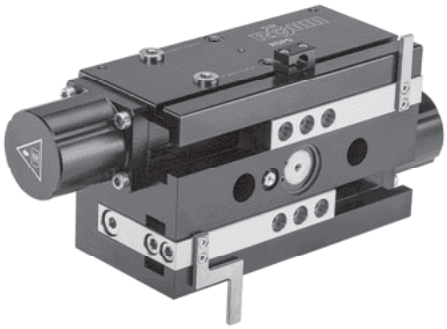
Clamping force diagram exterior gripping





2-jaw long stroke gripper

RGPO-63100



APPLICATION

Premium large stroke gripper with large stroke and ground jaw guides.

CUSTOMER BENEFITS

- Up to 5 million cycles maintenance-free
- Available on request: Temperature-resistant version (up to approx. 150° C)

TECHNICAL FEATURES

- Gripper body made of high-strength, hard-coated aluminum.
- Toothed racks, intermediate jaws and gear wheel made of hardened steel
- High torque absorption of the intermediate jaws due to the robust flat guide of the toothed racks
- Suitable for the use of long top jaws.
- Centric clamping is realized via the synchronization of the two toothed racks with one gear wheel
- Special gripper type available with additional spring set to prevent loss of gripping force during external or internal gripping on request
- Energy supply possible by means of screw connection or via hoseless direct connection

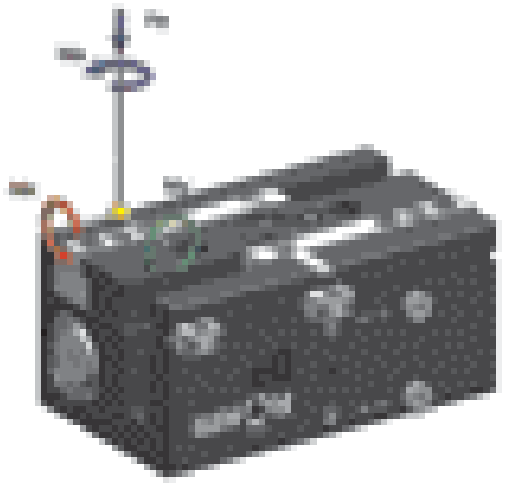
RGPO 63100 - 2-jaw large stroke gripper air operated

Item no.	172797
Design	RGPO 63100
Gripping force at 6 bar N	3000
Stroke per jaw mm	100
Recommended workpiece weight kg	15
Weight kg	13,4
Width mm	185
Height mm	121,5
Depth mm	154
Mx Nm	200
My Nm	300
Mz Nm	250
Fz N	9000
Operating pressure min./max. without GA/GI bar	3-8
Clamping time s	0,7
Opening time s	0,7
Air consumption per cycle cm^3	1180
Max. allowable length of jaw mm	200

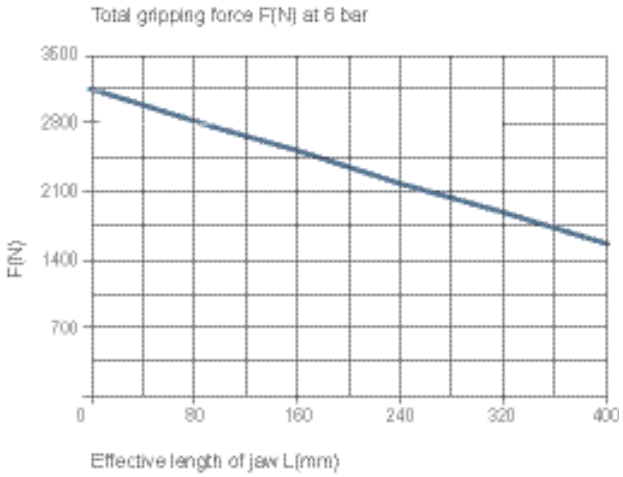
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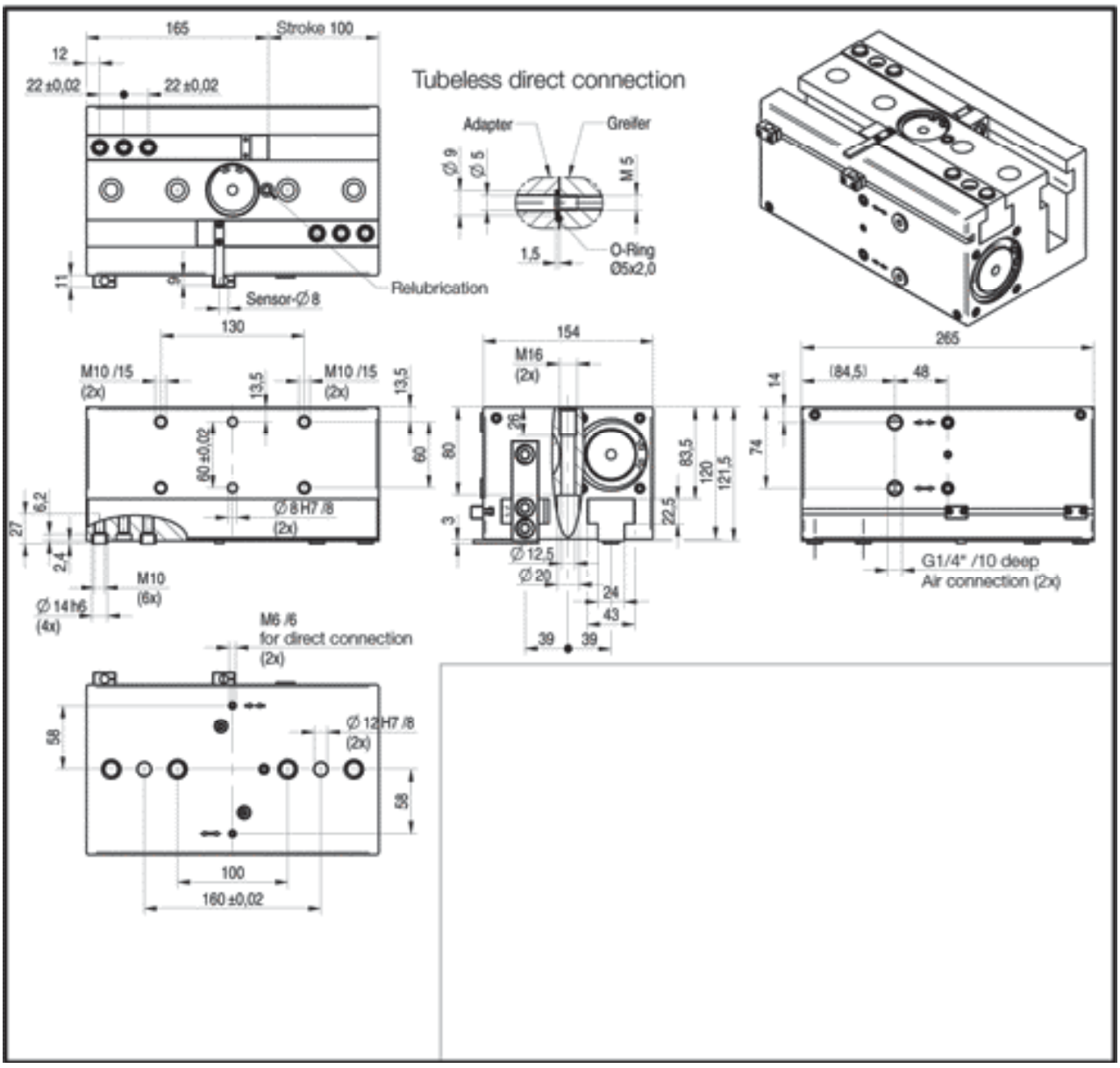
RGPO-63100

Max. load on gripper and jaw



Clamping force diagram exterior gripping





2-jaw long stroke gripper

Application-specific grippers





RDPP - Sealed parallel gripper

APPLICATION
Sealed parallel gripper with precise square guide for rough environments.

TYPE
Available in sizes 80 to 160 in especially compact design.

CUSTOMER BENEFITS
- Doubly seales precision square guide for use under drilling or grinding emulsions
- Optionally with gripping force securing device for inner and outer clamping
- Gripper fingers mounted laterally for minimum load distance
- Maximum flexibility thanks to versatile connection and fastening options

TECHNICAL FEATURES
Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy. All functional parts made of hardened steel for maximum service life; position can be queried using inductive and magnetic sensors.

Other sizes available on request. Optionally available with FKM seals for higher temperatures up to 150°C (on request).





RPR - Compact long stroke gripper

APPLICATION
Compact long stroke gripper for handling large parts and high part variety.

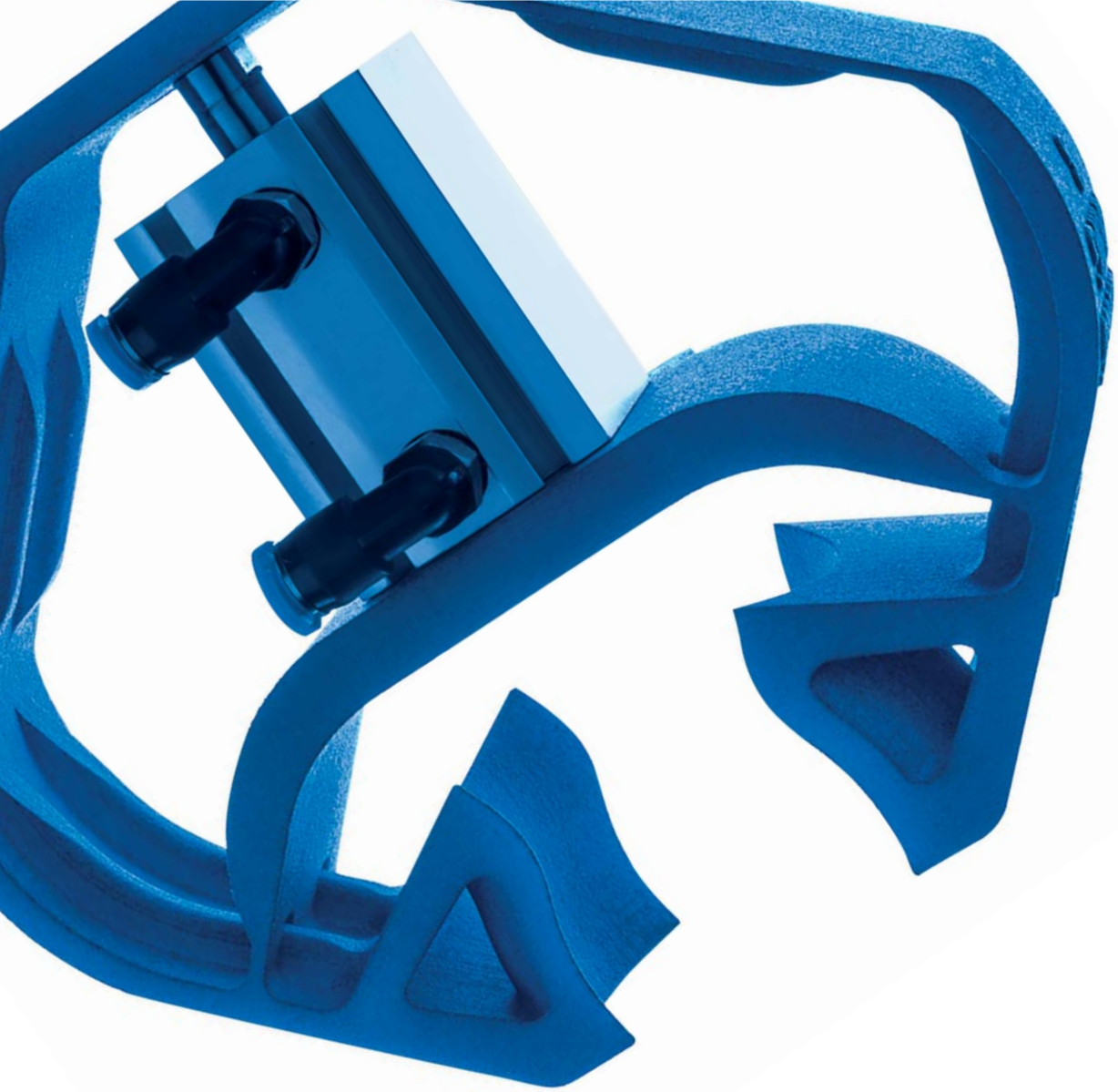
TYPE
Available in sizes 22 and 42 in especially compact design.
High precision thanks to double-piston drive synchronized via gear wheel.

CUSTOMER BENEFITS
- Compact design with long jaw stroke for especially cramped spatial conditions
- High gripping force with simultaneously long jaw stroke by means of double-acting pressure pistons
- Gripper fingers mounted laterally for minimum load distance
- Maximum flexibility thanks to versatile connection and fastening options

TECHNICAL FEATURES
Centrically clamping in compact design made of high-strength, hard-coated aluminum alloy. All functional parts made of hardened steel for maximum service life. Robust double-piston guide in compact housing, pneumatically actuated. Position can be queried using inductive and magnetic sensors. Integrated damping ring in the end positions for high availability.

Other sizes available on request. Optionally available with FKM seals for higher temperatures up to 150°C (on request).

Notes



INDIVIDUAL SINGLE PIECE WITH OPTIMIZED DESIGN

With the help of a 3D model of the workpiece, the synthetic RRMG gripper is individually and perfectly adapted to the respective workpiece. Special jaws with free-form surfaces allow the secure gripping and clamping of every sensitive workpiece with complex geometries.

The particularly robust and resistant design of the new synthetic RRMG gripper makes a 30% higher clamping force possible.

RRMG — **- 2**

RÖHM
Rapid
Manufacturing
Gripper

Sizes
2-3

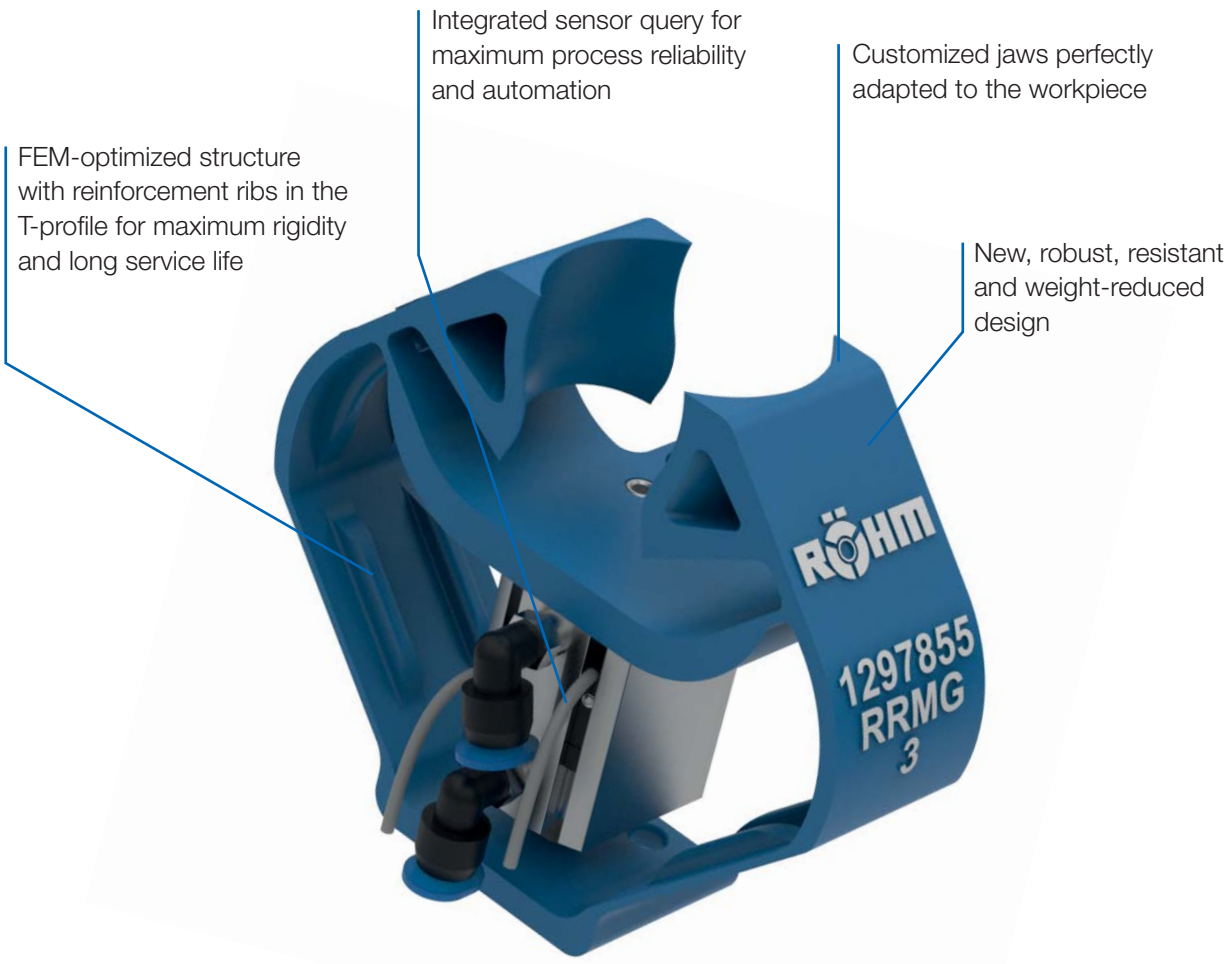
Video Synthetic gripper

SYNTHETIC GRIPPER

Whether round material, prismatic workpieces or free-form surfaces, the synthetic RRMG gripper from RÖHM is individually adapted to the workpiece and produced. Only a 3D model of the workpiece is required, and RÖHM will produce the individual synthetic RRMG gripper based on that. This customer-specific solution is therefore perfect for gripping and clamping sensitive workpieces with complex geometries.

ADVANTAGES AT A GLANCE

- Component-specific individual piece for sensitive workpieces with complex geometries
- FEM-optimized design with 30% higher clamping force for a greater range of use
- Up to 16 million gripper cycles without required maintenance or signs of wear



RRMG



APPLICATION

Synthetic gripper for easy, sensitive workpieces with complex geometries.

TYPE

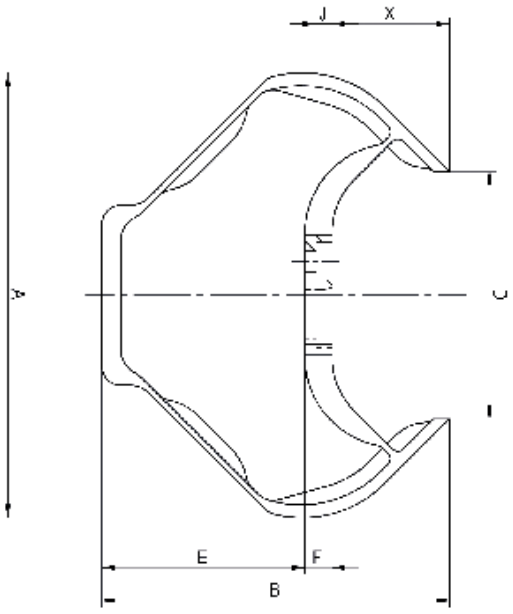
Synthetic gripper RRMG - customized and perfectly adapted jaws on the form of the workpiece.

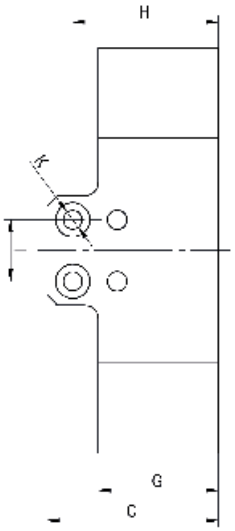
CUSTOMER BENEFITS

- Part specific unique gripper for sensitive workpieces with complex geometries
- FEM optimized structure with 30 % higher clamping force
- Customized and perfectly adapted to the workpiece using the 3D-model
- Application specific design of the flange for maximum flexibility
- Up to 16 million gripping cycles without maintenance or wear and tear

TECHNICAL FEATURES

- Synthetically built by selective laser sinthering for short delivery times
- Especially robust and durable material Polyamid with FEM-optimized structure
- Optional position monitoring by installable standard sensors
- Position monitoring by magnetic sensors possible
- Further designs and sizes on request (e.g. double gripper, internal gripper, etc.)





Synthetic gripper RRMG

	Size	Gripping force (N)*	Stroke (mm)*	Clamping point X	A	B	C	D	E	F	G	H	I	J	K Ø
RRMG	2	80	2,6	23,2	92	75,8	37	50	47	5,5	25	31	13	3,4	4,5
RRMG	3	152	4,3	31,2	118,6	92,4	50	66	54	7,2	35	42,5	18	4,2	5,5

* at clamping point X.

Notes

Operation guide



RSP-Flex - basic unit*

- With through hole



RSP-Flex - basic unit with fluid feedthrough*

- With fluid feedthrough and through hole
- -F4 4-way fluid feedthrough (RSP32-Flex)
- -F8 8-way fluid feedthrough (RSP42-Flex / RSP52-Flex)



RSP-Flex - basic unit with fluid and cable feedthrough*

- With fluid feedthrough, with cable feedthrough
- -F4 + -KD8 8-way cable feedthrough (RSP32-Flex)
- -F8 + -KD8 8-way cable feedthrough (RSP42-Flex / RSP52-Flex)



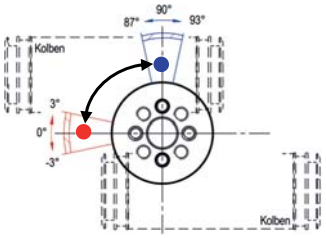
RSP-Flex - basic unit with fluid and cable feedthrough and inductive attachment kit*

- With fluid feedthrough, with cable feedthrough, with inductive attachment kit for monitoring the swivel position with proximity switches
- -F4 + -KD8 + -AS inductive attachment kit (RSP32-Flex)
  -F8 + -KD8 + -AS inductive attachment kit (RSP42-Flex / RSP52-Flex)

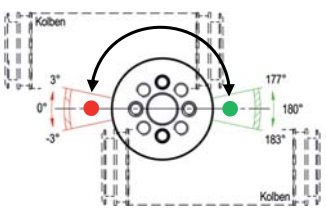
* The monitoring of the swivel position by up to 6 magnetic sensors is recommended for all swivel units

SWIVEL ANGLE AND END POSITION ADJUSTMENT

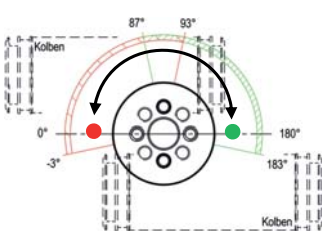
RSP-90-J3
Pivot angle 90°
End position ± 3°



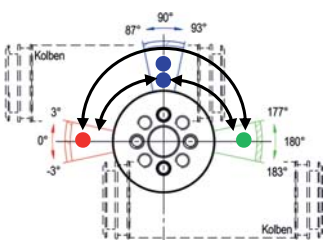
RSP-180-J3
Pivot angle 180°
End position ± 3°



RSP-180-J90
Pivot angle 180°
End position 90 ± 3°



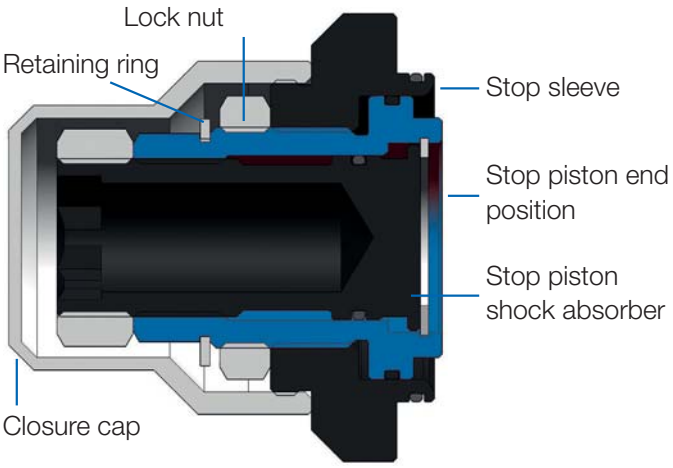
RSP-180-J3-MV
Pivot angle 90°-180°- 90°
End position ± 3°



with mechanically locked middle position

Operation guide

RSP END POSITION ADJUSTMENT



- No unintentional readjustment of the end position thanks to the use of the lock nut with fine thread
- Stepless adjustment of the end angle
- End position is not maladjusted when the shock absorber is adjusted



Step 1: Screw off the closure cap and loosen the lock nut



Step 2: Adjust end position



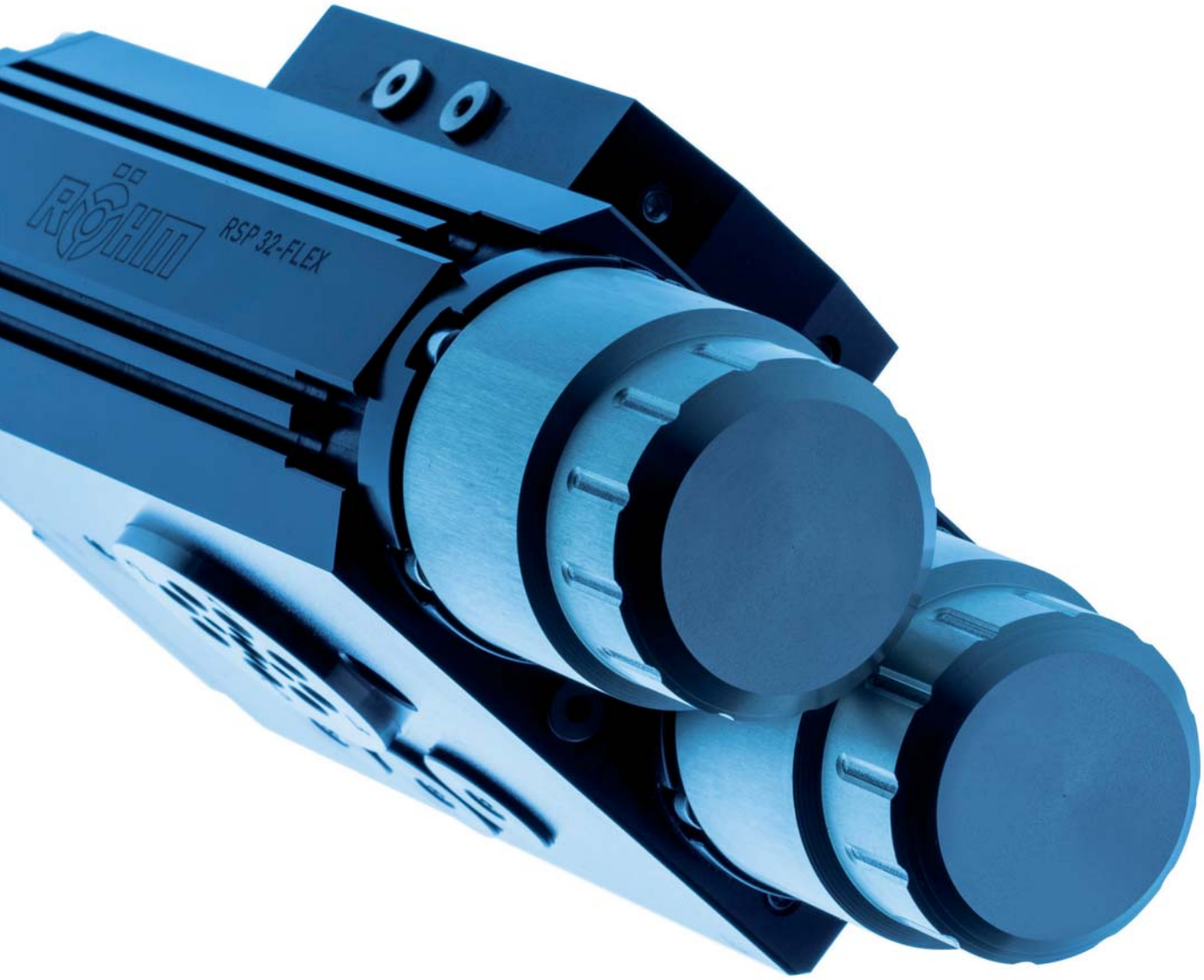
Step 3: Tighten the lock nut and screw on the closure cap

THE DAMPER SETTING MAKES THE DIFFERENCE



Simple load adaptation
Flexible and easy damper adjustment from outside using a wrench. It is not necessary to exchange or disassemble the swivel unit. Result: Can be quickly and easily integrated in the system.

The trick with the click
The shock absorber hardness can be uniquely documented. Thanks to the snap-in adjustability, the system-specific setting can be quickly and reliably reproduced.



NOMENCLATURE

RSP	52	-Flex	-180°	-J3	-MV	-F8	-KD8	-AS
Pneumatically actuated swivel unit	1. 32 / 42 / 52 (Size)	-Flex (flexible damper adjustment)	-180° (Swivel angle)	-J3 (End position adjustability)	-MV (Middle position locked)	2. -F4 / -F8 (4-/8-way fluid feedthrough)	3. Cable feed-through (M8), sensor plug	4. Inductive attachment kit

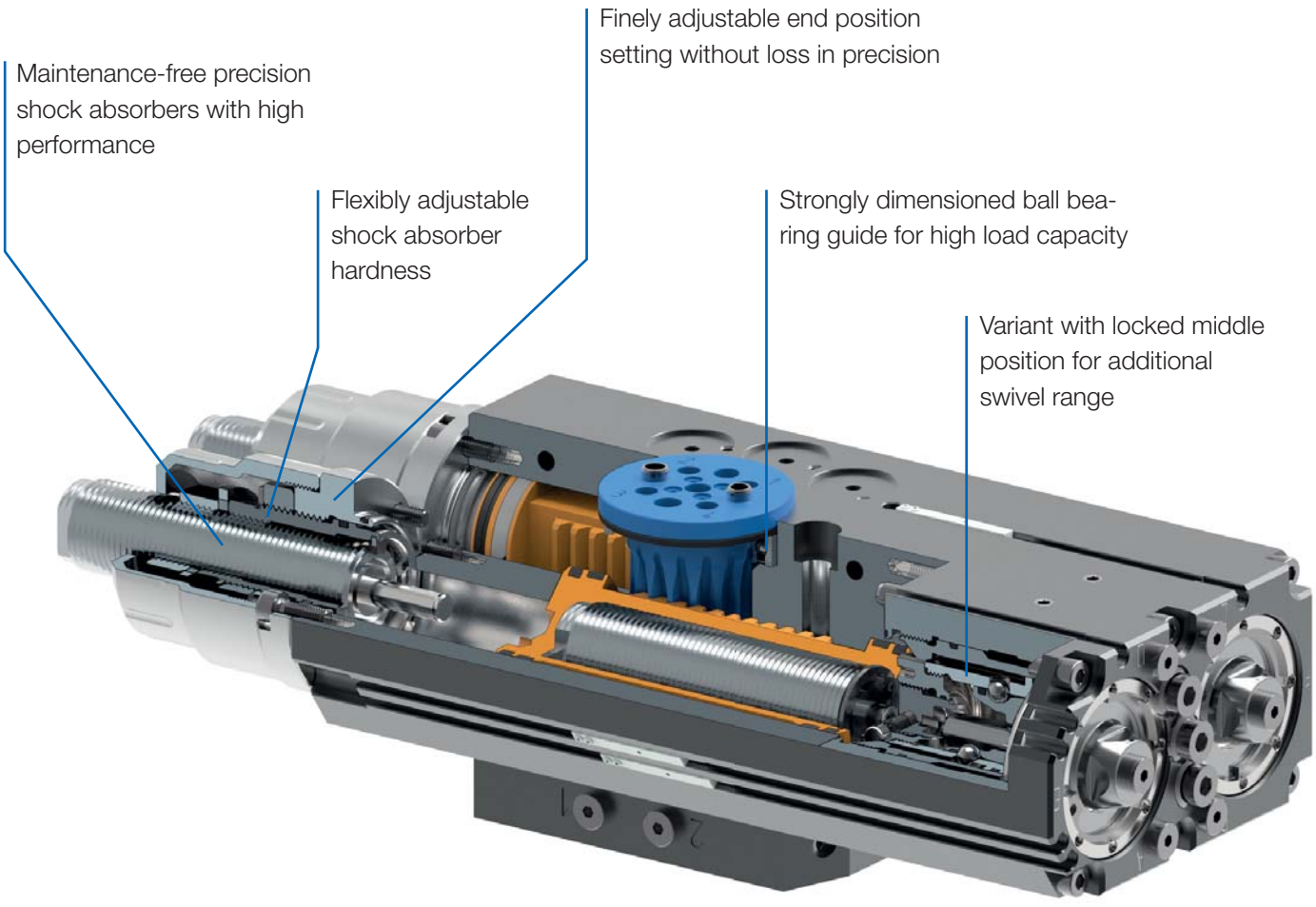
1. Select the size (32 / 42 / 52)
2. Is a fluid feedthrough required (yes/no)?
3. Cable feedthrough, yes/no?
4. Inductive attachment kit, yes/no?

SWIVEL UNIT RSP-FLEX

Especially for the automated loading and unloading to machine tools, as well as for the fast and precise insertion of components in assembly systems, the RSP Flex swivel units offer an alternative to complicated special designs. Thanks to the modular structure and the extensive expansion options, they are flexible and reliably Integrated. The innovative shock absorber concept with flexible and infinitely variable adjustability in all end positions allows for smoothly and precise swiveling.

ADVANTAGES AT A GLANCE

- Smoothly and precise swiveling thanks to innovative shock absorber concept
- High torque thanks to enlarged piston diameter for faster cycle times
- Maintenance-free up to 10 million swivel cycles



RSP-Flex 32



APPLICATION

Swivel unit with high torque and compact design.
Flexibly adjustable hardness of the shock absorbers.

TYPE

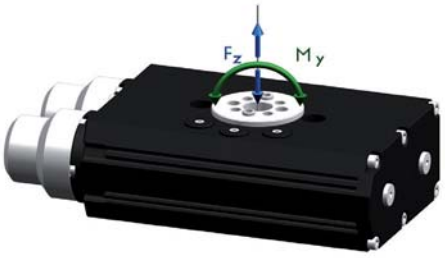
Realise two damping ranges, “hard” and “soft” with one swivel unit!

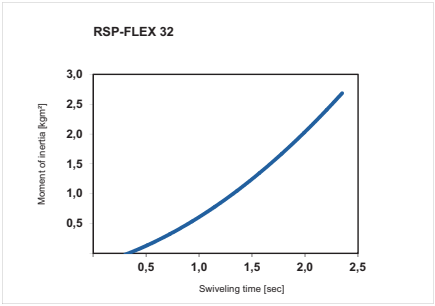
CUSTOMER BENEFITS

- Uniform damping in the end positions
- Fine adjustment of the dampers at the end position settings
- Optimal bearing support of the rotary plate for several million cycles
- Energy supply possible by means of screw connection or via hoseless direct connection
- Can be used in all positions - e.g. vertical, suspended, horizontal

TECHNICAL FEATURES

- Body made of high-strength, hard-coated aluminum
- Pinion shaft and rack made of hardened steel
- End position can be infinitely variably adjusted ± 3° or ± 90°
- Optional inductive and magnetic position sensors
- Up to 8-fold fluid feeder
- Up to 9-fold cable feed-through





C40
RSP-Flex 32
air operated

	RSP32-Flex-90-J3	RSP32-Flex-180-J3	RSP32-Flex-180-J90	RSP32-Flex-180-J3-MV
RSP-Flex Basic unit	**174000**	**174001**	**174002**	**174003**
RSP-Flex + fluid feed-through*	**174006**	**174007**	**174008**	**174009**
RSP-Flex + fluid feed-through* + cable feedthrough**	**174012**	**174013**	**174014**	**174015**
RSP-FLEX + fluid feed-through* + cable feedthrough** + proximity switch adapter***	**174018**	**174019**	**174020**	**174021**
Pivot angle °	90	180	180	180 + 2x90
End position adjustability °	± 3	± 3	± 3	± 3
Mid-position adjustability °	-	-	-	± 3
Torque at 6 bar Nm	10	10	10	10
Nominal operating pressure (min,/ max,) bar	6	6	6	6
Operating temperature min,/max, °C	5-80	5-80	5-80	5-80
Repeat accurancy °	± 0,01	± 0,01	± 0,01	± 0,01
Weight kg	2,5	2,5	2,5	3,6
Axial bearing load Fz N	800	800	800	800
Radial bearing load My Nm	19	19	19	19

* number of fluid feed-throughs RSP32=4; RSP42/RSP52=8 (max. 8 bar)
** number of signals=RSP32=8; RSP42/52=10 (24V, max. 1A), plug machine side M16, plug tool side M8
*** number of holders for proximity switches: 3

▲ on request

RSP-Flex 42



APPLICATION

Swivel unit with high torque and compact design.
Flexibly adjustable hardness of the shock absorbers.

TYPE

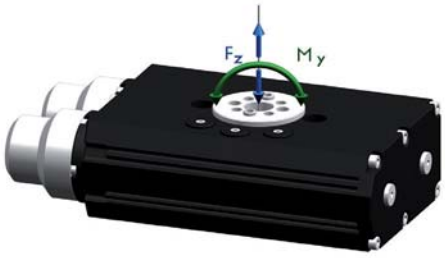
Realise two damping ranges, “hard” and “soft” with one swivel unit!

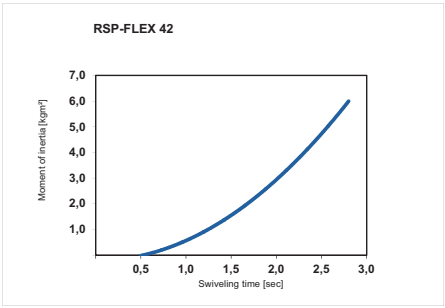
CUSTOMER BENEFITS

- Uniform damping in the end positions
- Fine adjustment of the dampers at the end position settings
- Optimal bearing support of the rotary plate for several million cycles
- Energy supply possible by means of screw connection or via hoseless direct connection
- Can be used in all positions - e.g. vertical, suspended, horizontal

TECHNICAL FEATURES

- Body made of high-strength, hard-coated aluminum
- Pinion shaft and rack made of hardened steel
- End position can be infinitely variably adjusted ± 3° or ± 90°
- Optional inductive and magnetic position sensors
- Up to 8-fold fluid feeder
- Up to 9-fold cable feed-through





C40
RSP-Flex 42
air operated

	RSP42-Flex-90-J3	RSP42-Flex-180-J3	RSP42-Flex-180-J90	RSP42-Flex-180-J3-MV
RSP-Flex Basic unit	**174024**	**174025**	**174026**	**174027**
RSP-Flex + fluid feed-through*	**174030**	**174031**	**174032**	**174033**
RSP-Flex + fluid feed-through* + cable feedthrough**	**174036**	**174037**	**174038**	**174039**
RSP-Flex + fluid feed-through* + cable feedthrough** + proximity switch adapter***	**174042**	**174043**	**174044**	**174045**
Pivot angle °	90	180	180	180 + 2x90
End position adjustability °	± 3	± 3	± 3	± 3
Mid-position adjustability °	-	-	-	± 3
Torque at 6 bar Nm	23	23	23	23
Nominal operating pressure (min,/ max,) bar	6	6	6	6
Operating temperature min,/max, °C	5-80	5-80	5-80	5-80
Repeat accurancy °	± 0,01	± 0,01	± 0,01	± 0,01
Weight kg	5	5	5	5
Axial bearing load Fz N	2900	2900	2900	2900
Radial bearing load My Nm	68	68	68	68

* number of fluid feed-throughs RSP32=4; RSP42/RSP52=8 (max. 8 bar)
** number of signals=RSP32=8; RSP42/52=10 (24V, max. 1A), plug machine side M16, plug tool side M8
*** number of holders for proximity switches: 3

RSP-Flex 52



APPLICATION

Swivel unit with high torque and compact design.
Flexibly adjustable hardness of the shock absorbers.

TYPE

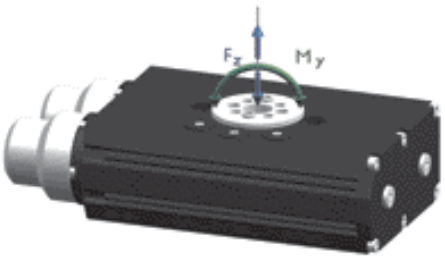
Realise two damping ranges, “hard” and “soft” with one swivel unit!

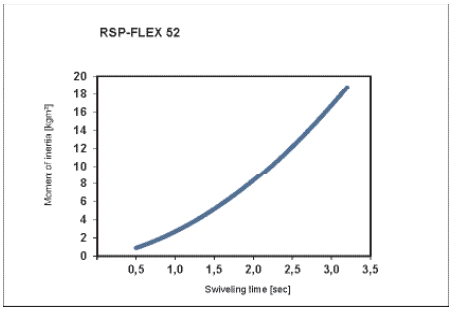
CUSTOMER BENEFITS

- Uniform damping in the end positions
- Fine adjustment of the dampers at the end position settings
- Optimal bearing support of the rotary plate for several million cycles
- Energy supply possible by means of screw connection or via hoseless direct connection
- Can be used in all positions - e.g. vertical, suspended, horizontal

TECHNICAL FEATURES

- Body made of high-strength, hard-coated aluminum
- Pinion shaft and rack made of hardened steel
- End position can be infinitely variably adjusted ± 3° or ± 90°
- Optional inductive and magnetic position sensors
- Up to 8-fold fluid feeder
- Up to 9-fold cable feed-through





C40
RSP-Flex 52
air operated

	RSP52-Flex-90-J3	RSP52-Flex-180-J3	RSP52-Flex-180-J90	RSP52-Flex-180-J3-MV
RSP-Flex Basic unit	**174048**	**174049**	**174050**	**174051**
RSP-Flex + fluid feed-through*	**174054**	**174055**	**174056**	**174057**
RSP-Flex + fluid feed-through* + cable feedthrough**	**174060**	**174061**	**174062**	**174063**
RSP-Flex + fluid feed-through* + cable feedthrough** + proximity switch adapter***	**174066**	**174067**	**174068**	**174069**
Pivot angle °	90	180	180	180 + 2x90
End position adjustability °	± 3	± 3	± 3	± 3
Mid-position adjustability °	-	-	-	± 3
Torque at 6 bar Nm	58	58	58	58
Nominal operating pressure (min,/ max,) bar	6	6	6	6
Operating temperature min,/max, °C	5-80	5-80	5-80	5-80
Repeat accurancy °	± 0,01	± 0,01	± 0,01	± 0,01
Weight kg	10,2	10,2	10,2	13,9
Axial bearing load Fz N	9000	9000	9000	9000
Radial bearing load My Nm	340	340	340	340

* number of fluid feed-throughs RSP32=4; RSP42/RSP52=8 (max. 8 bar)
** number of signals=RSP32=8; RSP42/52=10 (24V, max. 1A), plug machine side M16, plug tool side M8
*** number of holders for proximity switches: 3

▲ on request

Accessories RSP-Flex

Magnetic field sensors



Item no.	Design	For
1276722	3m cable, 3 litz wire	all sizes, all types
1276723	0,2m cable, M8x1 connector	all sizes, all types

Proximity switch

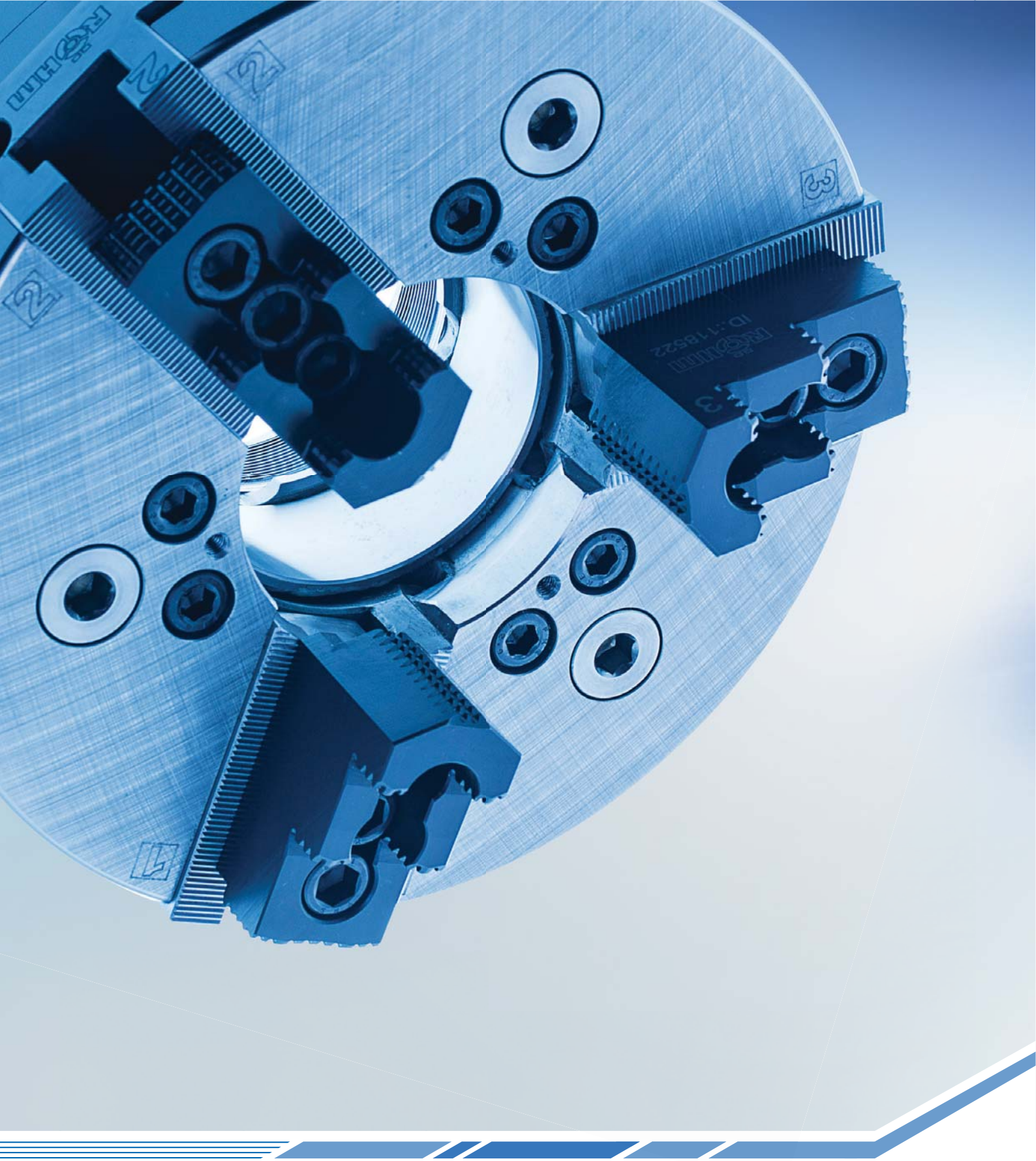


Item no.	Design	For
389661	3 m cable, open leads	all sizes, all types
1078808	3m cable, 3 open leads	all sizes, all types
680969	without cable, M8x1 connector	all sizes, all types

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info@roehm.biz
www.roehm.biz

driven by technology

Id.-Nr. 1242320 / 0915 AU



POWER CHUCKS
CYLINDERS / STEADY RESTS

2015/2016

RÖHM
driven by technology

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

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

Dynamism
Variety
Security
Partnership
Globality
Innovation


RÖHM



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POWER CHUCKS I CYLINDERS I STEADY RESTS

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- KFD-HE 6026
- KFG 6036
- PKF 6040

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- KFD-EC 6046
- KFD 6050
- KFD-G 6062

Power chucks with quick-acting jaw change system
- DURO-NCSE 6068
- DURO-NC 6078

Air-operated self-contained chucks
- LVE 6092
- LVE - large through-hole 6098

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- Power operated draw bar chuck ZFM 6114
- Power operated compensating chuck KFD-AF 6116
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Stationary power chucks
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- SSP 6184

Clamping force measurement device
- F-senso chuck 6190

Errors and corrections are reserved!

Operation guide






TYPE	KFD-HS	KFD-HE	KFG	PKF
	Power chucks with through-hole			
Feature	larger than average through-hole, high clamping precision, low centrifugal force losses	large through-hole, proven standard	large through-hole, large jaw stroke	maximum concentricity and axial run-out precision
Size	110 - 400	170 - 315	160 - 350	100 - 200
Chucking capacities	6 - 478 mm	20 - 393 mm	5 - 472 mm	-
Power transmission	wedge	wedge	angle lever	wedge
Clamping force	■■■■■	■■■■□	■□□□□	■□□□□
Speeds	■■■■■	■■■■□	■■□□□	■■■□□
Number of jaws	2-jaw chuck, 3-jaw chuck	3-jaw chuck	3-jaw chuck	3-jaw chuck
Type of Jaws	90°, tongue and groove	90°, 60°	60°	pin mounting
Workpiece	pipe, bar, flange, disc	pipe, bar, flange, disc	pipe, bar, flange, disc	flange, disc
Machining				
Mount	**DIN 6353** **ISO 702-1** (DIN 55026) **DIN 55021**	**DIN 6353**		
Page	6015	6026	6036	6040

2-jaw chuck
3-jaw chuck
60° serration 60°
90° serration 90°
tongue and groove
pipe
bar
disc
flange
asymmetrical workpiece

Operation guide





TYPE	KFD-EC	KFD	KFD-G
	Power chucks without through-hole		
Feature	low-maintenance and -wear	proven standard chuck for numerous applications	large jaw stroke, reduced interference contours
Size	200 - 400	85 - 630	125 - 315
Chucking capacities	16 - 490 mm	4 - 720 mm	-
Power transmission	wedge	wedge	wedge
Clamping force	■■■■■	■■■■■	■■■□□
Speeds	■■■□□	■■■□□	■■■□□
Number of jaws			
Type of Jaws	90°	90°	90°
Workpiece			
Machining			
Mount	DIN 6353	DIN 6353 similar DIN 6353	
Page	6046	6050	6062

side machining

lenght machining

short taper mount

cylindrical centre mount

Operation guide

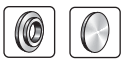
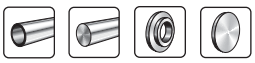
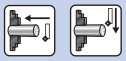
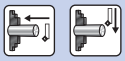





TYPE	DURO-NCSE	DURO-NC	LVE	LVE large through-hole
	Power chucks with quick-acting jaw change system		Air-operated self-contained chucks	
Feature	central jaw unlocking	central jaw unlocking	incorporated actuating cylinder	incorporated actuating cylinder, large through-hole
Size	180 - 630	140 - 630	125 - 315	400 - 1000
Chucking capacities	11 - 667 mm	5 - 780 mm	12 - 400 mm	85 - 1135 mm
Power transmission	wedge bar	wedge	wedge	wedge
Clamping force	■■■■■□	■■■■■□	■■■□□	■■■□□
Speeds	■■■■■	■■■■■□	■■□□□	■■□□□
Number of jaws	2-jaw chuck	2-jaw chuck	2-jaw chuck	2-jaw chuck
Type of Jaws	tongue and groove	tongue and groove	serration 90°	serration 90°
Workpiece	pipe, bar, disc, flange	pipe, bar, disc, flange	pipe, bar, flange	pipe, bar, flange
Machining				
Mount	**DIN 6353** **ISO 702-1** (DIN 55026) **DIN 55021**	**DIN 6353**		
Page	6068	6078	6092	6098

2-jaw chuck
3-jaw chuck
serration 60°
serration 90°
tongue and groove
pipe
bar
disc
flange
asymmetrical workpiece

Operation guide

TYPE	KBF-N draw-down chuck	ZFM draw-down chuck	KFD-AF compensating chuck	GF gripper chuck
				
	Application chucks			
Feature	for internal and external clamping, active pull down, hermetically sealed with oil bath lubrication	active pull down, only external clamping	compensating jaws, interchangeable centering inserts	automatic jaw resetting
Size	170 - 400	160 - 315	160 - 315	80 - 125
Chucking capacities	-	-	5 - 393 mm	-
Power transmission	wedge	draw rod studs system	wedge	spring system
Clamping force	■■■□□	■■□□□	■■■■□	■□□□□
Speeds	■■■■□	■■■■■	■■■□□	stationary
Number of jaws				
Type of Jaws		-		
Workpiece				
Machining				no machining (only gripping and positioning)
Mount	 **DIN 6353**  **ISO 702-1** (DIN 55026) **DIN 55021**		 with option for radial fine adjustment	cylindrical shank DIN 69880
Page	6110	6114	6116	6120

 side machining

 lenght machining

 short taper mount

 cylindrical centre mount

Operation guide







TYPE	EHS	SZS	LHS-L
	Cylinder with through-hole		
Feature	electrical cylinder with through-hole, drive via servo motor	hydraulical cylinder with through-hole for operating pressure 8 - 45 bar	pneumatical cylinder with through-hole for operating pressure 1,5 - 8 bar
Through-hole	37 - 67 mm	46 - 127 mm	26 - 42 mm
Stroke max.	32 mm	25 - 40 mm	20 - 32 mm
Pull force	max. 50 - 68 kN	46 - 145 kN (45 bar operating pressure)	10 - 16 kN (6 bar operating pressure)
Actuation			
Max. Speeds	6000 m^{-1}	7000 - 3200 m^{-1}	6500 - 4000 m^{-1}
Installation position	horizontal, vertical	horizontal	horizontal, vertical
Feature	high energy efficiency, environmentally friendly and high controllability	short design	short design
Workpiece			
Page	6128	6132	6134

 2-jaw chuck

 3-jaw chuck

 serration 60°

 serration 90°

 tongue and groove

 pipe

 bar

 disc

 flange

 asymmetrical workpiece

Operation guide







TYPE	EVS	OVS	LVS
	Cylinder without through-hole		
Feature	electrical cylinder without through-hole, drive via servo motor	hydraulical cylinder without through-hole for operating pressure 8 - 80 bar	pneumatical cylinder without through-hole for operating pressure 2 - 10 bar
Through-hole	-	-	-
Stroke max.	32 mm	32 - 50 mm	32 - 45 mm
Pull force	max. 50 kN	30 - 166 kN (60 bar operation pressure)	3 - 57 kN (6 operating pressure)
Actuation			
Max. Speeds	6000 m^{-1}	8000 - 4500 m^{-1}	5000 - 3200 m^{-1}
Installation position	horizontal, vertical	horizontal, vertical	horizontal, vertical
Feature	high energy efficiency, environmentally friendly, high controllability, prepared for media feed-through	prepared for media feed-through	media feed-through on request
Workpiece			
Page	6140	6144	6148

 side machining

 lenght machining

 short taper mount

 cylindrical centre mount

 hydraulical actuated

 pneumatically actuated

 elektrical actuated

Operation guide







TYPE	SLZN	SLZNB	SLZ heavy design	SLZC	SLZK
	Self-centering steady rests				
Feature	standard version with cylinder mounted at rear	with side mounted cylinder	heavy design for high loads	compact design, extra large clamping range	slim clamping arms
Chucking capacities	4 - 350	8 - 350	40 - 800	60 - 520	8 - 250
Max. clamping force per roller	1040 - 16000 N	3500 - 16000 N	35000 - 80000 N	14500 - 25000 N	2700 - 7500 N
Centering accuracy over the entire clamping range	0,02 - 0,06*	0,02 - 0,06*	0,04 - 0,06*	0,05 - 0,06*	0,03 - 0,06*
Repeatability at same clamping-Ø	0,005 - 0,01*	0,005 - 0,01*	0,01*	0,007 - 0,01*	0,007 - 0,01*
Rollers	cylindrical or convex	cylindrical or convex	cylindrical or convex	cylindrical or convex	cylindrical
Chip protection	with and without	with and without	with and without	with and without	with and without
Page	6158	6162	6166	6168	6170

* At constant pressure

2-jaw chuck

3-jaw chuck

serration 60°

serration 90°

tongue and groove

pipe

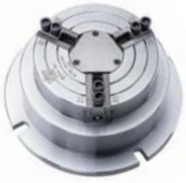
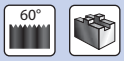
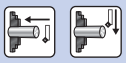
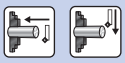
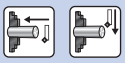
bar

disc

flange

asymmetrical workpiece

Operation guide

TYPE	KZS-P	KZS-PG	SSP	F-senso chuck
				
	Stationary power chucks			Clamping force measurement device
Feature	pneumatically, centering vices	pneumatically, centering vices, long jaw movement	pneumatically, without through-hole	measurement device incl. tablet and software
Size	64 - 250	100 - 250	160 - 315	-
Chucking capacities	-	-	28 - 400	75 - 175
Power transmission	wedge	wedge	wedge	-
Clamping force	■■□□□	■□□□□		max. 300 kN
Speeds	stationary	stationary	-	max. 8250 min^{-1}
Number of jaws				2-jaw (stationary) 3-jaw (rotating)
Type of Jaws				-
Workpiece				-
Machining				-
Mount	clamping sleeve DIN 7346	clamping sleeve DIN 7346	flange	-
Speciality	optimally suited for automated work sequences	optimally suited for automated work sequences	serration 60°, tongue and groove and / or through-hole on request	delivered in the practical hard-shell case
Page	6178	6181	6184	6190

 side machining

 lenght machining

 short taper mount

 cylindrical centre mount

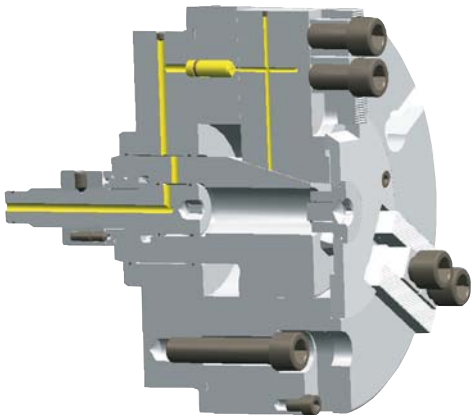
Flexibility of the media feed-through

For power chucks with and without through-hole

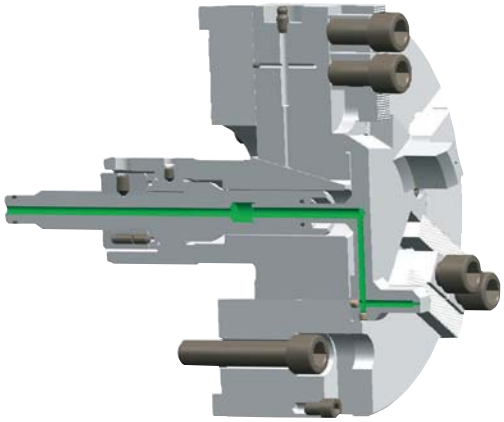
Available on request:

- with air feed-through for air sensing, purge or blast air
- Central lubrication
- with guided and sealed piston neck
- with water drain groove or water drain bore as well as cover or inserts for the through-hole bore

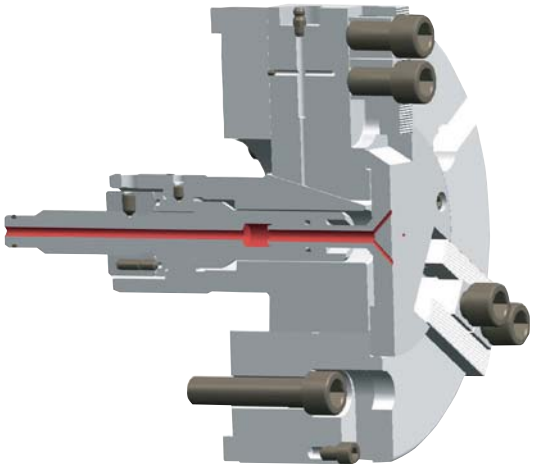
Examples of modified power chucks with feed-through for:



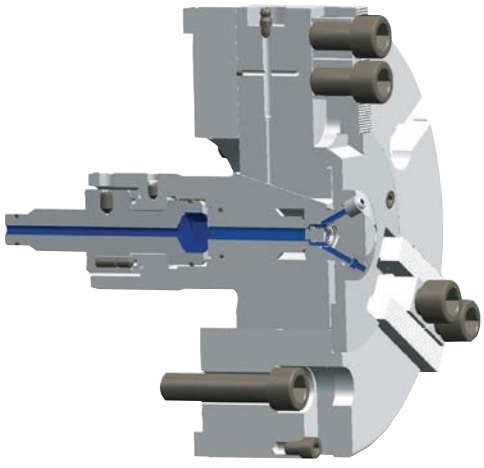
Central lubrication via distributor flange with dosing units



Air sensing



Blast air



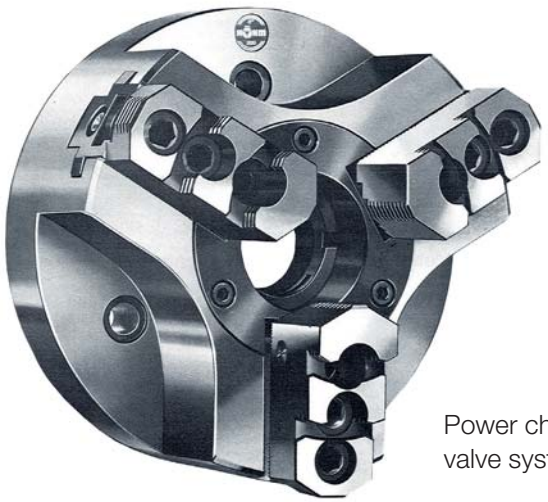
Coolant

Double feed-throughs, e.g. for central lubrication and air sensing, are possible.

Notes

USED UNIVERSALLY FOR DECADES

Founded in 1909, RÖHM began successively expanding their product range by the area of power chuck technology starting in 1950. Decades of experience and knowledge about power chucks make today‘s RÖHM power chucks so successful. Especially for the machining of bar material, these are not only characterized by the high flexibility due to the large through-hole, but also by the long service life, top precision and reliability.



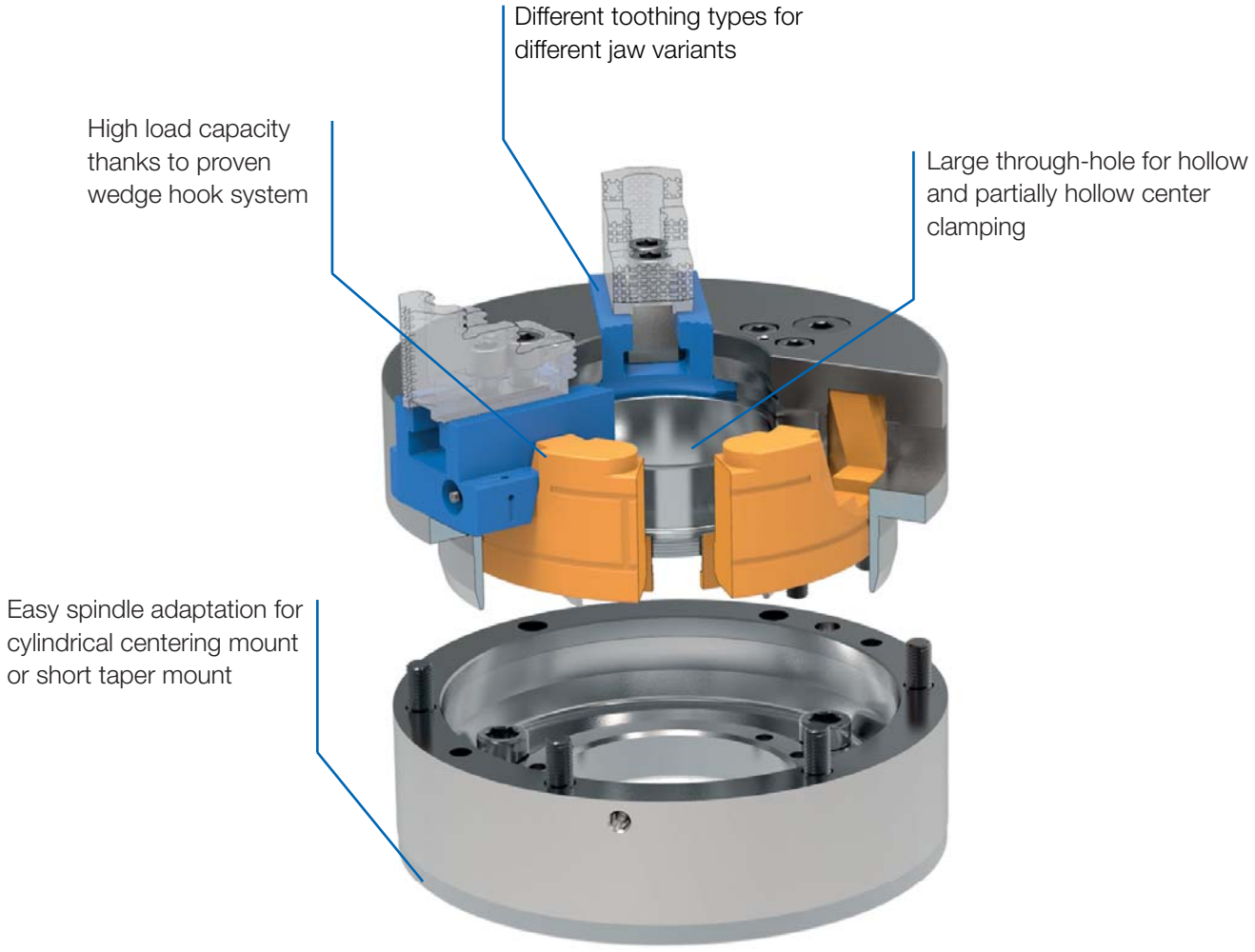
Power chucks with single wedge gate valve system and through-hole

POWER CHUCKS WITH THROUGH-HOLE

RÖHM power chucks with through-hole are successfully used both in bar and pipe machining, as well as in the machining of flange-type workpieces. The proven wedge system allows maximum clamping forces with maximum clamping precision at the same time. The rigidity of the power chucks which contributes to this is achieved with a sturdy chuck construction.

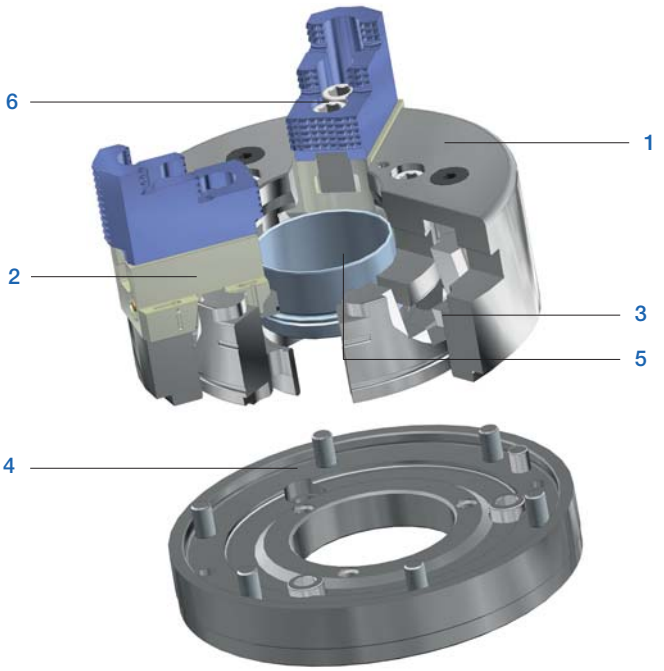
ADVANTAGES AT A GLANCE

- Large through-hole optimal for bar machining
- Proven power chucks with long service life
- Wedge hook system for high load capacity and clamping precision



KFD-HS

Two- and three-jaw chuck, with large through-hole, for very high speeds.
The construction principle of the power chuck KFD-HS consists of absorbing the centrifugal forces which occur during machining to the degree that the clamping force is hardly influenced.This occurs thanks to a special type of wedge hook connection. Even for extremely high speeds, the clamping force drop is very low.The high rigidity is achieved through the screw connection between the chuck body and chuck flange. Thus, this chuck type offers the optimal precondition for exactly machining shaft-type and flange-type workpieces.

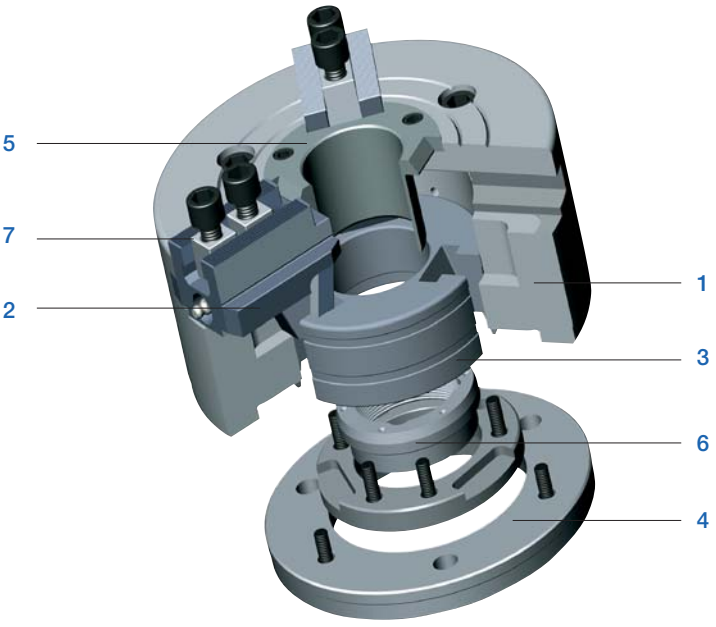


KFD-HS components

1. Body
2. Base jaw
3. Clamping piston
4. Chuck flange
5. Protective bushing
6. Slot nut

KFD-HE

Standard chuck for use on modern turning machines. A large through-hole allows both bar and pipe machining as well as the machining of flange-type workpieces. The power is transmitted via the proven wedge hook system.



KFD-HE components

1. Body
2. Base jaw
3. Piston
4. Chuck flange
5. Protective bushing
6. Ring nut
7. Slot nut

KFD-HS



APPLICATION

Premium power chucks with through-hole for maximum speeds with simultaneously low centrifugal force losses.

TYPE

Power chuck available with cylindrical center mount or short taper mount.
3-jaw version with serration (90°) or tongue and groove.
2-jaw version with serration (90°).

CUSTOMER BENEFITS

- Low centrifugal force losses and high speeds thanks to special wedge hook system with annular piston
- Larger than average through-hole for wide range of workpieces
- Maximum precision thanks to rigid chuck construction
- If necessary quick conversion to a different spindle nose, by simply exchanging the centering adapter

TECHNICAL FEATURES

- Universal construction of the piston connection (piston does not project into the spindle bore area, even with the piston position moved back)
- Long jaw guide
- Clamping inserts can be used for bar machining (special version)

Included in the scope of delivery:
Chuck, chuck and jaw mounting screws, mounting wrench, slot nuts (without top jaws)

Gripping force/speed diagram (3-jaw chucks only)

The loss of gripping force was determined experimentally on a chuck with matched UB top jaws. It is largely independent of the initial gripping force at zero speed.

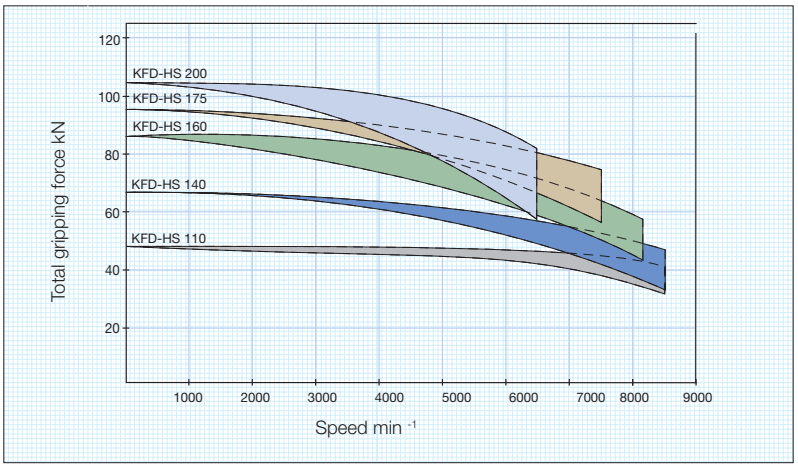
Upper curve: min. centrifugal force of top jaw

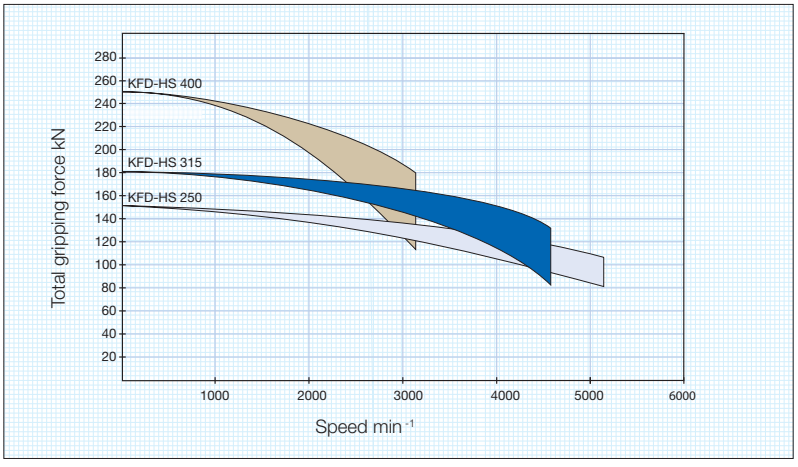


Lower curve: max. centrifugal force of top jaw

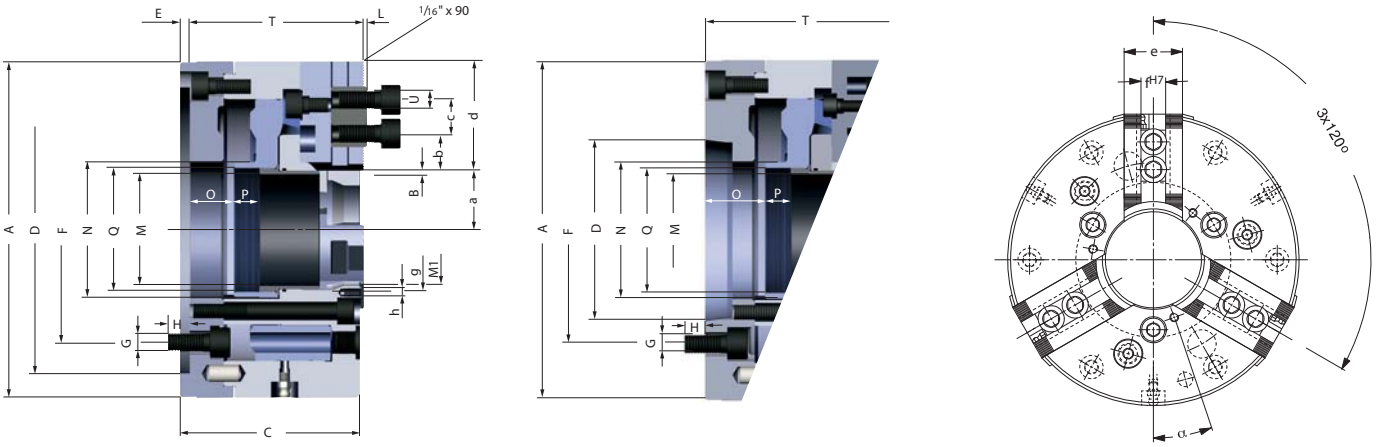


To obtain the specified gripping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM. Measuring point near chuck face.





KFD-HS 3-jaw, serration 90°



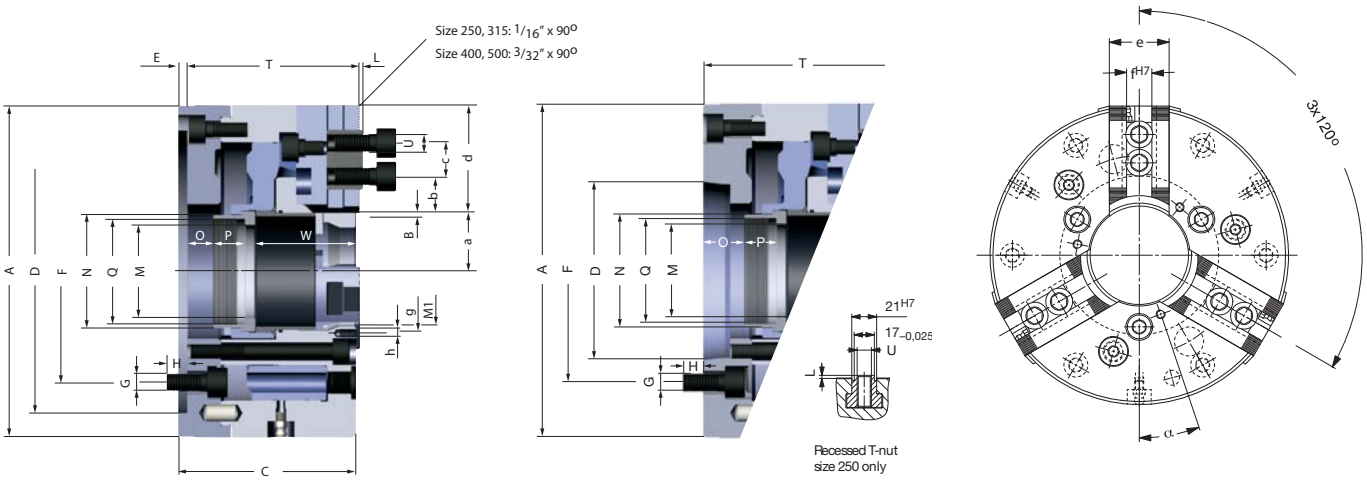
C 15
3 jaw power chuck **KFD-HS**, **with tightening thread, serration 90°**
Cylindrical center mount, connection dimensions in acc. with DIN 6353/short taper mount (KK) for ISO 702-1 (DIN 55026/55021)

Item no.	149406	149405	144258	142690	143692	142478	144259	143893	143888	142479
Size	110	110	140	140	160	160	175	175	200	200
number of jaws	3	3	3	3	3	3	3	3	3	3
A mm	110	110	140	140	160	160	175	175	200	200
Jaw travel B mm	3,2	3,2	3,2	3,2	4	4	4	4	5	5
C mm	78	86	88	92	102	108	102	108	107	112
Mount D	ZA 60	KK 4 1)	ZA 120	KK 5	ZA 140	KK 5	ZA 140	KK 5	ZA 170	KK 6
E mm	6	13	6	15	6	16	6	16	6	16
F mm	82,6	82,6	104,8	104,8	104,8	104,8	104,8	104,8	133,4	133,4
G	3xM10	3xM10	3xM10	3xM10	3xM10	3xM10	3xM10	3xM10	3xM12	3xM12
H mm	14	14	15	17	15	14	15	14	18	17
Wedge stroke K mm	12	12	12	12	15	15	15	15	18,5	18,5
L mm	2,5	2,5	2,5	2,5	2,5	2,5	2,5	2,5	2,5	2,5
M max. mm	26	26	37	37	46	46	56	56	66	66
M1H7 mm	32	32	37	37	46	46	56	56	66	66
N mm	38	38	48	48	58	58	68	68	80	80
O min.	-1	11	5	13	6	16	6	16	7,5	16,5
O max.	11	23	17	25	21	31	21	31	26	35
P mm	12	12	14	14	16	16	16	16	15	15
Q mm	M34x1,5	M34x1,5	M44x1,5	M44x1,5	M54x1,5	M54x1,5	M65x1,5	M65x1,5	M74x1,5	M74x1,5
T mm	80	84	84	90	98	106	98	106	103	110
U mm	M8	M8	M6	M6	M8	M8	M8	M8	M12	M12
a min.	10,8	10,8	16,8	16,8	24	24	29	29	35	35
a max.	14	14	20	20	28	28	33	33	40	40
b min.	3	3	0	0	0	0	0	0	8,5	8,5
b max.	23	23	26	26	22	22	24,5	24,5	32,5	32,5
c mm	15	15	2x12	2x12	2x15	2x15	2x15	2x15	19	19
d mm	41	41	50	50	52	52	54,5	54,5	60	60
e mm	24	24	25	25	32	32	32	32	40	40
fH7-0,025 mm	10	10	10	10	12	12	12	12	17	17
g mm	50	50	68	68	76	76	76	76	84	84
h		M5x8	M5x8	M5x8	M6x10	M6x10	M6x10	M6x10	M6x10	M6x10
α	0°	0°	22° 30‘	22° 30‘	20°	20°	20°	20°	20°	20°
Max. swing top jaws mm	113	113	180	180	195	195	210	210	250	250
Maximum draw bar pull kN	18	18	25	25	35	35	40	40	48	48
Max. total clamping force kN	48	48	70	70	86	86	95	95	110	110
Max. admissible speed min^{-1}	8500	8500	8000	8000	8000	8000	7000	7000	6500	6500
Moment of inertia J kgm2	0,007	0,007	0,022	0,022	0,0415	0,0415	0,057	0,057	0,1	0,1
Weight without jaws approx. kg	5	5	9	9	12	12	15	15	20	20
Actuating cylinders (recommended)	**OVS-85 / SZS-37/70**	**OVS-85 / SZS-37/70**	**OVS-105 / SZS-37/70**	**OVS-105 / SZS-37/70**	**OVS-105 / SZS-46/103**	**OVS-105 / SZS-46/103**	**OVS-105 / SZS-52/130**	**OVS-105 / SZS-52/130**	**OVS-130 / SZS-67/150**	**OVS-130 / SZS-67/150**

* ISO 702-1 (DIN 55026) only (DIN 55021 on request)

▲ on request

KFD-HS 3-jaw, serration 90°

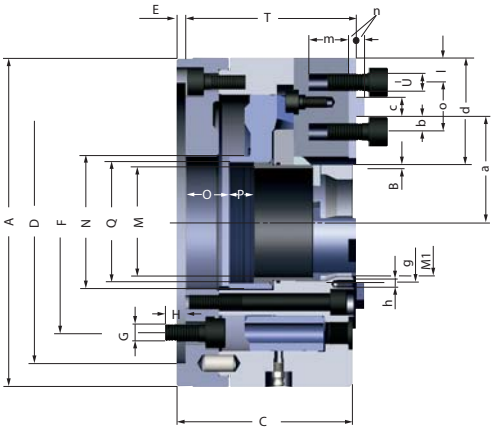


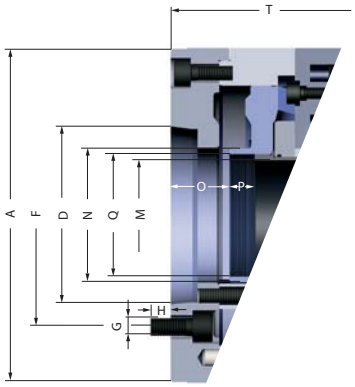
C 15
3 jaw power chuck **KFD-HS, with tightening thread, serration 90°**
Cylindrical center mount, connection dimensions in acc. with DIN 6353/short taper mount (KK) for ISO 702-1 (DIN 55026/55021)

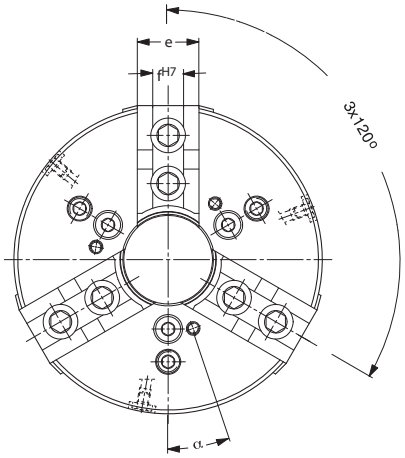
Item no.	161725	144260	143726	142691	144261	143748	144262	143749	144263	143750	143751
Size	250	250	250	250	315	315	315	315	400	400	400
number of jaws	3	3	3	3	3	3	3	3	3	3	3
A mm	250	250	250	250	315	315	315	315	400	400	400
Jaw travel B mm	6,2	6,2	6,2	6,2	6,2	6,2	6,2	6,2	7,5	7,5	7,5
C mm	128	128	130	130	128	130	139	143	156	156	156
Mount D	ZA 170	ZA 220	KK 6	KK 8	ZA 220	KK 8	ZA 300	KK 11	ZA 380	KK 11	KK 15
E mm	6	6	15	19	6	19	6	21	6	18	21
F mm	133,4	171,4	133,4	171,4	171,4	171,4	235	235	330,2	235	330,2
G	3xM12	3xM16	3xM12	3xM16	3xM16	3xM16	3xM20	3xM20	3xM24	3xM20	3xM24
H mm	16	24	18	24	24	24	30	30	30	30	30
Wedge stroke K mm	23	23	23	23	23	23	23	23	28	28	28
L mm	2,5	2,5	2,5	2,5	2,5	2,5	2,5	2,5	3,5	3,5	3,5
M max. mm	66	86	66	86	86	86	108	108	165	126	165
M1H7 mm	94	94	94	94	94	94	115	115	172	172	172
N mm	110	99	80	99	99	99	126	126	180	142	180
O min.	0	-6	2	2	-6	2	-9	1	-12	0	-6
O max.	23	17	25	25	17	25	14	24	16	28	22
P mm	19	25	25	25	25	25	25	25	35	35	35
Q mm	M74x1,5	M94x1,5	M74x1,5	M94x1,5	M94x1,5	M94x1,5	M120x1,5	M120x1,5	M172x3	M132x1,5	M172x3
T mm	124	124	132	132	124	132	135	145	153	159	159
U mm	M12	M12	M12	M12	M16	M16	M16	M16	M20	M20	M20
W mm	74	74	74	74	74	74	85	85	88	88	88
a min.	43,8	43,8	43,8	43,8	43,8	43,8	54,8	54,8	80,5	80,5	80,5
a max.	50	50	50	50	50	50	61	61	88	88	88
b min.	6	6	6	6	10,5	10,5	10,5	10,5	14,5	14,5	14,5
b max.	47,5	47,5	47,5	47,5	72	72	61	61	66,5	66,5	66,5
c mm	19	19	19	19	25	25	25	25	31	31	31
d mm	75	75	75	75	107,5	107,5	96,5	96,5	112	112	112
e mm	50	50	50	50	50	50	50	50	60	60	60
fH7-0,025 mm	17	17	17	17	21	21	21	21	25,5	25,5	25,5
g mm	108	108	108	108	108	108	136	136	190	190	190
h	M6x10	M6x10	M6x10	M6x10	M6x10	M6x10	M8x12	M8x12	M8x12	M8x12	M8x12
α	15°	0°	15°	0°	0°	0°	0°	0°	15°	15°	15°
Max. swing top jaws mm	305	305	305	305	380	380	380	380	520	520	520
Maximum draw bar pull kN	65	65	65	65	80	80	80	80	110	110	110
Max. total clamping force kN	150	150	150	150	180	180	180	180	250	250	250
Max. admissible speed min^{-1}	5000	5000	5000	5000	4200	4200	4200	4200	3150	3150	3150
Moment of inertia J kgm2	0,35	0,35	0,35	0,35	0,74	0,74	0,74	0,74	2,4	2,4	2,4
Weight without jaws approx. kg	40	40	40	40	56	56	56	56	120	120	120
Actuating cylinders (recommended)	**OVS-150 / SZS-67/150**	**OVS-150 / SZS-86/200**	**OVS-150 / SZS-67/150**	**OVS-200 / SZS-86/200**	**OVS-200 / SZS-86/200**	**OVS-200 / SZS-86/200**	**OVS-200 / SZS-110/250**	**OVS-200 / SZS-110/250**	**OVS 200 / -**	**OVS-200 / SZS-127/325**	**OVS-200 / -**

* ISO 702-1 (DIN 55026) only (DIN 55021 on request)

KFD-HS 3-jaw, tongue and groove







C15

3 jaw power chuck KFD-HS, with tightening thread, with tongue and groove

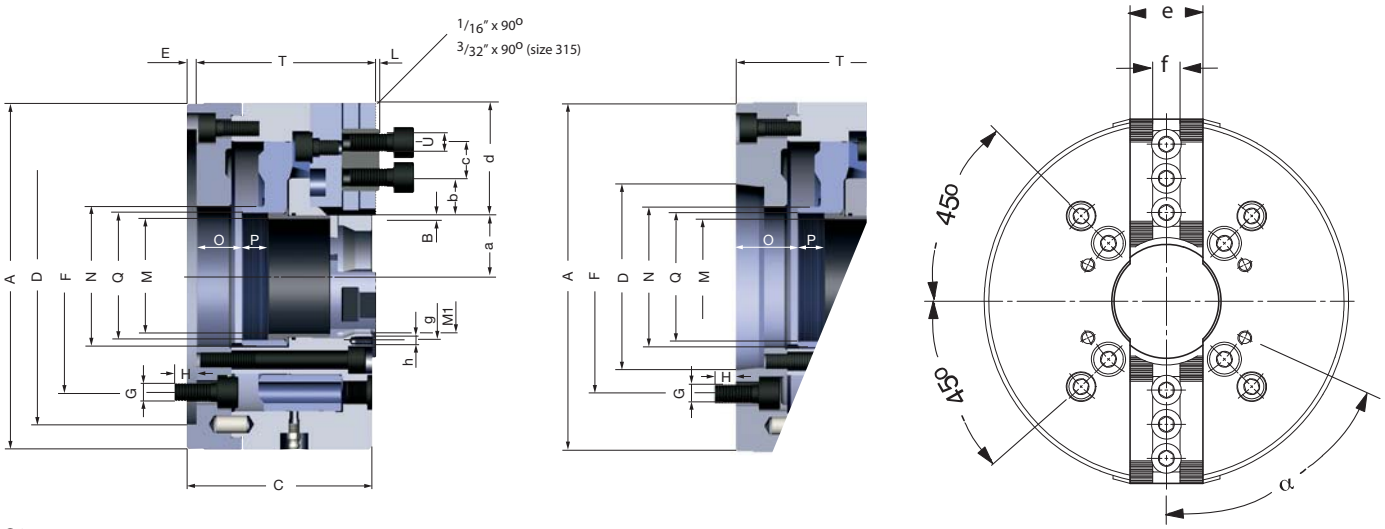
Cylindrical center mount, connection dimensions in acc. with DIN 6353/short taper mount (KK) for ISO 702-1 (DIN 55026/55021)

Item no.	149846	149543	151532▲	156580▲	153182	157768	154239	155099
Size	110	110	140	140	160	160	200	200
number of jaws	3	3	3	3	3	3	3	3
A mm	110	110	140	140	160	160	200	200
Jaw travel B mm	3,2	3,2	3,2	3,2	4	4	5	5
C mm	80	86	88	92	102	108	107	112
Mount D	ZA 60	KK 4 1)	ZA 120	KK 5	ZA 140	KK 5	ZA 170	KK 6
E mm	6	13	6	16	6	15	6	16
F mm	82,6	82,6	104,8	104,8	104,8	104,8	133,4	133,4
G	3xM10	3xM10	3xM10	3xM10	3xM10	3xM10	3xM12	3xM12
H mm	14	14	15	17	15	14	18	17
Wedge stroke K mm	12	12	12	12	15	15	18,5	18,5
M max. mm	26	26	37	37	46	46	66	66
M1H7 mm	32	32	37	37	46	46	66	66
N mm	38	38	48	48	58	58	80	80
O min.	-1	11	5	13	6	16	7,5	16,5
O max.	11	23	17	25	21	31	26	35
P mm	12	12	14	14	16	16	15	15
Q mm	M34x1,5	M34x1,5	M44x1,5	M44x1,5	M54x1,5	M54x1,5	M74x1,5	M74x1,5
T mm	78	80	84	90	98	106	103	110
U mm	M8	M8	M12	M12	M12	M12	M12	M12
a min.	31,8	31,8	45,3	45,3	43	43	59	59
a max.	35	35	48,5	48,5	47	47	64	64
c mm	10	10	13	13	10	10	12	12
d mm	30	30	50	50	56	56	65	65
e mm	24	24	25	25	32	32	40	40
fH7-0,025 mm	10	10	8	8	16	16	16	16
g mm	50	50	68	68	76	76	84	84
h	M5x8	M5x8	M5x8	M5x8	M6x10	M6x10	M6x10	M6x10
l mm	6,5	6,5	29	29	15,5	15,5	15	15
m mm	11	11	19	19	18	18	20	20
n mm	3	3	3	3	5	5	5	5
α	0°	0°	22° 30'	22° 30'	20°	20°	20°	20°
Max. swing top jaws mm	113	113	180	180	170	170	210	210
Maximum draw bar pull kN	18	18	25	25	35	35	48	48
Max. total clamping force kN	48	48	70	70	86	86	110	110
Max. admissible speed min-1	8500	8500	8000	8000	8000	8000	6500	6500
Moment of inertia J kgm2	0,007	0,007	0,022	0,022	0,0415	0,0415	0,1	0,1
Weight without jaws approx. kg	5	5	9	9	12	12	20	20
Actuating cylinders (recommended)	**OVS-85 / SZS-37/70**	**OVS-85 / SZS-37/70**	**OVS-105 / SZS-37/70**	**OVS-105 / SZS-37/70**	**OVS-105 / SZS-46/103**	**OVS-105 / SZS-46/103**	**OVS-130 / SZS-67/150**	**OVS-130 / SZS-67/150**

* ISO 702-1 (DIN 55026) only (DIN 55021 on request)

▲ on request

KFD-HS 2-jaw, serration 90°



C15
2 **jaw power chuck KFD-HS, with tightening thread, serration 90°**
Cylindrical center mount, connection dimensions in acc. with DIN 6353/short taper mount (KK) for ISO 702-1 (DIN 55026/55021)

Item no.	147281	147282	147285	147286	148036	148023	148031	162995
Size	160	160	200	200	250	250	250	315
number of jaws	2	2	2	2	2	2	2	2
A mm	160	160	200	200	250	250	250	315
Jaw travel B mm	4	4	5	5	6,2	6,2	6,2	6,25
C mm	102	108	107	112	128	132	132	130
Mount D	ZA 140	KK 5	ZA 170	KK 6	ZA 220	KK 6	KK 8	ZA 300
E mm	6	15	6	16	6	15	19	6
F mm	104,8	104,8	133,4	133,4	171,4	133,4	171,4	235
G	4xM10	4xM10	4xM12	4xM12	4xM16	4xM12	4xM16	4xM20
H mm	15	14	18	17	24	18	24	30
Wedge stroke K mm	15	15	18,5	18,5	23	23	23	23
L mm	2,5	2,5	2,5	2,5	2,5	2,5	2,5	3,5
M max. mm	46	46	66	66	86	66	86	108
M1H7 mm	46	46	66	66	94	94	94	115
N mm	58	58	80	80	99	80	99	126
O min.	6	16	7,5	16,5	-6	2	2	-9
O max.	21	31	26	35	17	25	25	14
P mm	16	16	15	15	25	25	25	25
Q mm	M54x1,5	M54x1,5	M74x1,5	M74x1,5	M94x1,5	M74x1,5	M94x1,5	M120x1,5
T mm	98	106	103	110	124	130	130	135
U mm	M8	M8	M 12	M12	M12	M12	M12	M16
W mm	-	-	-	-	-	74	74	85
a min.	24	24	35	35	43,8	43,8	43,8	54,8
a max.	28	28	40	40	50	50	50	61
b min.	0	0	8,5	8,5	6	6	6	10,5
b max.	22	22	32,5	32,5	47,5	47,5	47,5	61
c mm	2x15	2x15	19	19	19	19	19	25
d mm	52	52	60	60	75	75	75	96,5
e mm	32	32	40	40	50	50	50	50
fH7-0,025 mm	12	12	17	17	17	17	17	21
g mm	76	76	84	84	108	108	108	136
h	M6x10	M6x10	M6x10	M6x10	M6x10	M6x10	M6x10	M8x12
α	40°	40°	60°	60°	60°	60°	60°	60°
Max. swing top jaws mm	170	170	250	250	305	305	305	380
Maximum draw bar pull kN	20	20	30	30	42	42	42	55
Max. total clamping force kN	45	45	66	66	94	94	94	120
Max. admissible speed min-1	8000	8000	6500	6500	5000	5000	5000	4200
Moment of inertia J kgm2	0,0415	0,0415	0,1	0,1	0,35	0,35	0,35	0,62
Weight without jaws approx. kg	12	12	20	20	40	40	40	60
Actuating cylinders (recommended)	**OVS-105 / SZS-46/103**	**OVS-105 / SZS-46/103**	**OVS-130 / SZS-67/150**	**OVS-130 / SZS-67/150**	**OVS-150 / SZS-67/150**	**OVS-150 / SZS-67/150**	**OVS-150 / SZS-86/200**	**OVS-200 / SZS-110/250**

Other sizes on request

Jaws KFD-HS

C 21
Reversible top jaws, hardened serration 90° - material: 16 MnCr 5



Chuck Size	2-jaw set	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm	Serration
110	-	**149352**	45	32	26	1/16"x 90°
140	**046545**	**046544**	56	37,5	26	1/16"x 90°
160/175	**045796**	**046404**	56	37,5	26	1/16"x 90°
160/175	-	**351320**	51,5	26	26	1/16"x 90°
200/250	**118521**	**118522**	75	49	36	1/16"x 90°
315	**046435**	**046414**	103,5	58	50	1/16"x 90°
400	**046447**	**037531**	135	65	68	3/32"x 90°

[1] Additionally or later applied, hardened jaws must be ground out in the chuck!

C 21
Soft top jaws, can be hardened serration 90° - material: 16 MnCr 5



Chuck Size	2-jaw set	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm	Serration
110	-	**149353**	45	38	26,5	1/16"x 90°
140	**045794**	**046402**	53	30	22,5	1/16"x 90°
160/175	**045795**	**046403**	55	38	26,5	1/16"x 90°
200	**133147**	**133152**	66,7	53	36,5	1/16"x 90°
250	**133148**	**133153**	75	53	36,5	1/16"x 90°
315	**133149**	**133154**	95	54,5	45	1/16"x 90°
400	**133151**	**133156**	130	80	50	3/32"x 90°

C 21
Soft top jaws, 3-jaw set, can be hardened tongue and groove 120° bevelled, material: 16 MnCr 5



Chuck Size	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm
110	**144082**	53	30	22,5
140	**123355**	58	38	26,5
160	**123358**	72,7	53	36,5
200	**123430**	90,3	53	36,5

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 10



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
149920	110	42	27	37,1	1/16"x 90°
149921	110	42	27	23,4	1/16"x 90°
149922	110	47	27	17,7	1/16"x 90°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 10



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
147259	140	50	27	41	1/16"x 90°
147261	140	44	27	22	1/16"x 90°

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Jaws KFD-HS

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 12



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
144320	160/175	66	38	52	1/16"x 90°
144321	160/175	56	38	34	1/16"x 90°
144322	160/175	66	38	25	1/16"x 90°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 17



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137031	200/250	67	45	53	1/16"x 90°
137032	200/250	65	45	46	1/16"x 90°
137033	200/250	55	45	39	1/16"x 90°
137034	200/250	50	45	31	1/16"x 90°
137035	200/250	55	45	27	1/16"x 90°
137036	200/250	65	45	19	1/16"x 90°
137037	200/250	65	45	26	1/16"x 90°
137038	200/250	55	45	24	1/16"x 90°
137039	200/250	55	45	40	1/16"x 90°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 21



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137041	250/315	95	50	80	1/16"x 90°
137042	250/315	75	50	60	1/16"x 90°
137043	250/315	60	50	43	1/16"x 90°
137044	250/315	70	50	37	1/16"x 90°
137045	250/315	95	50	25	1/16"x 90°
137046	250/315	80	50	30	1/16"x 90°

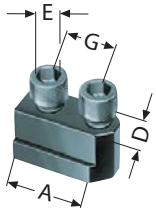
C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 25,5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137051	400	130	65	113	3/32"x 90°
137052	400	90	65	67	3/32"x 90°
137053	400	100	65	45	3/32"x 90°
137054	400	130	65	33	3/32"x 90°

Accessories KFD-HS

C 15
Extended T-nuts
With screw



Item no.	Chuck Size	Con-tents of delivery	A mm	D mm	E	G mm
1305164	110	piece	30	10	M8x20	15
1305165	140	piece	34	10	M6x18	2x12
1305166	160/175	piece	42	12	M8x20	2x15
1305167	200	piece	36	17	M12x25	19
1305168	250	piece	36	17	M12x25	19
1305169	315	piece	46	21	M16x30	25
1305170	400	piece	59	25,5	M20x40	31

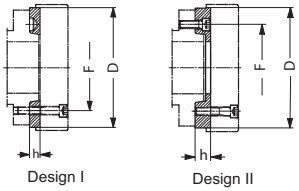
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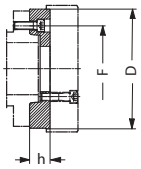
Accessories KFD-HS

C 15

Intermediate adaptor plates with cylindrical centre mount **DIN 6353 for 3-jaw chucks**
Mounting from front to ISO 702-1 **(DIN 55026/55021)** and **ASA B 5.9 A1/A2** with **metric mounting bolts**





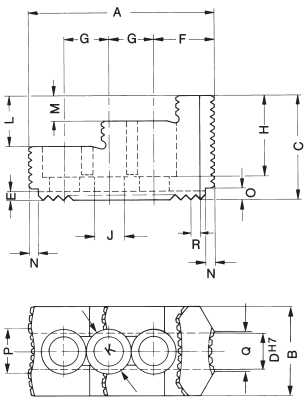


Item no.	Spindle nose size	Size	Design	h mm	F mm	D mm
145125[1]	4	160	II	18	82,6	140
145153	5	175	I	15	104,8	140
145127	5	200	II	21	104,8	170
145129	6	160	III	35	133,4	140
145297	6	175	III	35	133,4	140
145155	6	200	I	16	133,4	170
145131	6	250	II	27	133,4	220
145135	8	200	III	39	171,4	170
145157	8	250	I	18	171,4	220
145139	8	315	II	38	171,4	300
145143	11	250	III	48	235	220
145159	11	315	I	19	235	300
145147	11	400	II	40	235	380
145161	15	400/500/630	I	21	330,2	380

[1] DIN 55021 on request
All fastening parts are included
Intermediate adaptor plate for 2-jaw version on request

Jaw dimensions KFD-HS

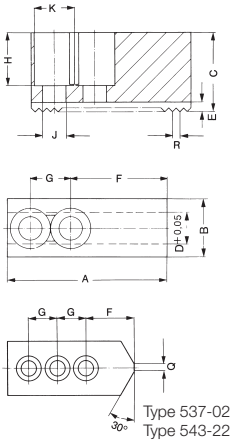
Reversible top jaws UB,
hardened, serration 90°,
material 16MnCr5



Chuck size	110	140	160/175	160	200/250	315	400/500
Type	543-21	537-02	538-02	543 1)	538-04	538-05	538-07
Item no. 2-jaw	**-**	**046545**	**045796**	**-**	**118521**	**046435**	**046447**
Item no. 3-jaw	**149352**	**046544**	**046404**	**351320**	**118522**	**046414**	**037531**
A	45	56	56	51,5	75	103,5	135
B	26	26	26	26	36	50	68
C	32	37,5	37,5	26	49	58	65
D^{H7}	10	10	12	12	17	21	25,5
E	3,5	3,5	3,5	3,5	5	5	5
F	15	10	14	23	21,5	33,5	48
G	15	12 3)	15	15 4)	19	25	31
H	23	29	29	17	37,5	45	48
J	8,4	6,4	8,4	9	13	17	21
K	13,5	10,4	13,5	14	19	25	31
L	14	20	20	-	24	28	-
M	7	10	10	8	12	14	26
N	4	4	4	3	6	6	6,5
O	4	4	4	4	7,5	6,5	5,5
P	8	5	5	20	18	24,5	34
Q	5	5	5	3	7	22,5	40
R	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	3/32"x90°
Weight/jaw kg	0,155	0,130	0,170	0,150	0,460	1,130	2,000

1) one step only, for 8000 min-1
2) one step only, extended
3) 4 mounting holes
4) 2 mounting holes

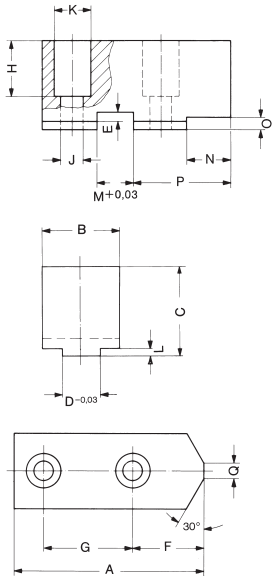
Soft top jaws AB,
serration 90°,
material 16MnCr5



Chuck size	110	140	160/175	200	250	315	400/500
Type	543-22	537-02	538-02	538-03	538-04	538-05	538-07
Item no. 2-jaw	**-**	**045794**	**045795**	**133147**	**133148**	**133149**	**133151**
Item no. 3-jaw	**149353**	**046402**	**046403**	**133152**	**133153**	**133154**	**133156**
A	45	53	55	66,7	75	95	130
B	26,5	22,5	26,5	36,5	36,5	45	50
C	38	30	38	53	53	54,5	80
D	10	10	12	17	17	21	25,5
E	3,5	3,5	3,5	5	5	5	5
F	15	20	31	36	44	55	79
G	15	12 1)	15	19	19	25	31
H	23	20	28	43	43	42,5	60
J	8,4	6,4	8,4	13	13	17	21
K	13,5	10,4	13,5	19	19	25	31
Q	5	3	-	-	-	-	-
R	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	3/32"x90°
Weight/jaw kg	0,210	0,223	0,320	0,700	0,880	1,400	3,100

1) 3 mounting holes

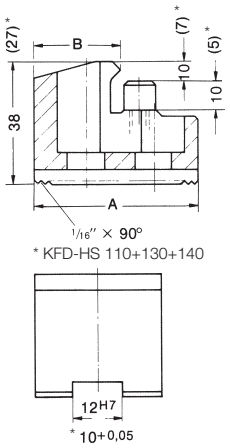
Soft top jaws AB,
with tongue and groove,
material 16MnCr5



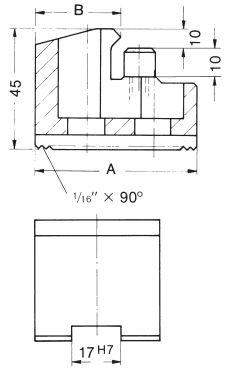
Chuck size	110	140	160	200
Type	549-10	538-22	538-13	538-14
Item no. 3-jaw	**144082**	**123355**	**123358**	**123430**
A	53	58	72,7	90,3
B	22,5	26,5	36,5	36,5
C	30	38	53	53
$D_{-0,03}$	10	8	16	16
E	3,5	3,5	5,5	5,5
F	26,5	31,5	32,2	45,3
G	17	-	25	30
H	20	25	38	38
J	9	13	13	13
K	15	19	19	19
L	2,5	2,5	4,5	4,5
$M^{+0,03}$	10	13	10	12
N	20	23	24,7	35,3
O	4	3	5	5
P	30	39,5	39,7	54,3
Q	3	3	3	6
Weight/jaw kg	0,21	0,46	0,720	1,0

Jaw dimensions KFD-HS

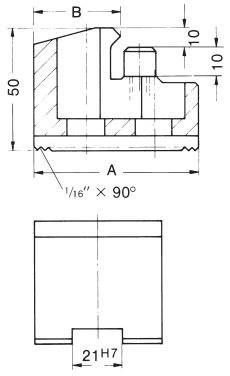
Claw type jaws KB
serration 90°



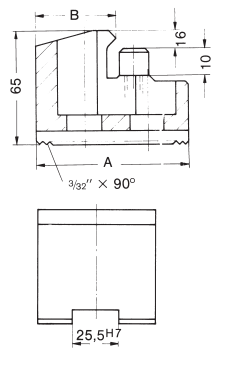
Piece	A	B	H	KFD-HS 110 External chucking	Piece	A	B	KFD-HS 140 External chucking
Item no.					Item no.			
149920	42	37,1	27	20-49	147259	50	41	27-67/35-72
149921	42	23,4	27	47-70	147261	44	22	58-108/61-114
149922	47	17,7	27	68-100				
Piece	A	B	H	KFD-HS 110 Internal chucking	Piece	A	B	KFD-HS 140 Internal chucking
Item no.					Item no.			
149922	47	17,7	27	45-75	147261	44	22	58-108/61-114
149921	42	23,4	27	56-102	147259	50	41	100-130/106-140
149920	42	37,1	27	84-130				



Piece	A	B	KFD-HS 160 External chucking	KFD-HS 175 External chucking
Item no.				
144320	66	52	38-84	48-100
144321	56	34	78-122	88-140
144322	66	25	120-146	130-160
Piece	A	B	KFD-HS 160 Internal chucking	KFD-HS 175 Internal chucking
Item no.				
144322	66	25	70-100	70-115
144321	56	34	92-140	102-155
144320	66	52	122-180	132-195



Piece	A	B	KFD-HS 200 External chucking	KFD-HS 250 External chucking
Item no.				
137031	67	53	55-110	68-162
137032	65	46	68-124	80-173
137039	55	40	95-150	108-200
137034	50	31	102-158	115-206
137035	55	27	110-168	125-220
Piece	A	B	KFD-HS 200 Internal chucking	KFD-HS 250 Internal chucking
Item no.				
137036	65	19	65-125	80-172
137037	65	26	86-142	100-192
137038	55	24	100-156	112-206
137035	55	27	120-178	135-228
137034	50	31	132-188	145-236
137039	55	40	136-195	150-245
137033	55	39	150-207	165-257
137032	65	46	164-222	179-270



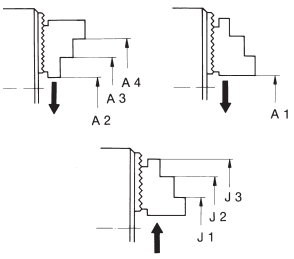
Piece	A	B	KFD-HS 315 (86) [1] External chucking	KFD-HS 315 (108) [1] External chucking
Item no.				
137041	95	80	46-175	65-175
137042	75	60	92-220	104-220
137043	60	43	114-250	135-250
137044	70	37	142-275	166-275
Piece	A	B	KFD-HS 315 (86) [1] Internal chucking	KFD-HS 315 (108) [1] Internal chucking
Item no.				
137045	95	25	65-200	82-200
137046	80	30	108-242	130-242
137044	70	37	142-275	164-275
137043	60	43	170-305	195-305
137042	75	60	202-340	224-340

Piece	A	B	KFD-HS 400 External chucking	KFD-HS 400 (165) [1] External chucking
Item no.				
137051	130	113	70-270	94-270
137052	90	67	150-304	183-304
137053	100	45	175-390	210-390
Piece	A	B	KFD-HS 400 Internal chucking	KFD-HS 400 (165) [1] Internal chucking
Item no.				
137054	130	33	96-290	110-290
137053	100	45	160-305	195-305
137051	130	113	280-490	302-490

1) chuck through-hole M

Chucking capacities KFD-HS

Chucking capacities with reversible top jaws UB,
for 3-jaw chucks



Chuck size		110	140	160	160*	175	200	200**	250	315	400
with reversible jaws	Type	543-21	527-02	538-02	543	538-02	538-04	543-09	538-04	538-05	538-07
	Jaw position										
External chucking	A1	6-46	5-68	6-67	4-52	6-82	12-98	4-70	22-144	25-169	30-203
	A2	-	-	-	21-73	-	26-112	-	40-156	45-196	47-250
	A3	41-76	52-115	53-118	-	54-133	82-165	-	94-210	127-280	-
	A4	68-106	87-150	88-165	94-146	90-180	132-218	112-170	146-262	209-360	245-453
Internal chucking	J1	42-80	35-100	36-99	32-84	36-114	61-144	60-126	76-192	76-216	96-280
	J2	70-108	70-135	71-134	-	71-149	110-198	-	128-244	150-348	-
	J3	96-135	117-182	118-181	102-157	118-196	162-248	-	182-298	230-380	277-478

* one step only
* one step only, extended

KFD-HE



APPLICATION

Standard power chuck with through-hole for bar and tube machining, as well as for flange-type workpieces.

TYPE

Standard version with cylindrical center mount.
3-jaw version with serration (90° and 60°).
Universal draw tube adapter at serration (60°).

CUSTOMER BENEFITS

- Large through-hole for hollow or partially hollow clamping
- Long-tested chuck principle for maximum service life

TECHNICAL FEATURES

- Power transmission by means of wedge hook principle
- Direct lubrication of all wear surfaces
- Sturdy chuck construction

Gripping force/speed diagram

The loss of gripping force was determined experimentally on a chuck with matched UB top jaws. It is largely independent of the initial gripping force at zero speed.

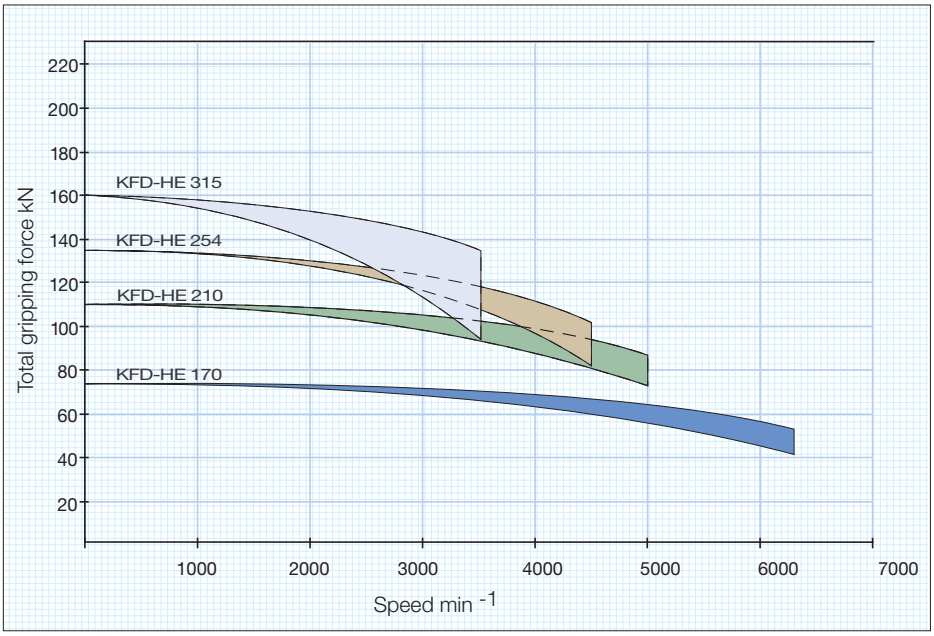
Upper curve: min. centrifugal force of top jaw



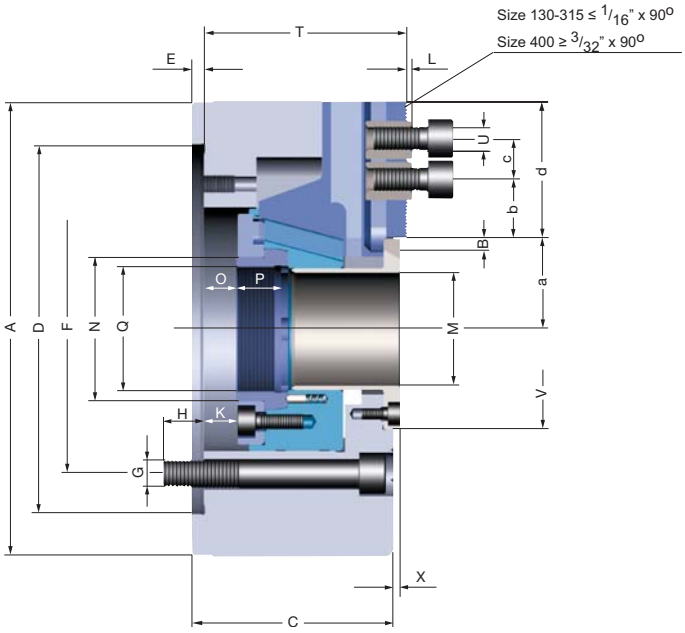
Lower curve: max. centrifugal force of top jaw

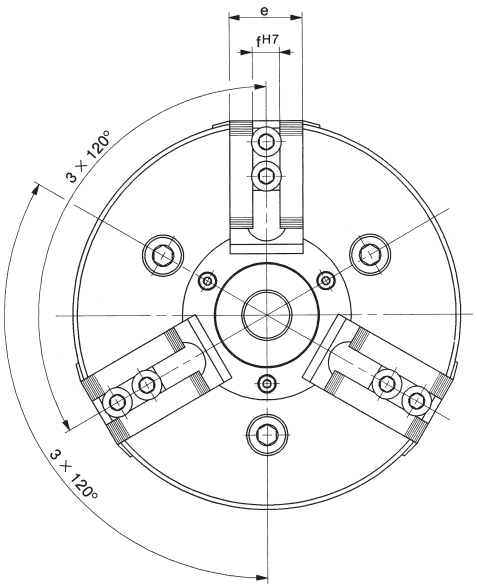


To obtain the specified gripping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM. Measuring point near chuck face.



KFD-HE 3-jaw, standard design, serration 90°

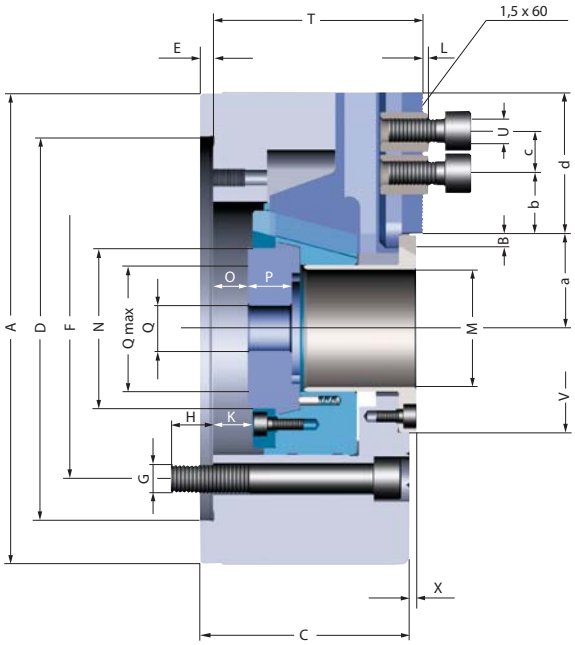


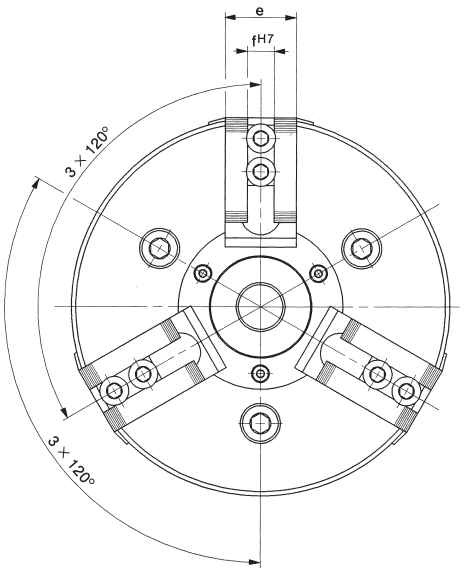


C 15
3 jaw power chuck KFD-HE, serration 90° Adaptor recess, mounting dimensions to **DIN 6353**

Item no.	154384	154031	154032	154829
Size	170	210	254	315
number of jaws	3	3	3	3
A mm	170	210	254	315
Jaw travel B mm	3,2	4,3	5,1	5,3
C mm	82	93	101	114
DH6 mm	140	170	220	300
E mm	6	6	6	6
F mm	104,8	133,4	171,4	235
G mm	3 x M 10	3 x M 12	3 x M 16	3 x M 20
H mm	15	19	23	28
Wedge stroke K mm	14	16	19	23
L mm	2,5	2,5	2,5	2,5
Through-hole M mm	43	52	75	121
N mm	57	66	94	143
O min.	-2,6	-0,7	-10,3	-9,4
O max.	11,4	15,3	8,7	13,6
P mm	19	20,5	28	26
Q mm	M 52 x 1,5	M 58 x 1,5	M 82 x 1,5	M 126 x 1,5
T mm	82	93	101	114
U mm	M 8	M 12	M 16	M 16
VH7-0,05 mm	74	92	125	170
X mm	3	3	3	3
a min.	34,8	37,7	50,9	72,2
a max.	38	42	56	77,5
b min.	7,5	9	10	12
c min.	2 x 15	19	25	25
c max.	-	47	59	69
d mm	47	63	71	80
e mm	32	40	50	50
fH7-0,025 mm	12	17	21	21
Max. swing top jaws mm	230	290	345	410
Maximum draw bar pull kN	25	40	60	60
Max. total clamping force approx. kN	75	110	135	160
Max. admissible speed min-1	6300	5000	4500	3500
Moment of inertia J kgm2	0,038	0,09	0,22	0,8
Weight without jaws approx. kg	12	18	29	50
Actuating cylinders (recommended)	**OVS-105 / SZS-46/103**	**OVS-130 / SZS-52/130**	**OVS-150 / SZS-77/170**	**OVS-200 / SZS-127/325**

KFD-HE 3-jaw, universal draw tube connector, serration 60°





C 15

3 jaw power chuck KFD-HE, serration 60°, with pre-machined draw tube-connector Adaptor recess, mounting dimensions to DIN 6353

Item no.	154390	154391	154392	154830
Size	170	210	254	315
number of jaws	3	3	3	3
A mm	170	210	254	315
Jaw travel B mm	3,4	4,3	5,1	5,3
C mm	82	93	101	114
DH6 mm	140	170	220	300
E mm	6	6	6	6
F mm	104,8	133,4	171,4	235
G mm	3 x M 10	3 x M 12	3 x M 16	3 x M 20
H mm	15	19	23	28
Wedge stroke K mm	14	16	19	23
L mm	3,2	3,2	3,2	3,2
Through-hole M mm	43	52	75	121
N mm	57	66	94	143
O min.	-2,6	-0,7	-10,3	-9,4
O max.	11,4	15,3	8,7	13,6
P mm	19	20,5	28	26
Q mm	Ø 20	Ø 30	Ø 45	Ø 60
Q max.	M 53 x 1,5	M 60 x 2	M 85 x 2	M 130 x 2
T mm	82	93	101	114
U mm	M 10	M 12	M 12	M 16
VH7-0,05 mm	74	92	125	170
X mm	3	3	3	3
a min.	34,8	37,7	50,9	72,7
a max.	38	42	56	77,5
b min.	4,5	9	8	12
c min.	20	25	30	30
d mm	47	63	71	80
e mm	32	40	50	50
fH7-0,025 mm	12	14	16	21
Max. swing top jaws mm	230	290	345	410
Maximum draw bar pull kN	25	40	60	60
Max. total clamping force approx. kN	75	110	135	160
Max. admissible speed min-1	6300	5000	4500	3500
Moment of inertia J kgm2	0,038	0,9	0,22	0,8
Weight without jaws approx. kg	12	18	29	50
Actuating cylinders (recommended)	**OVS-105 / SZS-46/103**	**OVS-130 / SZS-52/130**	**OVS-150 / SZS-77/170**	**OVS-200 / SZS-127/325**

Interchangeable with Kitagawa B-200A

Jaws KFD-HE

C 21
Reversible top jaws, 3-jaw set, hardened serration 90° - material: 16 MnCr 5



Chuck Size	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm	Serration
170	**046404**	56	37,5	26	1/16“x 90°
210	**118522**	75	49	36	1/16“x 90°
254/315	**046414**	103,5	58	50	1/16“x 90°

Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21
Reversible top jaws, 3-jaw set, hardened serration 60° - material: 16 MnCr 5



Chuck Size	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm	Serration
170	**154674**[1)]	66	36	34,7	1,5 x 60°
210	**154676**	81	49	36	1,5 x 60°
254	**154678**	99,5	54	44,5	1,5 x 60°
315	**154816**[1)]	103	55,5	50	1,5 x 60°

[1)] one step only
Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21
Soft top jaws, 3-jaw set, can be hardened serration 90° - material: 16 MnCr 5



Chuck Size	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm	Serration
170	**046403**	55	38	26,5	1/16“x 90°
210	**133153**	75	53	36,5	1/16“x 90°
254/315	**133154**	95	54,5	45	1/16“x 90°

C 21
Soft top jaws, 3-jaw set, can be hardened serration 60° - material: 16 MnCr 5



Chuck Size	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm	Serration
170	**154865**	72	43	30,5	1,5 x 60°
210	**154867**	95	45,5	35	1,5 x 60°
254	**154869**	110	45	50	1,5 x 60°
315	**154871**	130	55,5	50	1,5 x 60°

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Jaws KFD-HE

C 21
Claw-type jaws, 1 piece, hardened serration 60° - width of the groove 12



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
156025	170	67	45	53	1,5 x 60°
156027	170	65	45	46	1,5 x 60°
156029	170	55	45	40	1,5 x 60°
161189	170	55	45	24	1,5 x 60°

C 21
Claw-type jaws, 1 piece, hardened serration 60° - width of the groove 16



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
156099	254	95	50	80	1,5 x 60°
156101	254	75	50	60	1,5 x 60°
156103	254	60	50	43	1,5 x 60°
156105	254	70	50	37	1,5 x 60°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 17



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137031	210	67	45	53	1/16“x 90°
137032	210	65	45	46	1/16“x 90°
137039	210	55	45	40	1/16“x 90°
137034	210	50	45	31	1/16“x 90°
137035	210	55	45	27	1/16“x 90°
137036	210	65	45	19	1/16“x 90°
137037	210	65	45	26	1/16“x 90°
137038	210	55	45	24	1/16“x 90°
137033	210	55	45	39	1/16“x 90°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 21



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137041	254/315	95	50	80	1/16“x 90°
137042	254/315	75	50	60	1/16“x 90°
137043	254/315	60	50	43	1/16“x 90°
137044	254/315	70	50	37	1/16“x 90°
137045	254/315	95	50	25	1/16“x 90°
137046	254/315	80	50	30	1/16“x 90°

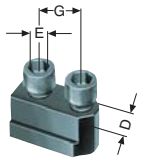
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▲ on request

Accessories KFD-HE

C 15

T-nuts
with screw, for SV 1/16 „ x 90°

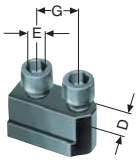


Item no.	Chuck Size	Con-tents of delivery	D mm	E	G mm
1305166	170	piece	12	M8x20	2x15
1305172[1)]	210	Piece	17	M12x25	-
1305169	254/315	piece	21	M16x30	25

[1)] Simple slot nut

C 15

T-nuts
with screw, for SV 1,5“ x 60°



Item no.	Chuck Size	Con-tents of delivery	D mm	E	G mm
1028192	170	piece	12	M10x25	20
1028193	210	piece	14	M12x30	25
1028194	254	piece	16	M12x30	30
1028196	315	piece	21	M16x40	30

C15

Special grease F80 for lathe chucks
for lubrication and conservation of clamping force

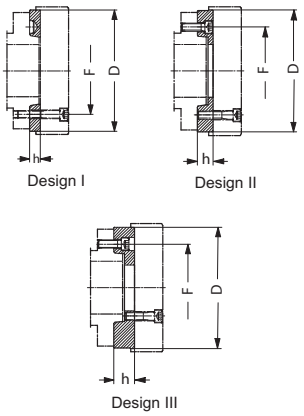


Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

Accessories KFD-HE

C 15
Intermediate adaptor plates with cylindrical centre mount **DIN 6353 for 3-jaw chucks**
Mounting from front to **ISO 702-1 (DIN 55026/55021) and ASA B 5.9 A1/A2 with metric mounting bolts**





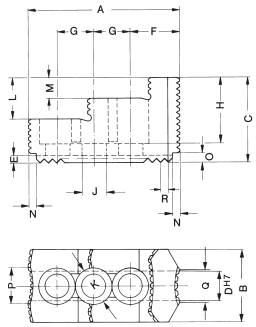
Item no.	Spindle nose size	Size	Design	h mm	F mm	D mm
145125[1)]	4	170	II	18	82,6	140
145153	5	170	I	15	104,8	140
145127	5	210	II	21	104,8	170
145129	6	170	III	35	133,4	140
145155	6	210	I	16	133,4	170
145131	6	254	II	27	133,4	220
145135	8	210	III	39	171,4	170
145157	8	254	I	18	171,4	220
145139	8	315	II	38	171,4	300
145143	11	254	III	48	235	220
145159	11	315	I	19	235	300

All fastening parts are included
[1)] DIN 55021 auf Anfrage

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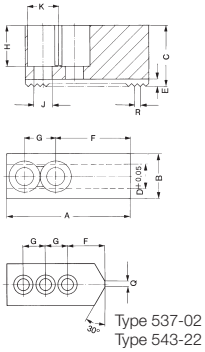
Jaw dimensions KFD-HE

Reversible top jaws UB,
hardened, serration 90°,
material 16MnCr5



Chuck size	170	210	254/315
Type	537-02	538-04	538-05
Item no. 3-jaw	**046404**	**118522**	**046414**
A	56	75	103,5
B	26	36	50
C	37,5	49	58
D^{H7}	12	17	21
E	3,5	5	5
F	14	21,5	33,5
G	15	19	25
H	29	37,5	45
J	8,4	13	17
K	13,5	19	25
L	20	24	28
M	10	12	14
N	4	6	6
O	4	7,5	6,5
P	5	18	24,5
Q	5	7	22,5
R	$^1/_{16}$"x90°	$^1/_{16}$"x90°	$^1/_{16}$"x90°
Weight/jaw kg	0,130	0,460	1,130

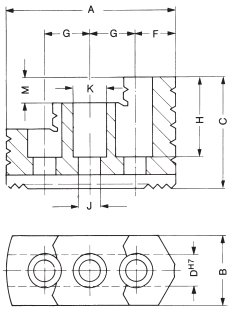
Soft top jaws AB,
serration 90°,
material 16MnCr5



Type 537-02
Type 543-22

Chuck size	170	210	254/315
Type	538-02	538-04	538-05
Item no. 3-jaw	**046403**	**133153**	**133154**
A	55	75	95
B	26,5	36,5	45
C	38	53	54,5
D	12	17	21
E	3,5	5	5
F	31	44	55
G	15	19	25
H	28	43	42,5
J	8,4	13	17
K	13,5	19	25
Q	-	-	-
R	$^1/_{16}$"x90°	$^1/_{16}$"x90°	$^1/_{16}$"x90°
Weight/jaw kg	0,320	0,880	1,400

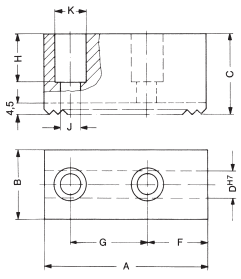
Reversible top jaws UB,
serration 60°,
material 16MnCr5



Chuck size	170	210	254	315
Type	543-31	543-31	543-31	543-31
Item no. 3-jaw	**154674** [1]	**154676**	**154678**	**154816** [1]
A	66	81	99,5	103
B	34,7	36	44,5	50
C	36	49	54	55,5
D	12	14	16	21
F	12,5	17,5	25,5	22,5
G	20	25	30	30
H	23	36,5	38,5	34
J	11	13	13	17
K	17	19	19	25
Serration	1,5 x 60°	1,5 x 60°	1,5 x 60°	1,5 x 60°
Weight/jaw kg	0,3	0,6	1,2	1,5

[1] Nur eine Spannstufe

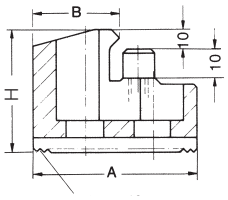
Soft top jaws AB,
serration 60°,
material 16MnCr5

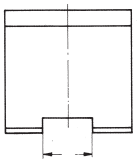


Chuck size	170	210	254	315
Type	543-32	543-32	543-32	543-32
Item no. 3-jaw	**154865**	**154867**	**154869**	**154871**
A	72	95	110	130
B	32,5	35	50	50
C	40	45,5	45	55,5
D	12	14	16	21
F	37	46	50	52
G	20	25	30	30
H	27	33	29	34
J	11	13	13	17
K	17	19	19	25
Serration	1,5 x 60°	1,5 x 60°	1,5 x 60°	1,5 x 60°
Weight/jaw kg	0,5	0,9	1,7	1,9

Chucking capacities KFD-HE

Claw-type jaws KB
Serration 90°,
Type 544-50





Piece	A	B	KFD-HE 170 1,5 x 60° External chucking
Item no.			
156025	67	53	39-83
156027	65	46	52-98
156029	55	40	78-124
161189	55	24	110-155
Piece	A	B	KFD-HE 170 1,5 x 60° Internal chucking
Item no.			
161189	55	24	92-135
156029	55	40	125-168
159027	65	46	150-190

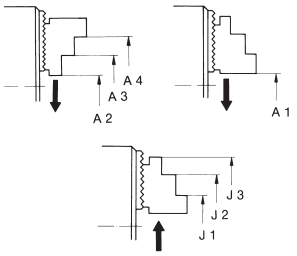
Piece	A	B	KFD-HE 210 1/16x90° External chucking
Item no.			
137031	67	53	60-96
137032	65	46	73-111
137039	55	40	88-127
137034	50	31	105-142
137035	55	27	119-157
Piece	A	B	KFD-HE 210 1/16x90° Internal chucking
Item no.			
137036	65	19	72-110
137037	65	26	90-125
137038	55	24	104-144
137035	55	27	124-156
137034	50	31	136-163
137039	55	40	144-175
137033	55	39	154-205
137032	65	46	168-218

Piece	A	B	KFD-HE 254 1,5 x 60° External chucking
Item no.			
156099	95	80	60-102
156101	75	60	99-140
156103	60	43	132-174
156105	70	37	163-205
Piece	A	B	KFD-HE 254 1,5 x 60° Internal chucking
Item no.			
156101	75	60	222-275
156103	60	43	188-250
156105	70	37	158-198

Piece	A	B	KFD-HE 254 1/16x90° External chucking	KFD-HE 315 1/16x90° External chucking
Item no.				
137041	95	80	53-95	66-160
137042	75	60	92-133	105-198
137043	60	43	125-167	138-232
137044	70	37	156-198	169-263
Piece	A	B	KFD-HE 254 1/16x90° Internal chucking	KFD-HE 315 1/16x90° Internal chucking
Item no.				
137045	95	25	68-112	81-177
137046	80	30	108-154	121-219
137044	70	37	146-186	159-240
137043	60	43	178-240	191-305
137042	75	60	212-265	225-330

Chucking capacities KFD-HE

Chucking capacities with reversible top jaws UB



Chuck size		170	210	254	315
with reversible jaws 1/16" x 90°	Type	538-02	538-04	538-05	538-05
	Jaw position				
External chucking	A1	20-83	19-108	25-134	57-189
	A2	-	36-128	48-162	50-217
	A3	80-150	94-182	130-226	134-297
	A4	120-192	145-234	210-272	212-332
Internal chucking	J1	63-130	78-156	80-190	70-233
	J2	102-173	128-209	156-261	146-313
	J3	154-210	181-263	246-338	236-393

Chuck size		170	210	254	315
with reversible jaws 1,5 x 60°	Type	543-31	543-31	543-31	543-31
	Jaw position				
External chucking	A1	17-100	19-111	25-130	28-190
	A2	-	-	-	-
	A3	97-174	82-170	124-219	-
	A4	-	133-224	170-265	170-317
Internal chucking	J1	74-154	63-160	84-197	116-271
	J2	-	112-213	129-244	-
	J3	-	170-273	211-328	-

Notes

KFG - Power operated angle lever chuck



APPLICATION

Optimally suited for clamping tasks demanding through-hole, flexibility, large strokes and low frictional losses.

TYPE

Angle laver power chuck with cylindrical center mount.
3-jaw version with serration (60°).

CUSTOMER BENEFITS

- Large through-hole
- Large jaw strokes and flexible use can be realized with angle lever system
- High efficiency thanks to low frictional losses (low-hysteresis chuck)
- Long service life - all moving parts are hardened and ground

TECHNICAL FEATURES

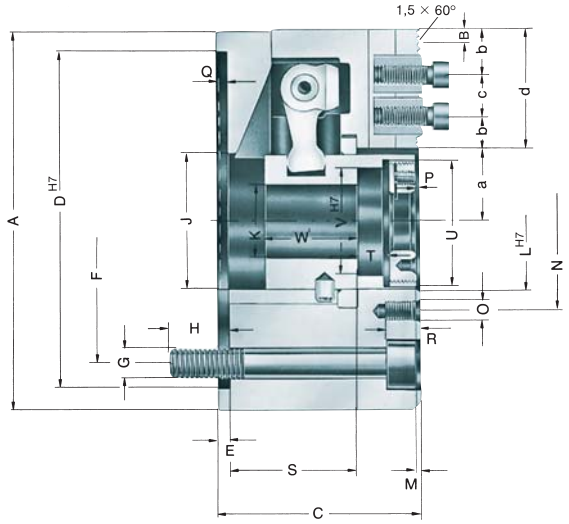
- Wide guidance of base jaws
- T-slots in the chuck body
- Lubrication of the jaw guide via easily accessible grease nipples on the axes of the angle lever

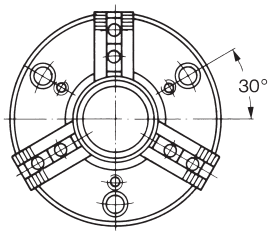
Included in the scope of delivery:
Chuck, chuck and jaw mounting screws, wrench, slot nuts, 2 wrenches for the sliding sleeve (without top jaws)

Big range of applications thanks to large through-hole.
Suitable for machining and other different workpieces.
The axial pull force is translated into the radial jaw movement supported by the angle lever.

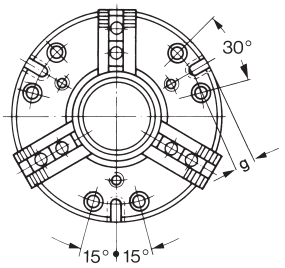
KFG - Extra large jaw stroke

KFG 3-jaw, large jaw movement, serration 60°

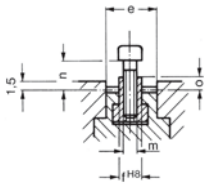




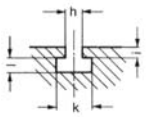
KFG 160



KFG 215 – 350



Serration base jaw



Clamping groove from KFG 215

C 15

3-jaw lever-type power chucks KFG, large jaw movement, with serration 60° cylindrical centre mount

Item no.	020666	020667	020668	020669
Size	160	215	280	350
Number of jaws	3	3	3	3
A mm	160	215	280	350
Jaw travel B mm	16	20	25	25
C mm	79	92	116,2	134,7
DH7	140	190	255	320
E mm	4,2	4,2	5,7	5,7
F mm	104,8	133,4	133,4	171,4
G	3xM10	6xM12	6xM12	6xM16
H mm	20	25	25	35
J mm	54	74	102	135
K mm	26	45,5	66,5	90,5
LH7 mm	66	80	105	140
M mm	2,5	2,5	2,5	2,5
N mm	76	90	120	156
O	M6	M 8	M 8	M 10
P mm	14	16,5	18,7	13,1
Q mm	3,2	3,7	3,2	4,1
R mm	13	15	15	20
S min.	19,8	25,3	28,8	32,9
S max.	39,8	50,3	63,8	77,9
T mm	8	12	18	22
U mm	M46x1,25	M65x1,25	M90x1,25	M112x1,5
VH7 mm	43	62	87	109
W mm	23	29	32	37
a min.	23	31,5	47,5	69,5
a max.	39	51,5	72,5	94,5
b mm	8	10	13	14
c min.	16	20	26	28
c max.	41	46	54	65
d mm	57	66	80	93
e mm	28	35	45	50
fH8 mm	11	14	20	21
g mm	-	35	63	73,5
h mm	-	16	16	22
i mm	-	10	10	15
k mm	-	24	24	35
l mm	-	10	10	17
m mm	M8	M10	M12	M16
n mm	7,5	8,5	13	15
o mm	1,5	1,5	2,5	3
Max. swing top jaws mm	242	295	380	480
Maximum draw bar pull kN	24	33,9	43	52
Max. total clamping force approx. kN	21	30	42	66
Max. admissible speed min-1	3400	2700	1950	1800
Moment of inertia J kgm2	0,031	0,11	0,425	1,22
Weight without jaws approx. kg	9,3	17	41	75
Actuating cylinders (recommended)	**OVS-105 / SZS-37/70**	**OVS-130 / SZS-46/103**	**OVS-150 / SZS-67/150**	**OVS-150 / SZS-86/200**

Jaws KFG

C 21
Reversible top jaws, 3-jaw set, hardened serration 60° - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
046410	160	62	37,5	26	1,5 x 60°
046412[1)]	215	81	52,5	36	1,5 x 60°
046416	280	96	54	44,5	1,5 x 60°
046422	350	112	61	49,5	1,5 x 60°

[1)] Lowered to 34 mm in the serration area
Reversible top jaws UB: Ground out on the associated chuck at extra charge

C 21
Soft top jaws, 3-jaw set, can be hardened serration 60° - material: 16 MnCr 5

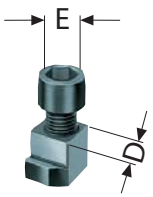


Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
046409	160	66,7	43	30,5	1,5 x 60°
046411	215	88,9	53	36,5	1,5 x 60°
046415	280	88,9	54,5	45	1,5 x 60°
046421	350	120	80	50	1,5 x 60°

Accessories KFG

C 15

T-nuts
with screw, for SV 1,5“ x 60°



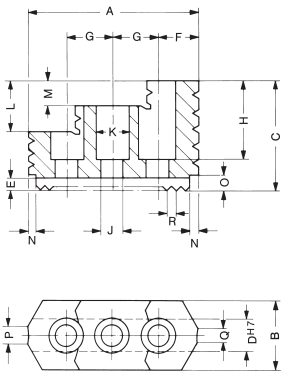
Item no.	Chuck Size	Contents of delivery	D mm	E
1305174	160	piece	11	M8x18
1305175	215	piece	14	M10x20
1305176	280	piece	20	M12x30
1305177	350	piece	21	M16x35

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Jaw dimensions und Chucking capacities KFG

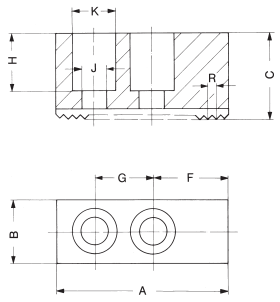
Reversible top jaws UB,
hardened, serration 60°,
material 16MnCr5

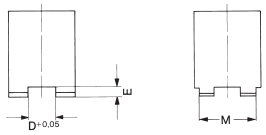


Chuck size	160	215	280	350
Type	530-05	530-07	530-09	530-12
Item no. 3-jaw	**046410**	**046412**	**046416**	**046422**
A	62	81	96	112
B	26	36 [1]	44,5	49,5
C	37,5	52,5	54	61
D	11	14	20	21
E	3,5	5	5	5,5
F	17,5	25	30	27
G	16,5	21	26	33
H	29	41	41	47,5
J	8,4	10,5	13	17
K	13,5	16,5	19	25
L	20	24	24	30
M	10	12	12	15
N	4	5	5	6,5
O	4	7	7	7
P	5	10	10	13
Q	5	5	5	13
R	1,5 x 60°	1,5 x 60°	1,5 x 60°	1,5 x 60°
Weight/jaw kg	0,215	0,600	0,750	1,550

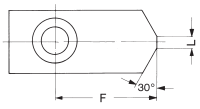
[1] Near the serration reduced to 34 mm
Reversible top jaws: ground to finished size at surcharge

Soft top jaws AB,
material 16MnCr5





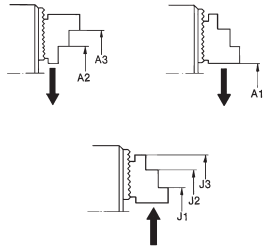
AB 530-04 und 530-07



AB 530-02

Chuck size		160	215	280	350
with reversible jaws	Type	530-04	530-07	530-09	530-12
	Jaw position				
External chucking	A1	5-115	5-136	11-185	50-248
	A2	58-175	81-220	123-295	159-354
	A3	92-208	132-272	190-363	242-438
Internal chucking	J1	52-159	61-186	70-238	108-301
	J2	85-193	109-238	133-305	189-385
	J3	129-240	167-298	202-378	274-472

Chucking capacities with
reversible top jaw UB



PKF Air-operated high-precision chuck



APPLICATION

Suitable for very high concentricity and clamping repeatability.

TYPE

Air-operated high precision wedge hook clamping chuck.

CUSTOMER BENEFITS

- Concentricity and axial run-out precision within 0.003 mm
- High amount of safety in event of pressure failure thanks to self-locking
- Low-maintenance thanks to oil-mist lubrication
- Optimal adaption of the clamping force for clamping deformation-sensitive parts thanks to large actuation range from 2-10 bar

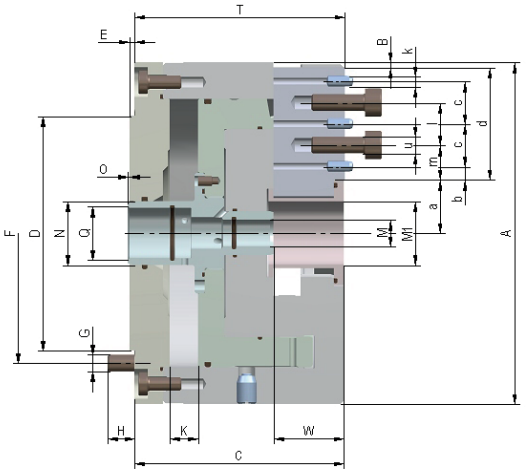
TECHNICAL FEATURES

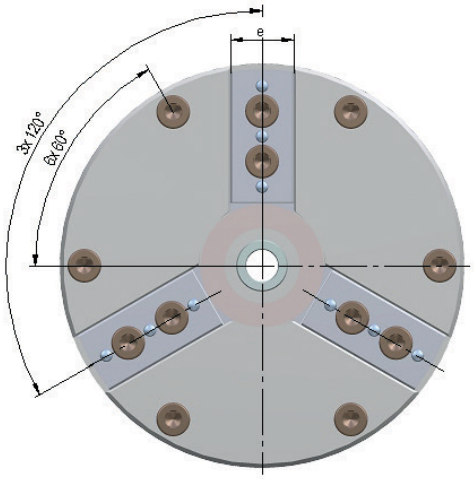
- Clamping piston construction with power transmission on both sides according to the ROHM KFD-HS principle
- Integrated pneumatic operation
- Through-hole for coolant supply for sizes 100-200

Note:
Please order air supply tube, maintenance unit, top jaws and actuation valves separately



PKF Air-operated high-precision chuck





C 15

High-precision air-operated lathe chuck PKF, concentricity 0.003 mm, **repetitive clamping accuracy 0.0015** mm with through-hole, pneumatically operated, with integrated **pneumatic piston**, clamping precision in the µ range

Item no.	153706 ▲	153707 ▲	153708 ▲	153709 ▲	153710 ▲
Size	100	100	150	150	200
A mm	102	102	151	151	202
Jaw travel B mm	0,75	1,5	0,75	1,5	1,5
C mm	52,5	62,5	52,5	62,5	85,5
D-0,01	82,55	82,55	124,97	124,97	167,64
E mm	1,5	1,5	1,5	1,5	3,2
F mm	88,9	88,9	135,9	135,9	182,9
G	M5	M5	M6	M6	M10
H mm	8	8	9	9	16
Wedge stroke K mm	4,25	8,5	4,25	8,5	8,5
M mm	3,2	3,2	3,2	3,2	3,2
M1 mm	19	19	25,4	25,4	25,4
N mm	19	19	19	19	19
O min.	0,5	0,5	0,5	0,5	0,5
O max.	4,75	9	4,75	9	9
Q mm	5/8“	5/8“	5/8“	5/8“	5/8“
W mm	19	19	19	19	35
T mm	52,8	62,8	52,8	62,3	85,9
a min.	16,75	16	22,75	22	21,9
a max.	17,5	17,5	23,5	23,5	23,4
b mm	3,9	3,9	14,9	14,9	4,5
c mm	2 x 12,7	2 x 12,7	2 x 12,7	2 x 12,7	2 x 31,75
d mm	33,5	33,5	52	52	76,1
e mm	16	16	24	24	32
k mm	1/8“	1/8“	1/8“	1/8“	1/4“
l mm	12,7	12,7	3 x 12,7	3 x 12,7	31,75
m mm	10,25	10,25	8,55	8,55	20,375
u	2 x M5	2 x M5	4 x M5	4 x M5	M10
Operating pressure bar	2-10	2-10	2-10	2-10	2-10
Area A1 clamping cm2	47,4	47,4	100	100	185,0
Area A2 releasing cm2	28,9	28,9	69	69	111,5
Total clamping force at 8 bar kN	13	13	27	27	31,5
Max. admissible speed at 8 bar min-1	5500	5500	4000	4000	3000
Moment of inertia J kgm2	0,0029	0,0029	0,015	0,015	0,08
Weight kg	2,3	2,3	5,5	5,5	16

Higher speeds available on request

Jaws PKF

C 21
Soft top jaws steel version, set of 3-jaws



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
153818 ▲	100	49	25	18,4
153819 ▲	150	74	30	26,5
153820 ▲	200	95	46	34,7

Accessories PKF

C 15
Air-operated control LSG R 1/4 up to 10 bar, for air-operated power chucks



Item no.	Width mm	Height mm	Depth mm	Control voltage	Conn. thread
437107 ▲	380	380	210	24V DC	R 3/8“ internal

Other control voltage on request

C 15
Service unit for air operated control



Item no.	Width mm	Height mm	Depth mm
216084 ▲	130	240	102

Max. flow Qn 33m3/h at 6 bar

C 15
Manually operated air control valve LHV with 2 switch settings and a safety switch lever



Item no.	Width mm	Height mm	Depth mm	Conn. thread internal	Conn. thread external
418224	66,5	64	38	R ¼ „	M 16 x 1,5

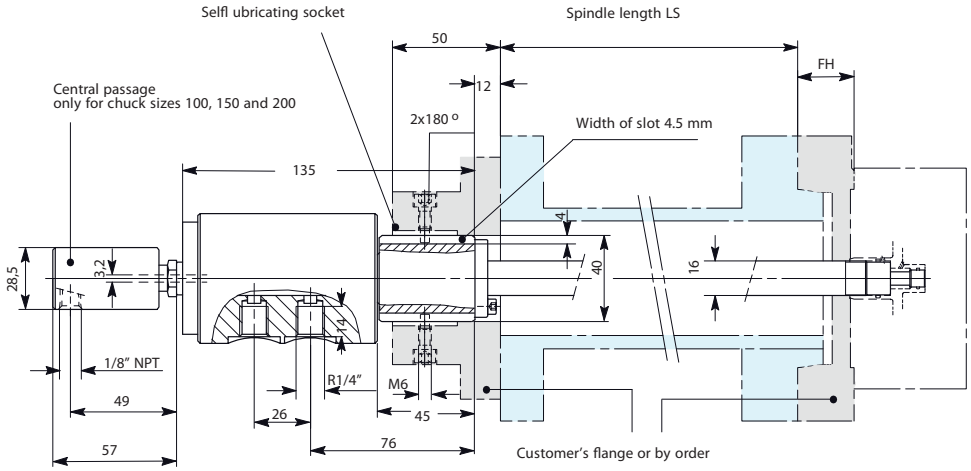
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▲ on request

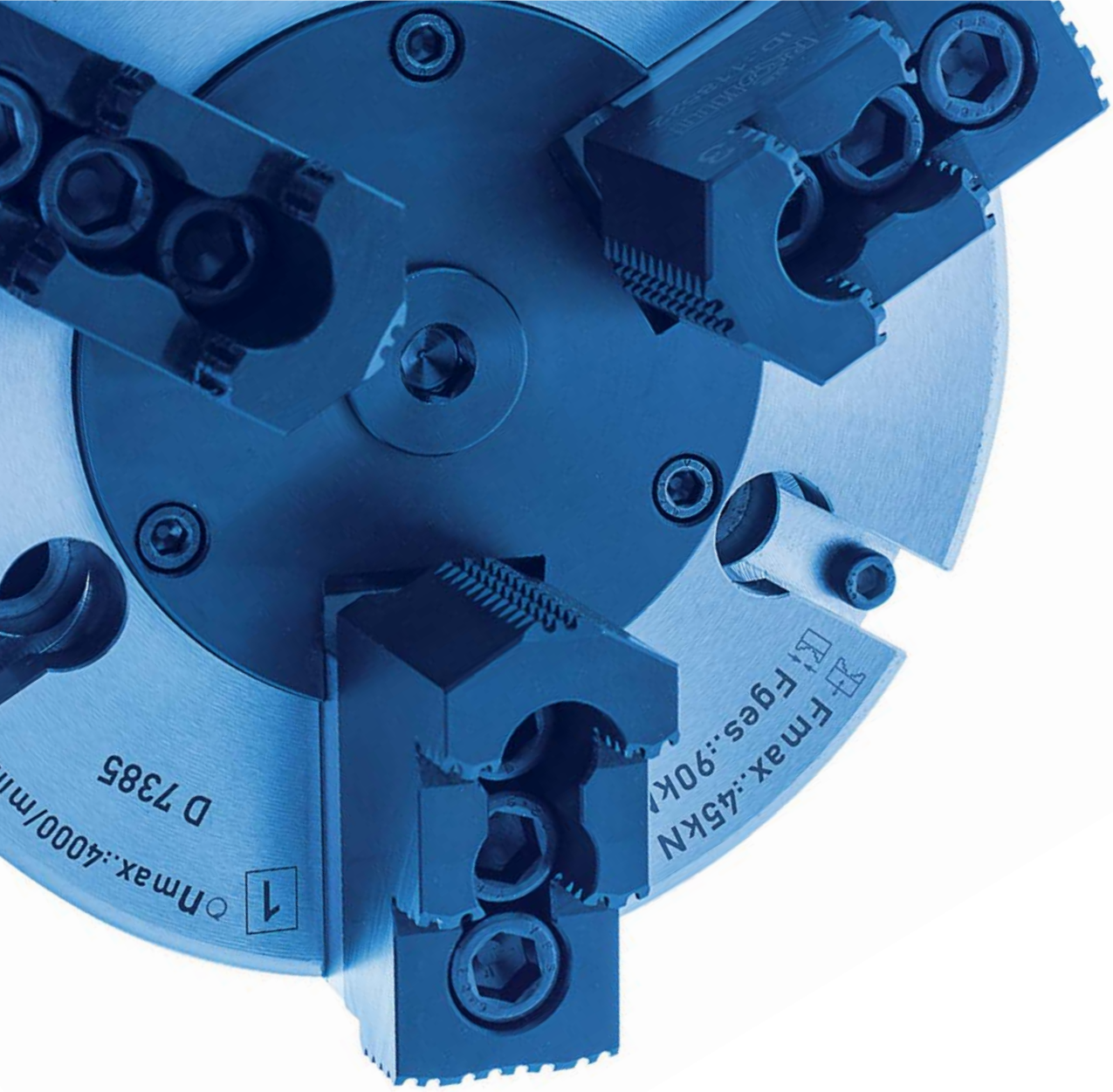
Accessories PKF

Air supply tube

Air supply tube 3/8” and 5/8”
Type 586-80
Max. speeds = 10 000 min-1
Central through-hole for air and coolant.
Max. air pressure = 10 bar

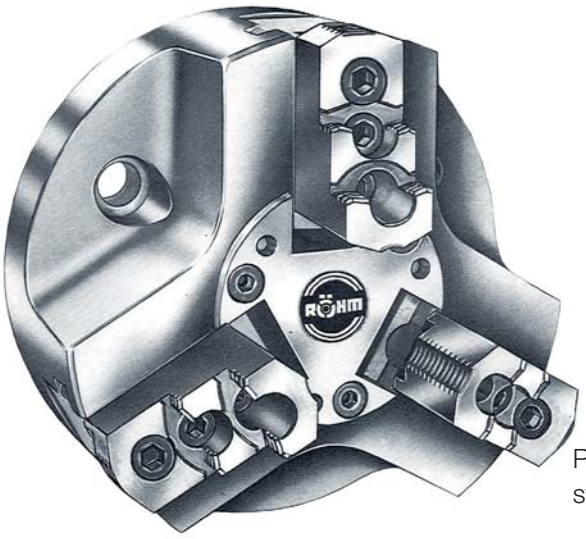


Ordering indications for air supply tube:
Chuck size + spindle length LS + height of flange FH



PROVEN WEDGE HOOK SYSTEM

Founded in 1909, RÖHM began successively expanding their product range by the area of power chuck technology starting in 1950. Decades of experience and knowledge about power chucks make today‘s RÖHM power chucks so successful. These are not only characterized by their long service life, but also by the top precision and reliability.



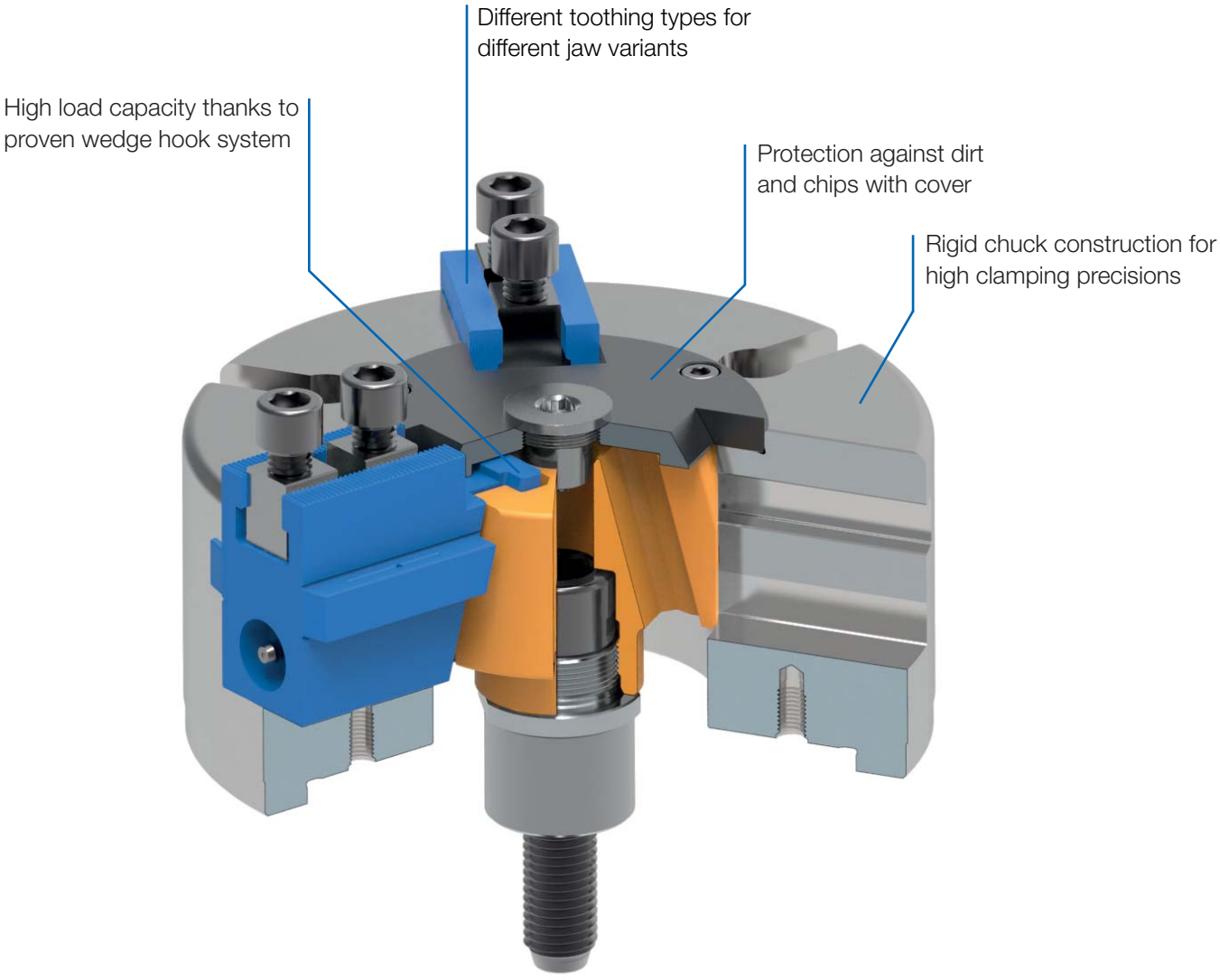
Power chuck KFD with wedge hook system without through-hole

POWER CHUCKS WITHOUT THROUGH-HOLE

The RÖHM power chucks without through-hole have already been used for decades and have proven themselves many times over in various clamping tasks. Thanks to the wedge hook system as well as the rigid chuck construction, the power chucks achieve a high load capacity and clamping precision along with a long service life.

ADVANTAGES AT A GLANCE

- Proven power chucks with long service life
- Wedge hook system for high load capacity and clamping precision
- Simple setup as basis for a wide range of applications



KFD-EC



APPLICATION

Especially for use under extreme operating conditions, e.g. dry or raw part machining and/or high coolant pressure.

TYPE

Power chuck with cylindrical center mount.
3-jaw version with serration (90°).

CUSTOMER BENEFITS

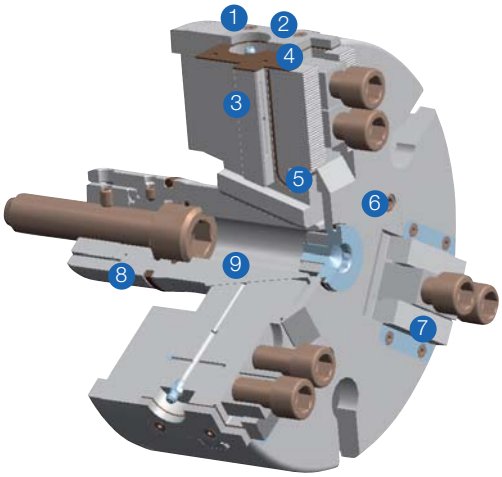
- Easy Care: Low-maintenance and -wear
- Lubrication interval, depending on operating conditions, up to approx. 600 operating hours
- Optimized protection against the penetration of dirt thanks to seals built into the jaw guides

TECHNICAL FEATURES

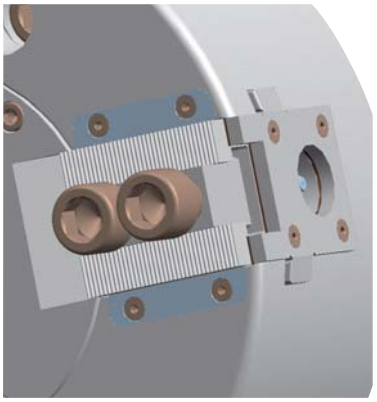
- Proven wedge hook system

Note:
KFD-EC with centrifugal force compensation on request

Structure KFD-EC

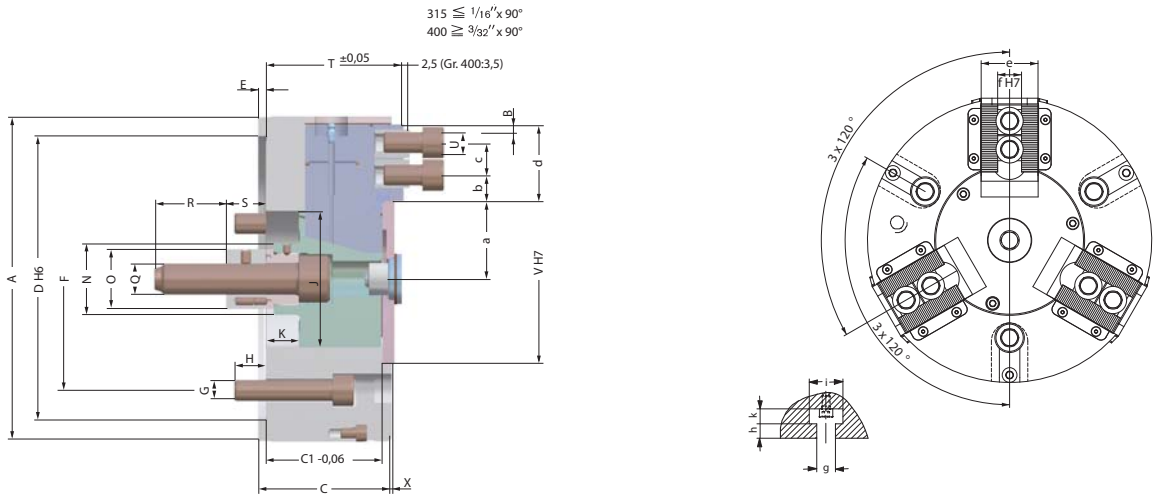


1. Body
2. End cover
3. Base jaw
4. Flat seal
5. Square ring
6. Cover
7. Wiper plates
8. O-Ring
9. Piston



▲ on request

KFD-EC 3-jaw, serration 90°



Low-Maintenance 3-jaw power chuck KFD-EC, with short piston, without force compensation, centric clamping
Adaptor recess, mounting dimensions **to DIN 6353**

Item no.	166183	166184	166185	166186
Size	200	250	315	400
A mm	200	250	315	400
Jaw travel B mm	6,7	6,7	8	9,3
C mm	86	98	113	121
C1-0,06 mm	80	92	107	115
Mount DH6	170	220	300	300
E mm	6	6	6	6
F mm	133,4	171,4	235	235
G mm	3xM12	3xM16	3xM20	3xM20
H mm	18	23	31	30
J mm	85	105	120	155
Wedge stroke K mm	25	25	30	35
N mm	45	55	60	60
O mm	40	46	46	55
Q mm	M20	M24	M24	M24
R mm	45	55	55	55
S min.	30	30	30	30
S max.	55	55	60	65
T±0,05 mm	90	105	120	130
U	M12x25	M16x30	M16x30	M20x40
VH7 mm	110	130	160	190
X mm	7	7	9	9
a min.	43,3	53,3	59,5	77,7
a max.	50	60	67,5	87
b min.	8	10	10	14
c min.	19	25	25	31
c max.	34,5	47,5	70,5	87
d mm	45	59	84	107
e mm	35	50	55	60
fH7 mm	17	21	21	25,5
g mm	14	18	18	22
h mm	11	13	13	22
i mm	11	14	14	18
k mm	25	32	32	40
Maximum draw bar pull kN	45	65	80	95
Max. total clamping force kN	90	140	190	250
Max. admissible speed min-1	4000	3200	2800	2000
Moment of inertia J kgm2	0,1	0,28	0,89	2,02
Weight without jaws approx. kg	19,3	34,8	63,6	88,4
Actuating cylinders (recommended)	**OVS-130**	**OVS-150**	**OVS-150**	**OVS-200**

Intermediate adaptors for short taper mount on request

Jaws KFD-EC

C 21
Reversible top jaws, 3-jaw set, hardened serration 90° - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
118522	200	75	49	36	1/16“x 90°
046414	250/315	103,5	58	50	1/16“x 90°
037531	400	135	65	68	3/32“x 90°

Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21
Soft top jaws, 3-jaw set, can be hardened serration 90° - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
133153	200	75	53	36,5	1/16“x 90°
133154	250	95	54,5	45	1/16“x 90°
133155	315	103	80	50	1/16“x 90°
133156	400	130	80	50	3/32“x 90°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 17



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137031	200	67	45	53	1/16“x 90°
137032	200	65	45	46	1/16“x 90°
137033	200	55	45	39	1/16“x 90°
137034	200	50	45	31	1/16“x 90°
137035	200	55	45	27	1/16“x 90°
137036	200	65	45	19	1/16“x 90°
137037	200	65	45	26	1/16“x 90°
137038	200	55	45	24	1/16“x 90°
137039	200	55	45	40	1/16“x 90°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 21



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137041	250/315	95	50	80	1/16“x 90°
137042	250/315	75	50	60	1/16“x 90°
137043	250/315	60	50	43	1/16“x 90°
137044	250/315	70	50	37	1/16“x 90°
137045	250/315	95	50	25	1/16“x 90°
137046	250/315	80	50	30	1/16“x 90°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 25,5



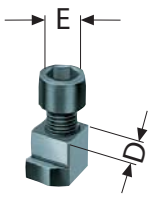
Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137051	400	130	65	113	3/32“x 90°
137052	400	90	65	67	3/32“x 90°
137053	400	100	65	45	3/32“x 90°
137054	400	130	65	33	3/32“x 90°

Configure your individual clamping jaws online! www.web2product.biz

Accessories KFD-EC

C 15

T-nuts
With screw



Item no.	Contents of delivery	D mm	E
241674	piece	17	M12x25
241675	piece	21	M16x30
241676[1)]	piece	25,5	M20x40

C 15

Special grease F80 for lathe chucks
for lubrication and conservation of clamping force



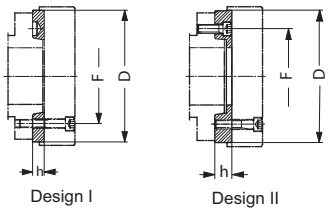
Item no.	Design	Contents
028975	Tin	1 kg
308555	Cartridge	0,5 kg

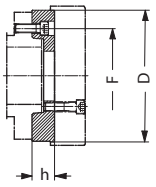
Accessories KFD-EC

C 15

Intermediate adaptor plates with cylindrical centre mount DIN 6353 for 3-jaw chucks
Mounting from front to ISO 702-1 (DIN 55026/55021) and ASA B 5.9 A1/A2 with metric mounting bolts







Item no.	Spindle nose size	Size	Design	h mm	F mm	D mm
145127	5	200	II	21	104,8	170
145155	6	200	I	16	133,4	170
145131	6	250	II	27	133,4	220
145135	8	200	III	39	171,4	170
145157	8	250	I	18	171,4	220
145137	8	315/400	II	38	171,4	300
145143	11	250	III	48	235	220
145159	11	315	I	19	235	300
145149	15	400	III	58	330,2	300

All fastening parts are included
Intermediate adaptor plate for 2- and 4-jaw version on request

KFD



APPLICATION

Standard power chuck without through-hole for various clamping tasks.

TYPE

Power chuck available with cylindrical center mount.
3-jaw version with serration (90°) or tongue and groove.
2-jaw and 3-jaw version with serration (90°) and weight reduction.

CUSTOMER BENEFITS

- Long service life - all moving parts are hardened and ground
- High clamping precision thanks to proven wedge hook system

TECHNICAL FEATURES

- Power transmission by means of powerfully dimensioned wedge hook system
- Direct lubrication of the base jaws
- Starting from size 200 with roller for limiting the jaw movement
- The forward movement of the piston is stopped in the cylinder, movement toward the rear is stopped at the spindle or spindle flange

Gripping force/speed diagrams

The loss of gripping force was determined experimentally on a chuck with matched UB top jaws. It is largely independent of the initial gripping force at zero speed.

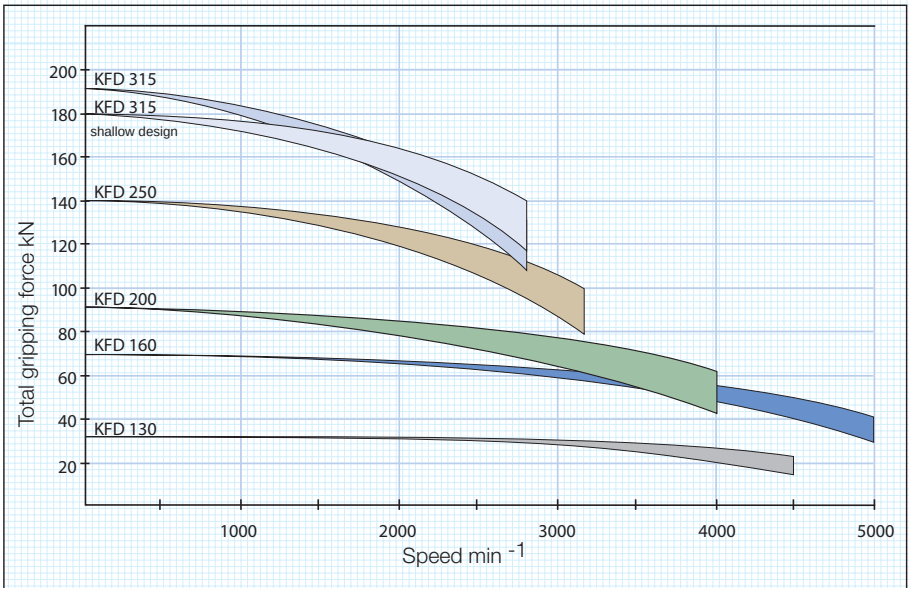
Upper curve:
min. centrifugal force of top jaw

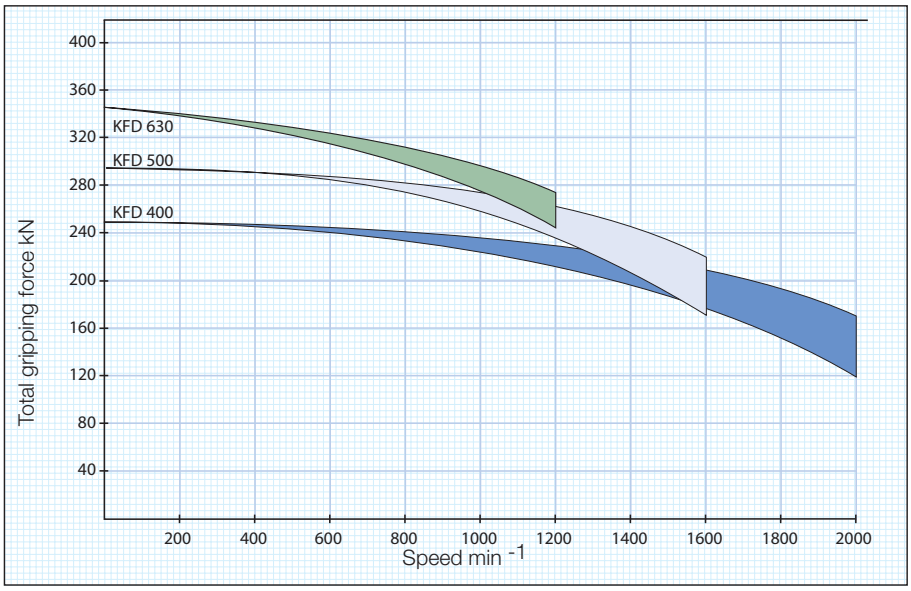


Lower curve:
max. centrifugal force of top jaw

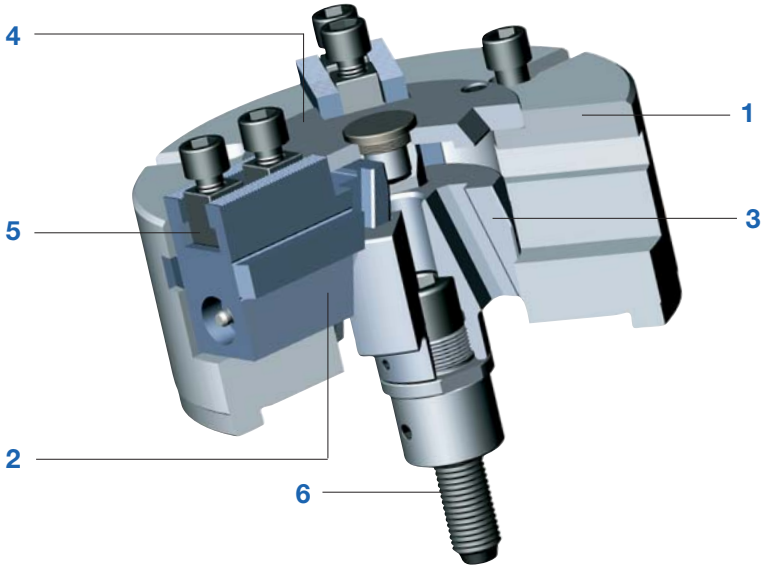


To obtain the specified gripping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM. Measuring point near chuck face.



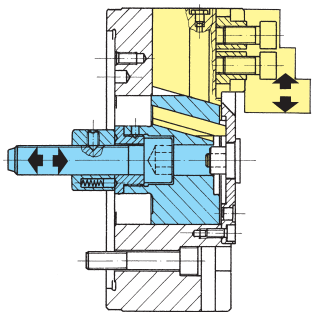


KFD



Components KFD

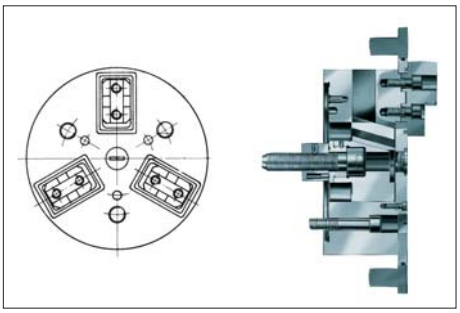
1. Body
2. Base jaw
3. Piston
4. Cover
5. T-nut
6. Draw bolt



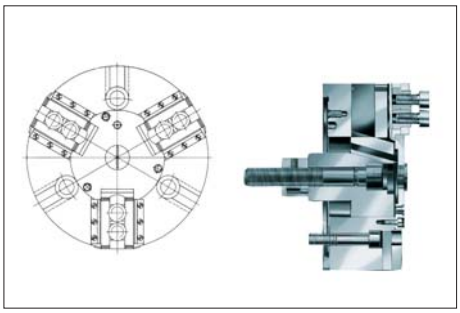
Design principle wedge system

On request:

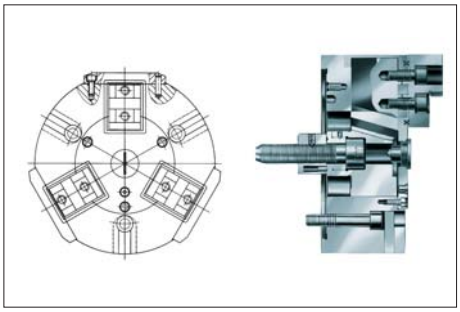
KFD in customized version (with additional seal)



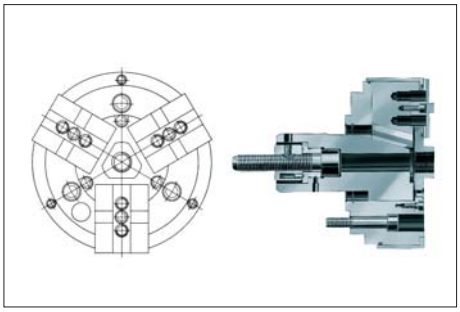
Type 538-40
Hermetically sealed for stationary attachment. Installation in transfer lines and rotary table machines



Type 538-42
Largely sealed with wiper blades. Mounting on lathes.

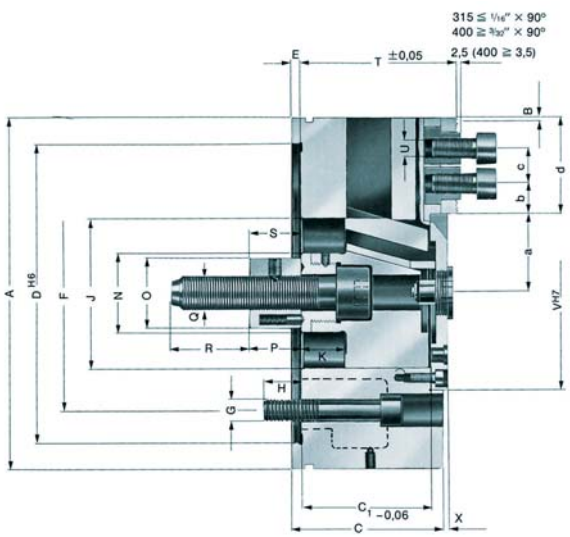


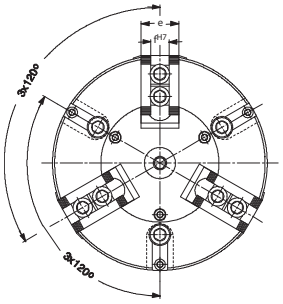
Type 538-41
Hermetically sealed for stationary or rotary attachment. Installation in transfer lines and rotary table machines in minimum amount of space.

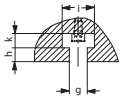


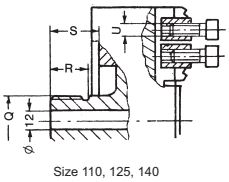
Type 538-43
Hermetically sealed for especially high chip and coolant accumulation on automats or production machines, rotating or stationary.

KFD 3-jaw, standard design, serration 90°

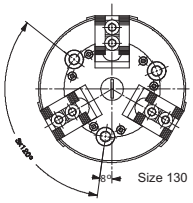








Size 110, 125, 140



Size 130

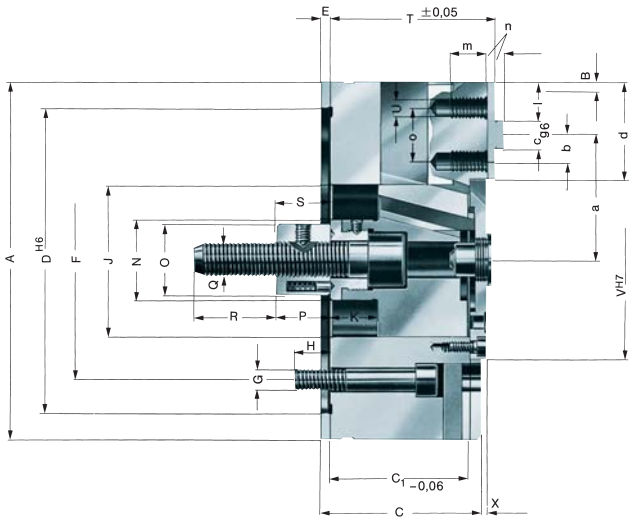
C15
3-jaw power chuck, standard design, serration 90°
Adaptor recess, mounting dimensions to DIN 6353

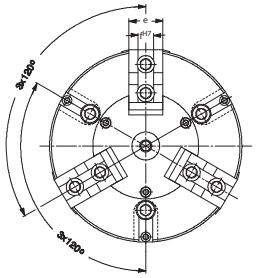
Item no.	004250	128405 1)	041240	023520	040630	144598	040653	040660	040669	040676
Size	110	125	130	160	200	250	315	400	500	630
A mm	110	125	130	160	200	250	315	400	500	630
Jaw travel B mm	2,1	3,7	5,3	5,3	6,7	6,7	8	9,3	9,3	10,5
C mm	31,5	40	69	79	87	102	117	127	127	140
C1-0,06 mm	28,55	37,05	58,05	66,05	74,05	89,05	104,05	111,05	111,05	125,05
Mount DH6	92	105	115	140	170	220	300	300	380	380
E mm	3	3	6	6	6	6	6	6	6	8
F mm	80	80	85	104,8	133,4	171,4	235	235	330,2	330,2
G mm	3 x M 8	3 x M 8	3 x M 10	3 x M 10	3 x M 12	3 x M 16	3 x M 20	3 x M 20	6 x M 24	6 x M 24
H mm	12	14	15	17	20	26	30	35	35	35
J mm	45	50	58	65	85	105	120	155	155	180
Wedge stroke K mm	8	14	20	20	25	25	30	35	35	40
N mm	-	-	35	35	45	55	60	60	60	80
O mm	-	-	34	34	40	46	46	55	55	55
P mm	-	-	25	25	30	30	30	30	30	30
Q mm	M20x1,5	M20x1,5	M 16	M 16	M 20	M 24	M 24	M 24	M 30	M 30
R mm	20	20	40	40	45	55	55	55	55	63
S min.	25	25	36	25	30	30	30	30	30	28
S max.	33	39	56	45	55	55	60	65	65	68
T±0,05 mm	34	44	73	80	90	105	120	130	130	148
U	M 6 x 18	M 6 x 18	M 8 x 20	M 12 x 25	M 12 x 25	M 16 x 30	M 16 x 30	M 20 x 40	M 20 x 40	M 20 x 40
VH7 mm	-	-	85	85	110	130	160	190	190	220
X mm	4	6	5	3	3	3	3	3	3	6
a min.	23,9	24,3	25	26,7	38,3	48,3	54	72,7	72,7	85,2
a max.	26	28	30,3	32	45	55	62	82	82	95,7
b min.	8,2	7	6	9	8	10	10	14	14	18
c min.	10	10	14	19	19	25	25	31	31	31
c max.	14,8	25	26	36,5	44,5	58,5	81,5	98	148	197
d mm	28	34,5	34,5	48	55	70	95	118	164	219,3
e mm	25	25	30	35	35	50	55	60	60	70
fH7 mm	10	10	12	17	17	21	21	25,5	25,5	25,5
g mm	-	-	-	14	14	18	18	22	22	22
h mm	-	-	-	11	11	13	13	22	22	22
i mm	-	-	-	25	25	32	32	40	40	40
k mm	-	-	-	11	11	14	14	18	18	18
Max. swing top jaws mm	172	192	184	215	290	345	410	560	660	790
Maximum draw bar pull kN	7	9	18	35	45	65	80	95	110	130
Max. total clamping force kN	12	15	35	70	90	140	190	250	300	360
Max. admissible speed min-1	4000	5000	5000	4500	4000	3200	2800	2000	1600	1200
Moment of inertia J kgm2	0,003	0,007	0,014	0,035	0,095	0,28	0,87	1,96	4,31	13,4
Weight without jaws approx. kg	2,1	3,6	6,8	10,9	19	35,5	70	98	138	270
Actuating cylinders (recommended)	**OVS-85**	**OVS-85**	**OVS-85**	**OVS-105**	**OVS-130**	**OVS-150**	**OVS-150**	**OVS-200**	**OVS-200**	**OVS-200**

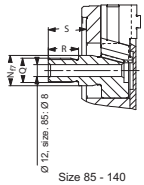
[1] Shallow design

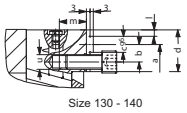
▲ on request

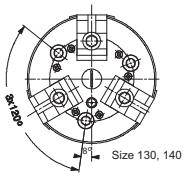
KFD 3-jaw, standard design, tongue and groove

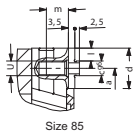


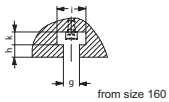










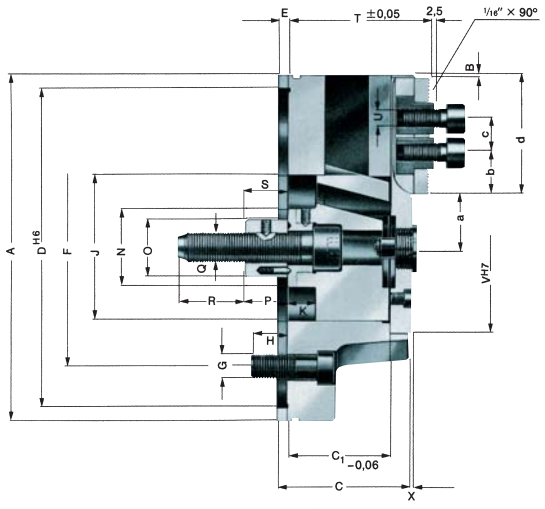


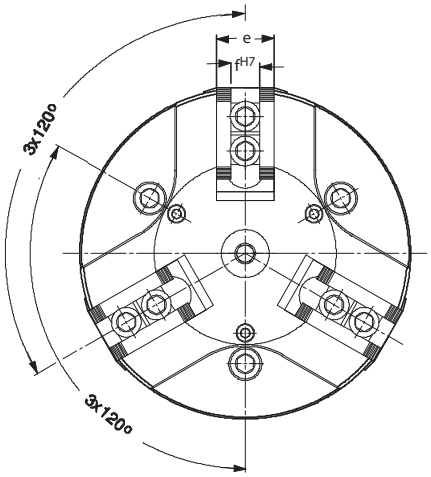
3-jaw power chuck, with tongue and groove
Adaptor recess, mounting dimensions to DIN 6353

Item no.	123110	004266	128427 1)	023529	040639	144604	144605 ▲
Size	85	110	125	160	200	250	315
A mm	85	110	125	160	200	250	315
Jaw travel B mm	2,6	2,1	3,7	5,3	6,7	6,7	6,7
C mm	31,5	31,5	40	79	87	102	102
C1-0,06 mm	28,55	28,55	37,05	66,05	74,05	89,05	89,05
Mount DH6	70	92	105	140	170	220	220
E mm	3	3	3	6	6	6	6
F mm	54	80	80	104,8	133,4	171,4	171,4
G mm	3 x M8	3 x M8	3 x M8	3 x M10	3 x M12	3 x M16	3 x M16
H mm	12	12	14	17	20	26	26
J mm	36	45	50	65	85	105	105
Wedge stroke K mm	10	8	14	20	25	25	25
N mm	20	-	-	35	45	55	55
O mm	-	-	-	34	40	46	46
P mm	-	-	-	25	30	30	30
Q mm	M16 x 1,5	M20 x 1,5	M20 x 1,5	M16	M20	M24	M24
R mm	20	20	20	40	45	55	55
S min.	25	25	25	25	30	30	30
S max.	35	33	39	45	55	55	55
T±0,05 mm	33	33	44	80	90	105	105
U	M8	M6	M6	M12	M12	M16	M16
VH7 mm	-	-	-	85	110	130	130
X mm	4	4	6	3	3	3	3
a min.	29,4	37,9	40,3	46,7	63,3	81,3	93,3
a max.	32	40	44	52	70	88	100
b mm	-	7,5	7,5	12,5	15	20	25
cg6 mm	8	8	8	10	12	16	16
d mm	22	28	34,5	48	55	70	102
e mm	20	25	25	35	35	50	50
fH7 mm	8	8	8	16	16	20	20
g mm	-	-	-	14	14	18	18
h mm	-	-	-	11	11	13	13
i mm	-	-	-	25	25	32	32
k mm	-	-	-	11	11	14	14
l mm	7	10	12,75	23	24	29	49
m mm	14	12	12	20	20	25	25
n mm	2,5	2,5	3	5	5	5	5
o mm	-	15	15	25	30	40	50
Maximum draw bar pull kN	7	7	9	35	45	65	75
Max. total clamping force kN	12	12	15	70	90	140	180
Max. admissible speed min-1	5000	4000	5000	4500	4000	3200	2800
Moment of inertia J kgm2	0,001	0,003	0,007	0,035	0,096	0,28	0,73
Weight without jaws approx. kg	1,3	2,1	3,7	11	19,2	36	59
Actuating cylinders (recommended)	**OVS-85**	**OVS-85**	**OVS-85**	**OVS-105**	**OVS-130**	**OVS-150**	**OVS-150**

1) Shallow design

KFD 3-jaw, weight reduced, serration 90°



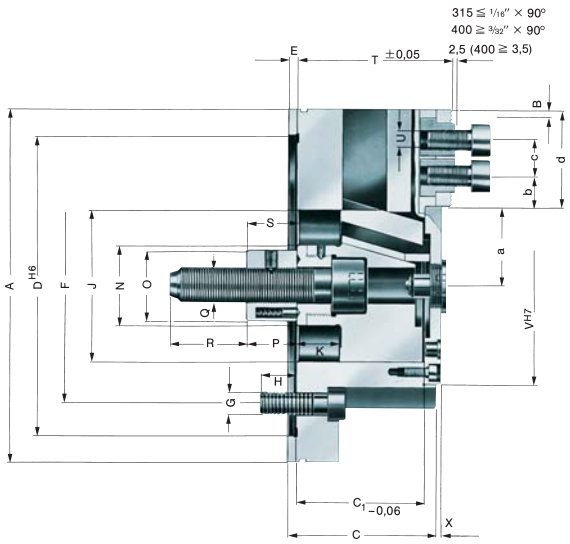


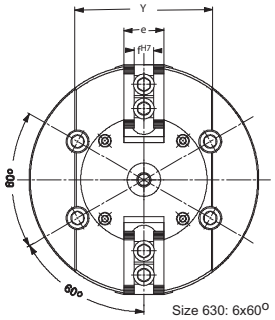
3-jaw power chuck, weight reduced, serration 90°
Adaptor recess, mounting dimensions to DIN 6353

Item no.	046730	046744	144594	144596
Size	160	200	250	315
A mm	160	200	250	315
Jaw travel B mm	5,3	6,7	6,7	6,7
C mm	79	87	102	102
C1-0,06 mm	66,05	74,05	89,05	89,05
Mount DH6	140	170	220	220
E mm	6	6	6	6
F mm	104,8	133,4	171,4	171,4
G mm	3 x M 10	3 x M 12	3 x M 16	3 x M 16
H mm	17	20	26	26
J mm	65	85	105	105
Wedge stroke K mm	20	25	25	25
N mm	35	45	55	55
O mm	34	40	46	46
P mm	25	30	30	30
Q mm	M16	M20	M24	M24
R mm	40	45	55	55
S min.	25	30	30	30
S max.	45	55	55	55
T±0,05 mm	80	90	105	105
U	M 12 x 25	M 12 x 25	M 16 x 30	M 16 x 30
VH7 mm	85	110	130	130
X mm	3	3	3	3
a min.	26,7	38,3	48,3	48,3
a max.	32	45	55	55
b min.	9	8	10	10
c min.	19	19	25	25
c max.	36,5	44,5	58,5	89,5
d mm	48	55	70	102,5
e mm	35	35	50	50
fH7 mm	17	17	21	21
Max. swing top jaws mm	215	290	345	410
Maximum draw bar pull kN	35	45	65	75
Max. total clamping force kN	70	90	140	180
Max. admissible speed min-1	4500	4000	3200	2800
Moment of inertia J kgm2	0,027	0,076	0,226	0,496
Weight without jaws approx. kg	8,5	15,2	29	40
Actuating cylinders (recommended)	**OVS-105**	**OVS-130**	**OVS-150**	**OVS-150**

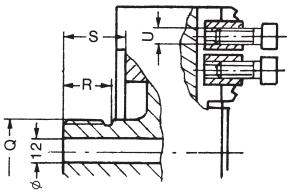
▲ on request

KFD 2-jaw, weight reduced, serration 90°





Size 630: 6x60°



Size 125, 140

2-jaw power chuck, weight reduced, serration 90°
Adaptor recess, mounting dimensions to DIN 6353

Item no.	128409[1)]	046736	046750	144608	045566	128421	128422 ▲	128423 ▲
Size	125	160	200	250	315	400	500	630
A mm	125	160	200	250	315	400	500	630
Jaw travel B mm	3,7	5,3	6,7	6,7	8	9,3	9,3	10,5
C mm	40	79	87	102	117	127	127	140
C1-0,06 mm	37+0,07	66,05	74,05	89,05	104,05	111,05	111,05	125,05
Mount DH6	105	140	170	220	300	300	380	380
E mm	3	6	6	6	6	6	6	8
F mm	80	104,8	133,4	171,4	235	235	330,2	330,2
G mm	4xM8	4 x M10	4 x M12	4 x M16	4 x M20	4 x M20	4 x M24	6 x M24
H mm	14	17	20	26	26	35	35	35
J mm	50	65	85	105	120	155	155	180
Wedge stroke K mm	14	20	25	25	30	35	35	40
N mm	-	35	45	55	60	60	60	80
O mm	-	34	40	46	46	55	55	55
P mm	-	25	30	30	30	30	30	30
Q mm	M20x1,5	M16	M20	M24	M24	M24	M30	M30
R mm	20	40	45	55	55	55	55	63
S min.	25	25	30	30	30	30	30	28
S max.	39	45	55	55	60	65	65	68
T±0,05 mm	44	80	90	105	120	130	130	148
U	M6x8	M12 x 25	M12 x 25	M16 x 30	M16 x 30	M20 x 40	M20 x 40	M20 x 40
VH7 mm	-	85	110	130	160	190	190	220
X mm	6	3	3	3	3	3	3	6
a min.	24,3	26,7	38,3	48,3	54	72,7	76,7	85,2
a max.	28	32	45	55	62	82	86	95,7
b min.	7	9	8	10	10	14	16	18
c min.	10	19	19	25	25	31	31	31
c max.	25	36,5	44,5	58,5	81,5	98	144	197
d mm	34,5	48	55	70	95	118	164	219,3
e mm	25	35	35	50	55	60	60	70
fH7 mm	10	17	17	21	21	25,5	25,5	25,5
Y mm	-	95	120	140	170	220	240	265
Max. swing top jaws mm	192	215	290	345	410	560	660	790
Maximum draw bar pull kN	6	23	30	43	55	65	75	90
Clamping force/jaw kN	6,5	25	33	48	62	75	85	120
Max. admissible speed min-1	5000	4500	4000	3200	2800	2000	1600	1200
Moment of inertia J kgm2	0,007	0,027	0,075	0,222	0,62	1,92	5,31	12,9
Weight without jaws approx. kg	3,6	8,5	15	28,5	53	96	170	200
Actuating cylinders (recommended)	**OVS-85**	**OVS-85**	**OVS-105**	**OVS-130**	**OVS-130**	**OVS-150**	**OVS-200**	**OVS-200**

[1)] chuck without weight reduction

Jaws KFD

C 21
Reversible top jaws, hardened serration 90° - material: 16 MnCr 5



Chuck Size	2-jaw set	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm	Serration
110/125	**046545**	**046544**	56	37,5	26	1/16"x 90°
130	**045796**	**046404**	56	37,5	26	1/16"x 90°
160/200	**046429**	**046408**	68	45	34,7	1/16"x 90°
160/200/250	**118521**	**118522**	75	49	36	1/16"x 90°
250/315	**046435**	**046414**	103,5	58	50	1/16"x 90°
400/500/630	**046447**	**037531**	135	65	68	3/32"x 90°

[1] one step only
Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21
Soft top jaws, can be hardened serration 90° - material: 16 MnCr 5



Chuck Size	2-jaw set	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm	Serration
110/125	**045794**	**046402**	53	30	22,5	1/16"x 90°
130	**045795**	**046403**	55	38	26,5	1/16"x 90°
160	**133147**	**133152**	66,7	53	36,5	1/16"x 90°
200	**133148**	**133153**	75	53	36,5	1/16"x 90°
250	**133149**	**133154**	95	54,5	45	1/16"x 90°
315	**133150**	**133155**	103	80	50	1/16"x 90°
400/500/630	**133151**	**133156**	130	80	50	3/32"x 90°
400/500/630	**046446**	**046423**	130	89	68	3/32"x 90°

C 21
Soft top jaws, can be hardened tongue and groove 120° bevelled, material: 16 MnCr 5



Chuck Size	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm
85	**119459**	40	30	22,5
110/125	**046859**	51	30	22,5
160	**123358**	72,7	53	36,5
200	**123430**	90,3	53	36,5
250	**123433**	115,3	54,5	45
315	**129849**	146	80	50

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 12



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
144320	130	66	38	52	1/16"x 90°
144321	130	56	38	34	1/16"x 90°
144322	130	66	38	25	1/16"x 90°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 17



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137031	160/200	67	45	53	1/16"x 90°
137032	160/200	65	45	46	1/16"x 90°
137039	160/200	55	45	40	1/16"x 90°
137034	160/200	50	45	31	1/16"x 90°
137035	160/200	55	45	27	1/16"x 90°
137036	160/200	65	45	19	1/16"x 90°
137037	160/200	65	45	26	1/16"x 90°
137038	160/200	55	45	24	1/16"x 90°
137033	160/200	55	45	39	1/16"x 90°

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Jaws KFD

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 21



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137041	250/315	95	50	80	1/16“x 90°
137042	250/315	75	50	60	1/16“x 90°
137043	250/315	60	50	43	1/16“x 90°
137044	250/315	70	50	37	1/16“x 90°
137045	250/315	95	50	25	1/16“x 90°
137046	250/315	80	50	30	1/16“x 90°

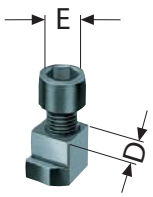
C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 25,5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137051	400/500/630	130	65	113	3/32“x 90°
137052	400/500/630	90	65	67	3/32“x 90°
137053	400/500/630	100	65	45	3/32“x 90°
137054	400/500/630	130	65	33	3/32“x 90°

Accessories KFD

C 15
T-nuts
With screw



Item no.	Chuck Size	Contents of delivery	D mm	E
1305163	110/125	piece	10	M6x18
241673	130	piece	12	M8x20
241674	160/200	piece	17	M12x25
241675	250	piece	21	M16x30
241676	400/500/630	piece	25,5	M20x40

C 15
Special grease F80 for lathe chucks
for lubrication and conservation of clamping force



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

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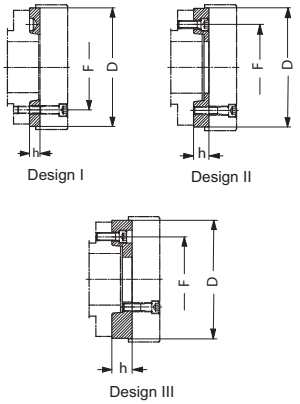
Accessories KFD

C 15

Intermediate adaptor plates with cylindrical centre mount DIN 6353 for 3-jaw chucks

Mounting from front to ISO 702-1 (DIN 55026/55021) and ASA B 5.9 A1/A2 with metric mounting bolts





Item no.	Spindle nose size	Size	Design	h mm	F mm	D mm
145125[1)]	4	160	II	18	82,6	140
145153	5	175	I	15	104,8	140
145127	5	200	II	21	104,8	170
145129	6	160	III	35	133,4	140
145155	6	200	I	16	133,4	170
145131	6	250	II	27	133,4	220
145135	8	200	III	39	171,4	170
145157	8	250	I	18	171,4	220
145137	8	315/400	II	38	171,4	300
145141	8	500/630	II	38	171,4	380
145143	11	250	III	48	235	220
145159	11	315/400	I	19	235	300
145145	11	500/630	II	40	235	380
145149	15	400	III	58	330,2	300
145161	15	400/500/630	I	21	330,2	380

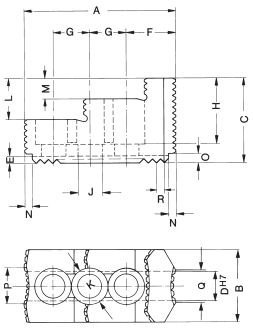
All fastening parts are included

Intermediate adaptor plate for 2-jaw version on request

1) DIN 55021 on request

Jaw dimensions KFD / KFD-EC

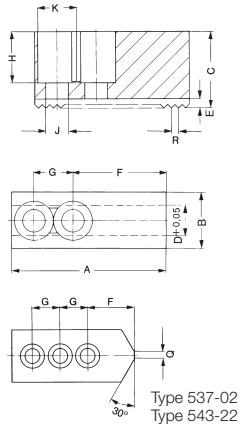
Reversible top jaw UB,
hardened, serration 90°



Chuck size	110/125/140	130	160	200/250 1)	250/315	400-800
Type	537-02	538-02	538-03	538-04	538-05	538-07 2)
Item no. 2-jaw	**046545**	**045796**	**046429**	**118521**	**046435**	**046447**
Item no. 3-jaw	**046544**	**046404**	**046408**	**118522**	**046414**	**037531**
A	56	56	68	75	103,5	135
B	26	26	34,7	36	50	68
C	37,5	37,5	45	49	58	65
DH7	10	12	17	17	21	25,5
E	3,5	3,5	5	5	5	5
F	10	14	17	21,5	33,5	48
G	12 3)	15	19	19	25	31
H	29	29	33,5	37,5	45	48
J	6,4	8,4	13	13	17	21
K	10,4	13,5	19	19	25	31
L	20	20	20	24	28	-
M	10	10	10	12	14	26
N	4	4	5	6	6	6,5
O	4	4	7	7,5	6,5	5,5
P	5	5	10	18	24,5	34
Q	5	5	5	7	22,5	40
R	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	3/32"x90°
Weight/jaw kg	0,130	0,170	0,350	0,460	1,130	2,000

1) Size 250: chuck in shallow design
2) one step only
3) 4 mounting holes

Soft top jaws AB,
Serration 90°
Module toothing
(Size 1000-1600)

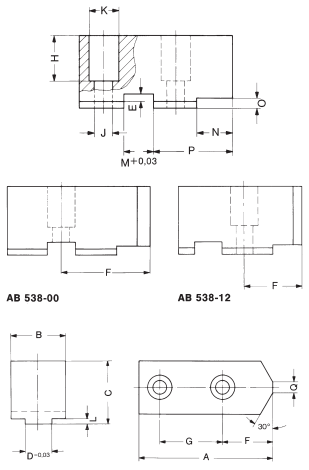


Type 537-02
Type 543-22

Chuck size	110/125/140	130	160	200/250 1)	250	315	400-800	400-800
Type	537-02	538-02	538-03	538-04	538-05	538-06	538-07	538-07 2)
Item no. 2-jaw	**045794**	**045795**	**133147**	**133148**	**133149**	**133150**	**133151**	**046446**
Item no. 3-jaw	**046402**	**046403**	**133152**	**133153**	**133154**	**133155**	**133156**	**046423**
A	53	55	66,7	75	95	103	130	130
B	22,5	26,5	36,5	36,5	45	50	50	68
C	30	38	53	53	54,5	80	80	89
D	10	12	17	17	21	21	25,5	25,5
E	3,5	3,5	5	5	5	5	5	5
F	20	31	36	44	55	62	79	75
G	12 3)	15	19	19	25	25	31	35
H	20	28	43	43	42,5	67	60	69
J	6,4	8,4	13	13	17	17	21	21
K	10,4	13,5	19	19	25	25	31	31
Q	3	-	-	-	-	-	-	-
R	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	3/32"x90°	3/32"x90°
Weight/jaw kg	0,223	0,320	0,700	0,880	1,400	2,580	3,1	5,120

1) Size 250: chuck in shallow design
2) heavy design
3) 3 mounting holes

Soft top jaws AB,
Tongue and groove

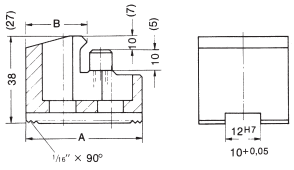


Chuck size	85	110/125 1)	160	200	250	315
Type	538-00	537-03	538-13	538-14	538-15	538-66
Item no. 3-jaw	**119459**	**046859**	**123358**	**123430**	**123433**	**129849**
A	40	51	72,7	90,3	115,3	146
B	22,5	22,5	36,5	36,5	45	50
C	30	30	53	53	54,5	80
D-0,03	8	8	16	16	20	20
E	3	3,5	5,5	5,5	5,5	5,5
F	29	29,5	32,5	45,3	58,3	63,5
G	-	15	25	30	40	50
H	20	20	38	38	38	60
J	9	6,4	13	13	17	17
K	15	10,4	19	19	25	25
L	2,5	2,5	4,5	4,5	4,5	4,5
M+0,03	8	8	10	12	16	16
N	18	23	24,7	35,3	45,3	43
O	4	4	5	5	5	5
P	25	33	39,7	54,3	70,3	80,5
Q	3	3	3	6	6	6
Weight/jaw kg	0,146	0,200	0,720	1,000	1,550	3,600

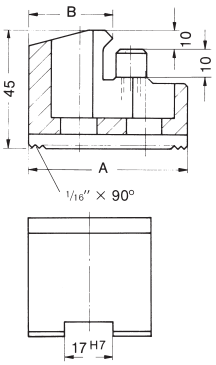
1) chuck in shallow design

Jaw dimensions KFD / KFD-EC

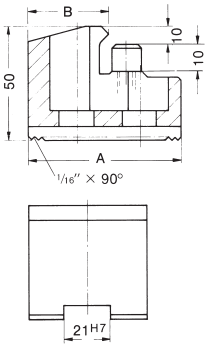
Claw type jaws KB,
Serration 90°



Size	A	B	130 External chucking
Item no. Piece			
144320	66	52	38-82
144321	56	34	78-122
144322	66	25	120-144
			Internal chucking
144322	66	25	70-98
144321	56	34	92-138
144320	66	52	122-178

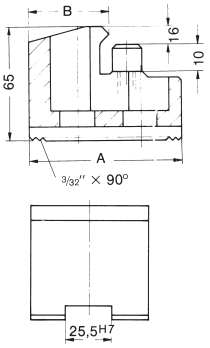


Size	A	B	160 External chucking	200 External chucking
Item no. Piece				
137031	67	53	38-56	60-96
137032	65	46	51-71	73-111
137039	55	40	66-87	88-127
137034	50	31	83-102	105-142
137035	55	27	97-117	119-157
			Internal chucking	
137036	65	19	50-70	72-110
137037	65	26	68-85	90-125
137038	55	24	82-104	104-144
137035	55	27	102-116	124-156
137034	50	31	114-123	136-163
137039	55	40	120-135	144-175
137033	55	39	132-165	154-205
137032	65	46	146-178	168-218



Size	A	B	250 External chucking	315 1) External chucking	315 External chucking
Item no. Piece					
137041	95	80	53-95	53-160	66-160
137042	75	60	92-133	92-198	105-198
137043	60	43	125-167	125-232	138-232
137044	70	37	156-198	156-263	169-263
				Internal chucking	
137045	95	25	68-112	68-117	81-177
137046	80	30	108-154	108-219	121-219
137044	70	37	146-186	146-240	159-240
137043	60	43	178-240	178-305	191-305
137042	75	60	212-265	212-330	225-330

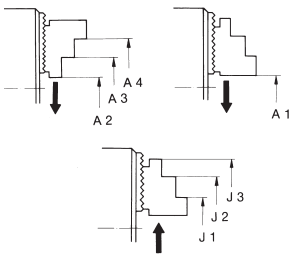
1) chuck in shallow design

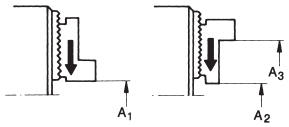


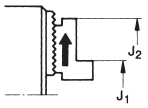
Size	A	B	400 External chucking	500 External chucking	630 External chucking
Item no. Piece					
137051	130	113	80-180	80-280	114-410
137052	90	67	170-270	170-370	204-500
137053	100	45	256-390	270-495	290-625
				Internal chucking	
137054	130	33	100-215	100-315	134-445
137053	100	45	260-395	275-500	295-625
137051	130	113	300-460	300-560	334-690

Chucking capacities KFD

Chucking capacities with reversible top jaw UB







Chuck size		110	125	130	140	160	200	250 [1]	250	315 [1]	315	400	500	630
with reversible jaws	Type	537-02	537-02	538-02	537-02	538-03	538-04	538-04	538-05	538-05	538-05	538-07	538-07	538-07
	Jaw position													
External chucking	A1	4-62	4-78	6-66	4-93	5-73	16-108	16-159	20-124	20-189	34-189	40-225	40-325	60-450
	A2	-	-	-	-	-	28-118	28-169	38-152	38-217	52-217	70-280	70-380	108-510
	A3	47-105	75-126	60-119	75-140	70-140	86-173	86-223	120-232	120-297	134-297	-	-	-
	A4	82-140	110-161	94-151	110-176	110-182	137-224	137-274	200-314	200-379	214-379	275-480	275-580	310-700
Internal chucking	J1	40-95	40-110	42-96	40-125	53-120	70-156	70-208	70-170	70-233	84-233	102-305	102-405	136-530
	J2	74-130	72-145	74-130	72-160	92-163	120-208	120-258	146-251	146-313	160-313	-	-	-
	J3	112-168	116-190	118-175	116-205	144-200	173-261	173-311	236-328	236-393	250-393	295-490	295-590	328-720

[1] chuck in shallow design

KFD-G



APPLICATION

Power chuck without through-hole for clamping workpieces with collars or shoulders (e.g. fittings), without having to give up high clamping force.

TYPE

Power chuck is available with cylindrical center mount.
2-jaw version with serration 90° (sizes 125 + 160 with tongue and groove).

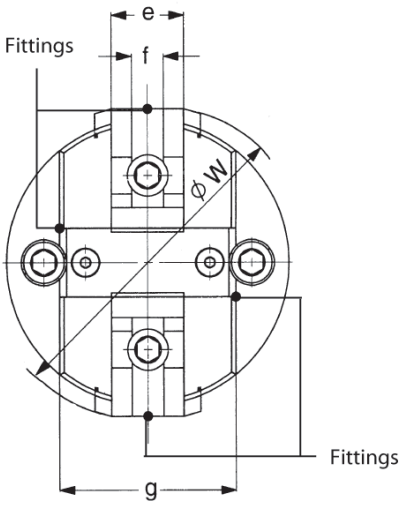
CUSTOMER BENEFITS

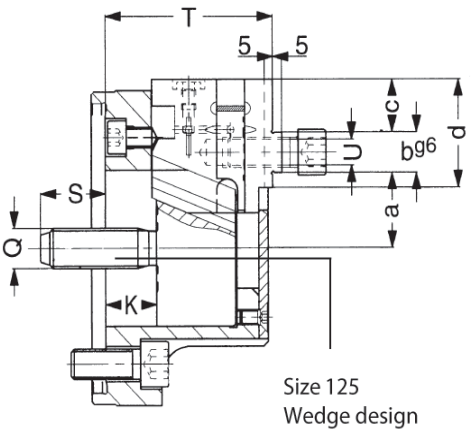
- Minimization of the interference contours of the chuck by means of bevels on the chuck body
- Excessively high jaw stroke for flexible chuck use
- Long service life - Sealed against dirt and water
- High clamping precision thanks to proven wedge hook system

TECHNICAL FEATURES

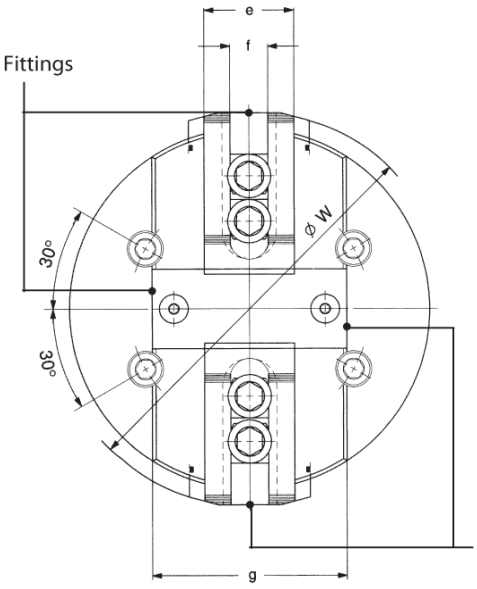
- Power transmission by means of wedge hook system
- Direct lubrication of base jaws and pistons (4 lubrication points)
- Full steel design

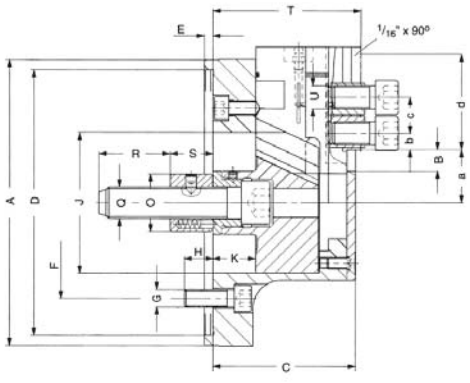
Size 125 + 160
Tongue and groove





Size 125
Wedge design





Fittings

▲ on request

KFD-G 2-jaw, large jaw movement, serration 90°

C15
2-jaw power chuck KFD-G, with large jaw movement,
Adaptor recess for clamping workpieces with collars or shoulders (e.g. fittings), without having to give up high clamping force.

Item no.	154025	154026	154027	154028	154029
Size	125	160	200	250	315
A mm	125	160	200	250	315
Jaw travel B mm	8,5	11	14	14,4	14,4
C mm	70	81	100	102	102
Mount DH6	115	140	185	220	220
E mm	6	6	6	6	6
F mm	92	104,8	133,4	171,4	171,4
G mm	2 x M 12	4 x M 10	4 x M 12	4 x M 16	4 x M 16
H mm	15	16	20	25	25
J mm	62	75	98	98	98
Wedge stroke K mm	22	27	30	31	31
O mm	-	35	44	44	44
Q mm	M 16	M 16	M 22	M 22	M 22
R mm	-	40	50	50	50
S min.	28	33	30	29	29
S max.	50	60	60	60	60
T±0,05 mm	72	84	103,7	105,7	105,7
U	M 12	M 16	M 16	M 20	M 20
WMax.	140	180	220	270	334
a min.	21,5	32,5	23	22,6	22,6
a max.	30	43,5	37	37	37
b min.	16g6	18g6	14	14	14
c min.	21	26	25	31	31
c max.	21	26	55,5	77	103
d mm	43	57,5	71,5	96	128,5
e mm	32	35	50	55	55
fH7 mm	14	18	21	25,5	25,5
g mm	78	91	108	120	120
Maximum draw bar pull kN	13	16	35	45	45
Max. total clamping force kN	10	12	25	29	29
Max. admissible speed min-1	3500	3000	3000	2500	2200
Moment of inertia J kgm2	0,01	0,04	0,09	0,2	0,4
Weight without jaws approx. kg	5	9	17	25	36,5
Actuating cylinders (recommended)	**OVS-85**	**OVS-85**	**OVS-105**	**OVS-130**	**OVS-130**

C 21
Soft top jaws, 2-jaw set, can be hardened tongue and groove for 2-jaw chucks, material: 16 MnCr 5



Chuck Size	2-jaw set	Jaw length mm	Jaw height mm	Jaw width mm
125	**120321**	56,5	53	36,5
160	**120320**	74,5	53	36,5

C 21
Soft top jaws, 2-jaw set, can be hardened serration 90° - material: 16 MnCr 5



Chuck Size	2-jaw set	Jaw length mm	Jaw height mm	Jaw width mm	Serration
200	**120318**	94	89	68	1/16"x 90°
200	**133149**	95	54,5	45	1/16"x 90°
250	**120316**	110	89	68	1/16"x 90°
315	**120073**	130	89	68	1/16"x 90°

Configure your individual clamping jaws online! www.web2product.biz

Special solutions - for power chucks without through-hole



KFD-HS oil - Power chuck with oil bath lubrication

APPLICATION

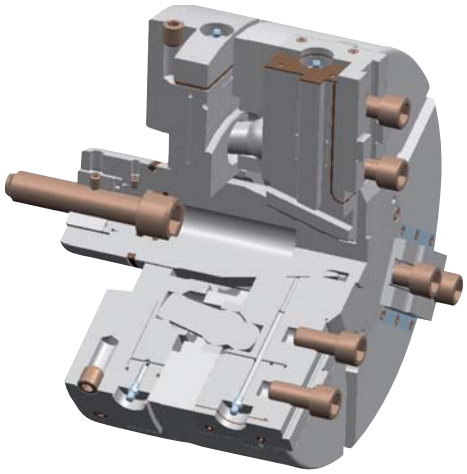
Ideal for use under extreme operating conditions thanks to hermetic seal against dirt and cooling water as well as no required maintenance, for the most time.

TYPE

2-, 3- or 4-jaw version with serration (90°) or tongue and groove. With short taper or cylindrical center mount.

CUSTOMER BENEFITS

- Largely maintenance-free thanks to constant lifetime lubrication of all moving parts through oil filling
- Hermetically sealed against dirt and cooling water
- Ideal for high speeds thanks to KFD-HS principle with simultaneously high concentricity and axial run-out



KFD-F-EC - Power chuck with centrifugal force compensation

APPLICATION

Especially for use under extreme operating conditions, e.g. dry or raw part machining and/or high coolant pressure with simultaneous centrifugal force-sensitive clamping.

TYPE

With centrifugal force compensation.

CUSTOMER BENEFITS

- Low-maintenance and -wear thanks to Easy Care
- Centrifugal force compensation for extremely high speeds



MSF - Diaphragm clamping chuck

APPLICATION

Optimally suited for grinding and hard turning with high precision.

TYPE

With quick-acting jaw change system via HSK interface and standard medium feed-through.

CUSTOMER BENEFITS

- Constant, uniform quality and clamping force thanks to diaphragm technology
- Contamination-resistant
- Quick-acting jaw change system via HSK interface for quick jaw change, maximum precision and change accuracy
- Nearly wear-free

Notes

QUICK-ACTING JAW CHANGE SYSTEM WITH INDIVIDUAL JAW UNLOCKING



The quick-acting jaw change system allows flexible use of the power chuck and drastically reduces of set-up times. The jaws can be flexibly offset, turned or changed.

Thanks to the individual jaw unlocking on the DURO-NCSE power chuck, handling with large, workpiece-specific customized top jaws is especially easy: Push the key till stop, then turn in the direction of the arrow.

Video DURO-NCSE

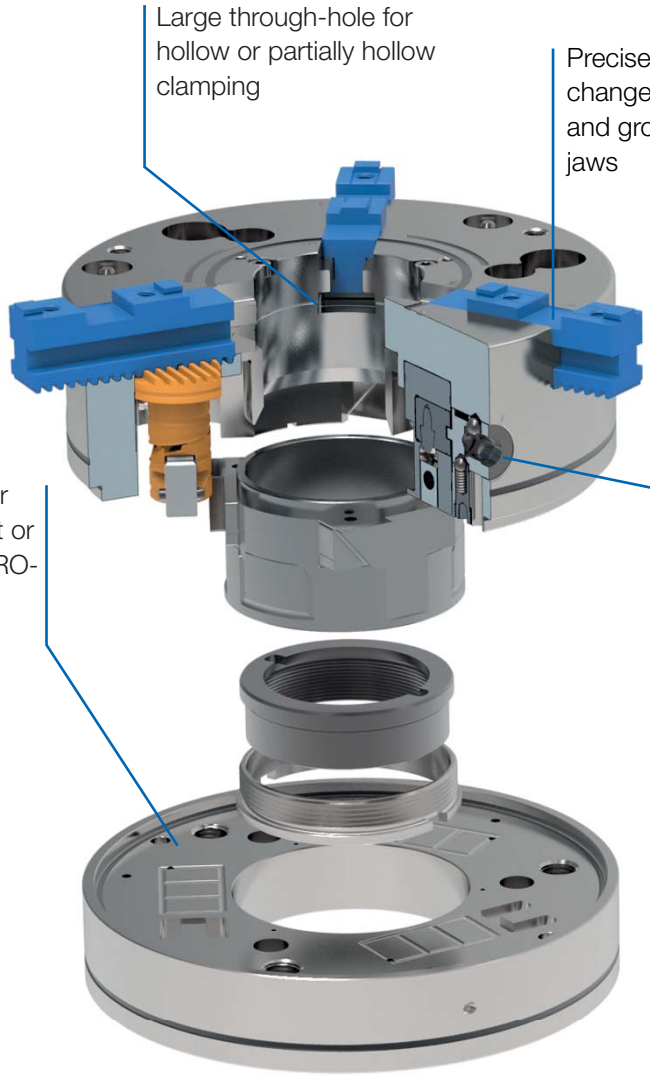
Video DURO-NC

POWER CHUCKS WITH QUICK-ACTING JAW CHANGE

Fast jaw change, high clamping precision and high clamping force characterize the power chucks DURO-NCSE and DURO-NC. Thanks to the quick-acting jaw change system, the jaws can be flexibly offset, turned or changed. The clamping precision of the chuck is always retained.

ADVANTAGES AT A GLANCE

- Flexible use thanks to quick-acting jaw change reducing set-up times
- Secure jaw lock via the safety key
- Large through-hole optimal for bar machining



DURO-NCSE



APPLICATION

Premium power chuck with through-hole for flexible use thanks to quick-action jaw change system for maximum speeds.

TYPE

Power chuck available with cylindrical center mount or short taper mount.
3-jaw version.

CUSTOMER BENEFITS

- Easy handling of the jaw change thanks to individual jaw unlocking
- Universal: Jaws can be offset, exchanged or turned
- For very high speeds - Low centrifugal force losses thanks to low jaw weights and wedge bar construction
- High clamping precision and clamping force thanks to rigid chuck construction
- Large through-hole for hollow or partially hollow clamping

TECHNICAL FEATURES

- Power transmission by means of wedge bar system
- Lubricated base jaw guides
- The toothing of the wedge bar always engages completely in the jaw
- Base jaws with straight teeth

Note:
1) Included in the scope of delivery: Chuck, chuck and jaw mounting screws, base jaws, safety wrench, mounting wrench.
2) The safety key can only be pulled out once the jaws are locked. This setup in combination with the key switch integrated in the machine also prevents the machine spindle from starting up unintentionally when the jaws are unlocked.

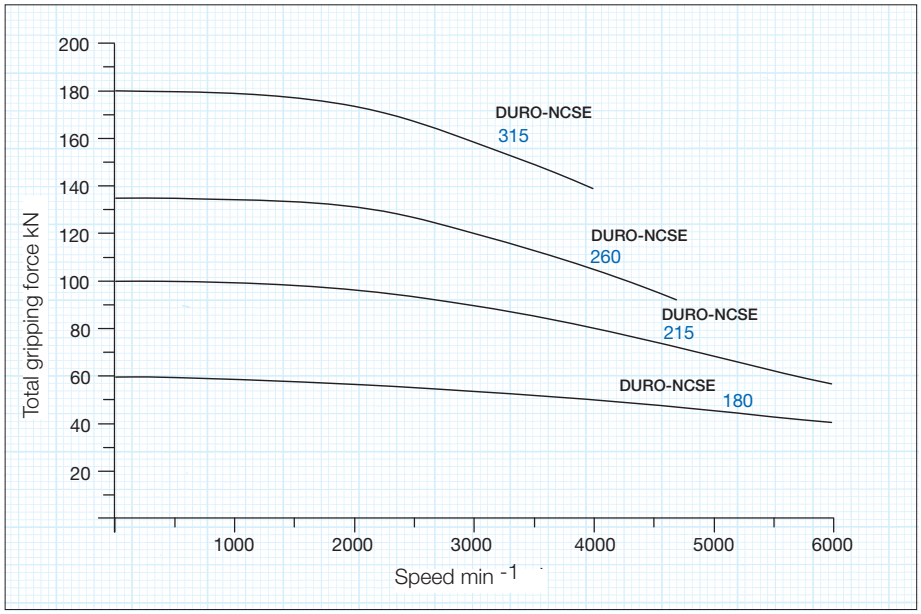
Gripping force / speed diagram

The loss of gripping force was determined experimentally on a chuck with matched UB top jaws. It is largely independent of the initial gripping force at zero speed.

curve:
max. centrifugal force of top jaw

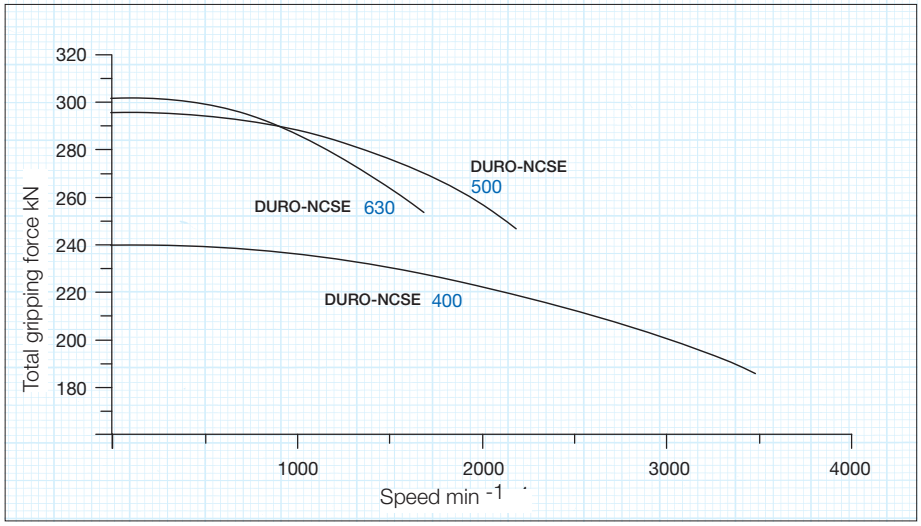


To obtain the specified gripping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM.
Measuring point near chuck face.

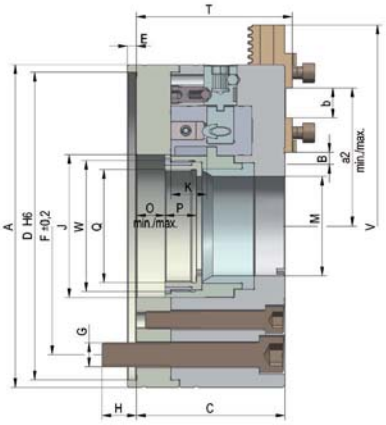


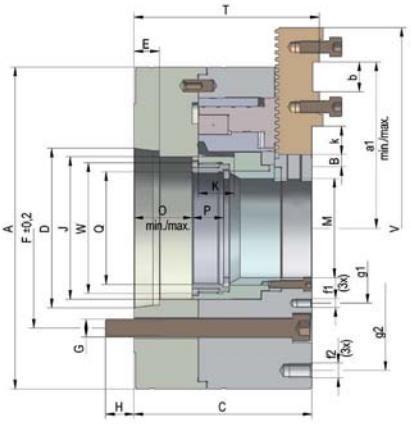
Quick-acting jaw change system with individual jaw unlocking
The individual locking arrangement means that handling is particularly easy with special large jaw pads when the workpiece requires them: Push key till stop, then turn in arrow direction.

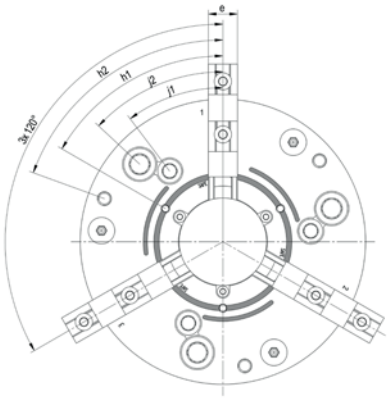




DURO-NCSE 3-jaw, individual jaw unlocking, straight teeth







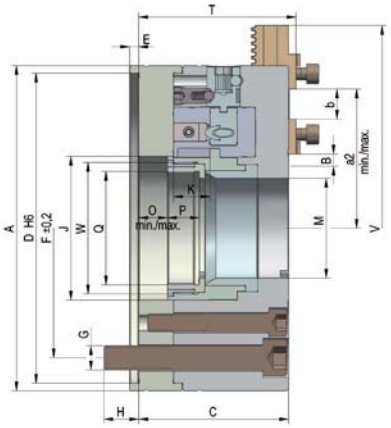
C 15

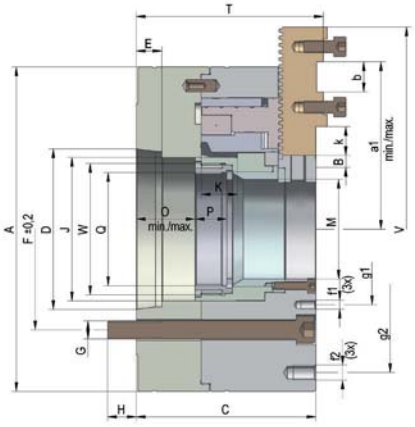
3-jaw power-chucks DURO-NCSE, quick-acting jaw change system, with individual jaw unlocking, with straight teeth

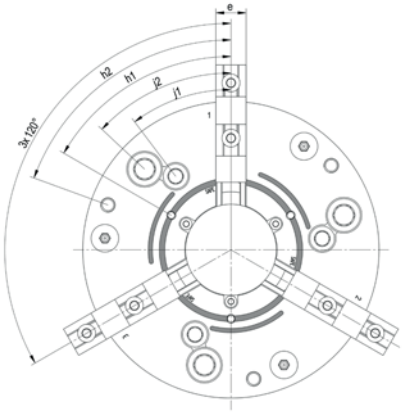
Cylindrical center mount DIN 6353 /short taper mount ISO 702-1 (DIN 55026/55021)

Item no.	438355	438356	438357	438358	438359	438360	438361	438362	438363	438364	438365
Size	180	180	180	180	215	215	215	260	260	260	260
Toothing	4,712	4,712	4,712	4,712	4,712	4,712	4,712	5,498	5,498	5,498	5,498
A mm	180	180	180	180	215	215	215	260	260	260	260
Jaw travel B mm	6,9	6,9	6,9	6,9	7,8	7,8	7,8	8,8	8,8	8,8	8,8
C mm	91,8	91,8	104,8	105,8	105	119	121	121	121	136	138
D mm	ZA 140	ZA 170	KK 5	KK 6	ZA 170	KK 6	KK 8	ZA 170	ZA 220	KK 6	KK 8
E mm	6	6	16	17	6	17	19	6	6	17	19
F mm	104,8	133,4	104,8	133,4	133,4	133,4	171,4	133,4	171,4	133,4	171,4
G mm	M10	M12	M10	M12	M12	M12	M16	M12	M16	M12	M16
H mm	14	16	16	17	17	18	24	17	26	17	24
J mm	78	78	78	78	95	95	95	115	115	110	110
Wedge stroke K mm	21	21	21	21	24	24	24	28	28	28	28
M mm	53	53	53	53	66	66	66	81	81	81	81
O min.	1	1	14	15	1	15	17	1	1	15	17
O max.	22	22	35	36	25	39	51	29	29	43	45
P mm	17	17	17	17	21	21	21	22	22	22	22
Q mm	M60x1,5	M60x1,5	M60x1,5	M60x1,5	M75x1,5	M75x1,5	M75x1,5	M90x1,5	M90x1,5	M87x1,5	M87x1,5
T mm	98,2	98,2	111,2	112,2	109,9	123,9	125,9	129,5	129,5	144,5	146,5
V max. mm	213	213	213	213	269	269	269	313	313	313	313
W mm	M72x1,5	M72x1,5	M72x1,5	M72x1,5	M87x2	M87x2	M87x2	M105x1,5	M105x1,5	M105x1,5	M105x1,5
a min.	59,1	59,1	59,1	59,1	77,9	77,9	77,9	96,8	96,8	96,8	96,8
a max.	87,4	87,4	87,4	87,4	110,9	110,9	110,9	129,8	129,8	129,8	129,8
a 2 min.	50,1	50,1	50,1	50,1	58,9	58,9	58,9	64,8	64,8	64,8	64,8
a 2 max.	78,4	78,4	78,4	78,4	91,9	91,9	91,9	97,8	97,8	97,8	97,8
Index adjustment	6 (x4,712 =28,3)	6 (x4,712 =28,3)	6 (x4,712 =28,3)	6 (x4,712 =28,3)	7 (x4,712 =32,98)	7 (x4,712 =32,98)	7 (x4,712 =32,98)	6 (x5,5 =33)	6 (x5,5 =33)	6 (x5,5 =33)	6 (x5,5 =33)
b mm	18	18	18	18	20	20	20	20	20	20	20
e mm	20	20	20	20	22	22	22	26	26	26	26
f1	M6/10	M6/10	M6/10	M6/10	M6/10	M6/10	M6/10	M8/15	M8/15	M8/15	M8/15
f2	M8/15	M8/15	M8/15	M8/15	M10/15	M10/15	M10/15	M10/15	M10/15	M10/15	M10/15
g1 mm	83	83	83	83	94	100	100	124	124	124	124
g2 mm	155	155	155	155	190	190	190	220	220	220	220
h1	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°
h2	60°	60°	60°	60°	70°	70°	70°	77°	77°	77°	77°
j1	35°	35°	35°	35°	37°	37°	37°	30°	30°	30°	30°
j2	45°	45°	45°	45°	47°	47°	47°	40°	40°	40°	40°
k mm	9	9	9	9	19	19	19	32	32	32	32
Maximum draw bar pull kN	33	33	33	33	52	53	53	73	73	73	73
Max. total clamping force approx. kN	60	60	60	60	95	100	100	135	135	135	135
Max. admissible speed min^{-1}	6300	6300	6300	6300	6000	6000	6000	4700	4700	4700	4700
Weight without jaws approx. kg	18	18	18	18	24	26	26	44	44	47	49
Actuating cylinders (recommended)	**OVS-105 / SZS-52/130**	**OVS-105 / SZS-52/130**	**OVS-105 / SZS-52/130**	**OVS-105 / SZS-52/130**	**OVS-130 / SZS-67/130**	**OVS-130 / SZS-67/130**	**OVS-130 / SZS-67/130**	**OVS-150 / SZS-86/200**	**OVS-150 / SZS-86/200**	**OVS-150 / SZS-85/200**	**OVS-150 / SZS-85/200**

DURO-NCSE 3-jaw, individual jaw unlocking, straight teeth







C 15

3-jaw power-chucks DURO-NCSE, quick-acting jaw change system, with individual jaw unlocking, with straight teeth

Cylindrical center mount DIN 6353 /short taper mount ISO 702-1 (DIN 55026/55021)

Item no.	438366	438367	438368	438369	438370	438371	438372	438373	438374 ▲	438375 ▲	438376 ▲	438377 ▲	438378 ▲
Size	315	315	315	315	400	400	400	400	500	500	500	630	630
Toothing	5,498	5,498	5,498	5,498	5,498	5,498	5,498	5,498	7	7	7	7	7
A mm	315	315	315	315	400	400	400	400	500	500	500	630	630
Jaw travel B mm	9,1	9,1	9,1	9,1	9,8	9,8	9,8	9,8	11,4	11,4	11,4	12,6	12,6
C mm	130	130	146	148	138	138	156	157	162	180	181	179,5	198,5
D mm	ZA 220	ZA 300	KK 8	KK 11	ZA 300	ZA 380	KK 11	KK 15	ZA 380	KK 11	KK 15	ZA 520	KK 15
E mm	6	6	19	21	8	8	21	23	8	21	23	8	23
F mm	171,4	235	171,4	235	235	330,2	235	330,2	330,2	235	330,2	463,6	330,2
G mm	M16	M20	M16	M20	M20	M24	M20	M24	M24	M20	M24	M24	M24
H mm	27	27	26	24	26	36,5	28	37,5	36	30	37	36	37
J mm	140	140	140	140	175,5	175,5	175,5	175,5	207	207	207	235	235
Wedge stroke K mm	28	28	28	28	30	30	30	30	35	35	35	40	40
M mm	104	104	104	104	128	128	128	128	155	155	155	167	167
O min.	1,5	1,5	17,5	19,5	1,5	1,5	19,5	20,5	1,5	19,5	20,5	1,5	20,5
O max.	29,5	29,5	45,5	47,5	31,5	31,5	49,5	50,5	36,5	54,5	55,5	41,5	60,5
P mm	25	25	25	25	29	29	29	29	29	29	29	35	35
Q mm	M110x2	M110x2	M110x2	M110x2	138x2	138,2	M138x2	M138x2	M165x2	M165x2	M165x2	M180x2	M180x2
T mm	139	139	155	157	147	147	165	166	172	190	191	189,5	208,5
V max. mm	351	351	351	351	424	424	424	424	524	524	524	643	643
W mm	M130x1,5	M130x1,5	M130x1,5	M130x1,5	M160x2	M160x2	M160x2	M160x2	M188x2	M188x2	M188x2	M215x2	M215x2
a min.	110,4	110,4	110,4	110,4	115,5	115,5	115,5	115,5	155,9	155,9	155,9	194,4	194,4
a max.	159,9	159,9	159,9	159,9	181,5	181,5	181,5	181,5	225,9	225,9	225,9	285,4	285,4
a 2 min.	66,4	66,4	66,4	66,4	76,5	76,5	76,5	76,5	94,9	94,9	94,9	94,4	94,4
a 2 max.	115,9	115,9	115,9	115,9	142,5	142,5	142,5	142,5	164,9	164,9	164,9	185,4	185,4
Index adjustment	9 (x5,5=49,5)	9 (x5,5=49,5)	9 (x5,5=49,5)	9 (x5,5=49,5)	12 (x5,5=66)	12 (x5,5=66)	12 (x5,5=66)	12 (x5,5=66)	10 (x7=70)	10 (x7=70)	10 (x7=70)	13 (x7=91)	13 (x7=91)
b mm	20	20	20	20	26	26	26	26	30	30	30	30	30
e mm	32	32	32	32	32	32	32	32	45	45	45	45	45
f1	M8/15	M8/15	M8/15	M8/15	M8/15	M8/15	M8/15	M8/15	M8/16	M8/16	M8/16	M8/16	M8/16
f2	M12/20	M12/20	M12/20	M12/20	M16/20	M16/20	M16/20	M16/20	M20/37	M20/37	M20/37	M16/30	M16/30
g1 mm	140	140	140	140	170	170	170	170	200	200	200	245	245
g2 mm	268	238	268	268	330,2	330,2	330,2	330,2	420	420	420	520	520
h1	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°
h2	77°	77°	77°	77°	70°	70°	70°	70°	77°	77°	77°	47°	47°
j1	40°	40°	40°	40°	42,5°	42,5°	42,5°	42,5°	30°	30°	30°	45°	45°
j2	45°	45°	45°	45°	45°	45°	45°	45°	45°	45°	45°	60°	60°
k mm	43	43	43	43	39	39	39	39	57	57	57	97	97
Maximum draw bar pull kN	100	100	100	100	133	133	133	133	173	173	173	173	173
Max. total clamping force approx. kN	180	180	180	180	240	240	240	240	305	305	305	312	312
Max. admissible speed min-1	4000	4000	4000	4000	3500	3500	3500	3500	2200	2200	2200	1700	1700
Moment of inertia J kgm2	0,96	0,96	0,96	0,96	2,67	2,67	2,67	2,67	16,1	16,1	16,1	22,8	22,8
Weight without jaws approx. kg	66	66	69	70	110	110	118	121	216	233	235	393	430
Actuating cylinders (recommended)	**OVS-200 / SZS-110/230**	**OVS-200 / SZS-110/230**	**OVS-200 / SZS-110/250**	**OVS-200 / SZS-110/250**	**OVS-200 / SZS-127/325**	**OVS-200 / SZS-127/325**	**OVS-200 / SZS-127/325**	**OVS-200 / SZS-127/325**	**OVS-200**	**OVS-200**	**OVS-200**	**OVS-200**	**OVS-200**

Balancing quality G 6.3 in acc. with DIN 1940

▲ on request

Jaws DURO-NCSE

C 21
Base jaws, 3-jaw-set, hardened straight toothing, incl. cylinder screws, DIN 912-12.9



Item no.	Chuck Size	Jaw length mm	Jaw width mm
463548	180	65	20
463549	215	85	22
463550	260	104	26
463551	315	115	32
463552	400	125	32
463553	500	160	45
463554 ▲	630	200	45

A 36
Reversible top jaws, 3-jaw set, hardened tongue and groove for external and internal clamping - Material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
094012	180	61,5	32,5	20,4
094013	215	70,5	38	24,4
094014	260/315	92	50	34,4
094015	400	107	56	35,7
094045	500/630	130	72	50,4

Additionally or later applied, hardened stepped jaws must be ground out in the chuck.

A28
Unstepped top jaw AB, 3-jaw set standard design, soft, material 16MnCr5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
094008	180	85	36,5	20,3
094009	215	105	40	22
094010	260/315	125	50	30,4
094011	400	145	50	34,3
094046	500/630	180	73	50,5

C 21
One-piece reversible jaws, 3-jaw set, hardened straight toothing - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
463555	180	58	44	20
463556	215	75	51	22
463557	260	90	60	26
463558	315	117	66	32
463559	400	137	70	32
463560 ▲	500	176	93	45

Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21
Soft one-piece jaws, 3-jaw set, can be hardened straight toothing, guidance hardened and ground - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
463562 ▲	180	65	55	20
463563 ▲	215	84	65	22
463564	260	99	84	26
463565	315	121	90	32
463566 ▲	400	148	100	32
463567 ▲	500	175	124	45
463568 ▲	630	230	134	45

Configure your individual clamping jaws online! www.web2product.biz

Jaws DURO-NCSE

C 21
Reversible claw-type top jaws, standard design tongue and groove, small clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137060	180	66	37,5	24
137119	500/630	124	62	50

C 21
Reversible claw-type top jaws, standard design tongue and groove, large clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137061	180	66	37,5	20
137064	215	81	43	24
137108	260/315	90	55	34
137114	400	100	62	34
137120	500/630	124	62	50

C 21
Reversible claw-type top jaws, standard design tongue and groove, medium clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137062	180	56	37,5	20
137065	215	66	43	24
137109	260/315	72	55	34
137115	400	86	62	34
137121	500/630	100	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, small clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137066	215	79	43	34
137110	260/315	80	55	50
137116	400	93	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, large clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137067	215	81	43	34
137111	260/315	90	55	50
137117	400	106	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, medium clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137068	215	66	43	34
137112	260/315	72	55	50
137118	400	86	62	50

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Jaws DURO-NCSE

C 21
Draw-down jaws, for interchangeable clamping inserts straight toothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
485522 ▲	180	65	43	20
485524 ▲	215	85	47	22
485526	260	104	58	26
485528 ▲	315	115	63	32
485530 ▲	400	125	63	32
485532 ▲	500	160	81	45

C 21
Draw-down jaws, additional clamping range, for interchangeable clamping inserts straight toothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
485523 ▲	180	72	43	20
485525 ▲	215	95	47	22
485527 ▲	260	104	58	26
485529 ▲	315	123	63	32
485531 ▲	400	134	63	32
485533 ▲	500	160	81	45

C 15
Interchangeable clamping inserts, 1 piece with claws



Item no.	Chuck Size
141049	180/215
141052	260/315/400
141055	500

C 15
Interchangeable clamping inserts, 1 piece with serrated toothing



Item no.	Chuck Size
141050	180/215
141053	260/315/400
141056	500

C 15
Interchangeable clamping inserts, 1 piece with heat treatable surface



Item no.	Chuck Size
141051	180/215
141054	260/315/400
141057	500

Configure your individual clamping jaws online! www.web2product.biz

Accessories DURO-NCSE

C 15

Mounting screws



Item no.	Size	Contents of delivery	Thread
233058	180/215	piece	M8x20
233030	260/315/400	piece	M12x30
216569	500/630	piece	M16x40

Socket head cap screw to DIN 912, 12.9

C 15

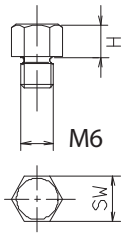
Special grease F80 for lathe chucks
for lubrication and conservation of clamping force



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

C 15

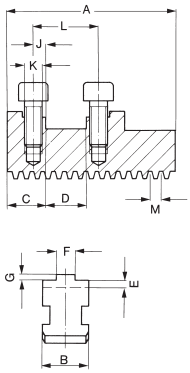
Changeable workpiece rests (in different lengths)



Item no.	H mm	M	Key-width SW
289188	5	M6	9
138950	10	M6	9
725581	15	M6	9

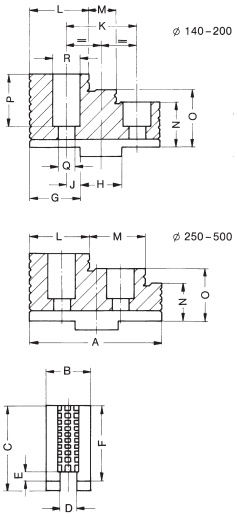
Jaw dimensions DURO-NCSE

Base jaw GB, with screws



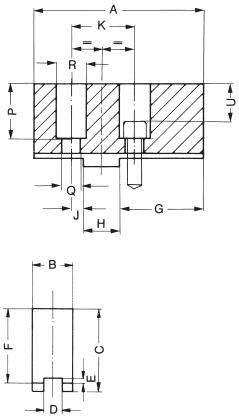
Chuck size	180	215	260	315	400	500	630
Type	574-11	574-11	574-11	574-11	574-11	574-11	574-11
Item no. 3-jaw	**463548**	**463549**	**463550**	**463551**	**463552**	**463553**	**463554**
A	65	85	104	115	125	160	200
B	20	22	26	32	32	45	45
C	19	23	26	26	30	35	35
D^{H7}	18	20	20	20	26	30	30
E	5	4,5	5,5	6	6	9	9
F	8	10	12	12	12	16	18
G	2,5	2,5	3	3	3	4	4
J	7	10	10	10	14	15	15
K	M8	M8	M12	M12	M12	M16	M16
L	32	40	40	40	54	60	60
M	4,712	4,712	5,498	5,498	5,498	7	7
Weight/set kg	0,7	1,0	1,8	2,7	3,0	7,1	9

Reversible top jaws UB,
hardened



Chuck size	180	215	260	315	400	500	630
Type	003-20	003-25	003-30	003-30	003-35	003-40	003-40
Item no. 3-jaw	**094012**	**094013**	**094014**	**094014**	**094015**	**094045**	**094045**
A	61,5	70,35	92	92	107	130	130
B	20,4	24,4	34,4	34,4	37,5	50,4	50,4
C	37	43	55	55	62	79	79
D	8	10	12	12	12	18	18
E	3	3,5	3,5	3,5	3,5	4,5	4,5
F	32,5	38	50	50	56	72	72
G	22,5	25,5	30	30	35,5	41,4	41,4
H	18	20	20	20	26	30	30
J	7	10	10	10	14	15	15
K	32	40	40	40	54	60	60
L	26,5	28,5	41	41	40	51	51
M	13	14	40,5	40,5	54	71	71
N	17,5	18	22	22	26	32	32
O	25	28	36	36	41	52	52
P	23,5	29	39	39	40	57	57
Q	9	9	14	14	14	18	18
R	15	15	20	20	20	26	26
Weight/set kg	0,6	1,0	2,4	2,4	3,4	7,6	7,6

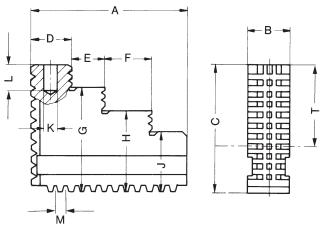
Soft top jaws AB,
material 16MnCr5



Chuck size	180	215	260	315	400	500	630
Type	002-20	002-25	002-30	002-30	002-35	002-40	002-40
Item no. 3-jaw	**094008**	**094009**	**094010**	**094010**	**094011**	**094046**	**094046**
A	85	105	125	125	145	180	180
B	20,3	22	30,4	30,4	34,3	50,5	50,5
C	41	45	55	55	56	80	80
D	8	10	12	12	12	18	18
E	3	3,5	3,5	3,5	3,5	4,5	4,5
F	36,5	40	50	50	50	73	73
G	42	50	70	70	74	100	100
H	18	20	20	20	26	30	30
J	7	10	10	10	14	15	15
K	32	40	40	40	54	60	60
P	27,5	31	39	39	34	58	58
Q	9	9	14	14	14	18	18
R	15	15	20	20	20	26	26
U	19,5	23	27	27	22	42	42
Weight/set kg	1,3	2,2	4,5	4,5	6,8	13,2	13,2

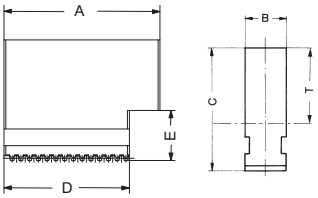
Jaw dimensions und Chucking capacities DURO-NCSE

Reversible one-piece jaws EB



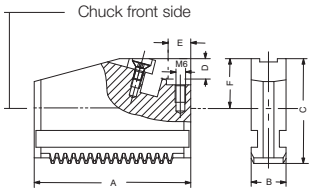
Chuck size	180	215	260	315	400	500/630
Type	574-27	574-27	574-27	574-27	574-27	574-27
Item no. 3-jaw	**463555**	**463556**	**463557**	**463558**	**463559**	**463560**
A	58	75	90	117	137	176
B	20	22	26	32	32	45
C	44	51	60	66	70	93
G	37	43	50	56	59	73
H	30	35	40	46	48	-
J	23	27	30	36	37	53
M	4,712	4,712	5,498	5,498	5,498	7
T	23	26	31	32	36	46
Weight/set kg	0,6	1,3	2,0	3,4	4,4	11,7

Soft one-piece jaws BL,
material 16MnCr5



Chuck size	180	215	260	315	400	500	630
Type	574-37	574-37	574-37	574-37	574-37	574-37	574-37
Item no. 3-jaw	**463562**	**463563**	**463564**	**463565**	**463566**	**463567**	**463568**
A	65	84	99	121	148	175	230
B	20	22	26	32	32	45	45
C	55	65	84	90	100	124	134
D	56	67,5	77	93	120	154	200
E	25	27	36	41	41	54	54
T	33	38	53	54	64	77	87
Weight/set kg	1,3	2,2	4,3	6,7	9,2	20,5	29,2

Draw-down jaws NBG,
Straight toothing, for inter-changeable clamping inserts (jaw without insert)

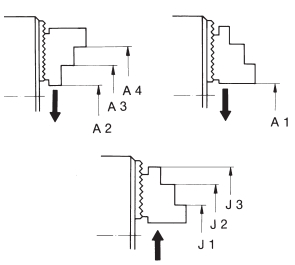


Chuck size	180	215	260	315	400	500
Jaw design			Type 545-30			
Item no. Piece	**485522**	**485524**	**485526**	**485528**	**485530**	**485532**
A	65	85	104	115	125	160
B	20	22	26	32	32	45
C	43	47	58	63	63	81
D	15	15	20	20	20	20
E	11	12	12	12	12	12
F	22,5	22,5	29,5	29,5	29,5	34
Capacities external	38-71	38-102	45-124	42-164	50-190	67-217
Capacities internal	125-160	170-223	207-289	234-344	252-397	346-500
Max. swing	197	251	306	374	425	524

Draw-down jaws NBG,
for interchangeable clamping inserts (jaw without insert)
Jaws for further clamping ranges

Chuck size	180	215	260	315	400	500
Jaw design			Type 549-30			
Item no. Piece	**485523**	**485525**	**485527**	**485529**	**485531**	**485533**
A	72	95	104	123	134	160
E	30	45	50,5	61,5	67	96
Capacities external	78-110	113-168	123-202	146-262	160-305	230-384
Capacities internal	98-122	114-166	131-214	136-245	140-285	180-332
Max. swing	197	271	306	390	443	524

Chucking capacities with reversible top jaws UB

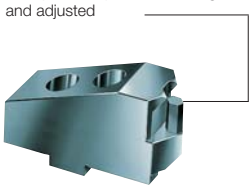


Chuck size		180	215	260	315	400	500	630
	Jaw position							
External chucking	A1	11-68	18-84	27-104	25-163	28-240	30-304	30-425
	A2	33-90	59-125	-	-	-	-	-
	A3	77-134	115-181	83-149	111-213	98-243	54-290	55-407
	A4	103-160	143-209	165-230	193-295	206-351	195-430	195-549
Internal chucking	J1	65-122	75-141	108-185	143-245	85-230	133-408	133-525
	J2	91-148	103-169	189-266	225-327	192-337	233-548	272-667
	J3	135-192	159-225	-	-	-	-	-

Jaw dimensions DURO-NCSE

Reversible claw-type top jaws **KB,** standard design

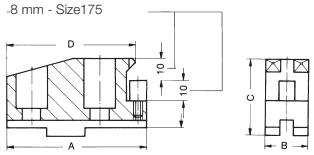
Workpiece stop, can be changed and adjusted



Chuck size	180	500	630
Jaw design		Type 544-00 Standard design	
Item no. Piece	**137060**	**137119**	**137119**
A	66	124	124
B	24	50	50
C	37,5	62	62
D	17	39	39
Capacities external	130-159	314-477	390-584
Capacities internal	53-84	101-249	101-290

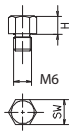
Jaws for further clamping ranges

8 mm - Size175



Chuck size	180	215	260	315	400	500	630
Jaw design			Type 544-00 Standard design				
Item no. Piece	**137061**	**137064**	**137108**	**137108**	**137114**	**137120**	**137120**
A	66	81	90	90	100	124	124
B	20	24	34	34	34	50	50
C	37,5	43	55	55	62	62	62
D	61	71	78	78	90	112	112
Capacities external	25-56	41-103	48-150	48-210	53-237	143-294	216-411
Capacities internal	136-188	181-255	85-238	136-300	240-435	268-420	265-460

Accessories: Interchangeable workpiece stop (different lengths)

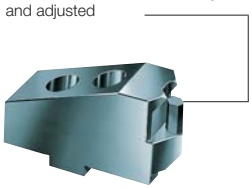


Item no.	289188	138950	725581
M		M6	
H	5	10	15
SW		9	

Chuck size	180	215	260	315	400	500	630
Jaw design			Type 544-00 Standard design				
Item no. Piece	**137062**	**137065**	**137109**	**137109**	**137115**	**137121**	**137121**
A	56	66	72	72	86	100	100
B	20	24	34	34	34	50	50
C	37,5	43	55	55	62	62	62
D	29	38,5	38	38	42	48	48
Capacities external	68-120	94-168	77-230	127-292	172-333	270-422	345-540
Capacities internal	93-126	116-200	85-238	136-300	168-329	142-293	139-333

Reversible claw-type top jaws **KB,** large design

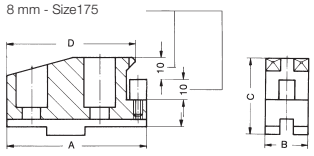
Workpiece stop, can be changed and adjusted



Chuck size	215	260	315	400
Jaw design		Type 544-05 Large design		
Item no. Piece	**137066**	**137110**	**137110**	**137116**
A	79	80	80	93
B	34	50	50	50
C	43	55	55	62
D	29,5	29	29	30
Capacities external	-	-	-	-
Capacities internal	90-151	73-203	80-264	130-291

Jaws for further clamping ranges

8 mm - Size175



Chuck size	215	260	315	400
Jaw design		Type 544-05 Large design		
Item no. Piece	**137067**	**137111**	**137111**	**137117**
A	81	90	90	106
B	34	50	50	50
C	43	55	55	62
D	71	78	78	90
Capacities external	41-103	53-152	70-214	76-237
Capacities internal	181-255	163-322	222-384	168-425

Chuck size	215	260	315	400
Jaw design		Type 544-05 Large design		
Item no. Piece	**137068**	**137112**	**137112**	**137118**
A	66	72	72	86
B	34	50	50	50
C	43	55	55	62
D	38,5	38	38	42
Capacities external	94-168	77-230	127-292	172-333
Capacities internal	116-200	85-238	136-300	168-329

DURO-NC



APPLICATION

Standard power chuck with through-hole for flexible use thanks to quick-action jaw change system.

TYPE

Power chuck available with cylindrical center mount.
3-jaw version.

CUSTOMER BENEFITS

- Universal: Jaws can be offset, exchanged or turned
- For high speeds thanks to lightweight jaws
- High clamping precision and clamping force thanks to proven wedge hook system
- Possible to use jaw units of the DURO manual clamping chuck

TECHNICAL FEATURES

- Central locking of the quick-action jaw change system
- Power transmission by means of wedge hook system
- Base jaws angle-serrated

Note:
1) Included in the scope of delivery: Chuck, chuck and jaw mounting screws, base jaws, safety wrench, mounting wrench.
2) The safety key can only be pulled out once the jaws are locked. This setup in combination with the key switch integrated in the machine also prevents the machine spindle from starting up unintentionally when the jaws are unlocked.

Gripping force / speed diagrams

The loss of gripping force was determined experimentally on a chuck with matched UB top jaws. It is largely independent of the initial gripping force at zero speed.

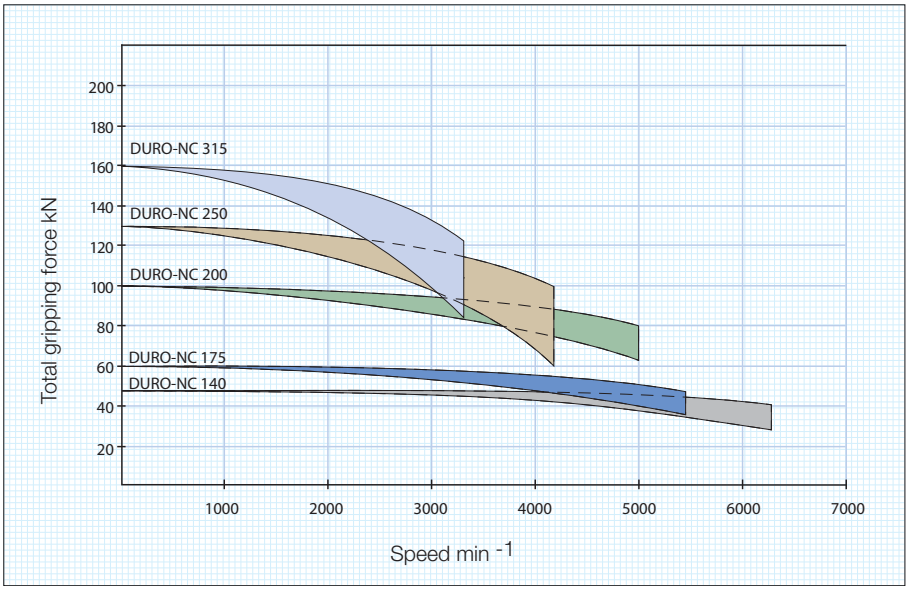
Upper curve:
min. centrifugal force of top jaw

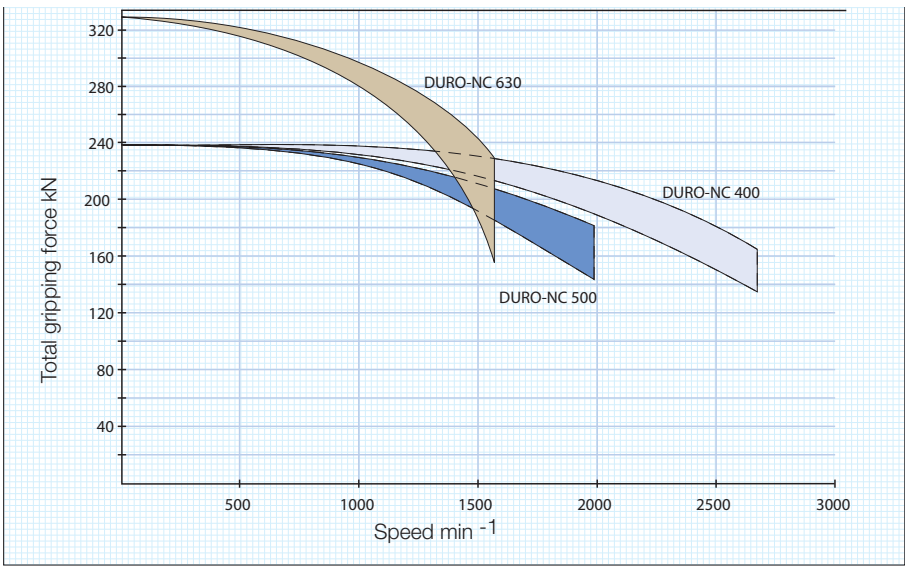


Lower curve:
max. centrifugal force of top jaw



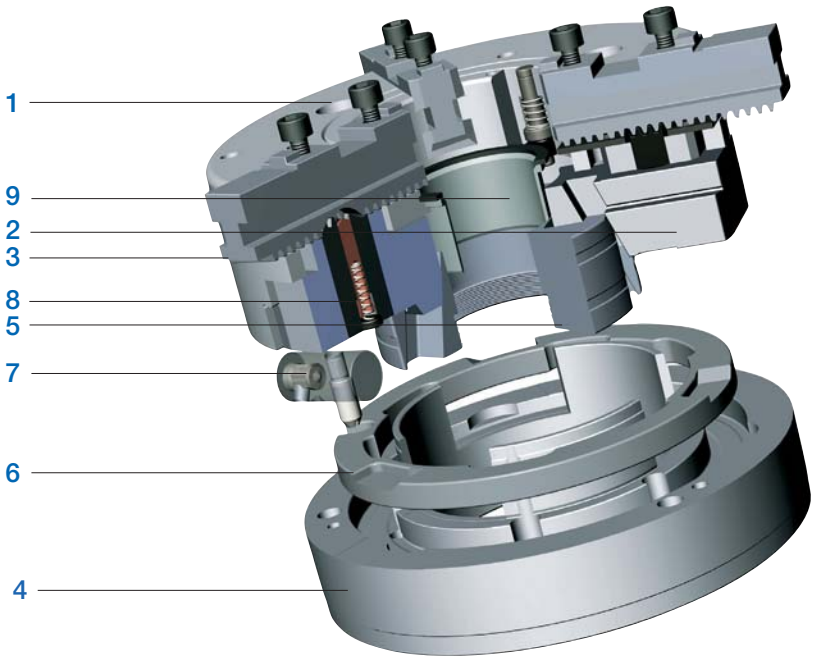
To obtain the specified gripping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM.
Measuring point near chuck face.





▲ on request

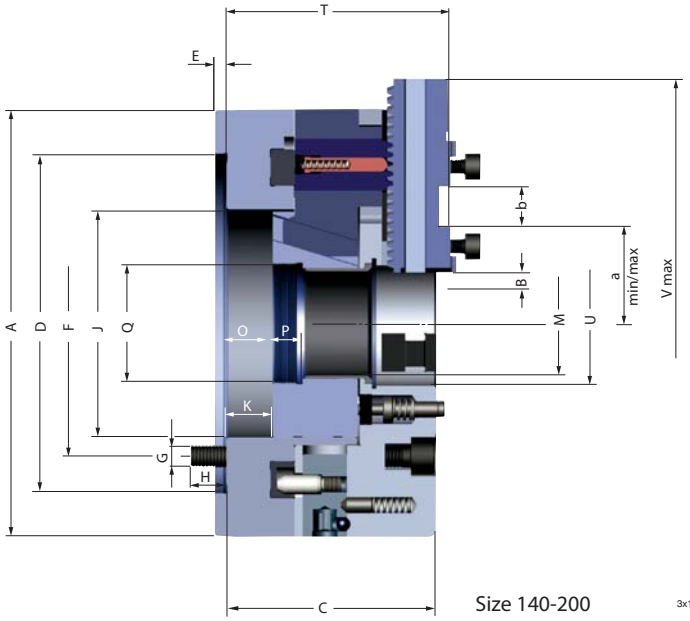
Structure DURO-NC



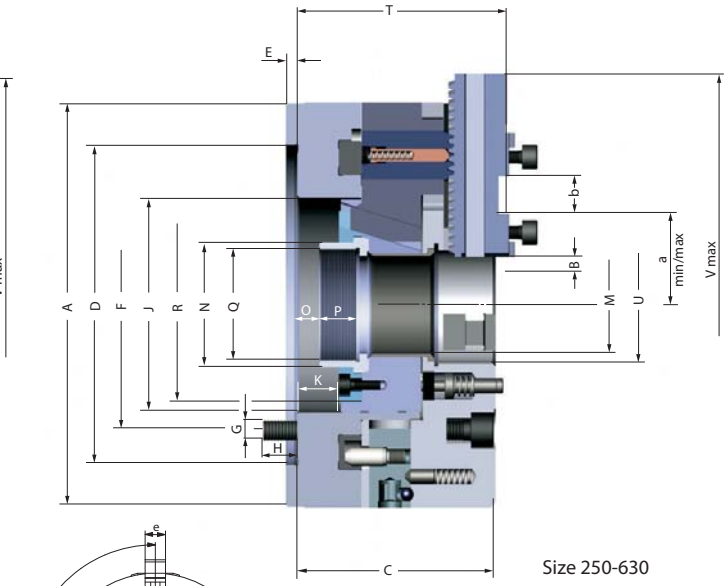
Components:

1. Body
2. Guide jaw
3. Base jaw
4. Adaptor plate
5. Piston
6. Adjusting ring
7. Turnable bolt
8. Rack
9. Protective bush

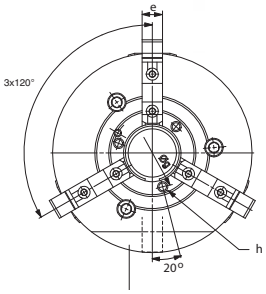
DURO-NC 3-jaw, central jaw unlocking, angle-serrated



Size 140-200



Size 250-630



C 15

3-jaws power chuck DURO-NC, with quick jaw change systems, central jaw unlocking, angle-serrated

Adaptor recess, mounting dimensions to DIN 6353

Item no.	159455	159456	159457	159458	159459	159460	159461 ▲	159462 ▲
Size	140	175	200	250	315	400	500	630
A mm	145	175	215	260	320	400	500	630
Jaw travel B mm	4,9	6,7	7	8,25	10,1	11,5	11,5	11,5
C mm	83	99	105	126	152	149	149	169
Mount DH6	120	140	170	220	300	380	380	380
E mm	6	6	6	6	6	6	6	6
F mm	104,8	104,8	133,4	171,4	235	330,2	330,2	330,2
G mm	3 x M 10	3 x M 10	3 x M 12	3 x M 16	3 x M 20	3 x M 24	3 x M 24	6 x M 24
H mm	18	15	18	21	29	35	35	36
J mm	80	88	114	147	173	210	210	286
Wedge stroke K mm	16	22	23	27	33	46	46	46
M mm	35	43	52	72	91	108	108	140
N mm	-	-	-	-	-	124	124	160
O min.	0,5	0	0	0	0	-61	-61	-41
O max.	16,5	22	23	27	33	-15	-15	5
P mm	9	10	15	15	19	35	35	25
Q mm	M 45 x 1,5	M 50 x 1,5	M 60 x 1,5	M 80 x 1,5	M 100 x 2	M 115 x 2	M 115 x 2	M 148 x 2
R mm	-	-	-	130	160	169	169	219
T mm	89	105	112	134	160,6	158,6	158,6	185
U mm	40	50	62	81	103	120	120	192
V max. mm	181	236	294	351	423	523	570	771
a min.	31,4	33,2	35,5	42,8	52,3	67,1	73,5	86,8
a max.	53,2	62,3	79,5	91,1	115,7	135,5	159	206,1
b mm	18	18	20	20	26	30	30	40
e mm	18	20	22	26	32	45	45	65
Ø g	54	64	76	93	120	140	140	210
h	M 5 x 8	M 6 x 10	M 6 x 10	M 6 x 10	M 6 x 10	M 8 x 12	M 8 x 12	M 8 x 12
Maximum draw bar pull kN	25	30	50	65	80	110	110	150
Max. total clamping force approx. kN	49	60	100	130	160	240	240	330
Max. admissible speed min^{-1}	6300	5300	5000	4300	3200	2700	2000	1500
Moment of inertia J kgm2	0,029	0,068	0,162	0,39	1,08	2,5	5	15,4
Weight without jaws approx. kg	11	18	28	46	85	126	185	310
Actuating cylinders (recommended)	**OVS-105 / SZS-37/70**	**OVS-105 / SZS-46/103**	**OVS-130 / SZS-52/130**	**OVS-150 / SZS-67/150**	**OVS-150 / SZS-92/225**	**OVS-200 / SZS-110/230**	**OVS-200 / SZS-110/250**	**OVS-200 / SZS-127/325**

▲ on request

Jaws DURO-NC

A28
Base jaw GB, 3-jaw set diagonally toothing, with mounting bolts



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw width mm
140636	140	3	set	56	18
094004	175	3	set	74	20
094005	200	3	set	90	22
094006	250	3	set	110	26
094007	315	3	set	125	32
094044	400/500	3	set	160	45
140194	630	3	set	230	65

A28
Unstepped top jaw AB, 3-jaw set standard design, soft, material 16MnCr5



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
094008	140/175	3	set	85	36,5	20,3
094009	200	3	set	105	40	22
094010	250	3	set	125	50	30,4
094011	315	3	set	145	50	34,3
094046	400/500	3	set	180	73	50,5
140716	630	3	set	260	102	68

A28
Reversible top jaw UB, 3-jaw set hardened



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
094012	140/175	3	set	61,5	32,5	20,4
094013	200	3	set	70,5	38	24,4
094014	250	3	set	92	50	34,4
094015	315	3	set	107	56	35,7
094045	400/500	3	set	130	72	50,4
140715	630	3	set	185	102	68

Additionally or later applied, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A28
Unstepped Jaw BL, 3-jaw set diagonally toothing, unstepped, soft, material 16MnCr5



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
626158	140	3	set	70,5	41,5	18
241699	175	3	set	84,4	45	20
249678	200	3	set	98,4	60	22
249679	250	3	set	118,7	70	26
249680	315	3	set	136,6	79	32
249681	400/500	3	set	173,6	93	45

A28
One-piece jaw EB, 3-jaw set diagonally toothing, hardened



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
140764	140	3	set	62	49,5	18
094000	175	3	set	77,7	45	20
094001	200	3	set	94,7	60	22
094002	250	3	set	114	70	26
094003	315	3	set	130	79	32
094043	400/500	3	set	167	93	45

Additionally or later applied, hardened stepped jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

Configure your individual clamping jaws online! www.web2product.biz

Jaws DURO-NC

C 21
Reversible claw-type top jaws, standard design tongue and groove, small clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137060	140/175	66	37,5	24
137119	400/500	124	62	50
151289	630	144	78	70

C 21
Reversible claw-type top jaws, standard design tongue and groove, large clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137061	140/175	66	37,5	20
137064	200	81	43	24
137108	250	90	55	34
137114	315	100	62	34
137120	400/500	124	62	50

C 21
Reversible claw-type top jaws, standard design tongue and groove, medium clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137062	140/175	56	37,5	20
137065	200	66	43	24
137109	250	72	55	34
137115	315	86	62	34
137121	400/500	100	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, small clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137066	200	79	43	34
137110	250	80	55	50
137116	315	93	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, large clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137067	200	81	43	34
137111	250	90	55	50
137117	315	106	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, medium clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137068	200	66	43	34
137112	250	72	55	50
137118	315	86	62	50

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Jaws DURO-NC

C 21
Draw-down jaws, without clamping inserts diagonally toothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
151030 ▲	140	63	41,5	18
141037	175	84,4	43,5	20
141039	200	98,4	47,5	22
141041	250	118,7	58,5	26
141043	315	136,4	63,9	32
141045	400/500	173,6	73,4	45

C 21
Draw-down jaws, additional clamping range, for interchangeable clamping inserts diagonally toothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
151031 ▲	140	63	41,5	18
141038	175	84,4	43,5	20
141040	200	98,4	47,5	22
141042	250	118,7	58,5	26
141044	315	136,4	63,9	32
141046	400	173,6	73,4	45
141048	500	173,6	73,4	45

C 15
Interchangeable clamping inserts, 1 piece with claws



Item no.	Chuck Size
151029	140
141049	180/215
141052	260/315/400
141055	500

C 15
Interchangeable clamping inserts, 1 piece with serrated toothing



Item no.	Chuck Size
151039	140
141050	180/215
141053	260/315/400
141056	500

C 15
Interchangeable clamping inserts, 1 piece with heat treatable surface



Item no.	Chuck Size
151040	140
141051	180/215
141054	260/315/400
141057	500

Configure your individual clamping jaws online! www.web2product.biz

Accessories DURO-NC

C 15

Mounting screws



Item no.	Size	Contents of delivery	Thread
200182	140/175/200	piece	M8x1x22
200183	250	piece	M12x1,5x30
202402	315	piece	M12x1,5x35
227618	400/500	piece	M16x1,5x40
249388	630	piece	M20x50

Socket head cap screw to DIN 912, 12.9

C 15

Special grease F80 for lathe chucks

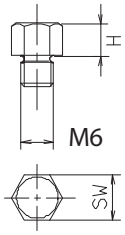
for lubrication and conservation of clamping force



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

C 15

Changeable workpiece rests (in different lengths)



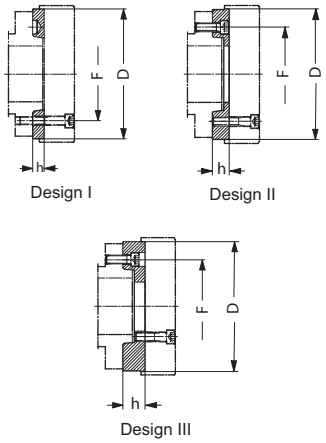
Item no.	H mm	M	Key-width SW
289188	5	M6	9
138950	10	M6	9
725581	15	M6	9

C 15

Intermediate adaptor plates with cylindrical centre mount **DIN 6353 for three-jaw chucks**

Mounting from front to **ISO 702-1 (DIN 55026/55021) and ASA B 5.9 A1/A2** with metric mounting bolts



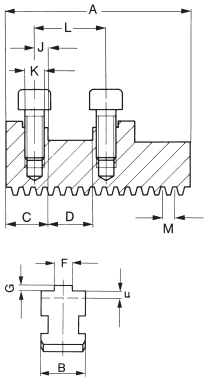


Item no.	Spindle nose size	Size	Design	h mm	F mm	D mm
159878	5	140	I	15	104,8	120
145153	5	175	I	15	104,8	140
145297	6	175	III	35	133,4	140
145155	6	200	I	16	133,4	170
145131	6	250	II	27	133,4	220
145135	8	200	III	39	171,4	170
145157	8	250	I	18	171,4	220
145139	8	315	II	38	171,4	300
145143	11	250	III	48	235	220
145159	11	315	I	19	235	300
145147	11	400	II	40	235	380
145161	15	400/500/630	I	21	330,2	380

All fastening parts are included

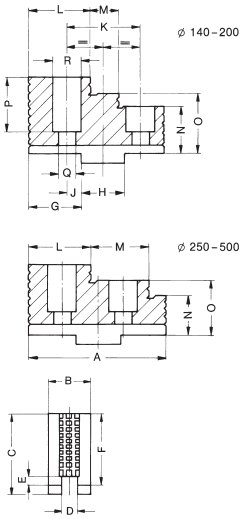
Jaw dimensions DURO-NC

Base jaw GB with screws



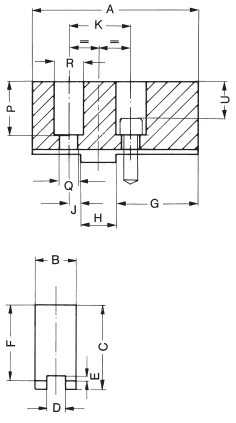
Chuck size	140	175	200	250	315	400/500	630
Type	503-80	002-20	002-25	002-30	002-35	002-40	002-50
Item no. 3-jaw	**140636**	**094004**	**094005**	**094006**	**094007**	**094044**	**140194**
A	56	74	90	110	125	160	230
B	18	20	22	26	32	45	65
C	19	19	23	26	30	35	52
D^{H6}	18	18	20	20	26	30	40
E	5	5	5,5	5,5	6,5	7,5	9
F	8	8	10	12	12	18	24
G	2,5	2,5	3	3	3	4	4
J	7	7	10	10	14	15	21
K	M8x1	M8x1	M8x1	M12x1,5	M12x1,5	M16x1,5	M20
L	32	32	40	40	54	60	82
M	3,63	4,84	4,89	6,03	7,05	8,55	8,53
Weight/set kg	0,43	0,8	1,1	2,1	3,2	7	17

Reversible top jaws UB, hardened



Chuck size	140/175	200	250	315	400/500	630
Type	003-20	003-25	003-30	003-35	003-40	003-50
Item no. 3-jaw	**094012**	**094013**	**094014**	**094015**	**094045**	**140715**
A	61,5	70,35	92	107	130	185
B	20,4	24,4	34,4	37,5	50,4	68
C	37	43	55	62	79	110
D	8	10	12	12	18	24
E	3	3,5	3,5	3,5	4,5	4,5
F	32,5	38	50	56	72	102
G	22,5	25,5	30	35,5	41,4	59
H	18	20	20	26	30	40
J	7	10	10	14	15	21
K	32	40	40	54	60	82
L	26,5	28,5	41	40	51	80
M	13	14	40,5	54	71	80
N	17,5	18	22	26	32	42
O	25	28	36	41	52	72
P	23,5	29	39	40	57	82
Q	9	9	14	14	18	22
R	15	15	20	20	26	33
Weight/set kg	0,6	1,0	2,4	3,4	7,6	19

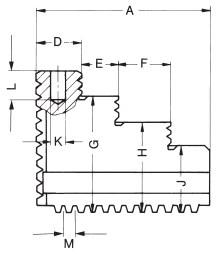
Soft top jaws AB, material 16MnCr5

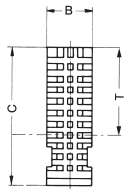


Chuck size	140/175	200	250	315	400/500	630
Type	002-20	002-25	002-30	002-35	002-40	002-50
Item no. 3-jaw	**094008**	**094009**	**094010**	**094011**	**094046**	**140716**
A	85	105	125	145	180	260
B	20,3	22	30,4	34,3	50,5	68
C	41	45	55	56	80	110
D	8	10	12	12	18	24
E	3	3,5	3,5	3,5	4,5	4,5
F	36,5	40	50	50	73	102
G	42	50	70	74	100	150
H	18	20	20	26	30	40
J	7	10	10	14	15	21
K	32	40	40	54	60	82
P	27,5	31	39	34	58	83
Q	9	9	14	14	18	22
R	15	15	20	20	26	33
U	19,5	23	27	22	42	63
Weight/set kg	1,3	2,2	4,5	6,8	13,5	40

Jaw dimensions DURO-NC

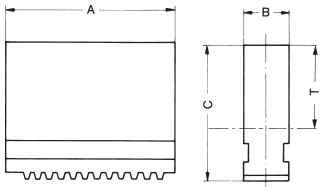
One-piece reversible jaws EB





Chuck size	140	175	200	250	315	400/500
Type	503-80	000-20	000-25	000-30	000-35	000-40
Item no. 3-jaw	**140764**	**094000**	**094001**	**094002**	**094003**	**0940043**
A	62	77,7	94,7	114	130	167
B	18	20	22	26	32	45
C	49,5	45	60	70	79	93
D	16,6	20,6	23	41,5	40,2	50,6
E	15,9	18,9	19,5	40,3	54	71
F	18	22	28	-	-	-
G	42	37,5	50	56	64	73
H	34,5	30	40	-	-	-
J	27	22,5	30	42	49	53
K	7	8	10	13	13	20
L	16	16	15	19,5	19,5	30
M	3,63	4,84	4,89	6,03	7,05	8,55
T	29	24	35	41	44,5	54
Weight/set kg	1,2	1,5	1,9	3,4	5,5	11

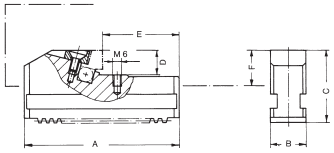
Soft one-piece jaws BL, material 16MnCr5

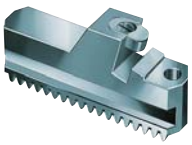


Chuck size	140	175	200	250	315	400/500
Type	503-80	000-20	000-25	000-30	000-35	000-40
Item no. 3-jaw	**626158**	**241699**	**249678**	**249679**	**249680**	**249681**
A	70,5	84,5	98,4	118,7	136,6	173,6
B	18	20	22	26	32	45
C	41,5	45	60	70	79	93
T	21	24	35	41	44,5	54
Weight/set kg	1,3	1,5	2,7	4,4	7,2	15

Draw-down jaws NB for interchangeable clamping inserts (jaw without insert)

Chuck front side



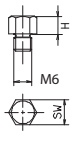


Chuck size	140	175	200	250	315	400	500
Type	545-00	545-00	545-00	545-00	545-00	545-00	545-00
Item no. Piece	**151030**	**141037**	**141039**	**141041**	**141043**	**141045**	**141045**
A	63	84,4	98,4	118,7	136,4	173,6	173,6
B	18	20	22	26	32	45	45
C	41,5	43,5	47,5	58,5	63,9	73,4	73,4
D	15	15	15	20	20	25	25
E	10,5	11	12	12	12	12	12
F	22,5	22,5	22,5	29,5	29,5	34,3	34,3
Capacities external	40-85	29-80	34-112	38-133	43-170	48-185	48-250
Capacities internal	124-168	162-205	190-263	235-325	275-398	360-490	354-556

Draw-down jaws NB for interchangeable clamping inserts (jaw without insert)

Jaws for further clamping ranges

Accessories: Changeable workpiece rests (in different lengths)



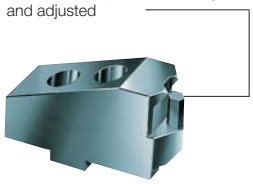
	2		
Item no.	289188	138950	725581
M	M6		
H	5	10	15
SW	9		

Chuck size	140	175	200	250	315	400	500
Type	545-00	545-00	545-00	545-00	545-00	545-00	545-00
Item no. Piece	**151031**	**141038**	**141040**	**141042**	**141044**	**141046**	**141048**
E	31,5	32	48	58	72	77	110
Capacities external	80-125	70-120	104-185	128-225	160-290	175-316	240-450
Capacities internal	85-126	120-164	120-192	145-236	158-278	230-362	162-360

Jaw dimensions DURO-NC

Reversible claw-type top jaws KB, Standard design

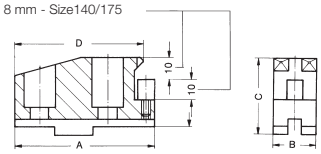
Workpiece stop, can be changed and adjusted



Chuck size	140	175	400	500	630
Jaw design	Type 544-00 Standard design				
Item no. Piece	**137060**		**137119**		**151289**
A	66		124		144
B	24		50		70
C	37,5		62		78
D	17		39		61
Capacities external	115-158	115-209	-	-	230-655
Capacities internal	50-84	50-136	100-350	100-410	185-610

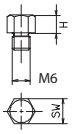
Jaws for further clamping ranges

8 mm - Size140/175



Chuck size	140	175	200	250	315	400	500
Jaw design	Type 544-00 Standard design						
Item no. Piece	**137061**		**137064**	**137108**	**137114**	**137120**	
A	66		81	90	100	124	
B	20		24	34	34	50	
C	37,5		43	55	62	62	
D	61		71	78	90	112	
Capacities external	24-60	24-110	40-130	50-185	50-222	50-270	50-335
Capacities internal	142-182	142-236	166-288	180-350	212-410	280-515	280-580

Accessories: Changeable workpiece rests (in different lengths)

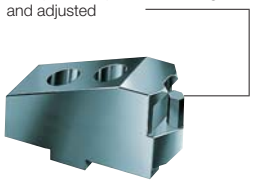


Item no.	289188	138950	725581
M	M6		
H	5	10	15
SW	9		

Chuck size	140	175	200	250	315	400	500
Jaw design	Type 544-00 Standard design						
Item no. Piece	**137062**		**137065**	**137109**	**137115**	**137121**	
A	56		66	72	86	100	
B	20		24	34	34	50	
C	37,5		43	55	62	62	
D	29		38,5	38	42	48	
Capacities external	74-118	47-170	76-200	94-260	120-320	165-400	165-465
Capacities internal	80-130	80-176	98-224	104-272	116-315	155-395	155-455

Reversible claw-type top jaws KB, large design

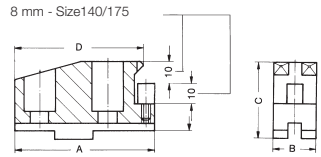
Workpiece stop, can be changed and adjusted



Chuck size	200	250	315
Jaw design	Type 544-05 Large design		
Item no. Piece	**137066**	**137110**	**137116**
A	79	80	93
B	34	50	50
C	43	55	62
D	29,5	29	30
Capacities external	-	-	-
Capacities internal	72-185	70-235	80-275

Jaws for further clamping ranges

8 mm - Size140/175

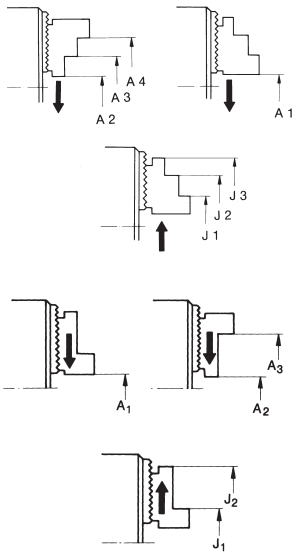


Chuck size	200	250	315
Jaw design	Type 544-05 Large design		
Item no. Piece	**137067**	**137111**	**137117**
A	81	90	100
B	34	50	50
C	43	55	62
D	71	78	90
Capacities external	40-130	50-185	50-222
Capacities internal	166-288	180-350	212-410

Chuck size	200	250	315
Jaw design	Type 544-05 Large design		
Item no. Piece	**137068**	**137112**	**137118**
A	66	72	86
B	34	50	50
C	43	55	62
D	38,5	38	42
Capacities external	76-200	94-260	120-320
Capacities internal	98-224	104-272	116-315

Chucking capacities DURO-NC

Chucking capacities with reversible top jaws UB

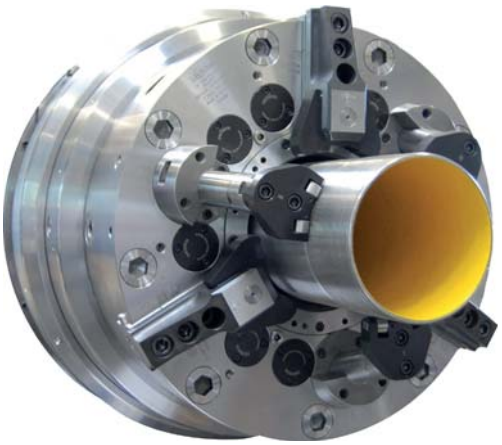


Chuck size		140	160	175	200	250	315	400	500	630
with reversible jaws	Type	003-20	003-20	003-20	003-25	003-30	003-35	003-40	003-40	003-50
	Jaw position									
External chucking	A1	10-58	5-51	5-60	5-65	8-93	30-125	55-156	45-230	42-468
	A2	14-62	45-94	45-103	58-118	-	-	-	-	-
	A3	57-105	89-138	89-147	114-174	82-168	93-210	119-260	122-326	112-487
	A4	89-131	115-164	115-173	142-202	163-249	201-317	260-401	264-470	275-650
Internal chucking	J1	65-112	67-108	67-117	71-126	99-178	120-207	155-260	155-460	195-615
	J2	91-138	93-135	93-144	99-154	178-257	207-313	260-400	265-600	355-780
	J3	133-182	135-177	135-186	154-209	-	-	-	-	-

Notes

CLAMPING TECHNOLOGY FOR THE ENERGY SECTOR

The crude oil and natural gas industries are still the center of the worldwide energy production today. The extraction and further processing of these two raw materials require top precision and maximum safety. Technically advanced products, such as the air-operated self-contained chucks from RÖHM, allow reliable machining of a wide range of workpieces at the top safety standard.



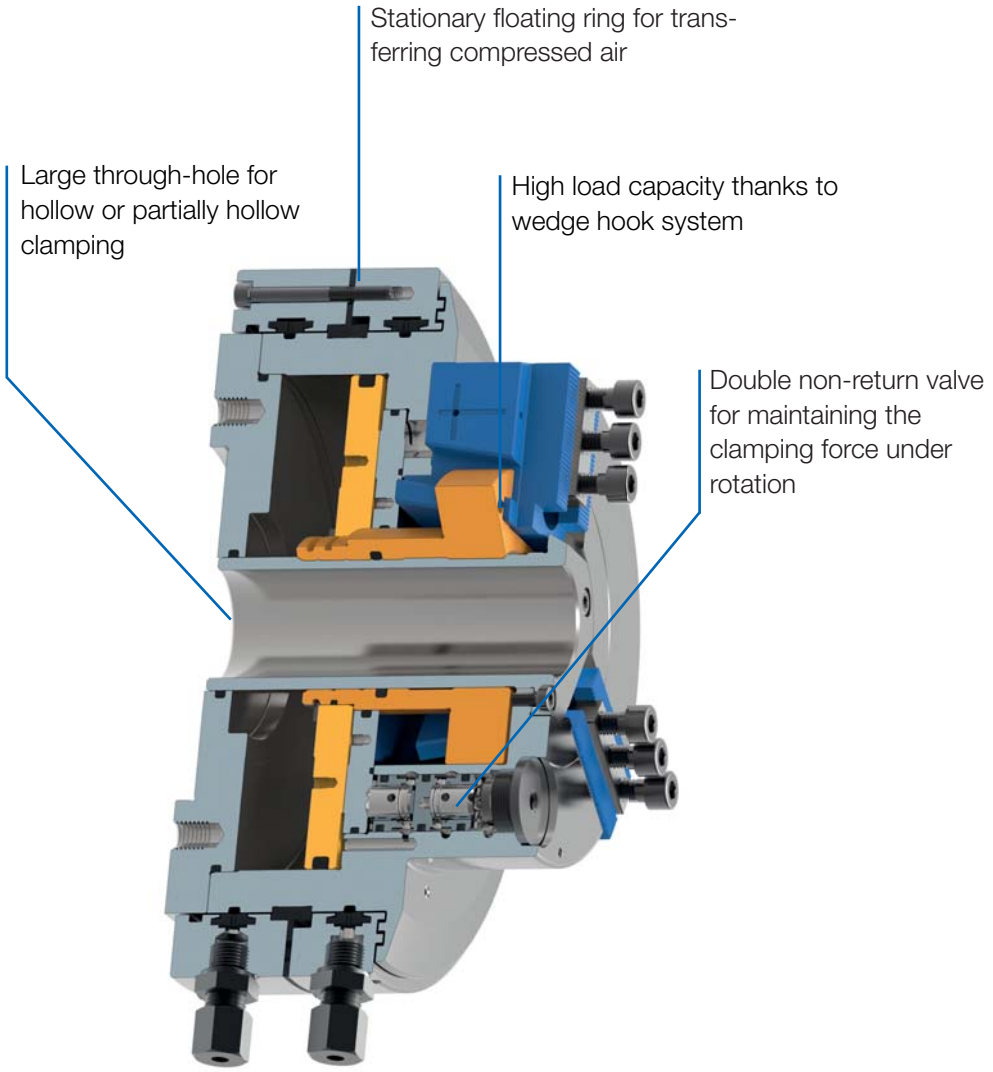
Video LVE

AIR-OPERATED SELF-CONTAINED CHUCKS

Air-operated self-contained chucks LVE are optimally suited for machining the ends of pipes, especially large and long pipes like the ones used for extracting crude oil or natural gas. For this, a chuck is mounted to the front and rear sides of the machine spindle. This combination allows large chip-cutting performance with high workpiece precision.

ADVANTAGES AT A GLANCE

- Large through-hole optimal for machining pipes and bars
- Cylinders integrated in the power chuck for flexible range of applications
- Wedge hook system for high load capacity and clamping precision



LVE



APPLICATION

Optimally suited for flange, bar and tube machining, especially for machines without a clamping cylinder.

TYPE

Power chuck with integrated pneumatic cylinder and cylindrical center mount.
3-jaw version with serration (90°).

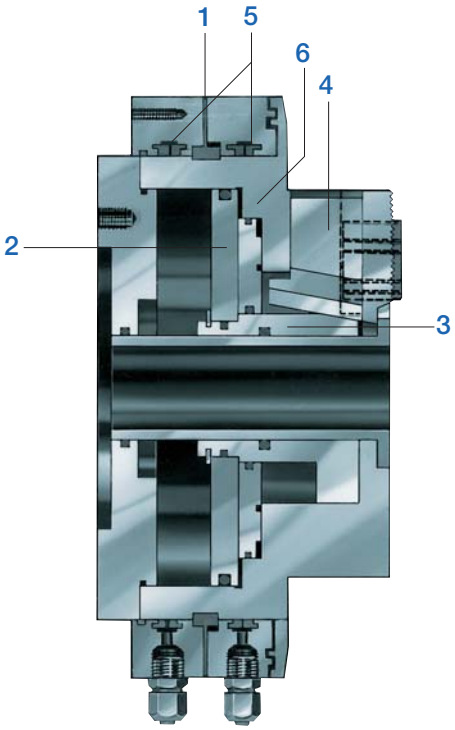
CUSTOMER BENEFITS

- Large through-hole
- Can be easily exchanged with manual clamping chuck
- Compact system dimensions because it is self-contained
- Unobstructed bore through spindle thanks to omission of the draw tube
- High clamping force already at 6 bar

TECHNICAL FEATURES

- Clamping and unclamping only when spindle at standstill
- Wedge hook system with integrated clamping cylinder

Included in scope of delivery:
Chuck, chuck and jaw mounting screws, slot nuts (without top jaws)



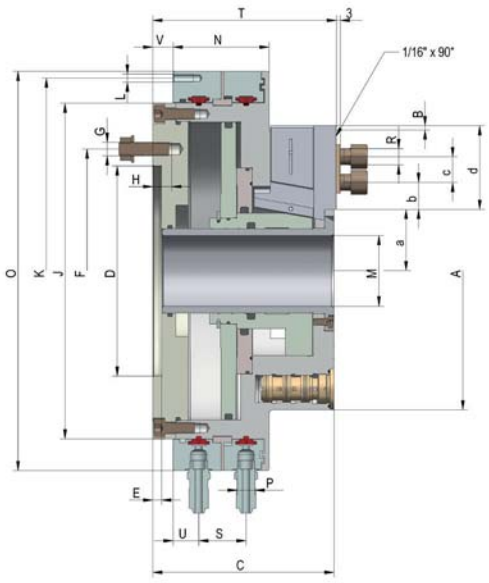
Components:

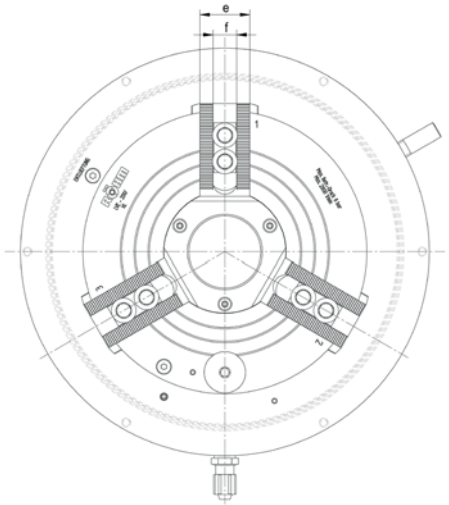
1. Floating ring
2. Pressure piston
3. Wedge system
4. Base jaws
5. Special seals
6. Body

Mode of operation:

The compressed air is conducted through the stationary floating ring **1** via a double non-return valve into one of the two pressure chambers. The force acting on the pressure piston **2** is transferred through the clamping piston to the base jaws **4** via the proven wedge hook system **3**. During the clamping and unclamping operation, profile seals **5** seal off the floating ring **1** from the body **6**. After the clamping operation is finished, the pressure in the chuck body is maintained by the valve, whereby the supply lines are depressurized.The profile seals lift up due to their elasticity and are not damaged by the rotating chuck body.

LVE up to 10 bar, cylindrical centre Mount, serration 90°





C 15

3-jaw self-contained chucks LVE, with through-hole, max. operating pressure 8 bar, with serration cylindrical centre mount

Item no.	420189	420190	420191	420192	420193
Size	125	160	200	250	315
A mm	136	168	205	255	320
Jaw travel B mm	3	4,2	4,2	5	5
C mm	101,5	130,5	134	146	156,5
DH6 mm	120	125	155	185	225
E mm	6	6,5	6,5	6,5	6,5
F mm	137	150	180	210	250
G	M 8	M 10	M 10	M 10	M 10
H mm	8	13	14	14	14
J mm	164	205	248	315	350
K mm	190	235	285	358	388
L	M 6	M 6	M 6	M 6	M 16
M mm	26	38	52	68	90
N mm	66,5	80,5	71	78,5	79,5
O mm	204	250	295	370	400
P mm	R 1/4“	R 1/4“	R 1/4“	R 1/4“	R 1/4“
R	M 8	M 8	M 12	M 16	M 6
S mm	32	41	35	37	36
T mm	103	131,5	134	147,5	158
U mm	20	20,7	19	19	18
V mm	-	4	15	15,5	25
a min.	24	31,8	41,2	50	61,5
a max.	27	36	45,4	55	66,5
b min.	10	10	13	15	14,5
b max.	21	19,5	35	43	64
c mm	min. 14 / max. 25	2 x 15	19	25	25
d mm	41	49,5	62	78	99
e mm	25	32	36	44	44
fH7 mm	12	12	17	21	21
Max. operating pressure bar	8	8	8	8	8
Min. operating pressure bar	2	2,5	2,5	2,5	2,5
Total clamping force at 6 bar kN	20	35	60	95	120
Max. admissible speed min-1	4000	3500	2800	2200	1800
Moment of inertia J kgm2	0,028	0,125	0,262	0,675	1,35
Air consumption/jaw travel at 6 bar NL	1,5	3,6	6,1	9,9	12,3
Weight without jaws approx. kg	13	25	36	57	85

Higher speeds by fastening the stationary floating ring
LVE chuck with short taper mount ISO 702-3 (DIN 55027, studs and locknuts) on request
LVE chuck with short taper mount ISO 702-2 (DIN55029, studs for Camlock) on request

Jaws LVE

C 21
Reversible top jaws, 3-jaw set, hardened serration 90° - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
046404	125/160	56	37,5	26	1/16“x 90°
118522	200	75	49	36	1/16“x 90°
046414	250/315	103,5	58	50	1/16“x 90°

Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21
Soft top jaws, 3-jaw set, can be hardened serration 90° - material: 16 MnCr 5

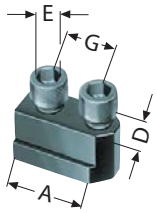


Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
046403	125/160	55	38	26,5	1/16“x 90°
133153	200	75	53	36,5	1/16“x 90°
133154	250/315	95	54,5	45	1/16“x 90°

Accessories LVE

C 15

Extended T-nuts
With screw



Item no.	Chuck Size	Con-tents of delivery	D mm	E	G mm
241673 [1]	125	piece	12	M8x20	-
1305178	160	piece	12	M8x25	2x15
1305179	200	piece	17	M12x30	19
1305180	250/315	piece	21	M16x35	25

[1] Simple slot nut

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Accessories LVE

C 15
Electro-pneumatic safety control block for LVE 125-315



Item no.	voltage
437747	220 V 50 Hz
437748	24 V Dc

Please order accessories and connection hoses separately

C 15
Manual pulse generator, without cable



Item no.	Contents of delivery
220629 ▲	piece

C 15
Double foot-control switch



Item no.	Contents of delivery
249325 ▲	piece

C 15
Service unit



Item no.	Contents of delivery
367444[1] ▲	piece

[1] Consisting of filter, water separator and oiler, R 3/8“

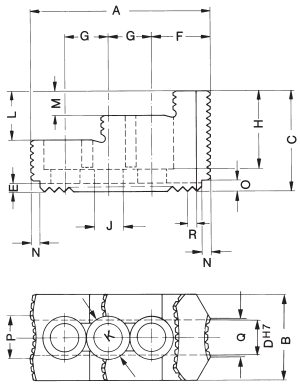
C 15
Connector



Item no.	Chuck Size	Design	Contents of delivery
720233	125-200	snap-on connector CX-R 1/4“-PX-6	piece
720235	125-200	swivel connector LCX-R 1/4“-PX-6	piece
720260	250-315	straight screw-in unions Ø 12/9 R 1/4“	piece
720261	250-315	swivel connector Ø 12/9 R 1/4“	piece

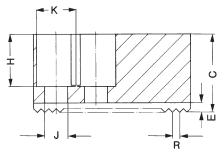
Jaw dimensions und Chucking capacities LVE

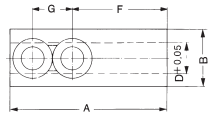
Reversible top jaws UB,
hardened, serration 90°,
material 16MnCr5

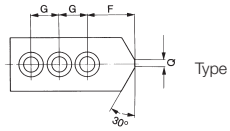


Chuck size	125	160	200	250	315
Type	538-02	538-02	538-04	538-05	538-05
Item no. 3-jaw	**046404**	**046404**	**118522**	**046414**	**046414**
A	56	56	75	103,5	103,5
B	26	26	36	50	50
C	37,5	37,5	49	58	58
D^{H7}	12	12	17	21	21
E	3,5	3,5	5	5	5
F	14	14	21,5	33,5	33,5
G	15	15	19	25	25
H	29	29	37,5	45	45
J	8,4	8,4	13	17	17
K	13,5	13,5	19	25	25
L	20	20	24	28	28
M	10	10	12	14	14
N	4	4	6	6	6
O	4	4	7,5	6,5	6,5
P	5	5	18	24,5	24,5
Q	5	5	7	22,5	22,5
R	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°
Weight/jaw kg	0,170	0,170	0,460	1,130	1,130

Soft top jaws AB,
material 16MnCr5



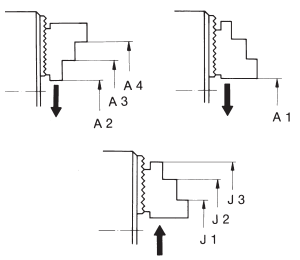




Type 537-02

Chuck size	125	160	200	250	250
Type	538-02	538-02	538-04	538-05	538-05
Item no. 3-jaw	**046403**	**046403**	**133153**	**133154**	**133154**
A	55	55	75	95	95
B	26,5	26,5	36,5	45	45
C	38	38	53	54,5	54,5
D^{H7}	12	12	17	21	21
E	3,5	3,5	5	5	5
F	31	31	44	55	55
G	15	15	19	25	25
H	28	28	43	42,5	42,5
J	8,4	8,4	13	17	17
K	13,5	13,5	19	25	25
R	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°
Weight/jaw kg	0,320	0,320	0,880	1,400	1,400

Chucking capacities with reversible top jaws UB



Chuck size		125	160	200	250	315
with reversible jaws	Type	538-02	538-02	538-04	538-05	538-05
	Jaw position					
External chucking	A1	12-63	28-80	30-115	20-128	41-194
	A2	17-69	32-84	44-128	46-154	67-220
	A3	67-119	82-132	101-185	128-238	150-303
	A4	101-153	118-168	152-236	210-318	231-384
Internal chucking	J1	49-99	64-116	80-165	70-188	91-244
	J2	81-131	96-148	130-214	146-255	168-320
	J3	125-175	140-192	182-266	225-334	246-400

Notes

LVE - large through-hole



APPLICATION

Optimal for the end machining of large and long pipes, e.g. for the oil and gas industry (especially as front and rear chuck).

TYPE

Power chuck with integrated pneumatic cylinder and cylindrical center mount. 3-jaw version with serration (90°).

CUSTOMER BENEFITS

- Extra-large through-hole
- Can be easily exchanged with manual clamping chuck
- Compact system dimensions because it is self-contained
- Unobstructed bore through spindle thanks to omission of the draw tube

TECHNICAL FEATURES

- Clamping and unclamping only when spindle at standstill
- Wedge hook system with integrated clamping cylinder
- Control valves maintain the clamping pressure during machining
- Short clamping cycle thanks to rapid and clamping stoke (optionally)
- Permanent monitoring of the clamping pressure while machining (optionally)

Note:
Other versions on request: e.g. front-end chucks for compensating clamping

Possible application

Two chucks are mounted on the front and rear sides of the machine spindle. Via a selection switch on our electronic control unit DF type 525-90 combined with one pneumatic control unit LSV type 525-91 each, the two chucks can be used together or separately and also with different clamping pressures. This combinations make a high cutting capacity and high turning precision possible for the end machining of long pipes.

Air-operated self-contained chucks, sizes 400-1000

Characteristic for this chuck is a pneumatic piston integrated in the chuck body for generating the clamping force. To clamp or unclamp the workpiece, the compressed air is conducted to the pneumatic piston while the chuck is stationary via the distributor ring and non-return valve. The pneumatic piston is screwed to the clamping piston, with which, in turn, the base jaws are connected via a wedge hook system. An axial movement of the pneumatic piston therefore causes a radial movement of the base jaws.

Distributor ring

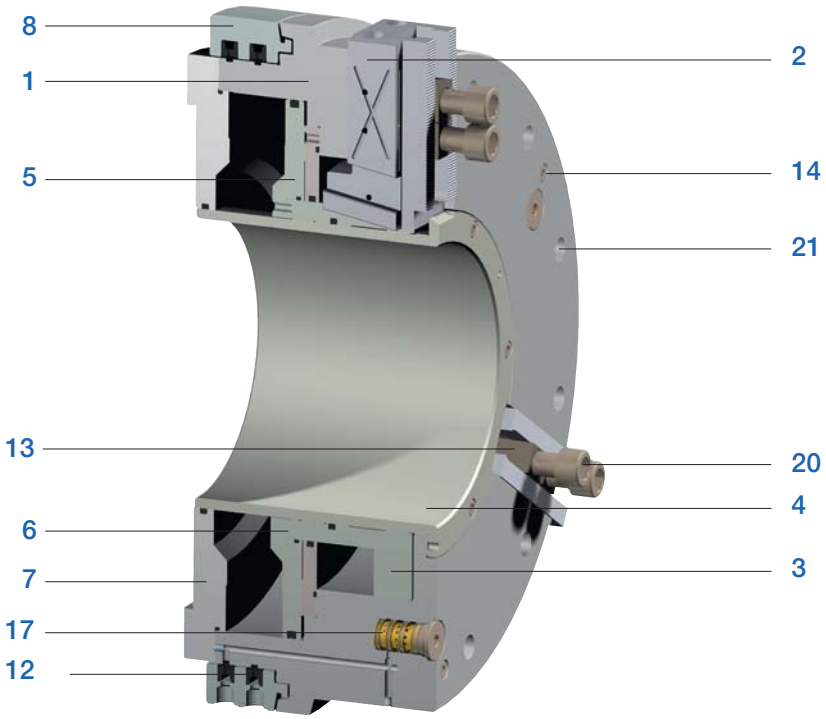
The distributor ring has the function of transferring compressed air from the outside into the chuck. This means that the distributor ring is always stationary, while the chuck rotates during workpiece machining. It is therefore mounted to the spindle box, and is therefore secured against rotating along. Special seals seal the gap between the distributor ring and chuck during the clamping operation so that the pressure can be transferred with no problems. Important: To prevent the sealing ring from being destroyed, the pressure may only be transferred when the chuck is at a standstill.

Control valve

The control valve has the job of securing the compressed air required for clamping in a closed system throughout machining. It automatically secures that piston side which is pressurized, whereby the compressed air of the opposite-lying piston side is unclamped automatically. The valve can be dismounted as a complete unit and is available as replacement unit.

▲ on request

LVE - large through-hole



Components LVE

1. Body
2. Base jaw
3. Piston
4. Protective bush
5. Intermediate washer
6. Piston plate
7. Flange
8. Distributor ring
12. Seal
13. T-nut
14. Air-vent screw
17. Control valve
20. Jaw fixing screws
21. Chuck fixing screws

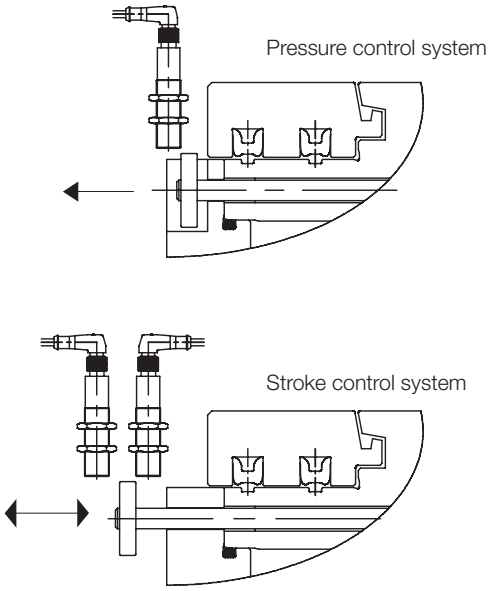
Control system
The clamping safety mainly depends on the leak-tightness of the closed pneumatic chamber. A pressure drop during machining causes a reduction in the clamping force.

The „**RÖHM control system**“ is used to control the pressure of the closed pneumatic chamber. If the pressure falls below a defined minimum level, a spring-loaded pin attached to the rear side of the chuck moves out to the rear.

At the same height as the pin, a contactless inductive probe is fastened at a certain radial distance. If the extended pin moves through the magnetic field of the probe, an electrical pulse is triggered, which can be used to shut the machine down.

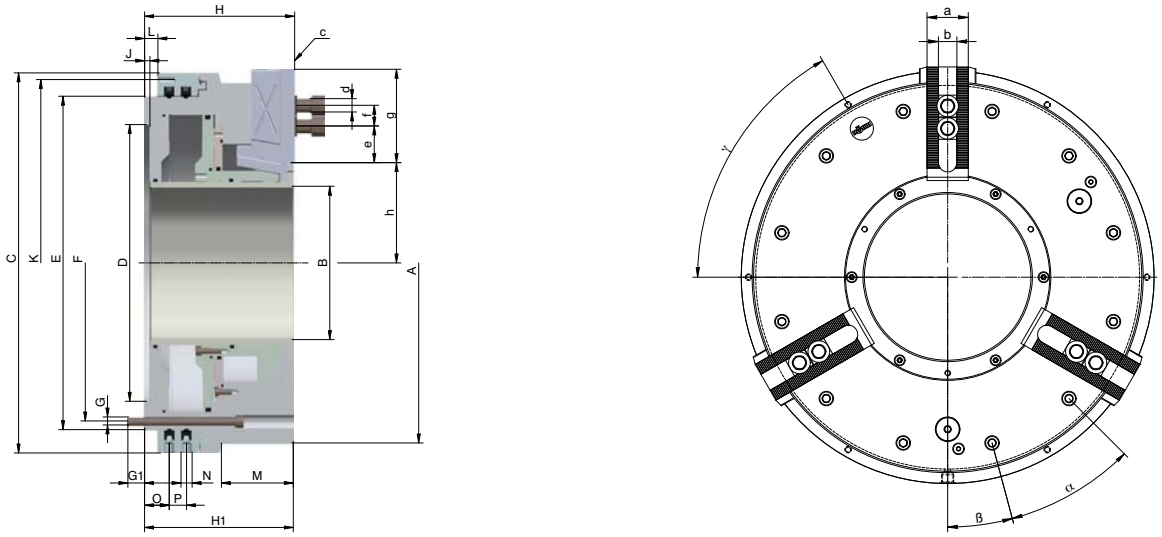
Wedge hook system
The axial piston force is transferred and transmitted into the radial jaw force via the proven wedge hooks. The large force transfer surfaces guarantee a long service life and a sustainably high clamping precision.These features apply both to the chuck with normal jaw stroke as well as to chucks with rapid and gripping jaw movements.

RÖHM-Control system



The control unit is designed for LVE chucks with rapid and clamping strokes only for external clamping.
For LVE chucks with a normal stroke only pressure control device for the external clamping is provided (on customer demand for internal clamping).

LVE - large through-hole, standard design



C 15

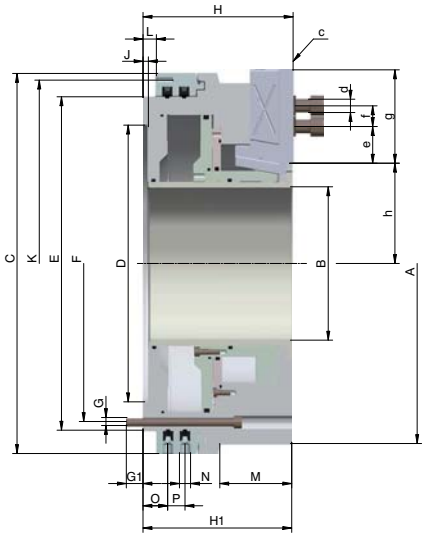
3-jaw self-contained chucks LVE, with large through-hole, max. operating pressure 8 bar, with serration

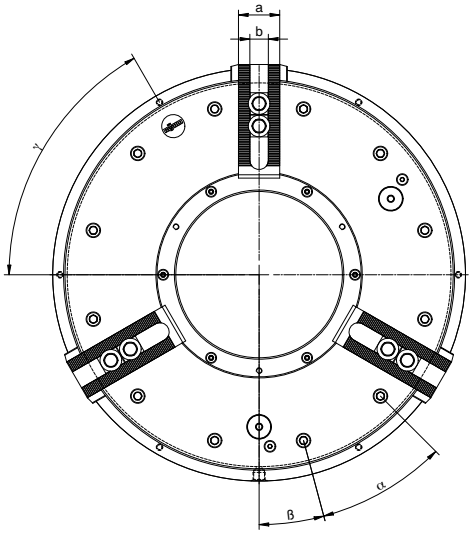
Cylindrical center mount (standard version)

Item no.	169400 ▲	169401 ▲	169402 ▲	169403 ▲	169404 ▲	169405 ▲	169406 ▲	169407 ▲	169409 ▲
Size	400	400	500	500	600	600	600	700	800
LVE	LVE 420-140	LVE 480-185	LVE 540-205	LVE 570-230	LVE 600-275	LVE 640-275	LVE 680-325	LVE 730-375	LVE 830-410
Jaw travel mm	7	8,5	8,5	8,5	8,5	10	10	10	12
A mm	425	480	540	570	605	640	685	735	835
B mm	140	185	205	230	280	275	325	375	410
C mm	470	530	570	570	605	685	685	735	850
DH6 mm	310	365	415	415	450	510	510	560	700
E mm	400	460	500	500	535	610	610	660	775
F mm	374	434	474	474	508	580	580	630	745
G	M12	M12	M12	M12	M12	M16	M16	M16	M16
G1 mm	25	25	25	25	25	30	30	30	30
H mm	196	225	225	225	225	263	263	263	305
H1 mm	194	223	223	223	223	261	261	261	303
J mm	8	8	8	8	8	8	8	8	8
K mm	448	510	550	550	585	666	666	716	830
L mm	20	20	20	20	20	20	20	20	25
M mm	70	90	100	-	-	110	-	-	155
N	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8
O mm	37	37	37	37	37	39,5	39,5	39,5	44,5
P mm	26	26	26	26	26	33	33	33	33
a mm	57	57	57	57	57	75	75	75	75
bH7 mm	25,5	25,5	25,5	25,5	25,5	30	30	30	30
c	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°
d	M20x50	M20x50	M20x50	M20x50	M20x50	M24x65	M24x65	M24x65	M24x65
e mm	20	20	20	20	20	28	28	28	28
f min.	32	32	32	32	32	42	42	42	42
f max.	85	85	105	105	105	100	100	100	125
g mm	120	120	140	140	135	145	145	145	173
h min.	94	118.5	131.5	141.5	164	175	195	220	242.5
h max.	101	127	140	150	172,5	185	205	230	254.5
α	30°	30°	30°	30°	30°	30°	30°	30°	30°
β	15°	15°	15°	15°	15°	15°	15°	15°	15°
γ	60°	60°	60°	60°	60°	60°	60°	60°	60°
Min. operating pressure bar	2	2	2	2	2	2	2	2	3
Max. operating pressure bar	8	8	8	8	8	8	8	8	8
Total clamping force at 6 bar kN	140	155	210	190	200	240	155	175	360
Cylinder surface area cm²	710	899	1045	940	1010	1414	1181	1307	2121
Air consumption (total stroke) l	20	31	36	32	35	58	49	55	104
Max. admissible speed min-1	1700	1500	1300	1300	1200	1000	900	800	750
Moment of inertia kgm2	3,50	7.50	10,65	8.00	15,50	24.25	29.10	45,80	71.25
Weight kg	150	215	225	200	275	413	418	560	650

▲ on request

LVE - large through-hole, with pressure control device





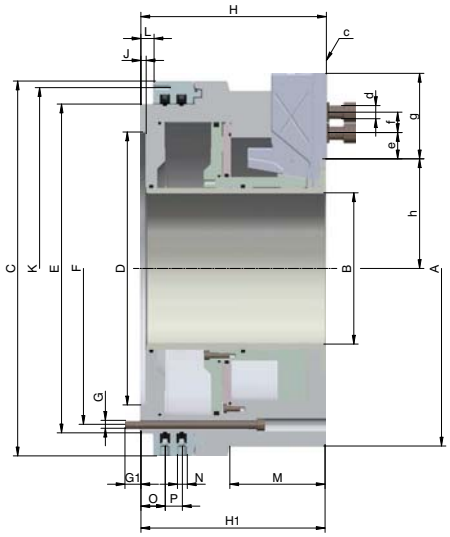
C 15

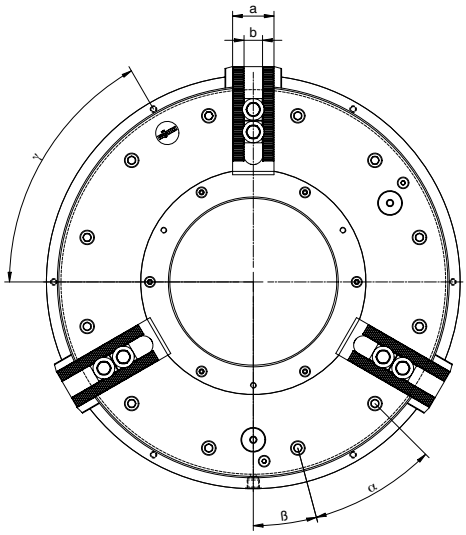
3-jaw self-contained chucks LVE, with large through-hole, max. operating pressure 8 bar, with serration

Cylindrical center mount with pressure control device for external clamping

Item no.	169411 ▲	169412 ▲	169413 ▲	169414 ▲	169415 ▲	169416 ▲	169417 ▲	169418 ▲	169420 ▲
Size	400	400	500	500	600	600	600	700	800
LVE	LVE 420-140	LVE 480-185	LVE 540-205	LVE 570-230	LVE 600-275	LVE 640-275	LVE 680-325	LVE 730-375	LVE 830-410
Jaw travel mm	7	8,5	8,5	8,5	8,5	10	10	10	12
A mm	425	480	540	570	605	640	685	735	835
B mm	140	185	205	230	280	275	325	375	410
C mm	470	530	570	570	605	685	685	735	850
DH6 mm	310	365	415	415	450	510	510	560	700
E mm	400	460	500	500	535	610	610	660	775
F mm	374	434	474	474	500	580	580	630	745
G	M12	M12	M12	M12	M12	M16	M16	M16	M16
G1 mm	25	25	25	25	25	30	30	30	30
H mm	196	225	225	225	225	263	263	263	305
H1 mm	194	223	223	223	223	261	261	261	303
J mm	8	8	8	8	8	8	8	8	8
K mm	448	510	550	550	585	666	666	666	830
L mm	20	20	20	20	20	20	20	20	25
M mm	70	90	100	-	-	110	-	-	155
N	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8
O mm	37	37	37	37	37	39,5	39,5	39,5	44,5
P mm	26	26	26	26	26	33	33	33	33
a mm	57	57	57	57	57	75	75	75	75
bH7 mm	25,5	25,5	25,5	25,5	25,5	30	30	30	30
c	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°
d	M20x50	M20x50	M20x50	M20x50	M20x50	M24x65	M24x65	M24x65	M24x65
e mm	20	20	20	20	20	28	28	28	28
f min.	32	32	32	32	32	42	42	42	42
f max.	85	85	105	105	105	100	100	100	125
g mm	120	120	140	140	135	145	145	145	173
h min.	94	118.5	131.5	141.5	164	175	195	220	242.5
h max.	101	127	140	150	172,5	185	205	230	254.5
α	30°	30°	30°	30°	30°	30°	30°	30°	30°
β	15°	15°	15°	15°	15°	15°	15°	15°	15°
γ	60°	60°	60°	60°	60°	60°	60°	60°	60°
Min. operating pressure bar	2	2	2	2	2	2	2	2	3
Max. operating pressure bar	8	8	8	8	8	8	8	8	8
Total clamping force at 6 bar kN	140	155	210	190	200	240	155	175	360
Cylinder surface area cm2	710	899	1045	939	1010	1414	1181	1307	2121
Air consumption (total stroke) l	20	31	36	32	35	58	49	55	104
Max. admissible speed min-1	1700	1500	1300	1300	1200	1000	900	800	750
Moment of inertia kgm2	3,50	7.50	10,65	8.00	15,5	24.25	29.10	45,80	71.25
Weight kg	150	215	255	200	275	413	418	560	650

LVE - large through-hole, standard design, with rapid and clamping jaw movement





C 15

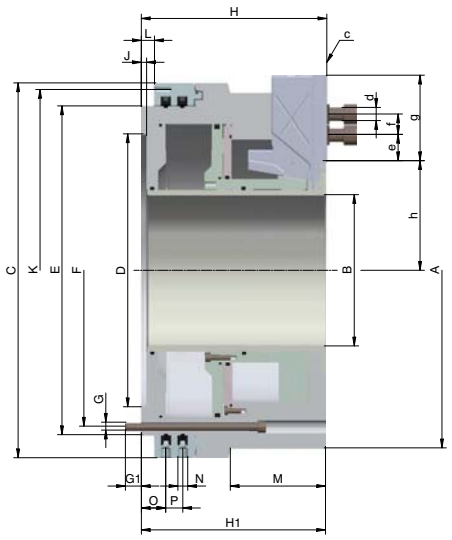
3-jaw self-contained chucks LVE, with rapid and clamping jaw movements, with large through-hole, external chucking, max. operating pressure 8 bar, with serration

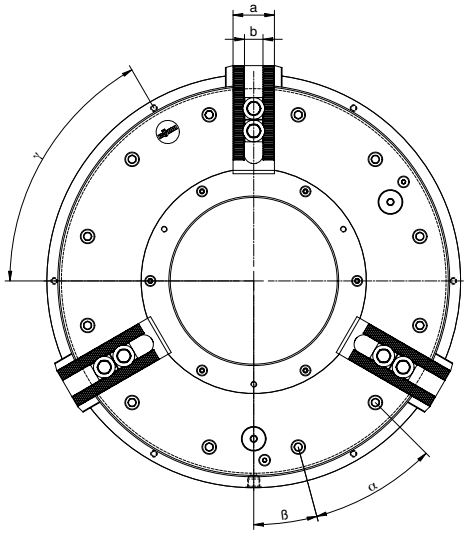
Cylindrical center mount (standard version)

Item no.	169422 ▲	169423 ▲	169424 ▲	169425 ▲	169426 ▲	169428 ▲	169429 ▲	169430 ▲	169432 ▲
Size	400	400	500	500	600	600	700	800	1000
LVE	LVE 470-140 ES	LVE 490-185 ES	LVE 570-205 ES	LVE 570-230 ES	LVE 610-275 ES	LVE 680-325 ES	LVE 730-375 ES	LVE 850-375 ES	LVE 1000-570 ES
Jaw travel mm	19	25,4	25,4	25,4	25,4	25,4	25,4	25,4	25,4
Rapid movement mm	12	16.9	16,9	16.9	16.9	16.9	16.9	14,9	14,9
clamping movement mm	7	8.5	8,5	8.5	8.5	8.5	8.5	10,5	10,5
A mm	470	490	570	570	605	685	735	850	1000
B mm	140	185	205	230	275	325	375	375	570
C mm	470	530	570	570	605	685	735	850	925
DH6 mm	310	365	415	415	450	510	560	700	700
E mm	400	460	500	500	535	610	660	775	850
F mm	374	434	474	474	508	580	630	745	815
G	M12	M12	M12	M12	M12	M16	M16	M16	M16
G1 mm	25	25	25	25	25	30	30	30	30
H mm	240	282	282	282	282	308	308	322	332
H1 mm	238	280	280	280	280	306	306	320	330
J mm	8	8	8	8	8	8	8	8	10
K mm	448	510	550	550	585	666	716	830	910
L mm	20	20	20	20	20	20	20	25	33
M mm	-	140	100	-	-	-	-	-	225
N	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8
O mm	37	37	37	37	37	39,5	39,5	44,5	52,5
P mm	26	26	26	26	26	33	33	33	33
a mm	57	57	57	57	57	75	75	75	75
bH7 mm	25,5	25,5	25,5	25,5	25,5	30	30	30	30
c	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°
d	M20x50	M20x50	M20x50	M20x50	M20x50	M24x65	M24x65	M24x65	M24x65
e mm	20	20	20	20	20	28	28	28	28
f min.	32	32	32	32	32	42	42	42	42
f max.	80	80	95	95	95	95	95	120	120
g mm	112	112	130	130	125	140	140	170	170
h min.	126	132.6	142,1	154.6	177.1	202.6	227.6	234,6	329,6
h max.	145	158	167,5	180	202.5	228	253	260	355
α	30°	30°	30°	30°	30°	30°	30°	30°	30°
β	15°	15°	15°	15°	15°	15°	15°	15°	15°
γ	60°	60°	60°	60°	60°	60°	60°	60°	60°
Min. operating pressure bar	2	2	2	2	2	2	2	3	3
Max. operating pressure bar	8	8	8	8	8	8	8	8	8
Total clamping force at 6 bar kN	120	150	190	170	180	200	175	200	180
Cylinder surface area cm2	700	862	1003	895	958	1181	1307	1345	1075
Air consumption (total stroke) l	32	42	48	45	46	57	63	80	65
Max. admissible speed min^{-1}	1500	1300	1200	1200	1100	800	750	750	450
Moment of inertia kgm2	6,50	8.25	14,65	12.75	19,10	34.25	47.50	103,0	158,2
Weight kg	200	260	320	270	350	490	580	970	955

▲ on request

LVE - large through-hole, with pressure control device, rapid and clamping jaw movement





C 15

3-jaw self-contained chucks LVE, with rapid and gripping jaw movements, with large through-hole, external chucking, max. operating pressure 8 bar, with serration

Cylindrical center mount with pressure control device for external clamping

Item no.	169433 ▲	169434 ▲	169435 ▲	169436 ▲	169437 ▲	169439 ▲	169440 ▲	169441 ▲	169443 ▲
Size	400	400	500	500	600	600	700	800	1000
LVE	LVE 470-140 ES	LVE 490-185 ES	LVE 570-205 ES	LVE 570-230 ES	LVE 610-275 ES	LVE 680-325 ES	LVE 730-375 ES	LVE 850-375 ES	LVE 1000-570 ES
Jaw travel mm	19	25,4	25,4	25,4	25,4	25,4	25,4	25,4	25,4
Rapid movement mm	12	16.9	16,9	16.9	16.9	16.9	16.9	14,9	14,9
Gripping movement mm	7	8.5	8,5	8.5	8.5	8.5	8.5	10,5	10,5
A mm	470	490	570	570	605	685	735	850	1000
B mm	140	185	205	230	275	325	375	375	570
C mm	470	530	570	570	605	685	735	850	925
DH6 mm	310	365	415	415	450	510	560	700	700
E mm	400	460	500	500	535	610	660	775	850
F mm	374	434	474	474	509	580	630	745	815
G	M12	M12	M12	M12	M12	M16	M16	M16	M16
G1 mm	25	25	25	25	25	30	30	30	30
H mm	240	282	282	282	282	308	308	322	332
H1 mm	238	280	280	280	280	306	306	320	330
J mm	8	8	8	8	8	8	8	8	10
K mm	448	510	550	550	585	666	716	830	910
L mm	20	20	20	20	20	20	20	25	33
M mm	-	140	100	-	-	-	-	-	225
N	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8
O mm	37	37	37	37	37	39,5	39,5	44,5	52,5
P mm	26	26	26	26	26	33	33	33	33
a mm	57	57	57	57	57	75	75	75	75
bH7 mm	25,5	25,5	25,5	25,5	25,5	30	30	30	30
c	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°	3/32“x90°
d	M20x50	M20x50	M20x50	M20x50	M20x50	M24x65	M24x65	M24x65	M24x65
e mm	20	20	20	20	20	28	28	28	28
f min.	32	32	32	32	32	42	42	42	42
f max.	80	80	95	95	95	95	95	120	120
g mm	112	112	130	130	125	140	140	170	170
h min.	126	132.6	142,1	154.6	177.1	202.6	227.6	234,6	329,6
h max.	145	158	167,5	180	202.5	228	253	260	355
α	30°	30°	30°	30°	30°	30°	30°	30°	30°
β	15°	15°	15°	15°	15°	15°	15°	15°	15°
y	60°	60°	60°	60°	60°	60°	60°	60°	60°
Min. operating pressure bar	2	2	2	2	2	2	2	3	3
Max. operating pressure bar	8	8	8	8	8	8	8	8	8
Total clamping force at 6 bar kN	120	150	210	170	180	200	175	200	180
Cylinder surface area cm2	700	862	1024	895	958	1181	1307	1345	1075
Air consumption (total stroke) l	32	42	50	45	46	57	63	80	65
Max. admissible speed min^{-1}	1500	1300	1200	1200	1100	800	750	750	450
Moment of inertia kgm2	6,50	8.25	14,65	12.75	19,10	34.25	47.50	103,0	158,2
Weight kg	200	260	320	270	350	490	580	970	955

Jaws LVE

C 21
Reversible top jaws, 3-jaw set, hardened serration 90° - material: 16 MnCr 5



Chuck Size	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm	Serration
400/500/600	**037531**	135	65	68	3/32"x 90°
600/700	**169464**	170	75	80	3/32"x90°
800/1000	**169466**	195	85	80	3/32"x90°

Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21
Extented soft top jaws, 3-jaw set serration 90° - material: 16 MnCr 5

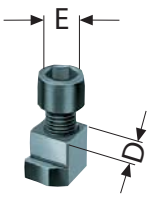


Chuck Size	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm	Serration
400/500/600	**137028**	180	80	50	3/32"x 90°
500/600	**169449**	205	80	50	3/32"x90°
600/700	**169450**	215	89	68	3/32"x90°
600/700/800/1000	**169452**	245	89	68	3/32"x90°

Accessories LVE

C 15

T-nuts
With screw



Item no.	Chuck Size	Contents of delivery	D mm	E
1305181	400/500/600	piece	25,5	M20x50
1305182	600/700/800/1000	piece	30	M24x60

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Accessories LVE

C 15
Pneumatic control unit for LVE 400-1000



Item no.	Width mm	Height mm	Depth mm	Control voltage	Connection	Weight approx. kg
426560	280	250	100	24 V	R ½ „ inside thread	3

When double chucks are used, two pneumatic control devices are required

C 15
Control units for single chucks with dual foot switch, wired, cable length 6 meters, for LVE 400-1000



Item no.	Design	Width mm	Width with plug mm	Height mm	Depth mm	Control voltage	Cable length
426481	without pressure monitoring	300	340	300	120	24 V	6 m
426263	with pressure monitoring	300	340	300	120	24 V	6 m

Power supplies on request: primary 35-264 V ~, 47-63 Hz - secondary 24V/1.5 A

C 15
Control units for dual chucks with dual foot switch, wired, cable length 6 meters, for LVE 400-1000

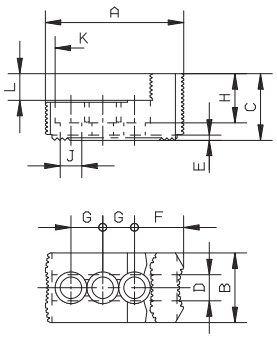


Item no.	Design	Width mm	Width with plug mm	Height mm	Depth mm	Control voltage	Cable length
426482 ▲	without pressure monitoring	300	340	300	120	24 V	6 m
426264 ▲	with pressure monitoring	300	340	300	120	24 V	6 m

Power supplies on request: primary 35-264 V ~, 47-63 Hz - secondary 24V/1.5 A

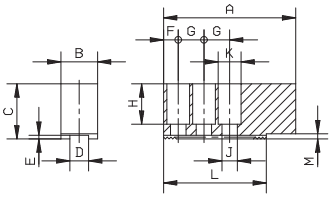
Jaw dimensions und Chucking capacities LVE

Reversible top jawsUB
serration 90°,
material 16MnCr5



Chuck size		400		500		600	700		800		1000
LVE		400-140	480-185	540-205	570-230	600-275	630-275	680-325	730-375	800-375	830-410	1000-570
Type		538-07		538-07		538-07	543-21		543-21	543-21		543-21
Item no. 3-jaw		**037531**		**037531**		**037531**	**169464**		**169464**	**169466**		**169466**
A		135	135	135	135	135	170	170	170	195	195	195
B		68	68	68	68	68	80	80	80	80	80	80
C		65	65	65	65	65	75	75	75	85	85	85
$D^{+0,05}$		25,5	25,5	25,5	25,5	25,5	30,0	30,0	30,0	30,0	30,0	30,0
E		5	5	5	5	5	6	6	6	6	6	6
F		48	48	48	48	48	56	56	56	78	78	78
G		31+31	31+31	31+31	31+31	31+31	42+42	42+42	42+42	42+42	42+42	42+42
H		48	48	48	48	48	58	58	58	62	62	62
J		21	21	21	21	21	26	26	26	26	26	26
K		31	31	31	31	31	40	40	40	40	40	40
L		26	26	26	26	26	32	32	32	35	35	35
M		--	--	--	--	--	--	--	--	--	--	--
Serration		3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°
Weight/jaw kg		2,4	2,4	2,4	2,4	2,4	3,6	3,6	3,6	4,5	4,5	4,5
External chucking	A1	85 - 255	135 - 305	160 - 370	180 - 390	220 - 430	225 - 420	265 - 460	315 - 510	280 - 530	315 - 565	500 - 750
	A2	125 - 295	175 - 345	200 - 410	220 - 430	260 - 470	275 - 470	315 - 510	365 - 560	370 - 620	405 - 655	585 - 835
	A3	330 - 500	380 - 550	405 - 615	425 - 635	465 - 675	540 - 735	580 - 775	630 - 825	640 - 890	675 - 925	855 - 1105
Internal chucking	J1	155 - 325	205 - 375	230 - 440	250 - 460	290 - 500	305 - 500	345 - 540	395 - 590	405 - 655	440 - 690	600 - 850
	J2	350 - 520	405 - 570	430 - 640	450 - 660	490 - 700	565 - 770	605 - 800	655 - 850	670 - 920	705 - 955	865 - 1035
max. interferences diameter	S	570	625	690	710	750	800	840	890	1000	1030	1215

Extended soft top jaws AB
serration 90°
material 16MnCr5



Chuck size	400		500				600					
LVE	400-140	480-185	540-205	570-230	540-205	570-230	600-275	630-275	680-325	600-275	630-275	680-325
Type	518-07		543-22		518-07		543-22	543-22		518-07	543-22	
Item no. 3-jaw	**137028**		**169449**		**137028**		**169449**	**169452**		**137028**	**169450**	
A	180	180	205	205	180	180	205	245	245	180	215	215
B	50	50	50	50	50	50	50	68	68	50	68	68
C	80	80	80	80	80	80	80	89	89	80	89	89
$D^{+0,05}$	25,5	25,5	25,5	25,5	25,5	25,5	25,5	30,0	30,0	25,5	30,0	30,0
E	5	5	5	5	5	5	5	6	6	5	6	6
F	20	20	20	20	20	20	20	25	25	20	25	25
G	35+35	35+35	35+35	35+35	35+35	35+35	35+35	45+45	45+45	35+35	45+45	45+45
H	60	60	60	60	60	60	60	69	69	60	69	69
J	21	21	21	21	21	21	21	25	25	21	25	25
K	31	31	31	31	31	31	31	37	37	31	37	37
L	180	180	190	190	180	180	190	140	140	180	140	140
M	--	--	6	6	-	-	6	7	7	-	7	7
Serration	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°
Weight/jaw kg	4,2	4,2	5,0	5,0	4,2	4,2	5,0	9,1	9,1	4,2	7,8	7,8
A1 Ø External chucking	20 - 155	30 - 200	10 - 220	30 - 240	60 - 270	80 - 290	75 - 285	60 - 255	100 - 295	125 - 335	120 - 315	160 - 355
S Ø max. interferences diameter	330	575	640	660	640	660	710	760	800	710	760	800

Chuck size	700		800		800		1000	
LVE	730-375		800-375	830-410	800-375	830-410	1000-570	
Type	543-22		543-22		543-22		543-22	
Item no. 3-jaw	**169452**	**169450**	**169456**		**169452**		**169456**	**169452**
A	245	215	285	285	245	245	285	245
B	68	68	68	68	68	68	68	68
C	89	89	89	89	89	89	89	89
$D^{+0,05}$	30,0	30,0	30,0	30,0	30,0	30,0	30,0	30,0
E	6	6	6	6	6	6	6	6
F	25	25	25	25	25	25	25	25
G	45+45	45+45	55+55	55+55	45+45	45+45	55+55	45+45
H	69	69	69	69	69	69	69	69
J	25	25	25	25	25	25	25	25
K	37	37	37	37	37	37	37	37
L	140	140	160	160	140	140	160	140
M	7	7	7	7	7	7	7	7
Serration	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°
Weight/jaw kg	9,1	7,8	10,9	10,9	9,1	9,1	10,9	9,1
A1 Ø External chucking	150 - 345	210 - 415	105 - 355	140 - 390	165 - 415	200 - 450	300 - 550	360 - 610
S Ø max. interference diameter	850	850	945	980	920	955	1100	1150

Notes

THE RIGHT CHUCK FOR EVERY APPLICATION



KBF-N draw-down power chuck



ZFM draw-down power chuck



KFD-AF compensating chuck



GF gripper chuck

The RÖHM application chucks are as versatile as the sectors where they are used. RÖHM application chucks are used successfully in the sectors of mechanical engineering, the automobile industry, for aerospace, as well as the energy sector to microtechnology sector.

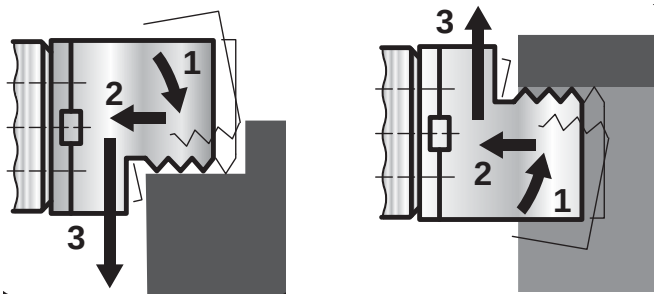
Video KBF-N draw-down power chuck

APPLICATION CHUCKS

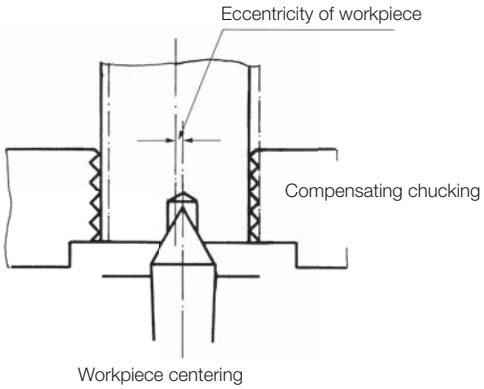
RÖHM application chucks are specially developed for the requirements of the respective sector and their applications in order to able to ensure top quality, reliability and safety. The application chucks are used successfully in the sectors of mechanical engineering, the automobile industry, for aerospace, as well as the energy sector to microtechnology sector.

ADVANTAGES AT A GLANCE

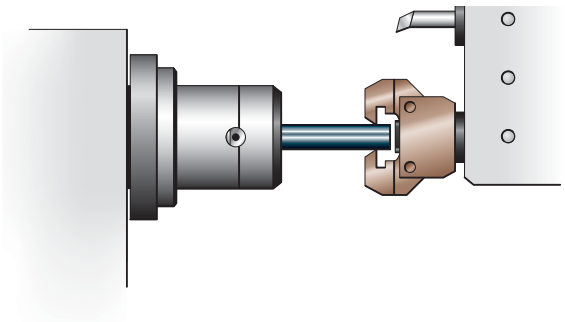
- Safe and precise clamping of complex and individual workpieces
- Adaptation of the clamping solution to the individual application
- Proven RÖHM quality for maximum reliability



Functionality of the draw-down power chucks, KBF-N and ZFM:
The workpiece is automatically drawn down onto a rigid plane face when it is clamped. In the process, the workpiece is moved and fixed by clamping jaws during the clamping-operation, before the clamping force is built up again in this axially defined position. Depending on the functional principle of the clamping chuck, internal and external clamping or external clamping only can be realized.



Functionality of the compensating chuck (KFD-AF):
The workpiece is taken up in the center point which is mounted in an insert, and clamped by centrically compensating jaws. Compensation is realized by the radially floating, chucking piston. By simply exchanging the center insert, the chuck can be very quickly retrofit to centric clamping.



Functionality of gripper chucks (GF):
To clamp, the gripper chuck is usually moved against the clamped-in material with the tool holder of the machine. In the process, the jaws are forced outward via their approach angle until the workpiece diameter is reached and they grab the workpiece in the cylindrical area. The clamping force is generated by a floating disc spring package acting on the jaws. The round material is now released in the clamping chuck and pulled into the intended position by the gripper chuck. Now the workpiece is clamped again and the gripper chuck simply pulled off by the workpiece. The jaws are automatically pressed inward into their original position by the disc spring package. The interchangeable take-up shaft meets DIN 69880.

KBF-N



APPLICATION

For clamping tasks for internal and external clamping where the axial run-out errors of the workpiece have to be minimized.

TYPE

Power chuck with draw-down and ball lock principle available with cylindrical center mount or short taper mount.

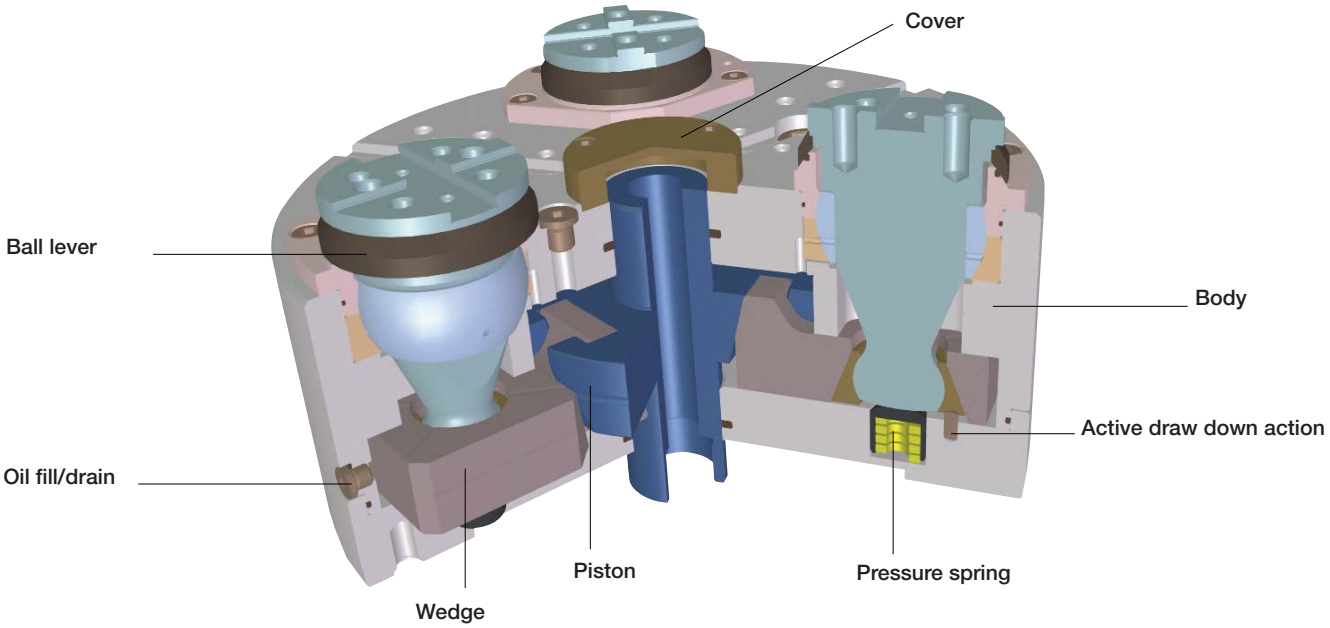
CUSTOMER BENEFITS

- Maximum plane-parallelism thanks to active draw-down by the jaws
- Maximum productivity thanks to long maintenance intervals - hermetically sealed against dirt and cooling water
- Consistent workpiece quality thanks to constant clamping force due to oil filling
- Suitable for high speeds (speed-dependent centrifugal influences are minimized by similar mass distribution to the right and left of the ball lock)

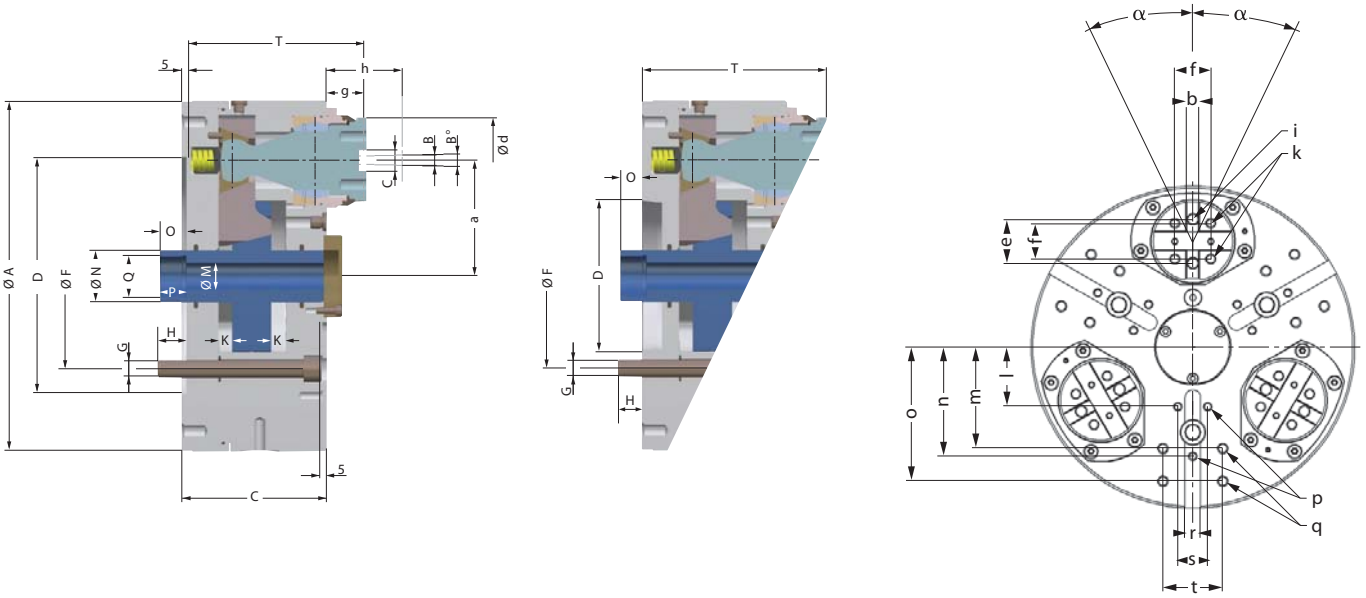
TECHNICAL FEATURES

- Ball lock principle with wedge hook system
- With fixed jaws (pendulum jaws on request)

Note:
Alternatively with swinging ball lock for clamping rough, easily deformable workpieces at six clamping points on request



KBF-N



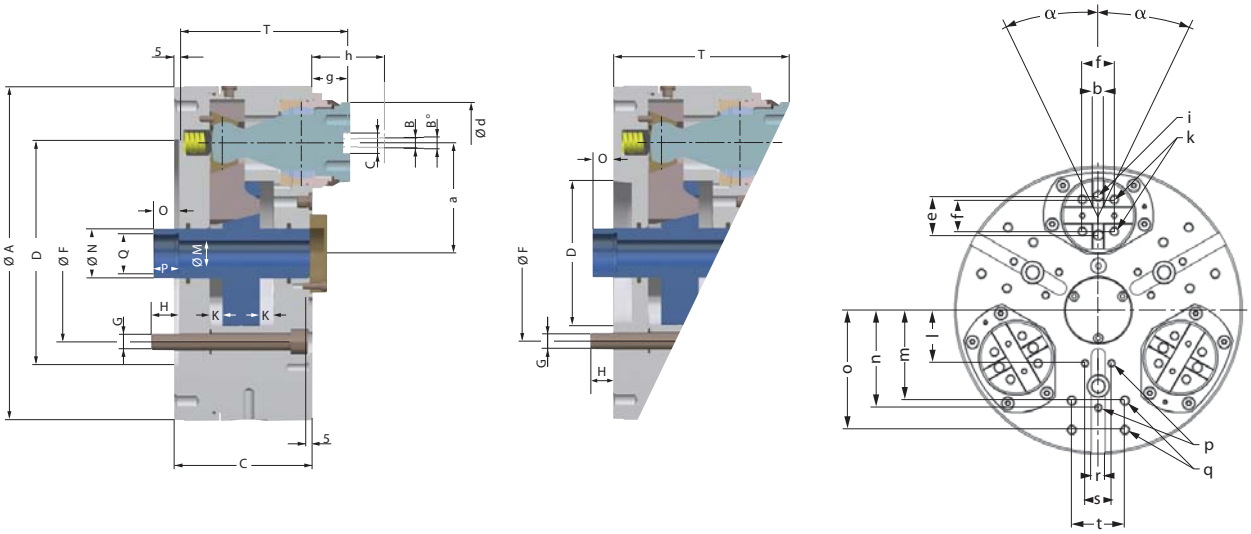
C 15

Power-operated ball lock draw-down chuck KBF-N with fixed jaws for internal and external clamping, with pull down effect, hermetically sealed, oil filled, centrical clamping
Cylindrical centre mount **DIN 6353**

Item no.	168355 ▲	165635	165637 ▲	165639 ▲	168056 ▲
Size	170	200	250	315	400
Jaw design	Fixed jaws	Fixed jaws	Fixed jaws	Fixed jaws	Fixed jaws
A mm	178	210	260	325	400
Jaw travel B mm	5,4	5,9	6,3	6,4	7,5
B°	5,2°	4,9°	4,4°	4,5°	4,7°
C mm	94	111	135	135	148
D	ZA 140	ZA 170	ZA 220	ZA 220	ZA 300
F mm	104,8	133,4	171,4	171,4	235
G	3 x M10	3xM12	3xM16	3xM16	3 x M20
H mm	15	17	22	22	30
Total wedge stroke K+K mm	21	25	25	25	30
M mm	14	14	18	25	52
Ng6 mm	30	36	38	48	75
O min.	12,5	12,5	12,5	12,5	10
O max.	33,5	37,5	37,5	37,5	40
P mm	20	18	20	25	25
Q mm	M22 x 1,5	M28x1,5	M32x1,5	M38x1,5	M60 x 1,5
T mm	116	139	163	163	180
a mm	55	64	82	107	130
bh8 mm	7,94	7,94	12,7	12,7	12,7
cH7 mm	12,68	12,68	19,03	19,03	19,03
d mm	60	65	75	80	105
e mm	32	38	44,4	44,4	63,5
f mm	24	32	36	36	48
g mm	27	33	33	33	37
Reference height h mm	50	60	70	70	80
i	M10	M12	M12	M12	M16
k	M8	M10	M10	M10	M12
l mm	-	30	50	60	80
m mm	65	80	102	102	140
n mm	68	50	65	110	144
o mm	-	-	-	135	170
p	M6	M6	M8	M8	M10
q	M8	M8	M10	M10	M12
r mm	16	16	16	16	20
s mm	-	25	30	30	36
t mm	36	45	60	60	80
Floating angle α	5°	5°	3°	3°	3°
Pull-down travel mm	0,3	0,3	0,3	0,3	0,3
Max. admissible speed min-1	5000	4500	3800	3000	2200
Maximum draw bar pull kN	18	30	40	45	50
Max. total clamping force kN	44	73	93	105	120
Weight approx. kg	18	30	55	80	130
Actuating cylinders (recommended)	**OVS-85**	**OVS-105**	**OVS-130**	**OVS-130**	**OVS-150**

▲ on request

KBF-N



C 15

Power-operated ball lock draw-down chuck KBF-N with fixed jaws for internal and external clamping, hermetically sealed, oil filled, centrical clamping

Short taper mount for **ISO 702-1** (DIN 55026/55021)

Item no.	168356 ▲	165636	165638 ▲	165640 ▲	168057 ▲
Size	170	200	250	315	400
Jaw design	Fixed jaws	Fixed jaws	Fixed jaws	Fixed jaws	Fixed jaws
A mm	178	210	260	325	400
Jaw travel B mm	5,4	5,9	6,3	6,4	7,5
B°	5,2°	4,9°	4,4°	4,5°	4,7°
C mm	94	111	135	135	148
D	KK 5	KK 6	KK 8	KK 8	KK 11
F mm	104,8	133,4	171,4	171,4	235
G	3 x M10	3xM12	3xM16	3xM16	3 x M20
H mm	15	17	22	22	30
Total wedge stroke K+K mm	21	25	25	25	30
M mm	14	14	18	25	52
Ng6 mm	30	36	38	48	75
O min.	7,5	7,5	7,5	7,5	5
O max.	28,5	32,5	32,5	32,5	35
P mm	20	18	20	25	25
Q mm	M22 x 1,5	M28x1,5	M32x1,5	M38x1,5	M60 x 1,5
T mm	121	144	168	168	185
a mm	55	64	82	107	130
bh8 mm	7,94	7,94	12,7	12,7	12,7
cH7 mm	12,68	12,68	19,03	19,03	19,03
d mm	60	65	75	80	105
e mm	32	38	44,4	44,4	63,5
f mm	24	32	36	36	48
g mm	27	33	33	33	37
Reference height h mm	50	60	70	70	80
i	M10	M12	M12	M12	M16
k	M8	M10	M10	M10	M12
l mm	-	30	50	60	80
m mm	65	80	102	102	140
n mm	68	50	65	110	144
o mm	-	-	-	135	170
p	M6	M6	M8	M8	M10
q	M8	M8	M10	M10	M12
r mm	16	16	16	16	20
s mm	-	25	30	30	36
t mm	36	45	60	60	80
Floating angle α	5°	5°	3°	3°	3°
Pull-down travel mm	0,3	0,3	0,3	0,3	0,3
Max. admissible speed min-1	5000	4500	3800	3000	2200
Maximum draw bar pull kN	18	30	40	45	50
Max. total clamping force kN	44	73	93	105	120
Weight approx. kg	18	30	55	80	130
Actuating cylinders (recommended)	**OVS-85**	**OVS-105**	**OVS-130**	**OVS-130**	**OVS-150**

▲ on request

Jaws KBF-N

C 21
Soft top jaws, 3-jaw set tongue and groove, material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
168383 ▲	170	70	26,5	60
165694 ▲	200	80	31,5	65
165696 ▲	250/315	90	41,5	75
168385 ▲	400	125	46,5	105

Workpiece-specific top jaws can be placed on the tongue and groove interface of the ball bolts.

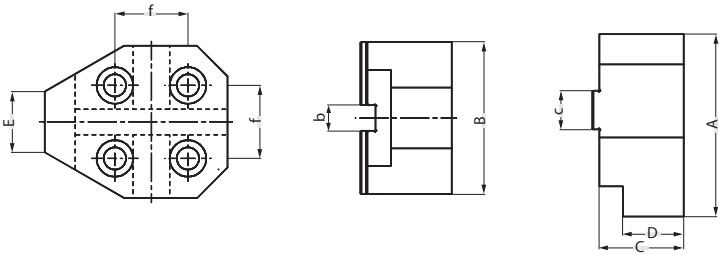
For exact clamping, soft top jaws are preferably used. They are to be turned out to the desired clamping diameter under clamping force. If these top jaws are still to be hardened, the chuck must be ground out afterward.

For raw-part clamping, hardened clamping inserts can be worked into the soft top jaws at the corresponding clamping diameter.

On request, special top jaws specific to the workpiece can also be delivered.

Soft top jaws for KBF-N

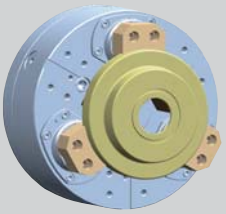
Chuck size	170	200	250	315	400
A	70	80	90	90	125
B	60	65	75	75	105
C	26,5	31,5	41,5	41,5	46,5
D	20	20	30	30	30
E	25	30	30	30	40
b H7	7,94	7,94	12,7	12,7	12,7
c h6	12,68	12,68	19,03	19,03	19,03
f	24	32	36	36	48



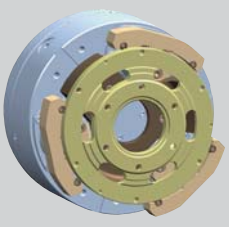
Examples for machined clamping jaws



Examples for applications:



Fixed jaws:
For exact clamping of flange-like workpieces, e.g. wheel hubs, spur gears, etc.



Optionally with pendulum jaws:
For clamping deformation-sensitive raw parts, e.g. coupling pressure plates or sprockets

Configure your individual clamping jaws online! www.web2product.biz

ZFM



APPLICATION

Simple clamping principle for external clamping of bars, pipes and shafts, as well as flange-type workpieces where the axial run-out errors of the workpiece have to be minimized.

TYPE

Collet pin system with cylindrical center mount.

CUSTOMER BENEFITS

- Maximum plane-parallelism thanks to active draw-down using axially movable draw rod studs
- Easy adaptation to various workpiece diameters thanks to interchangeable clamping inserts
- Insensitive clamping system thanks to simple setup, allows machining at maximum speeds

TECHNICAL FEATURES

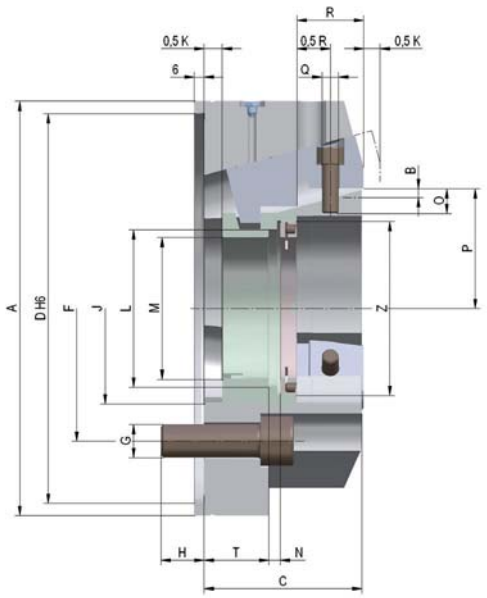
- Power transmission directly from the piston to the draw rod studs
- Clamping inserts hardened, adapted to the workpiece diameter

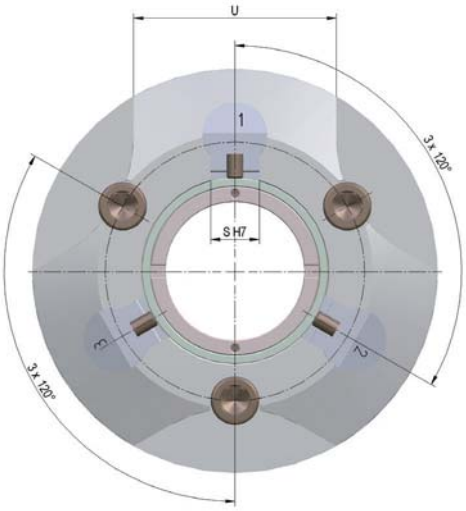


Special designs:

E.g. power operated draw bar chuck ZFM, diameter 220 mm, with clamping inserts with chip flow grooves and threads, for work stops for clamping of aluminum flanges.

ZFM





C 15

Power-operated draw bar chuck ZFM, with gripping inserts cylindrical centre mount

Item no.	201980 ▲	201981 ▲	201982 ▲	201983 ▲
Size	160	200	250	315
A mm	160	200	250	315
Jaw travel B mm	5,3	5,3	5,3	5,3
C mm	75	82	95	105
DH6 mm	145	185	235	235
F mm	100	140	160	200
G	3 x M 12	3 x M 16	3 x M 20	3 x M 20
H mm	18	20	26	26
J mm	71	95	115	160
Wedge stroke K mm	20	20	20	20
L mm	52	72	95	136
M mm	45,5	65,5	85,5	125,5
N mm	7	7	7	7
O mm	12	15	15	15
P max.	48,15	64,65	74,65	101,65
P min.	42,85	59,35	69,35	96,35
Q mm	M 8	M 10	M 10	M 12
R mm	30	35	40	45
SH7 mm	24	30	30	35
T max.	40	40	48	53
T min.	20	20	28	33
U mm	60	85	125	125
Z	M 62 x 1,25	M 85 x 1,25	M 105 x 1,25	M 150 x 1,25
Maximum draw bar pull kN	25	35	45	50
Max. total clamping force approx. kN	46	66	84	90
Max. admissible speed min-1	8000	6300	5500	4200
Moment of inertia J kgm2	0,026	0,072	0,183	0,508
Weight without jaw inserts approx. kg	7,5	13	21	35
Chucking capacity mm	0-40	4-70	24-80	30-130
Actuating cylinders (recommended)	**OVS-85/105**	**OVS-105**	**OVS-130**	**OVS-150**

C 21

Clamping Jaws, 3-jaw-set, prefabricated, can be hardened material: 16 MnCr 5



Chuck Size	3-jaw set	Jaw length mm	Jaw height mm	Jaw width mm
160	**210007** ▲	42,7	30	24
200	**210008** ▲	51,7	35	30
250	**210009** ▲	61,7	45	30
315	**210010** ▲	85,7	45	35

KFD-AF



APPLICATION

Centric or compensating clamping chuck with which the workpiece is centered either via a center or via the jaws.

TYPE

Compensating clamping power chuck with cylindrical center mount or short taper mount.
3-jaw version with serration (90°).

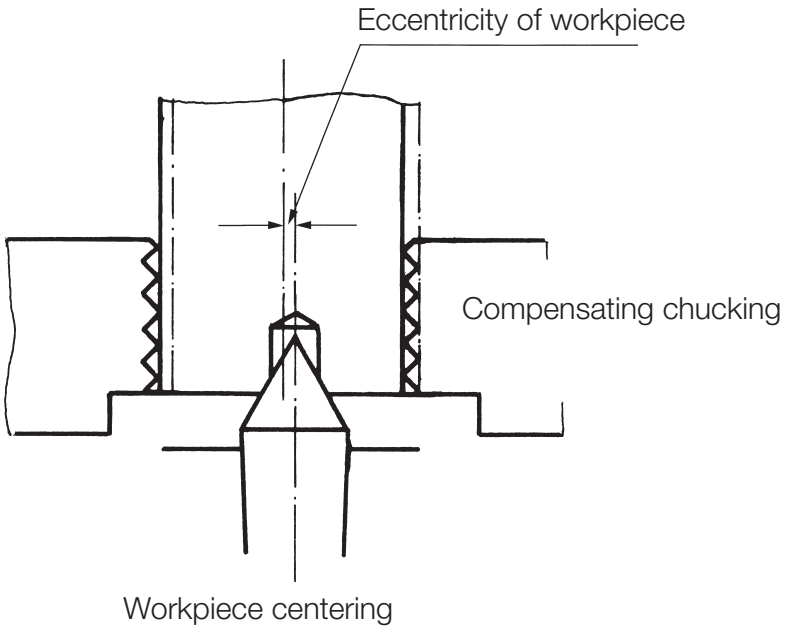
CUSTOMER BENEFITS

- Flexible use thanks to retrofitting to centric clamping using center inserts
- Low-maintenance thanks to special sealing against dirt and cooling water

TECHNICAL FEATURES

- Proven wedge hook system
- Compensation is realized by the radially floating chucking piston
- Piston lubrication at centric clamping
- Base jaw lubrication

Note:
When ordering, please specify power chuck, center insert and mounting flange



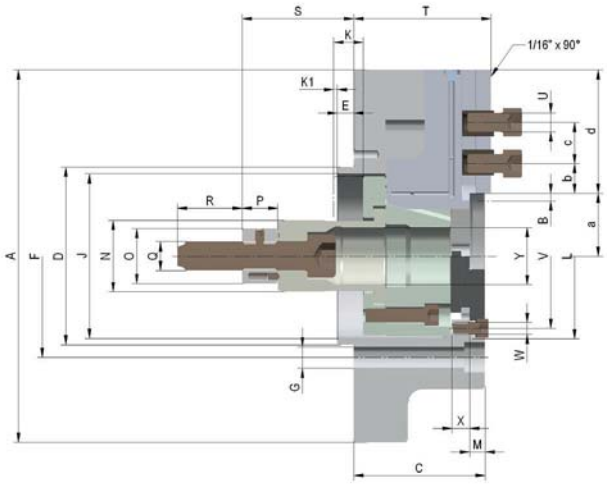
Functionality of the compensating chuck (KFD-AF):
The workpiece is taken up in the center point which is mounted in an insert, and clamped by centrically compensating jaws. Compensation is realized by the radially floating chucking piston. By simply exchanging the center insert, the chuck can be very quickly retrofit to centric clamping.

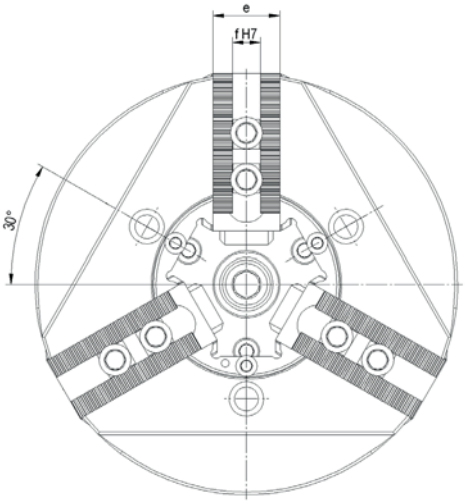
Interchangeable centering inserts:
- with spring-loaded center
- with solid center
- for self-centering chucking (no compensation)

Interchangeable mounting adapters:
- with cylindrical mount
- with short taper recess
- with option for radial fine adjustment, upon request

▲ on request

KFD-AF





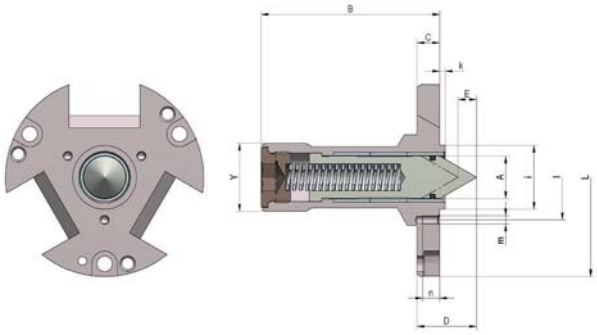
C 15
3-jaw compensation chucks KFD-AF, with serration 90° Center insert and chuck mount interchangeable

Item no.	144620	144621	144622	144623
Size	160	200	250	315
A mm	160	200	250	315
Jaw travel B mm	4,8	5,6	6,7	6,7
C mm	78	85	93	111
Dh6 mm	90	115	135	150
E mm	14	14	14	14
F mm	104,8	133,4	171,4	171,4
G mm	3 x ø 12	3 x ø 14	3 x ø 18	3 x ø 18
J mm	82	103	122	139
Wedge stroke K mm	18	21	25	25
K1 mm	2	2	3	3
LH6 mm	90	95	120	140
M mm	10	11	13	13
Ng6 mm	38	42	50	60
O mm	34	40	46	46
P mm	25	30	30	30
Q mm	M16	M20	M24	M24
R mm	40	45	55	55
S min.	56	75	94	94
S max.	74	96	119	119
T mm	82	90	98	116
U	M12	M12	M16	M16
V mm	72	80	102	102
W mm	3 x M8	3 x M8	3 x M10	3 x M10
X mm	12	15	15	15
YH6 mm	32	32	38	48
a min.	27,2	34,4	40,3	46,3
a max.	32	40	47	53
b min.	8	8	10	10
c min.	19	19	25	25
c max.	37	49	64	90
d mm	48	60	78	104,5
e mm	35	40	50	50
fH7 mm	17	17	21	21
Maximum draw bar pull kN	25	36	50	65
Max. total clamping force approx. kN	50	72	110	150
Max. admissible speed min-1	3500	3200	3000	2300
Compensation on Ø mm	3	3	4	4
Moment of inertia J kgm2	0,04	0,1	0,218	0,744
Weight without jaws approx. kg	13	20	28	60
Actuating cylinders (recommended)	**OVS-85/105**	**OVS-105**	**OVS-130**	**OVS-150**

Note: When ordering, specify power chuck, center insert and mounting flange
The diameter Ng6 must be guided in the spindle

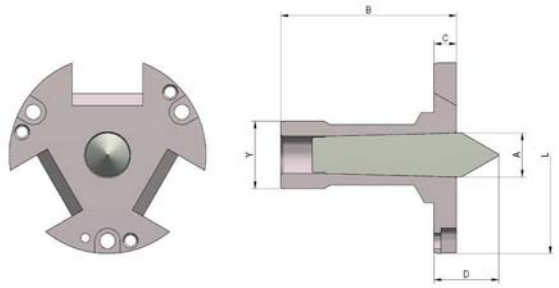
Accessories KFD-AF

C 15
Centering insert with spring-loaded centre



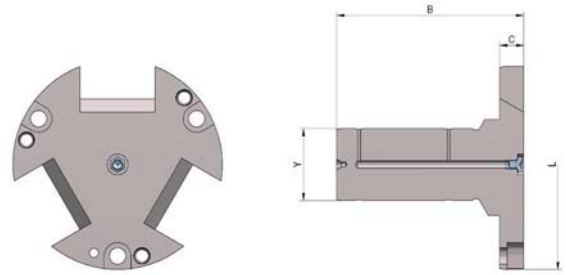
Item no.	Size	A mm	B mm	C mm	D mm	E mm	Lj6 mm	i- 0,05 mm	k mm	Yg6 mm	l mm	m	n mm
144624	160	17,5	90	13	~30	6	90	30	4	32	40	M 5	8
144625	200	20,5	91	14	~33	8	95	30	4	32	40	M 5	10
144626	250	25,5	109	16	~38	10	120	40	4	38	50	M 5	10
144627	315	30,5	125	16	~42	13	140	45	4	48	60	M 6	12

C 15
Centering insert with fixed centre



Item no.	Size	A mm	B mm	C mm	D mm	Lj6 mm	Yg6 mm
144628	160	~18	90	13	~33	90	32
144629	200	~18	91	14	~33	95	32
144630	250	~24	109	16	~38	120	38
144631	315	~32	125	16	~46	140	48

C 15
Centering insert for centric clamping



Item no.	Size	B mm	C mm	Lj6 mm	Yg6 mm
144632	160	90	13	90	32
144633	200	91	14	95	32
144634	250	109	16	120	38
144635	315	125	16	140	48

C 21
Reversible top jaws, 3-jaw set, hardened serration 90° - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
046408	160/200	68	45	34,7	1/16“x 90°
118522	160/200	75	49	36	1/16“x 90°
046414	250/315	103,5	58	50	1/16“x 90°

Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21
Soft top jaws, 3-jaw set, can be hardened serration 90° - material: 16 MnCr 5

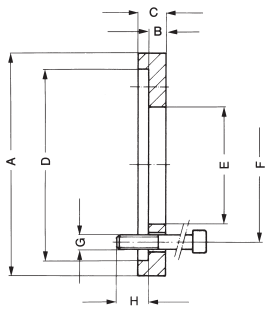


Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
133152	160	66,7	53	36,5	1/16“x 90°
133153	200	75	53	36,5	1/16“x 90°
133154	250	95	54,5	45	1/16“x 90°
133155	315	103	80	50	1/16“x 90°

▲ on request

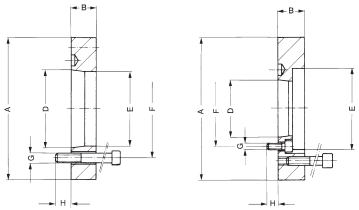
Accessories KFD-AF

C 15
Adaptor plates with cylindrical center mount to **DIN 6353 complete** with mounting screws

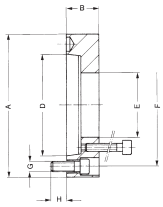


Item no.	Size	A mm	B mm	C mm	DH6 mm	EH6 mm	F mm	G	H mm
144636	160	160	16	22	140	90	104,8	3 x M 10	14
144637	200	200	16	22	170	115	133,4	3 x M 12	16
144638	250	250	17	23	220	135	171,4	3 x M 16	24
144639	315	280	17	23	220	150	171,4	3 x M 16	24

C 15
Adaptor plates with short taper mount **ISO 702-1 (DIN 55026/55021) complete** with mounting studs



Design I Design II



Design III

Item no.	Size	Design	A mm	B mm	D mm	EH6 mm	F mm	G	H mm
144643	160/5	I	135	29	KK 5	90	104,8	3 x M10	15
144646	160/6	III	165	30	KK 6	90	133,4	3 x M12	18
144649	200/5	II	165	33	KK 5	115	104,8	3 x M10	14
144652	200/6	I	165	30	KK 6	115	133,4	3 x M12	18
144655	250/6	II	210	36	KK 6	135	133,4	3 x M12	18
144658	250/8	I	210	33	KK 8	135	171,4	3 x M16	24
144661	315/8	I	210	34	KK 8	150	171,4	3 x M16	25
144664	315/11	III	280	46	KK 11	150	235	3 x M20	30

GF for cylindrical shank DIN 69880



APPLICATION

Optimal for moving and positioning bar material and pipes in automatic production sequence.

TYPE

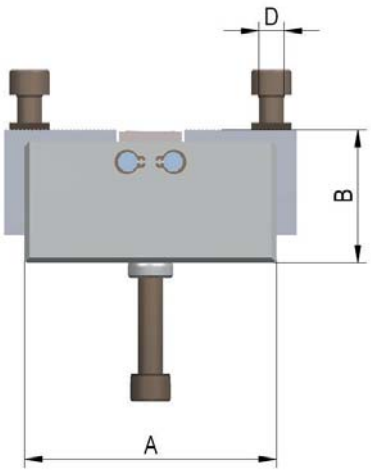
2-jaw gripper chuck GF for cylinder shaft DIN69880.

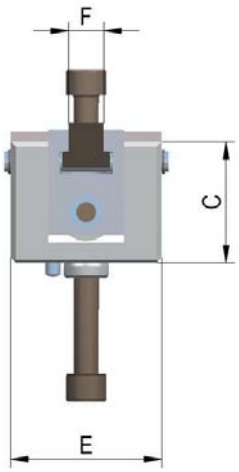
CUSTOMER BENEFITS

- Simple, operationally safe system thanks to spring pretensioning with automatic jaw resetting
- High efficiency thanks to direct placement on the tool turret without additional actuation device
- Simple retrofitting
- Clamping jaws can be adapted for special profiles

TECHNICAL FEATURES

- Clamping force by means of disc spring package
- With exchangeable take-up shaft





C 15

2-jaw gripper chucks GF for cylindrical shank **DIN 69880 Chucks without shank, without jaws**

Item no.	141077	141078	141079
Size	80	100	125
A mm	80	100	125
B mm	50,8	52,8	72,8
C mm	46	48	67
D	M8	M 10	M 10
E mm	50	60	65
FH7 mm	12	14	14
Stroke H mm	3	4	4
U	M8	M 10	M 10
Clamping force min. kN	1,3	2	5,3
Clamping force max. kN	1,7	2,7	6

▲ on request

GF

C 15
Cylindrical shank DIN 69880



Item no.	Initial size	Kh6 mm	L mm	M±0,05 mm
156806	25	25	48	23,5
141080	30	30	55	27
141081	40	40	63	36
141082	50	50	78	45



Jaws GF

C 21
Clamping jaws





Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
141084	80	28	26	28
141085	100/125	30	34	30

Special applications - rational clamping solutions

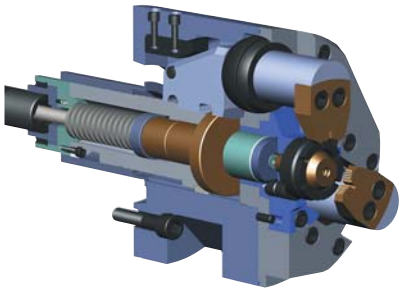


KFD-N Draw-down chuck

APPLICATION
Power chucks based on KFD principle with draw-down for clamping tasks for external clamping where workpiece axial run-out errors have to be minimized.

TYPE AND FUNCTION
Retractable chuck body for drawing down the workpiece onto a rigid plane face. Built-in pressure springs put the body back into its original position.

CUSTOMER BENEFITS
- High clamping precision and clamping force by means of the KFD principle
- With active pull-down for maximum plane-parallelism



KKHFR combination chuck

APPLICATION
Optimally suited for the complete machining of workpieces, such as crankshafts and cam shafts.

TYPE AND FUNCTION
With retractable clamping jaws and face driver. The clamping jaws are retracted for finish turning; the workpiece is moved by the face driver. This way, the outer diameter can be completely machined. For the force-actuated face driver with a rigid point, the chuck is actuated via the hydraulic double piston cylinder and, in the case of a face driver with spring-loaded point, via the hydraulic clamping cylinder with enlarged stroke.

CUSTOMER BENEFITS
- Efficient complete machining of shafts in one set-up



KTF indexing chuck

APPLICATION
For rationally turning of workpieces with a centric and an eccentric center of rotation (or several eccentric centers of rotation), such as crankshafts, housings or pistons.

TYPE AND FUNCTION
Force-actuated. Clamping and indexing via rotary piston cylinders with 4-way oil distributor in connection with Cardan linkage assembly. Indexing angle 180°. Eccentric dimension constant or adjustable.

CUSTOMER BENEFITS
- Efficient machining of workpieces by shifting the center to be machined without reclamping



HTF indexing chuck

APPLICATION
Optimally suited for rationally turning workpieces with a centric and an eccentric center of rotation (or several eccentric centers of rotation), such as crankshafts, housings or pistons.

AUSFÜHRUNG UND FUNKTION
Hydraulically operated. Indexing is done using 2 hydraulically actuated racks. Clamping by means of integrated hydraulic pistons. Indexing angles 180°, 4x90°, 5x72°, 6x60°.

CUSTOMER BENEFITS
- Efficient machining of workpieces by shifting the center to be machined without reclamping

Special applications - rational clamping solutions



HSF indexing chuck

APPLICATION
For machining workpieces with crossing axes.

TYPE AND FUNCTION
Hydraulically actuated indexing chuck.The swivel axes lie perpendicular to the rotational axis. Oil distributor or clamping cylinder required for actuation. Equipped with a moving clamping jaw and a swivelable console jaw. The console jaws define the height of the clamping position of the inserted workpiece.

CUSTOMER BENEFITS
- Rational machining in one set-up
- Fully automated work sequence of swivel positions while the machine is running
- High workpiece precision with regard to the crossing axes, since there is no reclamping
- Long service life thanks to sturdy construction



KSFZ indexing chuck

APPLICATION
For workpieces, such as forgings and castings, where a large diameter tolerance is to be compensated during clamping.

TYPE AND FUNCTION
Force-actuated indexing chuck.

CUSTOMER BENEFITS
- Centrically clamping - Raw part tolerances are compensated
- Maximum productivity thanks to rational machining option in one set-up
- High workpiece precision, since no reclamping



HSFZ ring indexing chuck

APPLICATION
Optimally suited for machining couplings from 2-3/8“ to 20“.

AUSFÜHRUNG UND FUNKTION
Hydraulically actuated ring indexing chuck. 3 jaws centrically and 3 jaws compensating clamping.

CUSTOMER BENEFITS
- No deformation of the workpiece thanks to clamping inserts with several clamping points
- Maximum productivity thanks to rational machining option in one set-up
- High repeat positioning accuracy for maximum precision requirements

Quick-action clamping device change system

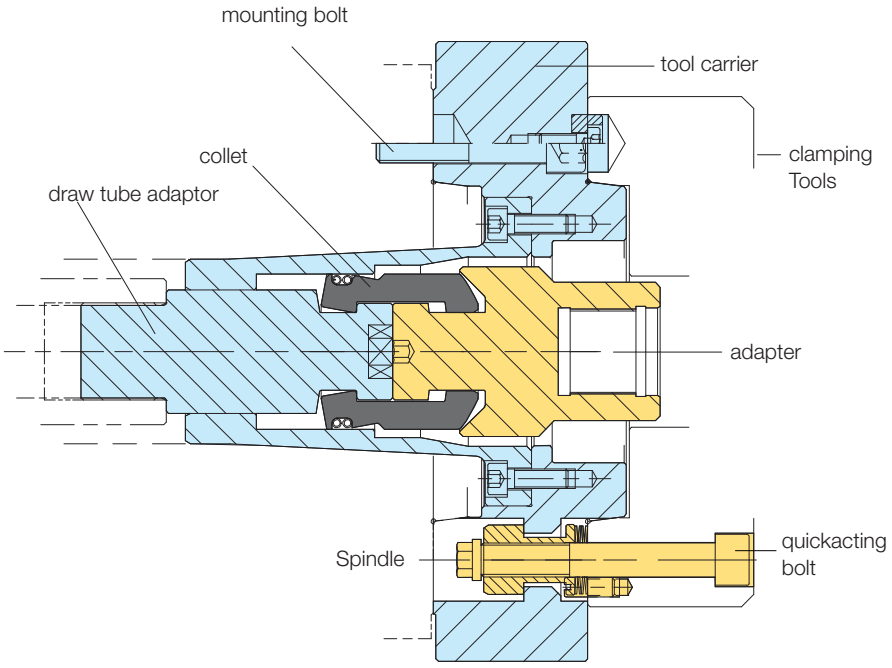
For quickly changing the clamping device

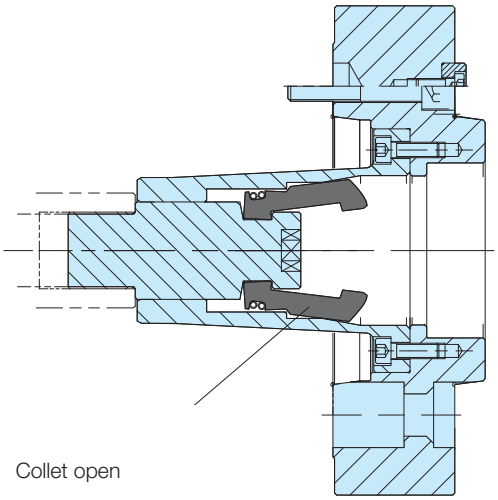
- Easy clamping device change taking all the safety features of modern clamping technology into account
- Use of nearly any clamping mandrels, face drivers or power chucks - They must only have the same connections - on the basic adapter, with shortest time required

Construction:

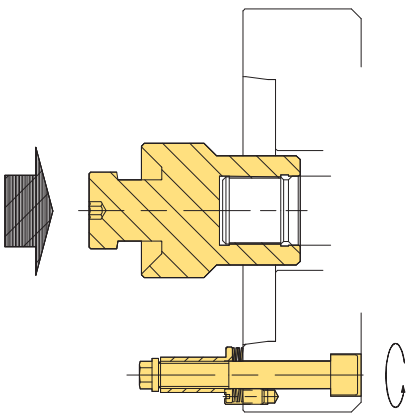
Similar to the automatic / semi-automatic clamping device change system, on the manual change system, too, an increasing number of variants can be produced in decreasing batch sizes more cost-effectively. A standard clamping cylinder without additional devices is sufficient for quickly changing the clamping device.

Particularly clamping mandrels, which often require a change in the clamping mandrel size due to its design, but also clamping systems such as face drivers or power chucks, can be quickly and safely interchanged among each other.





Collet open

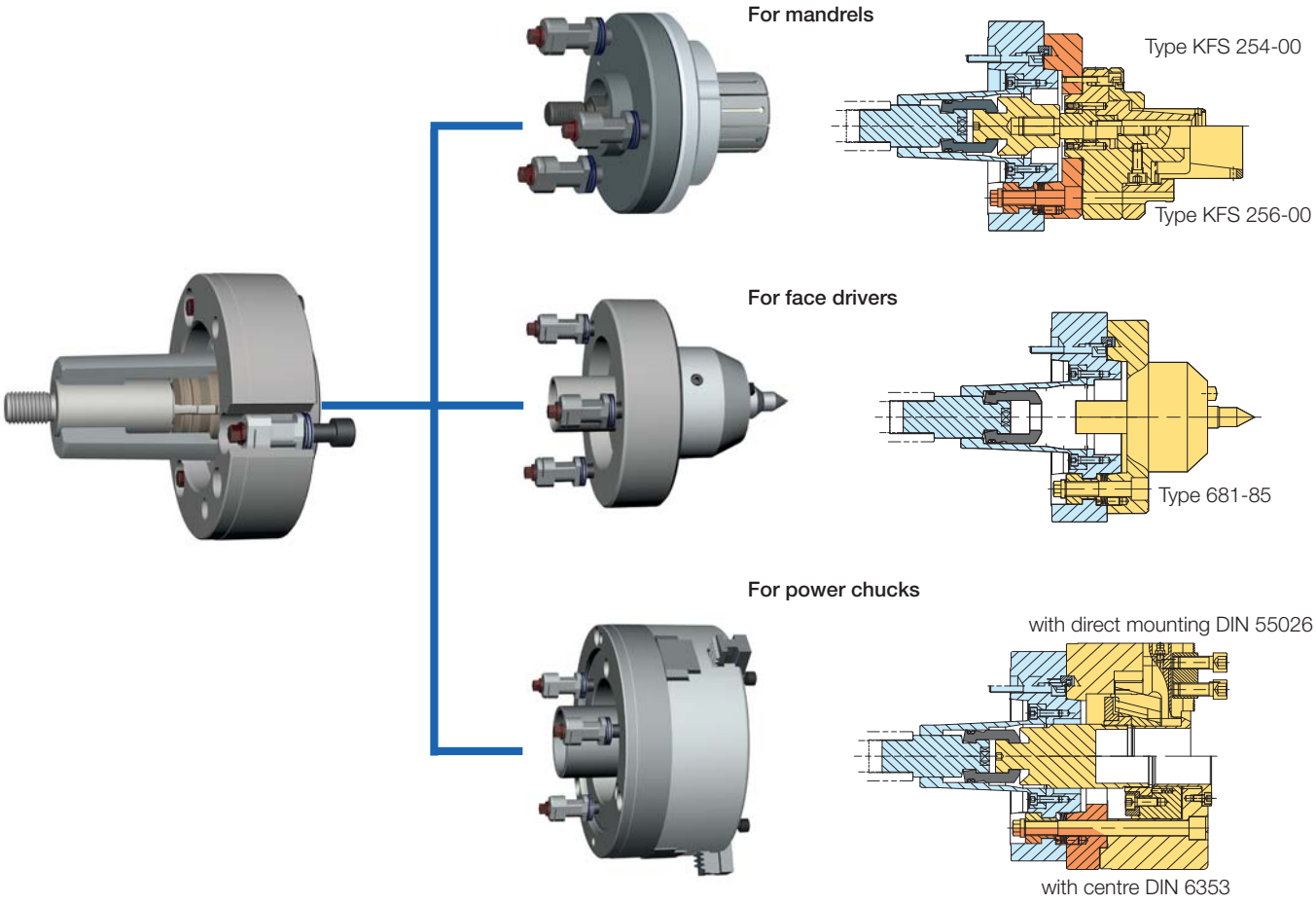


Quick-acting bolt backed off 1/2 turn

Changing the clamping device:

- Move clamping cylinder to the front position
- Loosen the quick-action clamping screw by 1/2 turn
- Lift up the clamping device

Quick-action clamping device change system



Technical features:

- Exact take-up and positioning of the clamping device using short taper mount
- Change precision within 0.005 mm
- Change time approx. 30 seconds
- Easy handling of the change operation
- Locking the clamping device with 3 bayonet nuts and a collet chuck as intermediate piece for draw connection
- Rotary lock of bayonet nut
- High clamping precision
- Clamping cylinders without additional devices
- Stroke control on clamping cylinder
- Central lubrication and/or air sensing possible
- The manual quick-action clamping device change systems RMS, in combination with the RÖHM safety cylinders SZS, OVS, LHS-L, LVS, EHS and EVS, meet the guidelines of the Employer‘s Liability Insurance Association.

Function:

A basic adapter is fastened to a turning spindle, in which a collet chuck is integrated for force transfer. The actual clamping device is adjusted on this basic adapter with quick-action clamping screws by a half turn of the wrench and then tightened. The collet chuck and clamping device are actuated via a safety clamping cylinder mounted to the end of the spindle without additional devices.

Function description:

The basic adapter with built-in collet chuck and draw piece with draw tube connection is screwed onto the spindle with 3 fastening screws. Through the positioning of the adapter of the respective clamping device (e.g. clamping mandrel, face driver, power chuck), the collet chuck is closed, thereby establishing the connection between the draw bar and actuating element (e.g. piston). The clamping device is fastened manually via 3 quick-action clamping screws by turning the wrench 1/2 turn each. The rotary lock of the bayonet nut is secured by a cylinder pin system. This guarantees equivalent fastening as compared to conventional fastening types. The clamping device is dismounted in the opposite order.



FOR EVERY APPLICATION

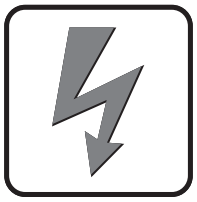
In order to be able to satisfy every application, RÖHM has hydraulically, pneumatically as well as electrically actuated cylinders with through-hole in their product range.



hydraulical operated



pneumatical operated



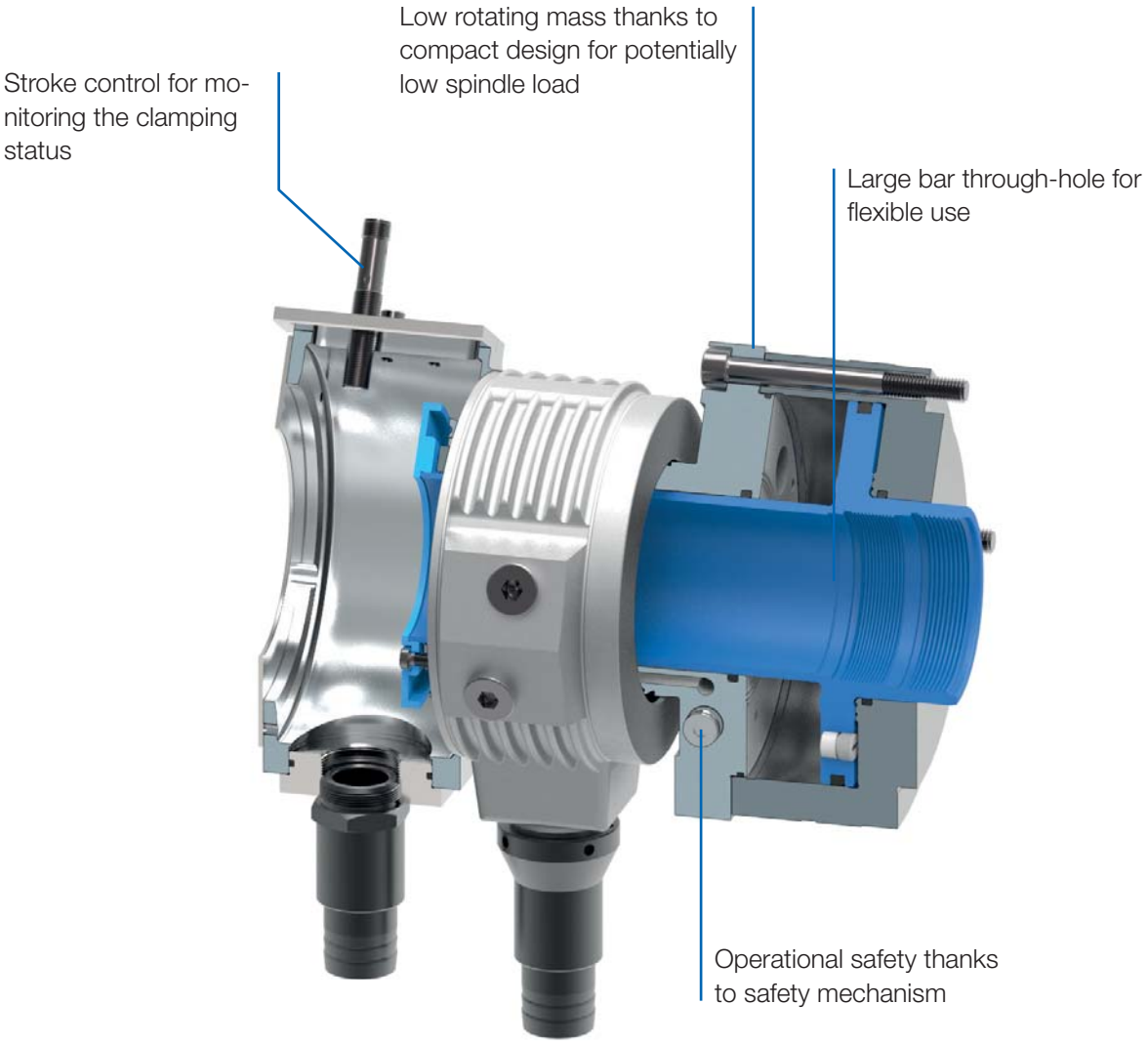
electrical operated

CYLINDERS WITH THROUGH-HOLE

RÖHM clamping cylinders with through-hole are optimally suited for machining different bar material thanks to their large through-hole. The short design and low weight of the clamping cylinders protect the machine spindle and the safety device ensures operational safety, even if the power fails during spindle rotation.

ADVANTAGES AT A GLANCE

- Safe actuation of power chucks and collet chucks for hollow clamping
- Versatile applications thanks to oil, air or electricity actuator media
- Flexible use thanks to large strokes and forces



EHS



APPLICATION

Electrical actuation of power chucks/collet chucks with through-hole.

TYPE

Hollow clamping cylinder with bar through-hole up to 67 mm.

CUSTOMER BENEFITS

- Energy-efficient, since energy is only required during the clamping and unclamping operation
- Flexible use thanks to optimal stroke and force control option (force change, even during rotation)
- High precision thanks to low thermal influences
- Increase in operational safety and quality thanks to constant monitoring of the clamping status
- Low-maintenance and environmentally friendly thanks to omission of hydraulic components
- Stroke sensor outside of dirty area to reduce error susceptibility

TECHNICAL FEATURES

- Coolant collector
- Standard spindle fastening: EHS-37 from the rear, EHS-67 from the front (other spindle flanges on request)
- Motor mount must be fastened to the machine

Scope of delivery:
Mechanical electric clamping cylinder, incl. stroke and force sensor, stationary motor mount, incl. connection components of the toothed belt drive

Note:
Servo motor, control unit, servo amplifier, set of cables and electronic accessories must be ordered separately

Sample calculation for energy savings with an electrical cylinder:

Energy consumption of an oil-operated clamping cylinder

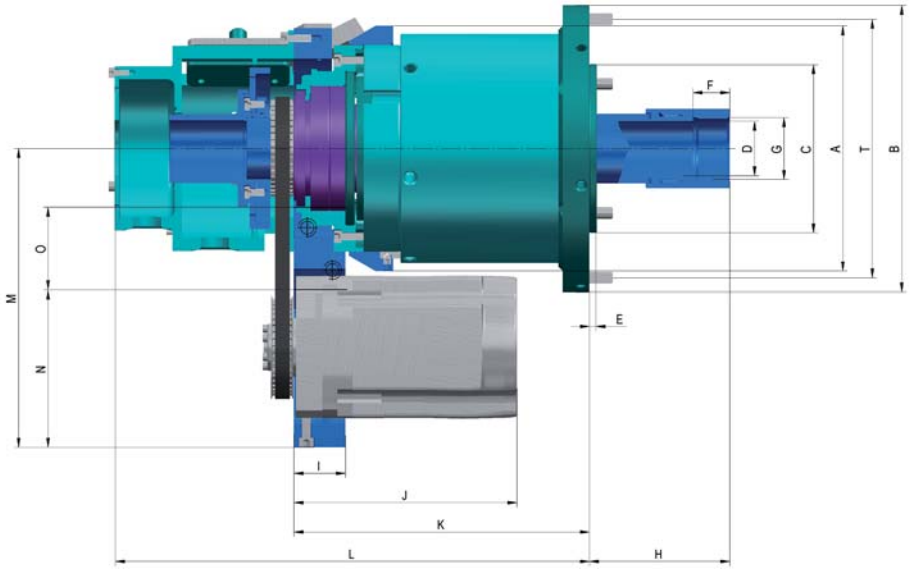
Output of hydraulic unit	1,5 kW
Power dissipation from cylinders:	0,9 kW
Total output of an oil-operated clamping cylinder:	2,4 kW
Energy consumption per year:	14.400 kWh

Energy consumption of an electrical cylinder:

Total output of the EHS	0,1 kW
Energy consumption per year:	600 kWh
Energy saving potential per year:	**13.800 kWh**

The above assumptions have been based on a standard manufacturing process in three-shift operation and may vary depending on the application involved. Where greater efficiency is achieved in the processing (e.g. by getting the best possible match between the cylinder and the process, or through shorter lift times), even more energy can be saved by indirect means.

EHS



C 15

Electrical cylinder with through-hole EHS

Item no.	1289821 ▲	1290622 ▲
Pull force area kN	5-50	5-68
Total stroke mm	32	32
External Ø A mm	167	255,5
Ø B mm	195	209,8
C h 6 mm	115	170
Through-hole D mm	37	67
E mm	5	8
T Pitch circle spindle connection	176 (M8 - 6x60°) Fastening from the rear	196 (M6 - 12x30°) Fastening from the front
F mm	25	25
G	M42x1,5	M75x2
Stroke min/max	63/95	57/89
I mm	35	33,5
J mm	151,5	177,5
K mm	200,7	226,6
L mm	322,5	348
M mm	203	260
N mm	98	130
O mm	55	55
Speed max. min-1	6000	6000
Weight approx. kg	28,9	60
Rotating mass kg	25	53
Moment of inertia kg/m2	0,086	0,36

Accessories EHS - Necessary for function

C 15
Servo drive for electrical cylinders

Item no.	Size	Contents of delivery	Type
1293003 ▲	EHS-37	piece	Siemens 1FK7040-2AK71-1TG0, Type: Resolver, without brake
1293004 ▲	EHS-67	piece	Siemens 1FK7042-2AK71-1TG0, Type: Resolver, without brake

C 15
Control unit for electrical cylinders

Item no.	Contents of delivery	Type
1266223 ▲	piece	Controller for electrical cylinders, communication Type: PROFIBUS, incl. software with standard functions

Optional: PROFINET, CANopen, Digital/Analog on request

C 15
Servo amplifier for electrical cylinders

Item no.	Contents of delivery	Type
1290634 ▲	piece	Servo amplifier AC12A00S03.00 to control servo motor; without security card
1290635 ▲	piece	Servo amplifier SIK2 AC12A00S03.00 to control servo motor; with security card

A servo amplifier optionally with or without security card will be needed.

C 15
Cable set for electrical cylinders

Item no.	Contents of delivery	Type
1268783 ▲	piece	Contains encorder cable and power line between servo drive and servo amplifier; sensor cable between electrical cylinder and control unit; CAN-line (3m) between servo amplifier and control unit (cable length: 20m)

All electrical connections and cables between machine and cylinder have to be provided by the customer

Accessories EHS - Optionally for function

C 15
Brake module for electrical cylinders

Item no.	Contents of delivery	Type
1266231 ▲	piece	Brake modul 11BC1-14: For connection to the servo amplifier to dissipate the braking energy. Necessary if there is no intermediate circuit supply at the machine

C 15
Brake resistor for electrical cylinders

Item no.	Contents of delivery	Type
1266232 ▲	piece	Brake resistor 39BR006: For dissipate of the braking energy. Necessary if there is no intermediate circuit supply at the machine

Notes

SZS



APPLICATION

Hydraulic actuation of power chucks/collet chucks with through-hole.

TYPE

Hollow clamping cylinders for actuation pressures of 8-45 bar.

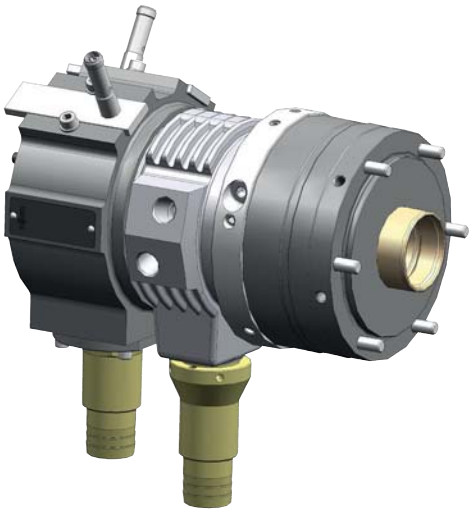
CUSTOMER BENEFITS

- Short design and low weight ensure small machine spindle load and also allow high speeds
- Thanks to the large through-hole, optimally suited for machining bar material
- Operational safety thanks to safety mechanism, guaranteed even if there is a pressure drop during spindle rotation

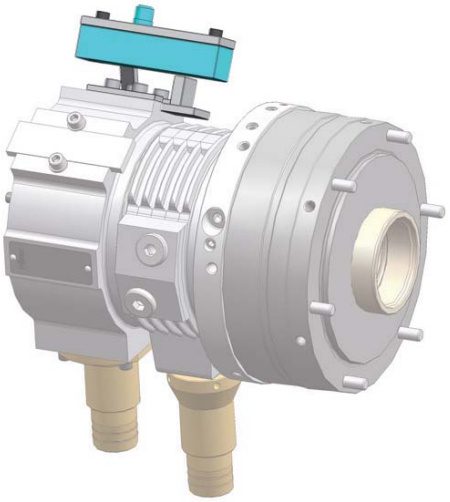
TECHNICAL FEATURES

- Stroke control by means of inductive proximity system or linear path measuring system F90 (stroke control system not included in the scope of delivery)
- Overpressure safeguard
- Coolant collector
- Fastening from the rear with through bolts
- For its actuation, we recommend hydraulic oil H-LP 32, DIN 51525 (32 centistokes at 40° Celsius)
- Insert a filter unit (10 µm) between the pump and control valve
- Can also be actuated during rotation
- Hollow clamping cylinders can usually only be used for horizontal machining axes

Note:
RÖHM clamping cylinders meet the testing requirements of the Employer's Liability Insurance Association thanks to their safety system and stroke check



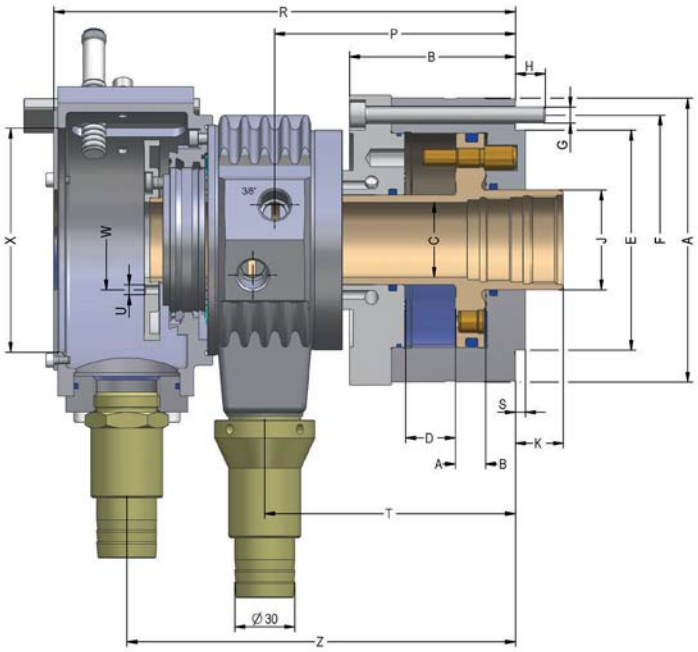
Standard:
Prepared for inductive proximity system

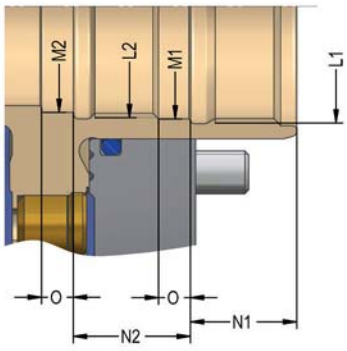


Optional stroke monitoring with F 90:
High resolution, minimal temperature drift, contactless, teachable, inductive effect principle

▲ on request

SZS up to 45 bar, short design



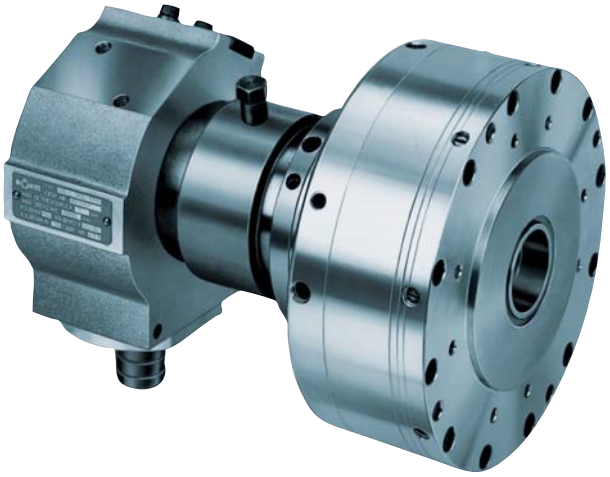


C 15

Oil operated actuating cylinders SZS Basic model up to 45 bar, short design for high speeds

Item no.	432765	432766	432767	432768	432769 ▲	432770 ▲	435766 ▲	433217 ▲
Size	46/103	52/130	67/150	77/170	86/200	95/225	110/250	127/325
A mm	162	182	197	212	228	245	264	295
B mm	83	83	94	94	104	104	104	127
C mm	46,5	52,5	67,5	77	86,5	95,5	110,5	127,5
Stroke D mm	25	25	30	30	35	35	35	40
Eh6 mm	130	140	160	160	180	210	210	250
F mm	147	165	180	185	210	227	240	270
G	6xM8	6xM8	6xM10	6xM10	6xM10	6xM10	6xM10	6xM12
H mm	15	15	15	15	15	15	16	20
J mm	61	70	85	95	105	115	130	145
K max.	22	22	25	25	31	31	31	44
K min.	-3	-3	-5	-5	-4	-4	-4	4
L1	M55x2	M60x1,5	M75x2	M85x2	M95x2	M105x2	M120x2	M135x2
L2	M50x1,5	M55x2	M72x1,5	M80x2	M90x2	M100x2	M115x2	-
M1 mm	52,5	57,5	72,5	82	92	102,5	117,5	132
M2 mm	47	52,5	69	77	87	97	112	-
N1 mm	25	25	25	25	32	32	32	30
N2 mm	25	28	28	28	30	30	30	-
O mm	6	6	6	6	6	6	6	6
P mm	120,5	120,5	138,5	138,5	155	159	166,3	196
R mm	231	231	269	269	292	302	321	355
S mm	5	5	8	8	8	8	8	5
T mm	125,75	125,75	142,75	142,75	159,25	163,25	171,5	201,5
U	2xM6	2xM6	2xM6	2xM6	2xM6	2xM6	4xM6	2xM6
W mm	68	76	91	91	116	120	135	150
X mm	122	122	135	145	167	177	116	131
Z mm	195,5	195,5	225	226	249	259	275	307
Piston area A cm2	109,8	142,4	164,5	184	212,6	243,5	267	337
Piston area B cm2	103,5	131	152	170	197	226,2	247,4	325,7
Eff. draw bar pull (F=45 bar) kN	46	58	68	76	88	100	110	145
Max. admissible speed min-1	7000	6300	5500	5000	4500	4000	3500	3200
Oil leakage rate (30 bar 50° C - n max.) l/min	3	3,5	4	4,5	5	5	5	6
Moment of inertia J kgm2	0,03	0,045	0,07	0,13	0,17	0,3	0,35	0,58
Weight approx. kg	16	18	22	30	35	38	48	66

LHS-L



APPLICATION

Pneumatic actuation of power chucks/collet chucks with through-hole.

TYPE

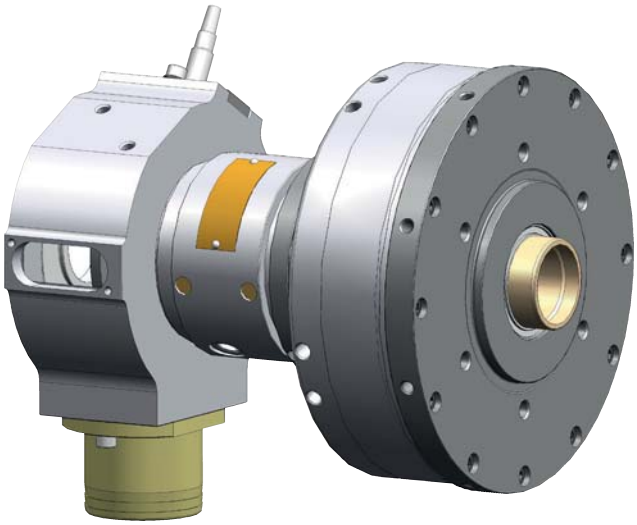
Hollow clamping cylinders for actuation pressures from 1.5-8 bar.

CUSTOMER BENEFITS

- Short design and low weight ensure small machine spindle load and also allow high speeds
- Thanks to the large through-hole, optimally suited for machining bar material
- Operational safety thanks to safety mechanism, guaranteed even if there is a pressure drop during spindle rotation

TECHNICAL FEATURES

- Stroke control via inductive proximity switches (not included in the scope of delivery)
- Coolant collector
- Can also be actuated during rotation



Accessories:

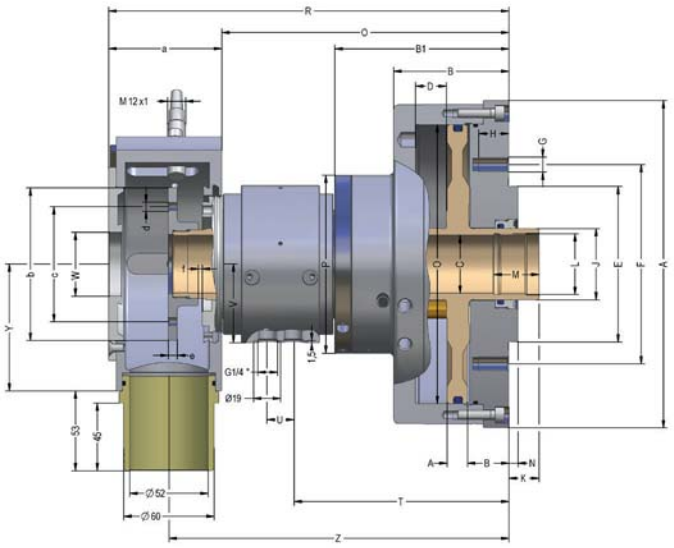
Connection for supply and drain hoses

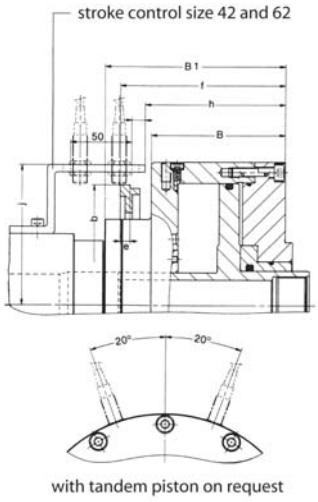
Special accessories:

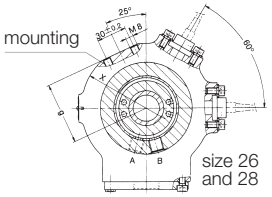
2 inductive proximity switches Piece/Item no. 381551 (Opener)
or 2 inductive proximity switches Piece/Item no. 202759 (Closer)

With tandem piston on request.

LHS-L







C 15

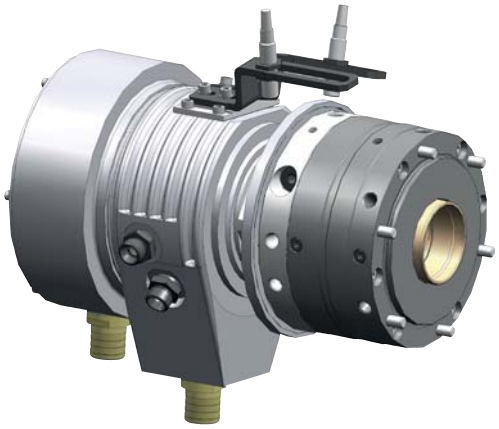
Air actuating cylinders with through-hole LHS-L with safety valve

The coolant collection shell (sizes 26 and 38) must be held centrically by a bracket on the machine.

Item no.	417310 ▲	417311 ▲	417312 ▲
Size	26/190	38/251	42/289
A mm	187	215	235
B mm	76	78	109,7
B1 mm	110	110	147,5
C mm	26,2	38,2	42
Stroke D mm	20	20	32
E-0,01 mm	70	103	103
F mm	105	132	145
G	6 x M 8	6 x M 10	8 x M 8
H mm	15	20	20
J mm	38	50	57
K max.	20	20	20
K min.	0	0	-12
L	M 32 x 1,25	M 44 x 1,5	M 52 x 1,5
M mm	25	30	30
N mm	5	6	6
O mm	160	185	200
P mm	106	118	140
Q mm	197	198	263,7
R mm	275	273	337,7
S mm	210	211	283,5
T mm	141	140	188
U mm	23	23	28,5
V mm	46	52	60
W mm	42	42	51
X mm	130	151	151
Y mm	73,5	84	84
Z mm	233,5	233	297,7
a mm	78	75	74
b mm	77	101	197
c mm	61	76	-
d	4 x M 6	4 x M 6	-
e mm	7,5	7,5	8
f max.	22,5	22,5	135
f min.	2,5	2,5	167
g mm	62	72	-
h mm	-	-	114,7
j mm	-	-	115
Piston area A cm2	189,7	249,1	288,6
Piston area B cm2	190,9	251,4	291,3
Eff. draw bar pull (F=6 bar) kN	10,47	13,75	15,90
Max. admissible speed min-1	6500	6500	4000
Volume for full double stroke l	0,762	1	1,9
Moment of inertia J kgm2	0,03	0,06	0,102
Weight approx. kg	11,8	16	25,5

When working with high and low pressure, the release of the safety valve is guaranteed for clamping pressure: Unclamping pressure 2:1

Special solutions - on request



SZS (80 bar) Hollow clamping cylinder

APPLICATION

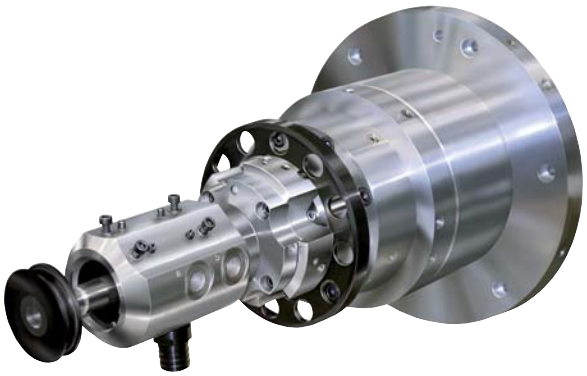
For the hydraulic actuation of power chucks/collet chucks with through-hole.

TYPE

Hollow clamping cylinders for actuation pressures up to 80 bar.

CUSTOMER BENEFITS

- Stroke control outside of the coolant collection bowl
- Operational safety thanks to safety valve, guaranteed even if there is a pressure drop during spindle rotation
- Low mass moment of inertia and required installation space thanks to reduced external diameter
- Flexible application: Low draw forces thanks to reduced piston surface, and nevertheless maximum draw forces thanks to high maximum actuation pressure



OVUSHH Double piston cylinder

APPLICATION

For hydraulic actuating of power chucks with additional functions (ejector, retractable center points, etc.).

TYPE

With 4-way oil supply.

CUSTOMER BENEFITS

- Different strokes, piston surfaces and arbitrary safety requirements can be realized thanks to modular system
- Feed-through of another medium (coolant, oil, air, etc.) through the cylinder axis by installing an additional rotary feed-through.

Notes



FOR EVERY APPLICATION

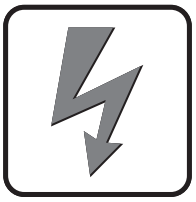
In order to be able to satisfy every application, RÖHM has hydraulically, pneumatically as well as electrically actuated cylinders without through-hole in their product range.



hydraulical operated



pneumatical operated



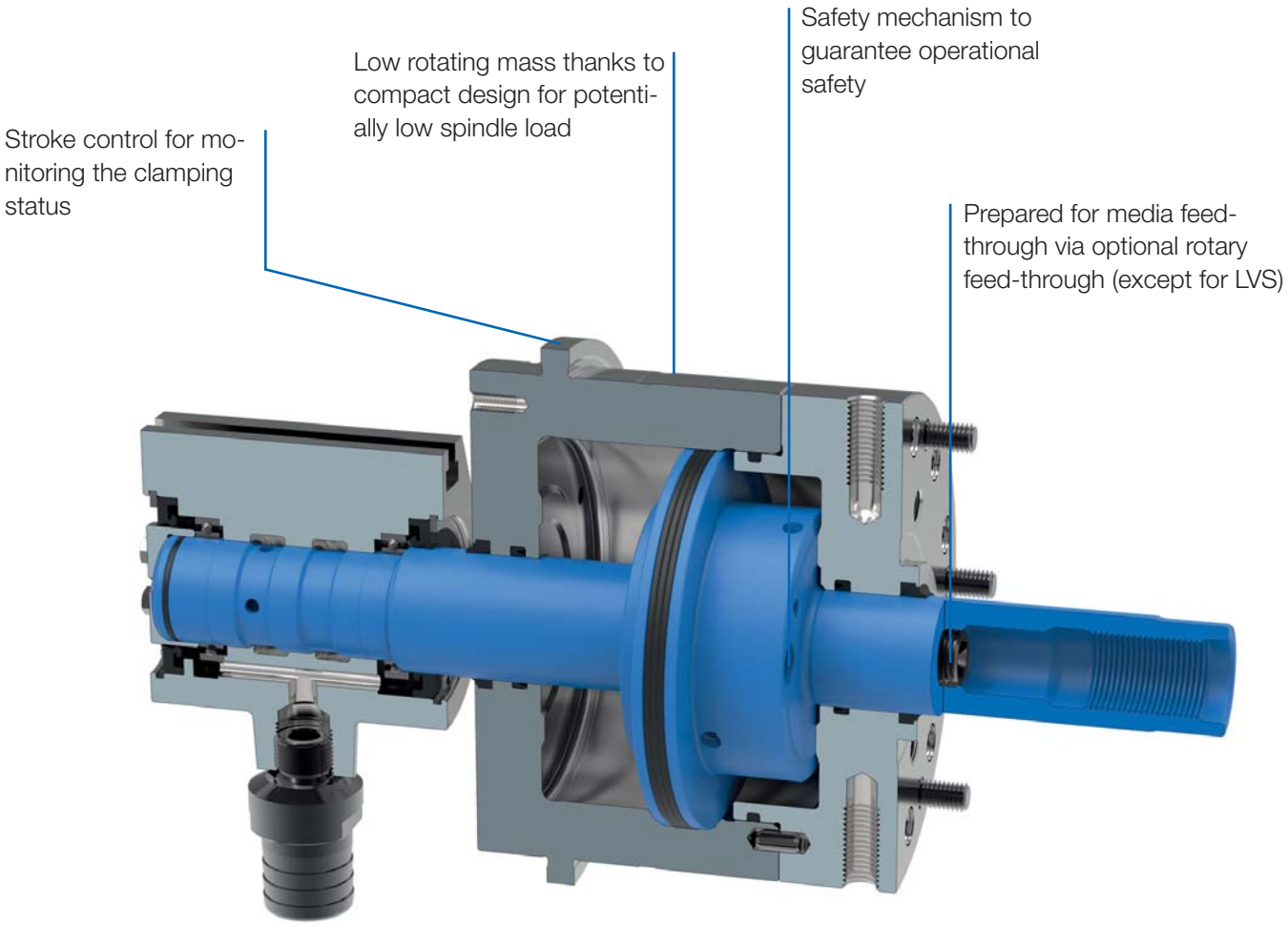
electrical operated

CYLINDER WITHOUT THROUGH-HOLE

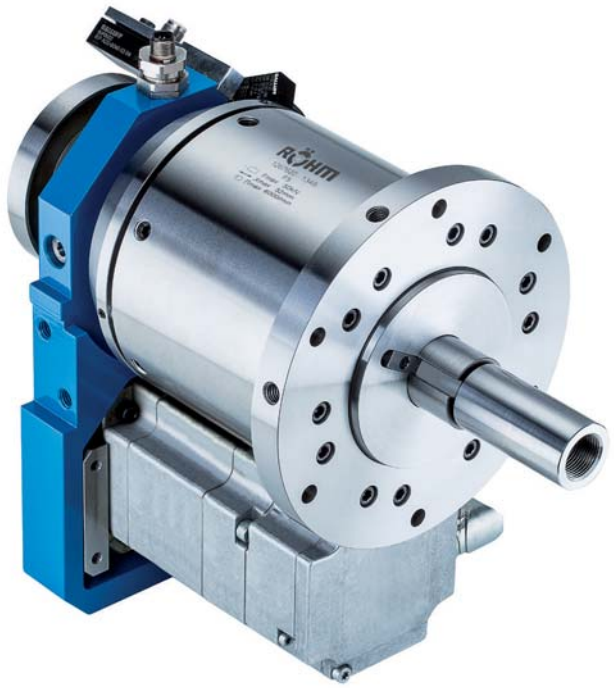
RÖHM clamping cylinders without through-hole are optimally suited for actuating power chucks or special clamping devices for full or partial hollow clamping. Thanks to the possibility of a horizontal or vertical installation position, the clamping cylinders can be used flexibly and the safety mechanism guarantees operational safety, even if the power fails during spindle rotation.

ADVANTAGES AT A GLANCE

- Safe actuation of power chucks or special clamping devices for full or partial hollow clamping
- Versatile applications thanks to oil, air or electricity actuator media
- Flexible use thanks to large strokes and forces



EVS



APPLICATION

Electrical actuation of power chucks without through-hole.

TYPE

Clamping cylinder with feed-through Ø 11 mm for coolant or other media.

CUSTOMER BENEFITS

- Energy-efficient, since energy is only required during the clamping and unclamping operation
- Flexible use thanks to optimal stroke and force control option (force change, even during rotation)
- High precision thanks to low thermal influences
- Low-maintenance and environmentally friendly thanks to omission of hydraulic components
- Increase in operational safety and quality thanks to constant monitoring of the clamping status

TECHNICAL FEATURES

- Standard spindle mounting from the rear (other spindle flange on request)
- Motor mount must be fastened to the machine
- Possible attachment of rotary feed-throughs

Scope of delivery:
Mechanical electric clamping cylinder, incl. stroke and force sensor, stationary motor mount, incl. connection components of the toothed belt drive

Note:
Servo motor, control unit, servo amplifier, set of cables and electronic accessories must be ordered separately.

Sample calculation for energy savings with an electrical cylinder:

Energy consumption of an oil-operated clamping cylinder

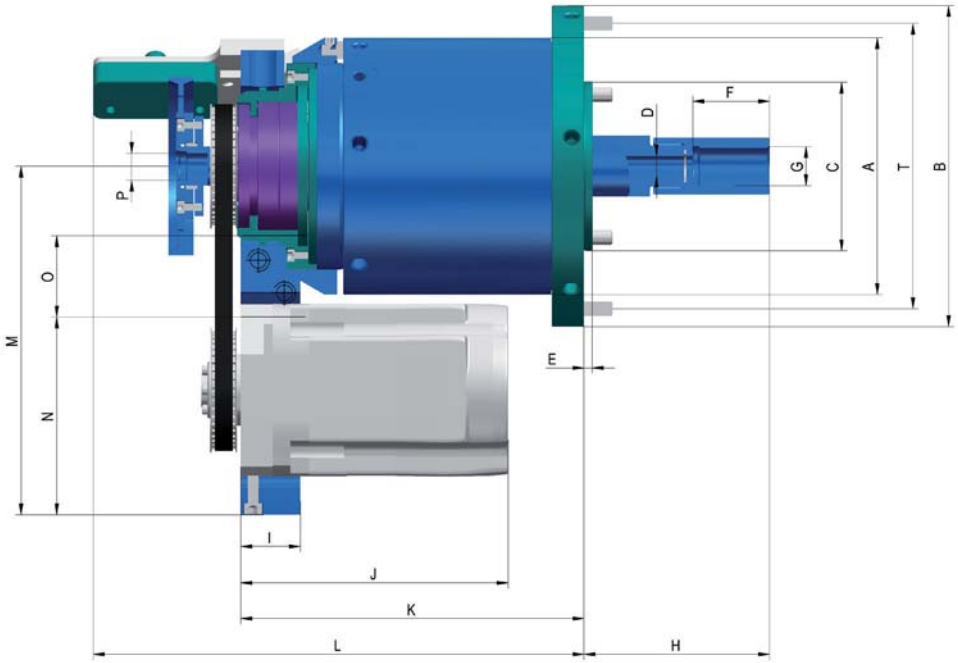
Output of hydraulic unit	1,5 kW
Power dissipation from cylinders:	0,9 kW
Total output of an oil-operated clamping cylinder:	2,4 kW
Energy consumption per year:	14.400 kWh

Energy consumption of an electrical cylinder:

Total output of the EVS	0,1 kW
Energy consumption per year:	600 kWh
Energy saving potential per year:	**13.800 kWh**

The above assumptions have been based on a standard manufacturing process in three-shift operation and may vary depending on the application involved. Where greater efficiency is achieved in the processing (e.g. by getting the best possible match between the cylinder and the process, or through shorter lift times), even more energy can be saved by indirect means.

EVS



C 15

Electrical cylinder without through-hole EVS with feed-through Ø 11 mm for coolant or other media

Item no.	1267620 ▲
Pull force area kN	5-50
Total stroke mm	32
External Ø A mm	144
Ø B mm	180
C h 6 mm	95
Through-hole D mm	11
Pitch circle spindle connection T	160 (M8 6x60°)
E mm	5
F mm	43
G	M22x1,5
Stroke min/max	72/104
I mm	33,5
J mm	150
K mm	192,5
L mm	275
M mm	195,5
N mm	110,5
O mm	55
P	5/8-18 UNF
Speed max. min-1	6000
Rotating mass kg	22,8
Weight approx. kg	34,8
Moment of inertia kg/m2	0,059

Accessories EVS - Necessary for function

C 15
Servo drive for electrical cylinders

Item no.	Size	Contents of delivery	Type
1293003 ▲	EVS-50	piece	Siemens 1FK7040-2AK71-1TG0, Type: Resolver, without brake

C 15
control unit for electrical cylinders

Item no.	Contents of delivery	Type
1266223 ▲	piece	Controller for electrical cylinders, communication Type: PROFIBUS, incl. software with standard functions

Optional: PROFINET, CANopen, Digital/Analog on request

C 15
Servo drive for electrical cylinders

Item no.	Contents of delivery	Type
1290634 ▲	piece	Servo amplifier AC12A00S03.00 to control servo motor; without security card
1290635 ▲	piece	Servo amplifier SIK2 AC12A00S03.00 to control servo motor; with security card

A servo amplifier optionally with or without security card will be needed

C 15
Cable set for electrical cylinders

Item no.	Contents of delivery	Type
1268783 ▲	piece	Contains encorder cable and power line between servo drive and servo amplifier; sensor cable between electrical cylinder and control unit; CAN-line (3m) between servo amplifier and control unit (cable length: 20m)

All electrical connections and cables between machine and cylinder have to be provided by the customer

Accessories EVS - Optionally for function

C 15
Brake module for electrical cylinders

Item no.	Contents of delivery	Type
1266231 ▲	piece	Brake modul 11BC1-14: For connection to the servo amplifier to dissipate the braking energy. Necessary if there is no intermediate circuit supply at the machine

C 15
Type 7700 Brake resistor for electrical cylinders

Item no.	Contents of delivery	Type
1266232 ▲	piece	Brake resistor 39BR006: For dissipate of the braking energy. Necessary if there is no intermediate circuit supply at the machine

Notes

OVS



APPLICATION

Hydraulic actuation of power chucks (full or partial hollow clamping).

TYPE

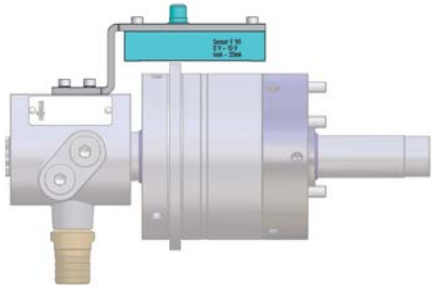
Clamping cylinders without through-hole for actuation pressures from 8-80 bar.

CUSTOMER BENEFITS

- Compact design and low mass moment of inertia for low machine spindle load
- Operational safety thanks to safety mechanism, guaranteed even if there is a pressure drop during spindle rotation
- Flexible use thanks to possible horizontal or vertical installation position

TECHNICAL FEATURES

- Stroke control by means of inductive proximity system or linear path measuring system F90 (stroke control system not included in the scope of delivery)
- Through hole for media feed-through
- For its actuation, we recommend hydraulic oil H-LP 32, DIN 51525 (32 centistokes at 40° Celsius)
- Insert a filter unit (10 µm) between the pump and control valve

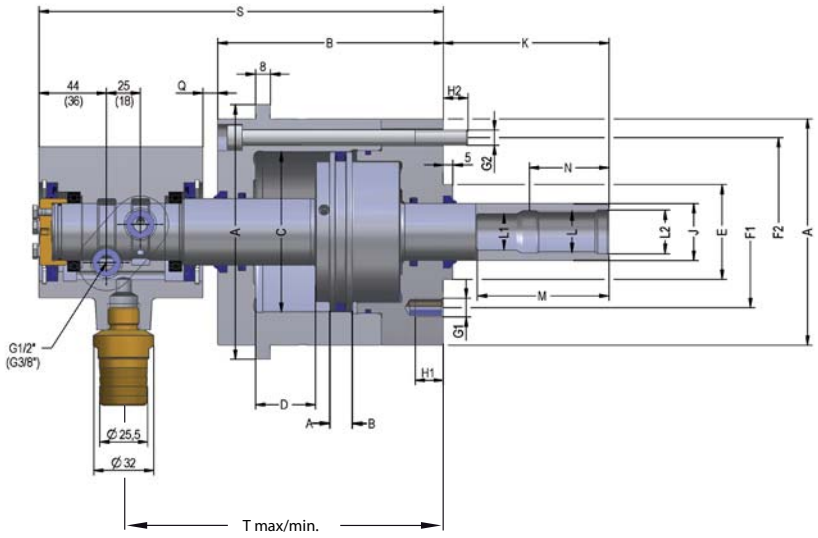


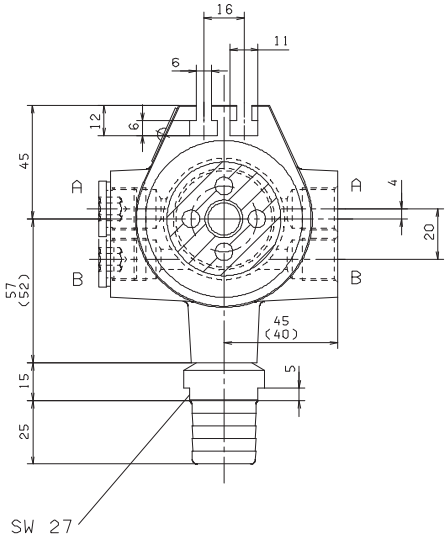
Stroke control with monitoring system F 90:

- High resolution and accuracy
- Minimal temperature drift
- Contactless
- Teaching mode
- Inductive principle of operation

With high and low pressure chucking the change-over of the safety valve is guaranteed when:
chucking pressure : releasing pressure =< 5,5 : 1 (Size 85 - 130)
chucking pressure : releasing pressure =< 3,8 : 1 (Size 150 - 200)

OVS



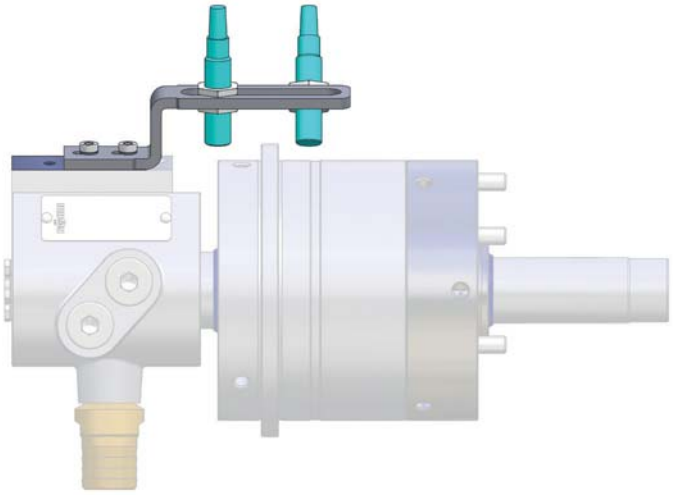


C 15

Oil-operated actuating cylinders without through-hole OVS Basic model, with safety device, up to 80 bar -
Steel design for high speed, fastening from the rear, central through-hole

Item no.	438261	438262	438263	438264	438265
Size	85	105	130	150	200
Design	steel	steel	steel	steel	steel
A mm	120	140	165	193	245
A1 mm	135	155	180	208	260
B mm	120	120	120	147	164
C mm	85	105	130	150	200
Stroke D mm	32	32	32	45	50
Eh6 mm	50	50	80	95	125
F1 mm	80	80	105	145	170
F2 mm	100	120	145	170	220
G1	M10 (3x120°)	M10 (4x90°)	M12 (4x90°)	M16 (4x90°)	M16 (6x60°)
G2	M8 (6x60°)	M8 (6x60°)	M8 (8x45°)	M10 (8x45°)	M12 (8x45°)
H1 mm	15	15	18	24	29
H2 mm	13	13	13	14	19
J mm	30	32	42	50	70
K max.	88	88	82	98	108
K min.	56	56	50	53	58
L mm	M 22 x 1,5	M 22 x 1,5	M 30 x 2	M 36 x 2	M 48 x 2
L1 mm	19	19	26	30	42
L2 mm	23	23	32	38	50
M mm	70	70	88	105	125
Min. reach of draw bar N mm	43	43	65	78	90
Q max.	40	40	40	53	58
Q min.	8	8	8	8	8
S max.	252	247	247	307	329
S min.	220	215	215	262	279
T max.	202	202	202	250	272
T min.	170	170	170	205	222
Piston area A cm2	47,1	77	116,8	160,8	298,2
Piston area B cm2	49,7	78,6	118,9	157,1	275,7
Eff. draw bar pull (F=60 bar) kN	29,50	47	71,3	94	165,4
Max. admissible speed min-1	8000	8000	5000	5500	4500
Volume for full double stroke l	0,31	0,5	0,775	1,43	2,87
Moment of inertia J kgm2	0,018	0,03	0,066	0,142	0,36
Weight approx. kg	10	12,7	17,7	31,4	49
Suitable connecting flange for Duoflow Rotating Unions	**1022186**	**1022186**	**1022187**	**1022187**	**1022187**

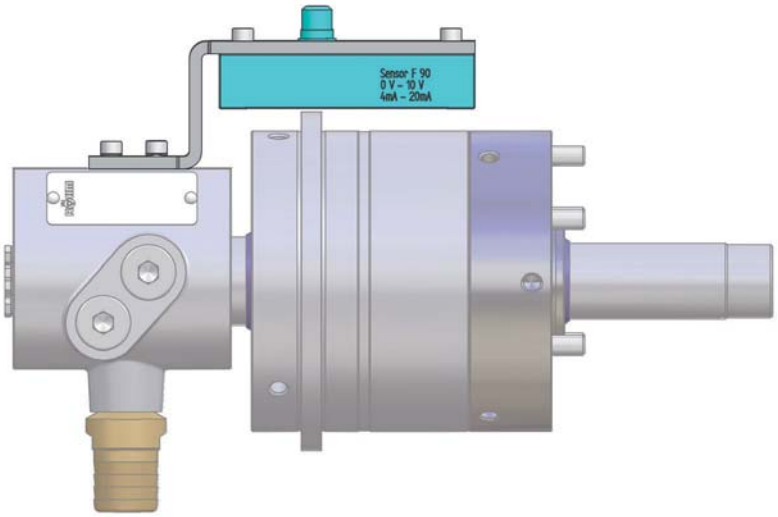
Stroke Monitors OVS



C 15
OVS-stroke monitoring by inductive proximity switches (Limit switch not included in the scope of delivery)

Item no.	Size
1159712	OVS 85
1159713	OVS 105
1159714	OVS 130
1159715	OVS 150
1159716	OVS 200

Order cylinder separately
External rotary feed-throughs fitting Deublin/Rotoflux



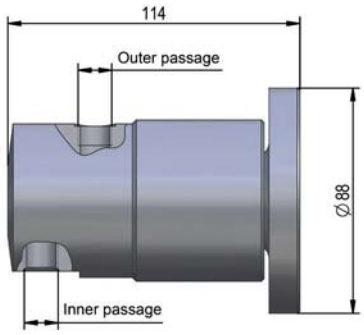
C 15
OVS-stroke monitoring linear, inductive F90 (F90 system included)

Item no.	Size
1159707	OVS 85
1159708	OVS 105
1159709	OVS 130
1159710	OVS 150
1159711	OVS 200

Order cylinder separately
External rotary feed-throughs fitting Deublin/Rotoflux

▲ on request

Accessories



C 15

2-Through-hole rotating unions

Item no.	Inner passage			Outer passage		
	Connection	Media	Max. Pressure	Connection	Media	Max. Pressure
1118079	1/4	Oil	70	1/4	Air	10
1118080	1/4	Coolant	70	1/4	Air	10
1118081	3/8	Air	10	1/8	Air	10
1118082	1/4	Air	10	1/4	Oil	40
1118083	1/4	Air	10	1/4	Coolant	40

Optional: 1-Through-hole Rotating Union for OVS Size 85-105 Item No.: 600599
Optional: 1-Through-hole Rotating Union for OVS Size 130-150 Item No.: 326372
Optional: 1-Through-hole Rotating Union for OVS Size 200 Item No.: 611172
Connecting flange complete for 2-passage roating union size 85-105 Item no.: 1022186
Connecting flange complete for 2-passage roating union size 130-200 Item No.: 1022187

LVS



APPLICATION

Pneumatic actuation of power chucks or special clamping devices (full or partial hollow clamping).

TYPE

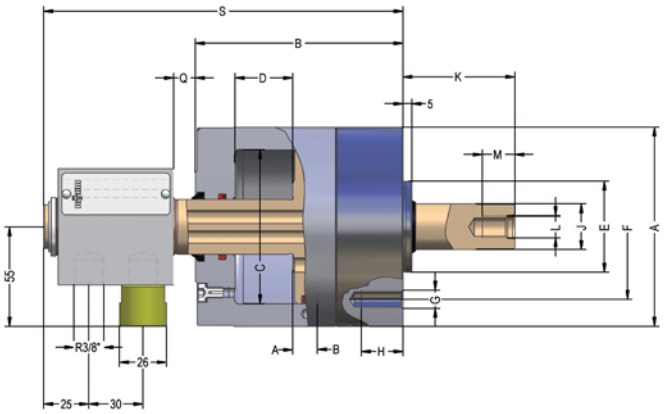
Clamping cylinders without through-hole for actuation pressure 2-10 bar.

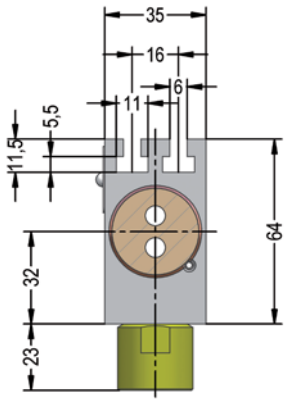
CUSTOMER BENEFITS

- Operational safety thanks to standard safety mechanism, guaranteed even if there is a pressure drop during spindle rotation
- Flexible use thanks to possible horizontal or vertical installation position

TECHNICAL FEATURES

- Stroke control by means of inductive proximity system or linear path measuring system F90, fastened on the machine side (stroke control system not included in the scope of delivery)
- The maximum permissible speed can be run in continuous operation (100% ED)
- Can also be actuated during rotation
- On request with central media feed-through





C 15

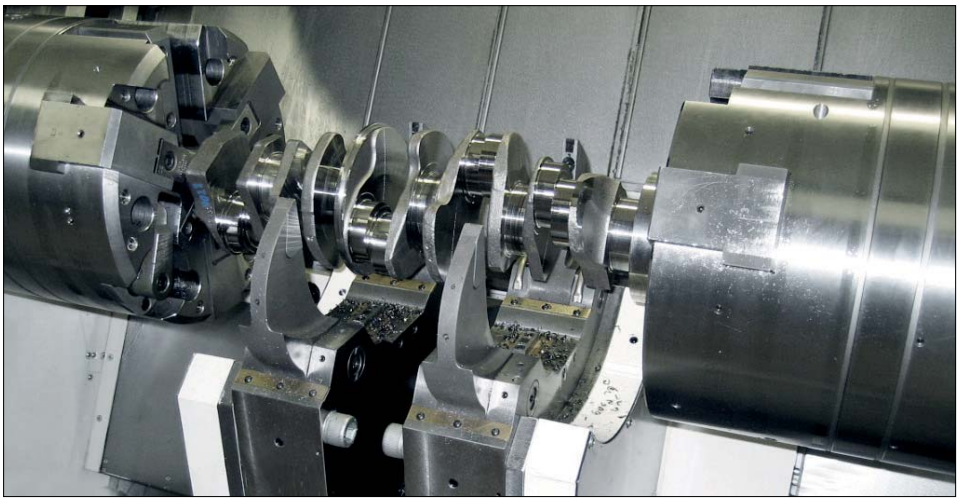
LVS Air actuating cylinders without through-hole, with safety mechanism and stroke control

Item no.	096553	096554	096555	096556	096557	096558	096560
Size	85	105	130	150	200	250	350
A mm	110	130	155	180	240	287	387
B mm	115	115	117	128	125	125	148
C mm	85	105	130	150	200	250	350
Stroke D mm	32	32	32	32	32	32	45
Eh6 mm	50	50	80	95	95	125	125
F mm	80	80	105	145	145	170	170
G	3 x M 10	3 x M 10	3x M 12	4 x M 16	4 x M 16	6 x M 16	6 x M 16
H mm	23	23	27	35	35	35	35
J mm	25	25	25	25	35	35	35
K max.	62	88	79	74	87	87	82
K min.	30	56	47	42	55	55	37
L	M 12	M 12	M 16	M 16	M 24	M 24	M 24
M mm	18	18	24	24	36	36	36
Q max.	44	44	44	44	44	44	57
Q min.	12	12	12	12	12	12	12
S max.	231	231	233	244	241	241	277
S min.	199	199	201	212	209	209	232
Piston area A cm2	49,7	79,5	125,7	169,6	307,1	483,8	955
Piston area B cm2	51,8	81,7	127,8	171,8	304,5	481,5	952,5
Eff. draw bar pull (F=6 bar) kN	3	4,80	7,50	10	18	28,50	56,50
Max. admissible speed min-1	5000	5000	5000	5000	4500	4000	3200
Air consumption for full double stroke at 6 bar NL	2,8	4,6	6,5	7,5	12,5	18	50
Moment of inertia J kgm2	0,007	0,009	0,03	0,06	0,09	0,10	0,45
Weight approx. kg	5,3	6,5	9	12,5	19,5	23	32,5

▲ on request

Notes

OPTIMAL COMPONENT SUPPORT



Optimal support of components for every application, e.g. crankshaft machining

SELF-CENTERING STEADY RESTS

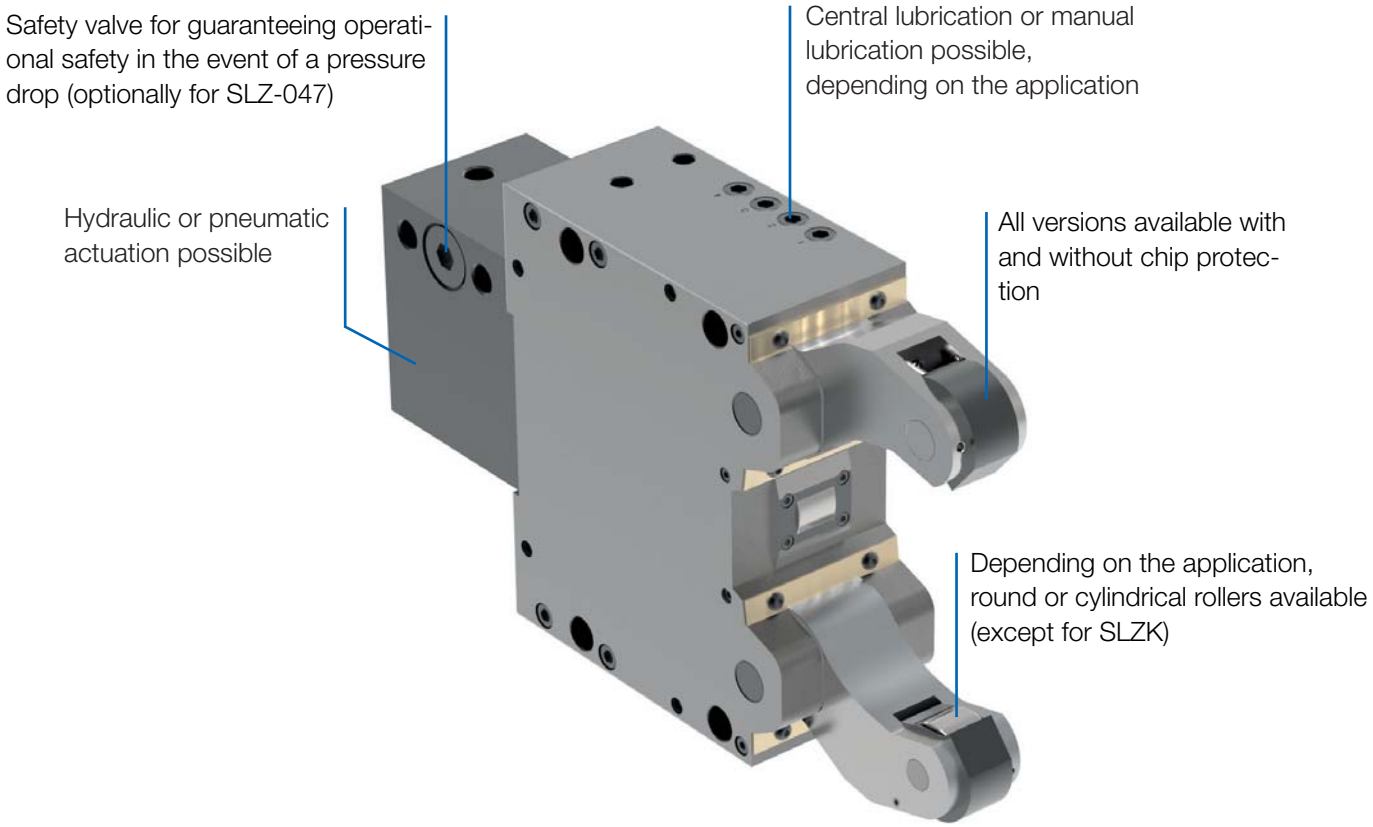
With self-centering steady rests, RÖHM makes an important contribution toward the support of slender turned parts on lathes and meets all requirements for a large clamping range without change elements, a short and sturdy design, high centering precision and repeatability, as well as precision stability for clamping pressure changes and central lubrication.

ADVANTAGES AT A GLANCE

- Support of components with extreme center precision and repeatability thanks to optimized cam lever system
- Standardized equipped with central lubrication for use under difficult conditions and with high dirt accumulation
- Large clamping range without change elements thanks to special curved geometry

NEW

Simple attachment of a safety valve and dosing valves for the central lubrication system to increase maintenance friendliness for SLZN or SLZN-B



Function description

Different attachment options allow possible use for turning, facing, centering, drilling, internal machining, copy turning, etc., both as a stationary as well as a rotating steady rest in any angular position relative to the lathe tool.

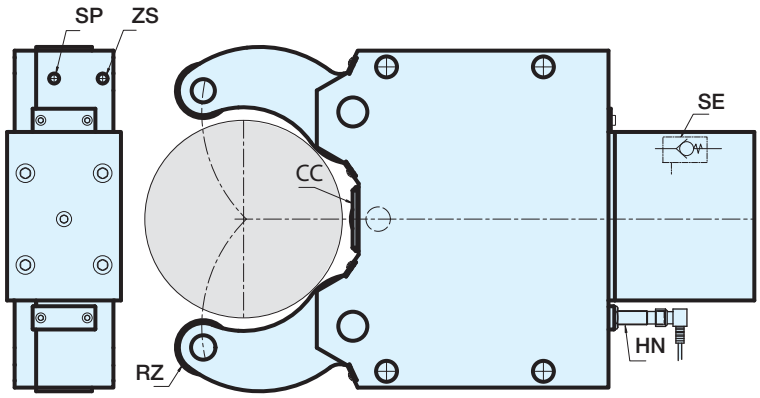
Also in the case of a stationary steady rest, the shaft can be machined along the entire length since, on the one hand, the opening between the rollers leaves room for tools and on the other hand, the rollers reclamp self-centering. Here, 2 supporting steady rests are to be provided so that one of these can support the workpiece over the entire width of the roller.

The cylinder installed to actuate the steady rest can be selected for hydraulic or pneumatic actuation. The only difference is the size of the piston surfaces.

List of abbreviations

SP	=	Air purge connection
ZS	=	Central lubrication of the steady rest
HN	=	Check via steady rest proximity switch (not included in delivery) in the open position
HK	=	Stroke control rod
RZ	=	Rollers, cylindrical
RB	=	Rollers, convex

Standard configuration



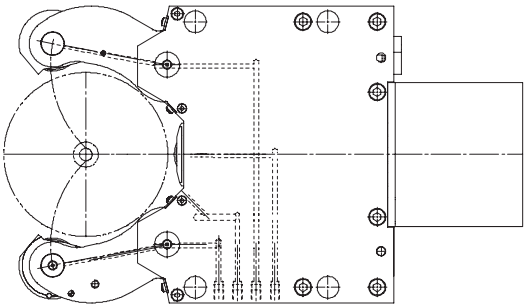
The standard steady rest is configured as follows:

– Cylindrical rollers
– Pressurization
– Central lubrication
– Axially extended cylinder with safety valve (except SLZ-047)
– Proximity switch component (open steady rest) for possible using of HN
– Device for manual lubrication via grease cup or oiler

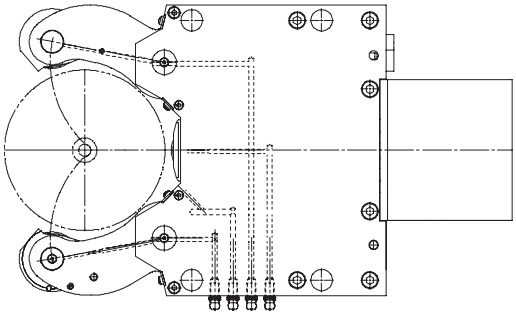
Function description

Lubrication
Only one connection is required for the central lubrication system. The dosing units for the rollers are integrated in the steady rest body and ensure sufficient lubrication in the corresponding time interval.

Oil central lubrication (standard)
RÖHM steady rests are standard-equipped with a central lubrication system. The dosing valves required for lubrication are built into the steady rest body. Lubrication intervals (depending on load) 2-5 minutes at an operating pressure of 16-50 bar.

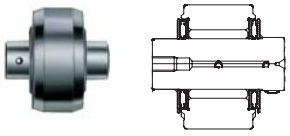


Manual lubrication (option)
Steady rest for moderate load and low dirt accumulation. Lubrication points and rollers are supplied with grease via grease nipples and grease gun. Lubrication intervals every 4 to 8 operating hours, depending on application.

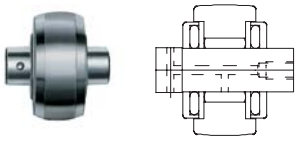


Rollers
The rollers are supported by roller bearings radially and axially. In the standard version, these are cylindrical or convex. In the case of conical workpieces and for follower rests arrangement, convex rollers are to be used. Here, too, customized designs on request supplement the product range.

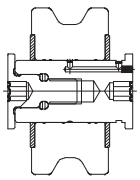
Cylindrical rollers
Roller version for standard inserts



Convex rollers
For conical workpieces and for following steady rest arrangement

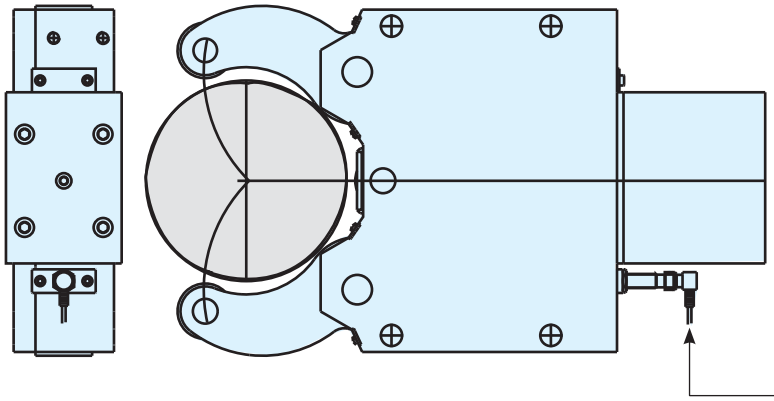


Customized rollers
on request



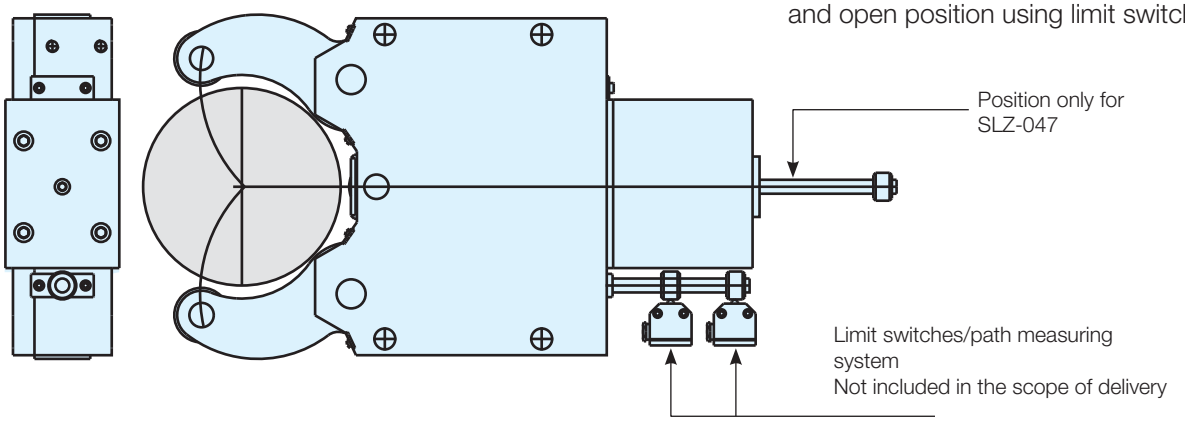
Standard accessories of SLZN series

Clamping arm control system SLZ-HN



There is the option of attaching a sensor (proximity switch) to the steady rests as standard, which measures the position of the opened steady rest. This option is not available for the steady rest of type SLZ-047. The proximity switch is not included in the delivery of the steady rest.

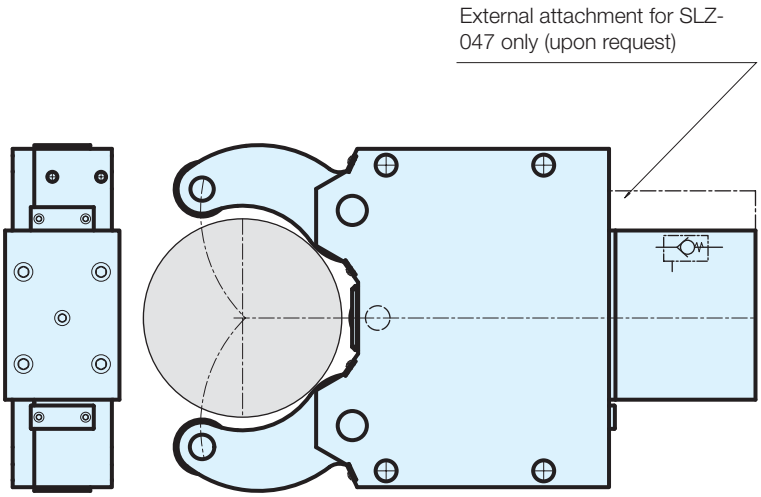
Control system of the clamping arms SLZ-HK



All steady rests of type SLZN and SLZNB can be equipped with holders and rods or only with rods, in order to be able to control the clamping position and open position using limit switches.

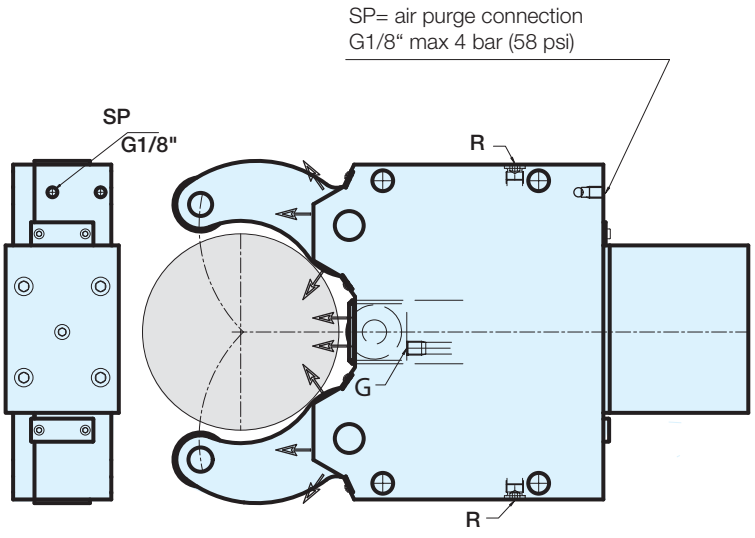
Standard accessories of SLZN series

Safety valve SE



All standard steady rests come equipped with a safety valve integrated in the cylinder. If the clamping pressure in the cylinder should be interrupted, the valve prevents the steady rest from opening. With moving applications, the safety valve isn‘t necessary. We would be happy to help you if need be. This device is available as an option for the SLZ-047 series.

Pressurization



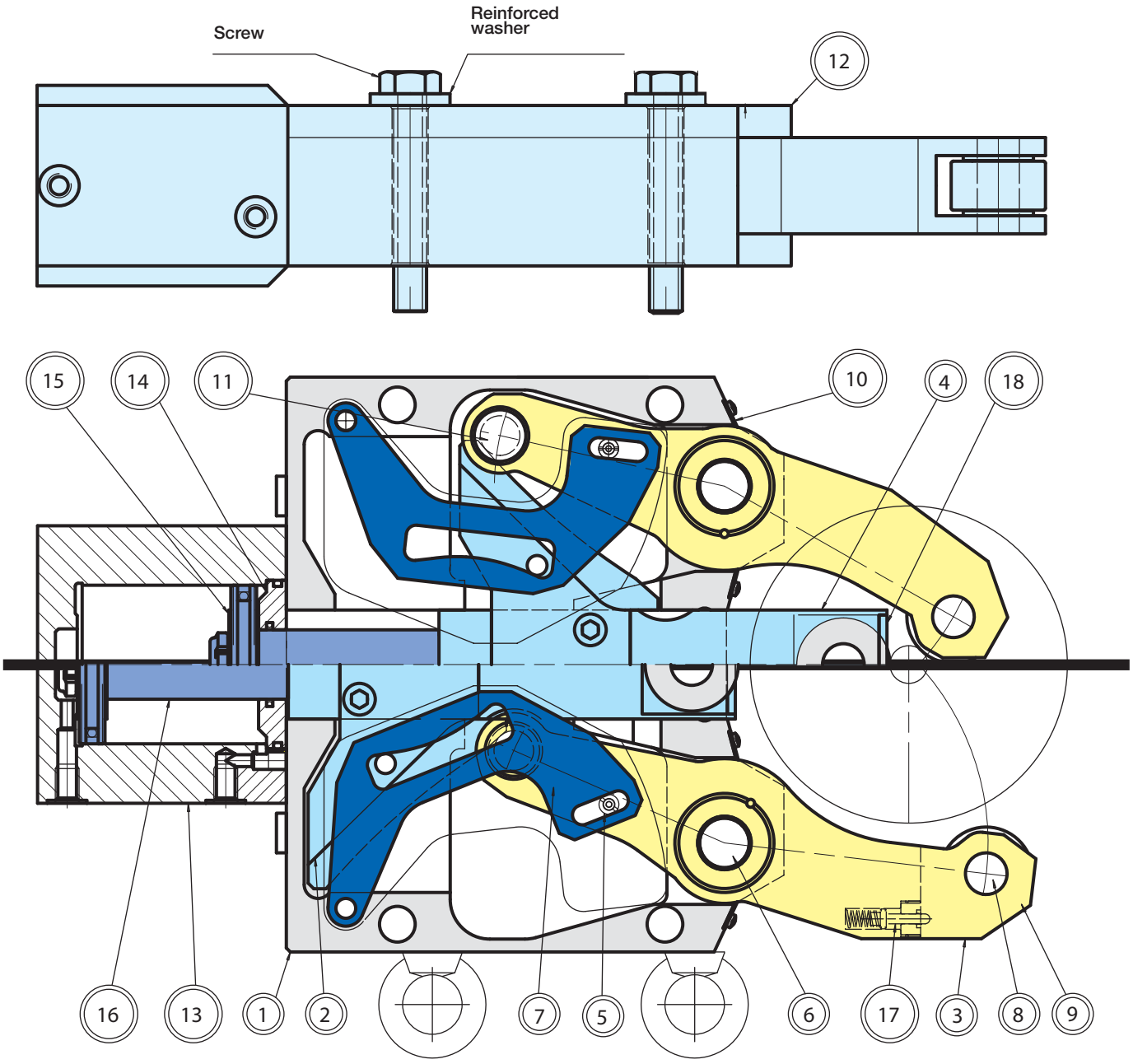
All RÖHM steady rests have a G 1/8“ air purge connection; This system protects the body of the steady rest from chip and dust penetration. When the steady rest is completely open, the air consumption is automatically reduced, but not completely interrupted to prevent unnecessary air consumption. The system includes the cleaning of the middle roller bearings.
To activate this option, the screw „G“, which is located in the housing floor, must be removed. The pressure can vary between a minimum of 2 bar and maximum of 4 bar (58 psi). The steady rest can also be used without the air purge.
Drain holes are on the top and bottom part of the steady rest housing.
It is recommended that the lower one of the two seals be loosened to allow the cooling water to drain and to prevent penetration of contaminants into the body of the steady rest.

Set-up principle SLZN

All steady rests have an engraved identification number. This number must be provided when ordering replacement parts.

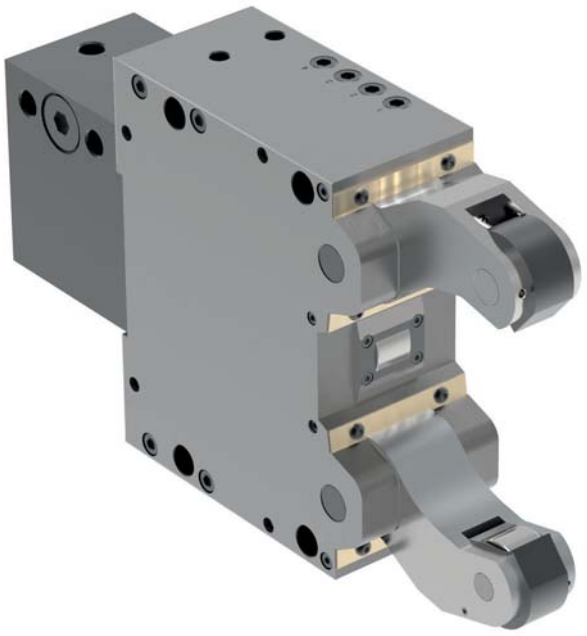
Components SLZN/SLZNB

1. Body
2. Carm segment
3. Clamping arm outside
4. Clamping arm center
5. Bolt and roller
6. Clamping arm arbore
7. Return lever
8. Roller center
9. Roller
10. Scraper band
11. Axle and rollers
12. Cover
13. Cylinder housing
14. Cylinder flange
15. Piston
16. Piston rod
17. Pressure sleeve
18. Scraper center



Notes

SLZN - standard design



APPLICATION

Support of slender shafts for rational turning and end machining.

TYPE

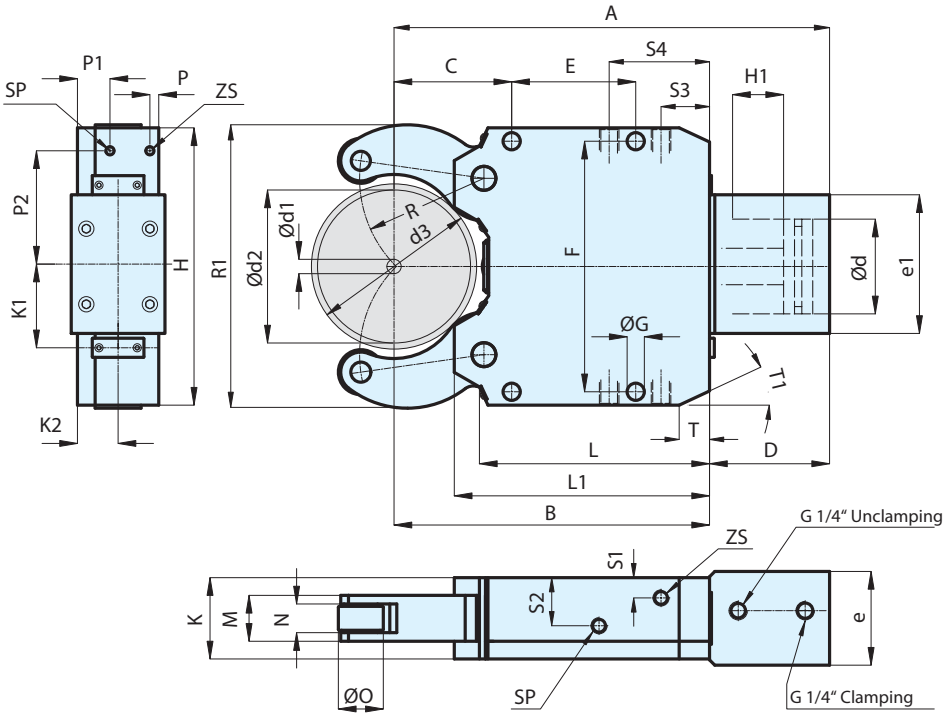
Standard version with cylinder mounted at rear.

CUSTOMER BENEFITS

- Large clamping range without change elements
- Operational safety thanks to safety valve, even if pressure drops (SLZ-047 optional)
- Compact and sturdy design for variable use
- High centering precision and repeatability thanks to proven cam lever system
- Resilient chip protection for optimal workpiece wiping (for version „with chip protection“)
- Purge air connection to prevent penetration of dirt inside the steady rest

TECHNICAL FEATURES

- Central lubrication or manual lubrication possible, depending on the operating conditions
- Standard version available with cylindrical or convex rollers
- Available with and without chip protection
- Prepared for end position check, except SLZ-047 (limit switch not included in the scope of delivery)



SLZN - standard design

C 15

Self-centering steady rests SLZN - oil or air operated with mounted cylinder

Clamping ranges Type	SLZ 047	SLZN 067	SLZN 08105	SLZN 1152	SLZN 1517	SLZN 40200	SLZN 325	SLZN 50315	SLZN 85350
Clamping range - with chip protection mm	15-62	11-70	16-101	22-140	25-158	40-195	40-240	50-305	85-345
Clamping range - without chip protection mm	4-70	6-75	8-105	11-152	15-170	40-200	30-250	50-315	85-350
Max. radial clamping range - d3 mm	70	79	105	161	170	200	250	320	350
With chip protectors RZ	**685751**	**1685567**	**1685571**	**1685575** ▲	**1685579** ▲	**1685583** ▲	**1685587** ▲	**1685591** ▲	**1685595** ▲
With chip protectors RB	**685752**	**1685568**	**1685572**	**1685576** ▲	**1685580** ▲	**1685584** ▲	**1685588** ▲	**1685592** ▲	**1685596** ▲
Without chip protectors RZ	**685753**	**1685569**	**1685573**	**1685577** ▲	**1685581** ▲	**1685585** ▲	**1685589** ▲	**1685593** ▲	**1685597** ▲
Without chip protectors RB	**685754**	**1685570**	**1685574**	**1685578** ▲	**1685582** ▲	**1685586** ▲	**1685590** ▲	**1685594** ▲	**1685598** ▲
d1 mm	4	6	8	11	15	40	30	50	85
d2 mm	70	75	105	152	170	200	250	315	350
d3 mm	70	79	105	161	170	200	250	315	350
A mm	206	214	279,5	432,5	440,5	459,5	617,5	699	716,5
B mm	137	149	197	306	314	333	448	510	530
C mm	51	52	70	115	123	138	146	203	198
D mm	69	65	82,5	126,5	126,5	126,5	162	186,5	186,5
E mm	64	66	85	135	135	135	240	270	270
F mm	118	140	170	262	262	262	365	400	400
G mm	11	11	14	18	18	18	23	23	23
H mm	132	160	190	290	290	290	400	440	440
K mm	54	63	75	85	85	85	110	145	145
L mm	102	108,5	146	223	223	223	328,5	353,5	353,5
L1 mm	115,5	125,5	164	251	251	251	361	394,5	394,5
Clamping arm width M mm	20	28	35	48	48	48	60	75	75
Roller width N mm	11,5/9	17,5/14	20,5/18	30/25	30/25	30/25	40/35	45/40	45/40
O mm	19	24	35	47	47	47	52	60	60
P mm	-	9,75	-	9,5	9,5	9,5	12,5	21,5	21,5
P1 mm	-	8,75	-	34	34	34	12,5	68,5	68,5
P2 mm	-	51,5	-	117,5	117,5	117,5	160	183	183
R mm	48,5	55	74,5	122	130	143,5	178,5	209	229
S1 mm	8	-	10	-	-	-	-	-	-
S2 mm	23	-	40	-	-	-	-	-	-
S3 mm	10	-	28	-	-	-	-	-	-
S4 mm	34,5	-	28	-	-	-	-	-	-
K1 mm	-	51,5	59,5	85	85	85	110	140	140
K2 mm	-	31	36,5	42,5	42,5	42,5	55	59,5	59,5
d mm	40	35	50	80	80	80	100	100	100
e mm	60	62	68	98	98	98	124	142	143
e1 mm	87	22	92	145	145	145	136	156	175
T mm	-	-	-	-	-	-	45	31,5	54,5/22
T1	-	-	-	-	-	-	30°	30°	18°/40°
R1 mm	121	144	190	291	303	326	394	483	512
Weight kg	7	10	14,5	47	47	48	115	185	188
ZS	M 10x1	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"
SP	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"
Cylinder-Ø	C40	C 35	C50	C80	C80	C80	C100	C100	C100
Cylinder surface area cm2	12,5	9,6	19,6	50	50	50	78,5	78,5	78,5
Max. operating pressure bar	25	54	53	62	68	40	57	80	61
Operating pressure bar	6-20	6-30	8-30	8-40	8-44	8-25	8-42	8-58	8-40
Clamping force per roller at max. operating pressure N	830	960	1960	6500	6500	4160	11000	15000	10460
Max. permissible clamping force per roller N	1040	1700	3500	10000	10000	6670	15000	20000	16000
Clamping force per roller at 20 bar N	830	640	1300	3300	3300	3300	5200	5200	5200
Centering accurancy over the entire clamping range mm	0,02*	0,02*	0,02*	0,04*	0,04*	0,04*	0,05*	0,06*	0,06*
Repeat accurancy for the same clamping-Ø at the same operating pressure mm	0,005	0,005	0,005	0,005	0,005	0,005	0,005	0,01	0,01
Max. roller peripheral speed m/min	800	800	800	725	725	725	715	700	700
Max. roller peripheral speed at half the max. clamping force per roller m/min	900	900	950	875	875	875	860	850	850
Displacement of the geometrical workpiece center in the event of a 20-70% change in the operating pressure /at constant force) mm	0,02	0,02	0,02	0,03	0,03	0,03	0,03	0,03	0,03

*) At constant pressure and clamping force

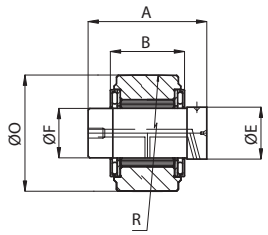
Accessories SLZN

C 15
Cylindrical rollers

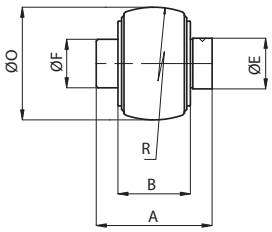


Item no.	For	A mm	B mm	Ø F mm	Ø O mm	Ø E mm	R mm
735120	SLZ 047	20	11,5	6	19	6	500
1835444	SLZN 067	28	17,5	8	24	8	500
1835388	SLZN/SLZNB 08105	31	20,5	15	35	15	500
649513	SLZN/SLZNB 1152, SLZN/SLZNB 1517, SLZN/SLZNB 40200	48	30	20	47	21	1000
649514	SLZN/SLZNB 325	60	40	20	52	21	3000
381420	SLZN/SLZNB 50315, SLZN/SLZNB 85350	75	45	20,1	60	21	3000

Rollers SLZ 047 and SLZNB 08105 without axle



C 15
Convex rollers

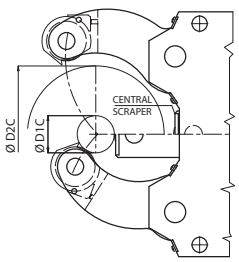


Item no.	For	A mm	B mm	Ø F mm	Ø O mm	Ø E mm	R mm
835542	SLZ 047	20	11,5	6	19	6	100
1835572	SLZN 067	28	17,5	8	24	8	100
1835513	SLZN/SLZNB 08105	31	20,5	15	35	15	100
649515	SLZN/SLZNB 1152, SLZN/SLZNB 1517, SLZN/SLZNB 40200	48	30	20	47	21	100
649516	SLZN/SLZNB 325	60	40	20	52	21	100
381426	SLZN/SLZNB 50315, SLZN/SLZNB 85350	75	45	20,1	60	21	500

C 15
Central scraper RZ



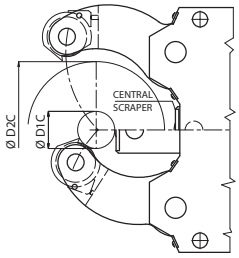
Item no.	For	Clamping ranges D1C mm	Clamping ranges D2C mm
836591	SLZ 047	15	62
1835423	SLZN 067	11	70
1835391	SLZN/SLZNB 08105	16	101
1831222	SLZN/SLZNB 1152	22	140
1831134	SLZN/SLZNB 1517, SLZN/SLZNB 40200	25/40	158/195
735005	SLZN/SLZNB 325	40	240
836584	SLZN/SLZNB 50315, SLZN/SLZNB 85350	50/85	305/345



▲ on request

Accessories SLZN

C 15
Central scraper RB

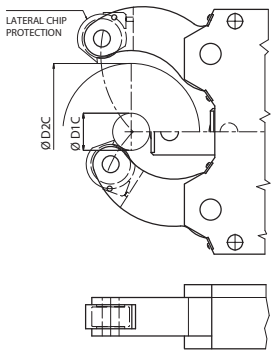


Item no.	For	Clamping ranges D1C mm	Clamping ranges D2C mm
1836046	SLZ 047	15	62
1835573	SLZN/SLZNB 067	11	70
1835606	SLZN/SLZNB 08105	16	101
1831220	SLZN/SLZNB 1152	22	140
1831282	SLZN/SLZNB 1517, SLZN/SLZNB 40200	25/40	158/195
1831403	SLZN/SLZNB 325	40	240
836820	SLZN 50315, SLZN 85360	50/85	305/345

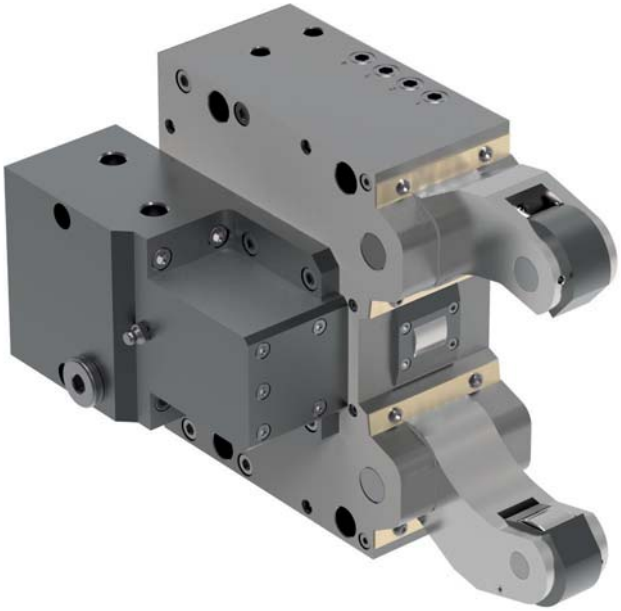
C 15
Chip protector outer Set = 2 Pieces



Item no.	For	Clamping ranges D1C mm	Clamping ranges D2C mm
836609	SLZ 047	15	62
1835435	SLZN 067	11	70
836610	SLZN/SLZNB 08105	16	101
836611	SLZN/SLZNB 1152, SLZN/SLZNB 1517, SLZN/SLZNB 40200	22/25/40	140/158/195
836612	SLZN/SLZNB 325	40	240
836613	SLZN/SLZNB 50315, SLZN/SLZNB 85350	50/85	305/345



SLZNB - with side mounted cylinder



APPLICATION

Support of slender shafts for rational turning and end machining.

TYPE

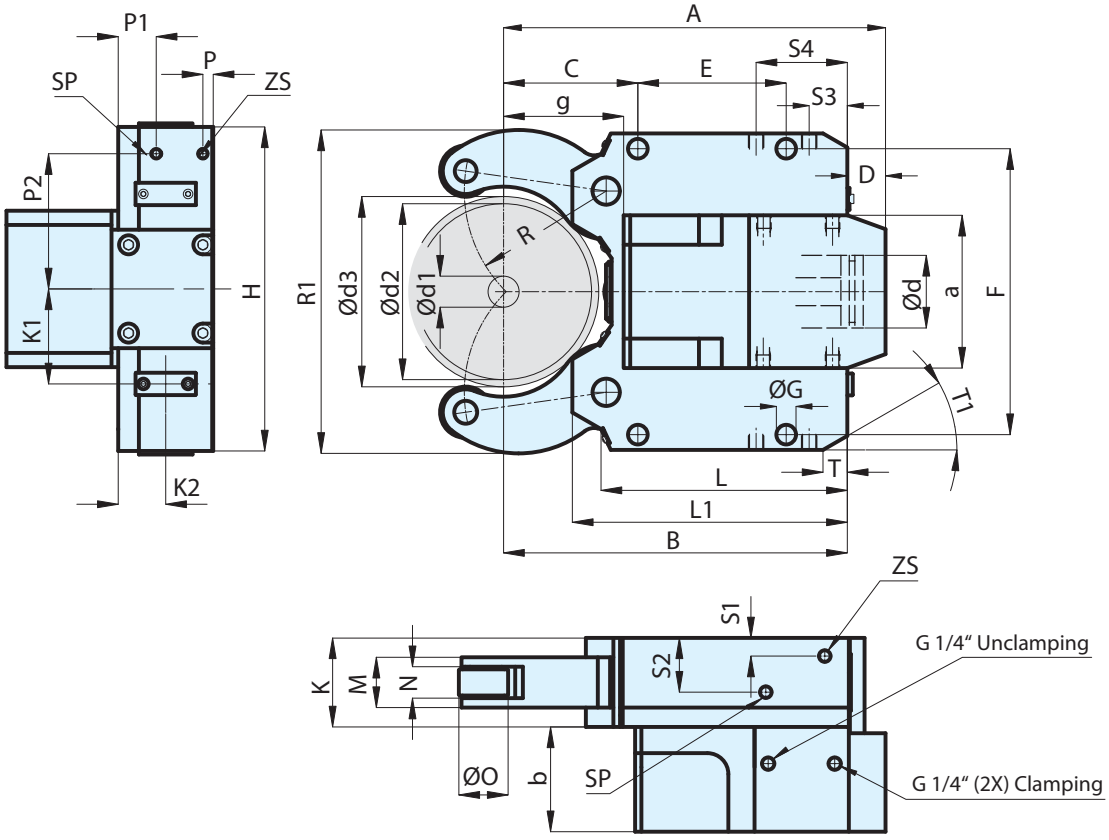
Standard version with cylinder mounted cylinder.

CUSTOMER BENEFITS

- Flexible use when less back-space available
- Large clamping range without change elements
- Operational safety thanks to safety valve, even if pressure drops
- High centering precision and repeatability thanks to proven cam lever system
- Resilient chip protection for optimal workpiece wiping (for version „with chip protection“)
- Purge air connection to prevent penetration of dirt inside the steady rest

TECHNICAL FEATURES

- Central lubrication or manual lubrication possible, depending on the operating conditions
- Standard version available with cylindrical or convex rollers
- Available with and without chip protection
- Prepared for end position check (limit switch not included in the scope of delivery)



SLZNB - with side mounted cylinder

C 15

Self-centering steady rests SLZNB - oil or air operated, with side mounted cylinder

Clamping ranges type	SLZNB 08105	SLZNB 1152	SLZNB 1517	SLZNB 40200	SLZNB 325	SLZNB 50315	SLZNB 85350
Clamping range - with chip protection mm	16-101	22-140	25-158	40-195	40-240	50-305	85-345
Clamping range - without chip protection mm	8-105	11-152	15-170	40-200	30-250	50-315	85-350
Max. radial clamping range - d3 mm	105	161	170	200	250	320	350
With chip protectors RZ	**1685539 ▲**	**1685543 ▲**	**1685547 ▲**	**1685551 ▲**	**1685555 ▲**	**1685559 ▲**	**1685563 ▲**
With chip protectors RB	**1685540 ▲**	**1685544 ▲**	**1685548 ▲**	**1685552 ▲**	**1685556 ▲**	**1685560 ▲**	**1685564 ▲**
Without chip protectors RZ	**1685541 ▲**	**1685545 ▲**	**1685549 ▲**	**1685553 ▲**	**1685557 ▲**	**1685561 ▲**	**1685565 ▲**
Without chip protectors RB	**1685542 ▲**	**1685546 ▲**	**1685550 ▲**	**1685554 ▲**	**1685558 ▲**	**1685562 ▲**	**1685566 ▲**
d1 mm	8	11	15	40	30	50	85
d2 mm	105	152	170	200	250	315	350
d3 mm	105	161	170	200	250	320	350
A mm	228	341	349	368	483,5	574	594
B mm	197	306	314	333	448	510	530
C mm	70	115	123	138	146	178	198
D mm	31	35	35	35	35,5	64	64
E mm	85	135	135	135	240	270	270
F mm	170	262	262	262	365	400	400
G mm	14	18	18	18	23	23	23
H mm	190	290	290	290	400	440	440
K mm	75	85	85	85	110	145	145
L mm	146	223	223	223	328,5	353,5	353,5
L1 mm	164	251	251	251	361	394,5	394,5
Clamping arm width M mm	35	48	48	48	60	75	75
Roller width N mm	20,5/18	30/25	30/25	30/25	40/35	45/40	45/40
O mm	35	47	47	47	52	60	60
P mm	-	9,5	9,5	9,5	12,5	21,5	21,5
P1 mm	-	34	34	34	12,5	68,5	68,5
P2 mm	-	117,5	117,5	117,5	160	183	183
R mm	74,5	122	130	143,5	178,5	209	229
S1 mm	10	-	-	-	-	-	-
S2 mm	40	-	-	-	-	-	-
S3 mm	28	-	-	-	-	-	-
S4 mm	28	-	-	-	-	-	-
K1 mm	59,5	85	85	85	110	140	140
K2 mm	36,5	42,5	42,5	42,5	55	59,5	59,5
a mm	95	140	140	140	180	180	180
b mm	71	98	98	98	124	143	143
d mm	50	80	80	80	100	100	100
g mm	68	102	110	129	169	196	216
T mm	-	-	-	-	48	54,5/22	54,5/22
T1	-	-	-	-	30°	18°/40°	18°/40°
R1 mm	192	291	303	326	403	486	512
Weight kg	14,5	51	51	52	134	194	198
ZS	G 1/8“	G 1/8“	G 1/8“	G 1/8“	G 1/8“	G 1/8“	G 1/8“
SP	G 1/8“	G 1/8“	G 1/8“	G 1/8“	G 1/8“	G 1/8“	G 1/8“
Cylinder-Ø	C50	C80	C80	C80	C100	C100	C100
Cylinder surface area cm2	19,6	50	50	50	78,5	78,5	78,5
Max. operating pressure bar	53	62	68	40	57	80	61
Operating pressure bar	8-30	8-40	8-44	8-25	8-42	8-58	8-40
Clamping force per roller at max. operating pressure N	1960	6500	7000	4160	11000	15000	10460
Max. permissible clamping force per roller N	3500	10000	10000	6670	15000	20000	16000
Clamping force per roller at 20 bar N	1300	3300	3300	3300	5200	5200	5200
Centering accurancy over the entire clamping range mm	0,02*	0,04*	0,04*	0,04*	0,05*	0,06*	0,06*
Repeat accurancy for the same clamping-Ø at the same operating pressure mm	0,005	0,005	0,005	0,005	0,01	0,01	0,01
Max. roller peripheral speed m/min	800	725	725	725	715	700	700
Max. roller peripheral speed at half the max. clamping force per roller m/min	950	875	875	875	860	850	850
Displacement of the geometrical workpiece center in the event of a 20-70% change in the operating pressure /at constant force) mm	0,02	0,03	0,03	0,03	0,03	0,03	0,03

*) At constant pressure and clamping force

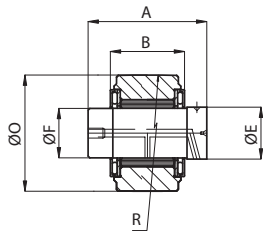
Accessories SLZNB

C 15
Cylindrical rollers

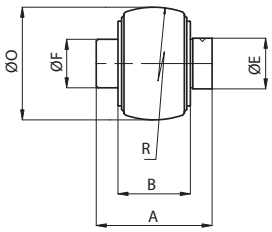


Item no.	For	A mm	B mm	Ø F mm	Ø O mm	Ø E mm	R mm
1835388	SLZN/SLZNB 08105	31	20,5	15	35	15	500
649513	SLZN/SLZNB 1152, SLZN/SLZNB 1517, SLZN/SLZNB 40200	48	30	20	47	21	1000
649514	SLZN/SLZNB 325	60	40	20	52	21	3000
381420	SLZN/SLZNB 50315, SLZN/SLZNB 85350	75	45	20,1	60	21	3000

Rollers SLZNB 08105 without axle



C 15
Convex rollers

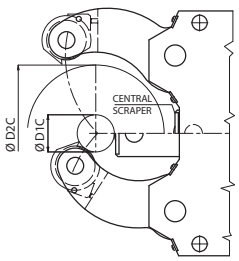


Item no.	For	A mm	B mm	Ø F mm	Ø O mm	Ø E mm	R mm
1835513	SLZN/SLZNB 08105	31	20,5	15	35	15	100
649515	SLZN/SLZNB 1152, SLZN/SLZNB 1517, SLZN/SLZNB 40200	48	30	20	47	21	100
649516	SLZN/SLZNB 325	60	40	20	52	21	100
381426	SLZN/SLZNB 50315, SLZN/SLZNB 85350	75	45	20,1	60	21	500

C 15
Central scraper RZ



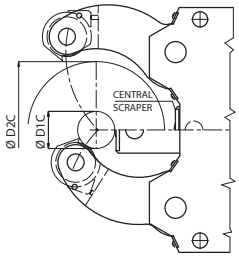
Item no.	For	Clamping ranges D1C mm	Clamping ranges D2C mm
1835391	SLZN/SLZNB 08105	16	101
1831222	SLZN/SLZNB 1152	22	140
1831134	SLZN/SLZNB 1517, SLZN/SLZNB 40200	25/40	158/195
735005	SLZN/SLZNB 325	40	240
836584	SLZN/SLZNB 50315, SLZN/SLZNB 85350	50/85	305/345



▲ on request

Accessories SLZNB

C 15
Central scraper RB

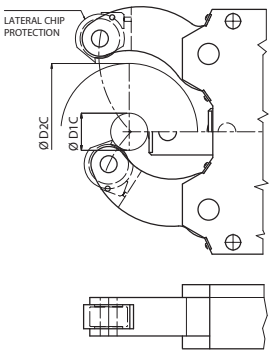


Item no.	For	Clamping ranges D1C mm	Clamping ranges D2C mm
1835606	SLZN/SLZNB 08105	16	101
1831220	SLZN/SLZNB 1152	22	140
1831282	SLZN/SLZNB 1517, SLZN/SLZNB 40200	25/40	158/195
1831403	SLZN/SLZNB 325	40	240
836820	SLZN 50315, SLZN 85360	50/85	305/345

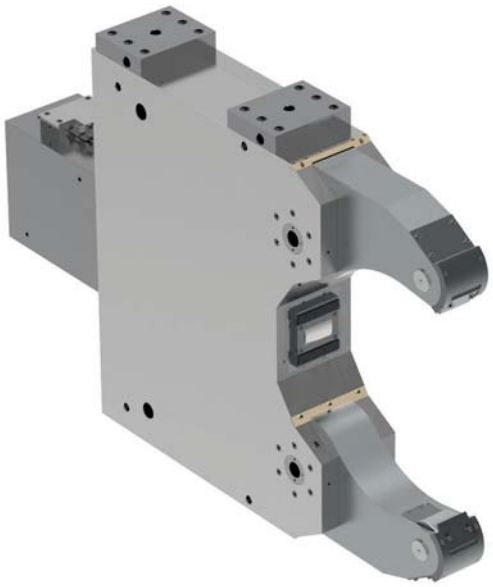
C 15
Chip protector outer Set = 2 Pieces



Item no.	For	Clamping ranges D1C mm	Clamping ranges D2C mm
836610	SLZN/SLZNB 08105	16	101
836611	SLZN/SLZNB 1152, SLZN/SLZNB 1517, SLZN/SLZNB 40200	22/25/40	140/158/195
836612	SLZN/SLZNB 325	40	240
836613	SLZN/SLZNB 50315, SLZN/SLZNB 85350	50/85	305/345



SLZ - heavy design



APPLICATION

Support of shafts for rational turning and end machining preferential for heavy solid materials.

TYPE

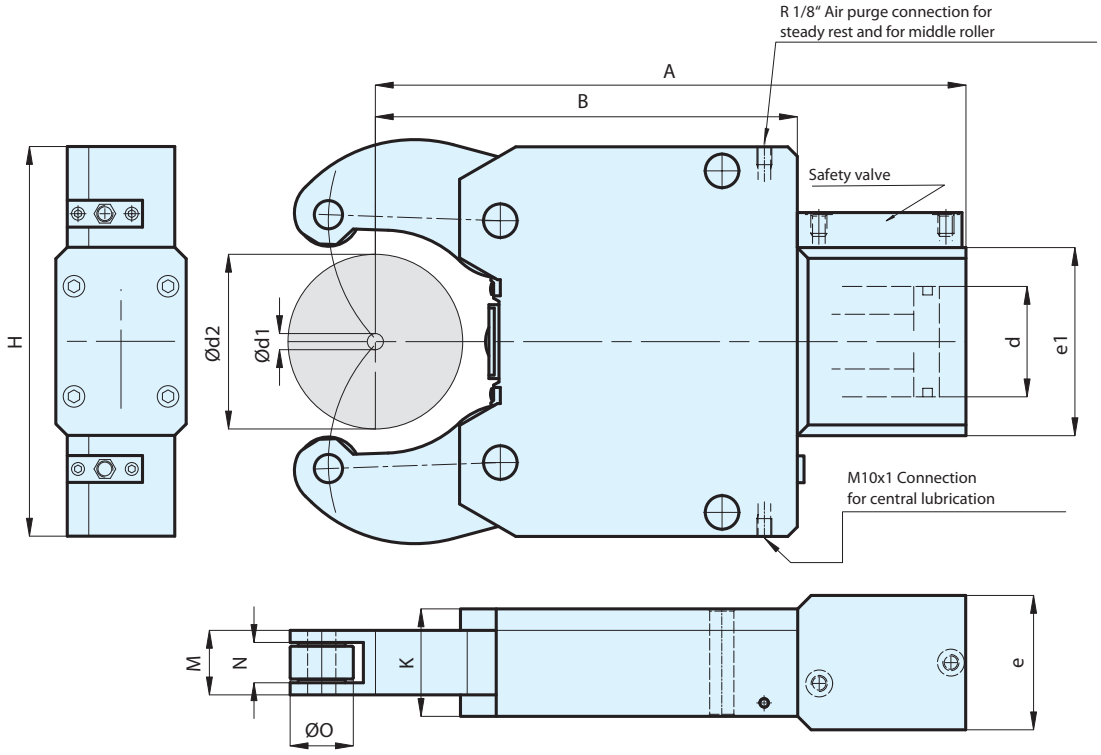
Heavy design for high loads.

CUSTOMER BENEFITS

- Large clamping range without change elements
- Operational safety thanks to safety valve, even if pressure drops
- Sturdy design for variable use - Increased stability thanks to steady rest fastened with clamping arm axis
- High centering precision and repeatability thanks to proven cam lever system
- Resilient chip protection for optimal workpiece wiping (for version „with chip protection“)
- Purge air connection to prevent penetration of dirt inside the steady rest

TECHNICAL FEATURES

- Central lubrication or manual lubrication possible, depending on the operating conditions
- Standard version available with cylindrical or convex rollers
- Available with and without chip protection
- Prepared for end position check (limit switch not included in the scope of delivery)
- Recommendation: Higher precision in case of vertical installation of the steady rest



SLZ - heavy design

C 15

Self-centering steady rests SLZ heavy design - oil or air operated, heavy design for high loads

Clamping ranges type	SLZ 437	SLZ 5040	SLZ 1546	SLZ 1060	SLZ 3580
Clamping range - with chip protection mm	75-350	75-380	150-430	100-590	350-770
Clamping range - without chip protection mm	40-375	50-400	150-460	100-600	350-800
With chip protectors RZ	**685899 ▲**	**1685722 ▲**	**685897 ▲**	**685896 ▲**	**685895 ▲**
With chip protectors RB	**685894 ▲**	**685893 ▲**	**685892 ▲**	**685891 ▲**	**685890 ▲**
Without chip protectors RZ	**685889 ▲**	**685888 ▲**	**685887 ▲**	**685886 ▲**	**685885 ▲**
Without chip protectors RB	**685884 ▲**	**685883 ▲**	**685882 ▲**	**685881 ▲**	**685880 ▲**
d1 mm	40	50	150	100	350
d2 mm	370	400	460	600	800
A mm	1086	1100	1110	1465	1810
B mm	762	800	800	1105	1340
H mm	730	730	730	1020	1270
K mm	170	170	170	270	440
Clamping arm width M mm	90	90	90	170	240
Roller width N mm	60/50	60/50	60/50	104/95	150/138
O mm	80	80	80	160	220
d mm	120	120	120	150	180
e mm	150	150	150	260	370
e1 mm	240	240	240	280	320
Weight kg	490	500	570	2000	4000
Cylinder-Ø	C120	C120	C120	C150	C180
Cylinder surface area cm2	113	113	113	176	254
Max. operating pressure bar	100	100	85	90	98
Operating pressure bar	10-40	10-40	10-40	10-40	10-40
Clamping force per roller at max. operating pressure N	15000	15000	15000	23000	32000
Max. permissible clamping force per roller N	35000	35000	40000	50000	80000
Centering accurancy over the entire clamping range mm	0,04*	0,04*	0,04*	0,04*	0,06*
Repeat accurancy for the same clamping-Ø at the same operating pressure mm	0,01	0,01	0,01	0,01	0,01
Max. roller peripheral speed m/min	725	725	725	725	715
Max. roller peripheral speed at half the max. clamping force per roller m/min	875	875	875	875	860
Displacement of the geometrical workpiece center in the event of a 20-70% change in the operating pressure /at constant force) mm	0,06	0,06	0,06	0,06	0,06

*) At constant pressure and clamping force

SLZC - extremely compact design



APPLICATION

Support of shafts for rational turning and end machining optimal for pipe materials.

TYPE

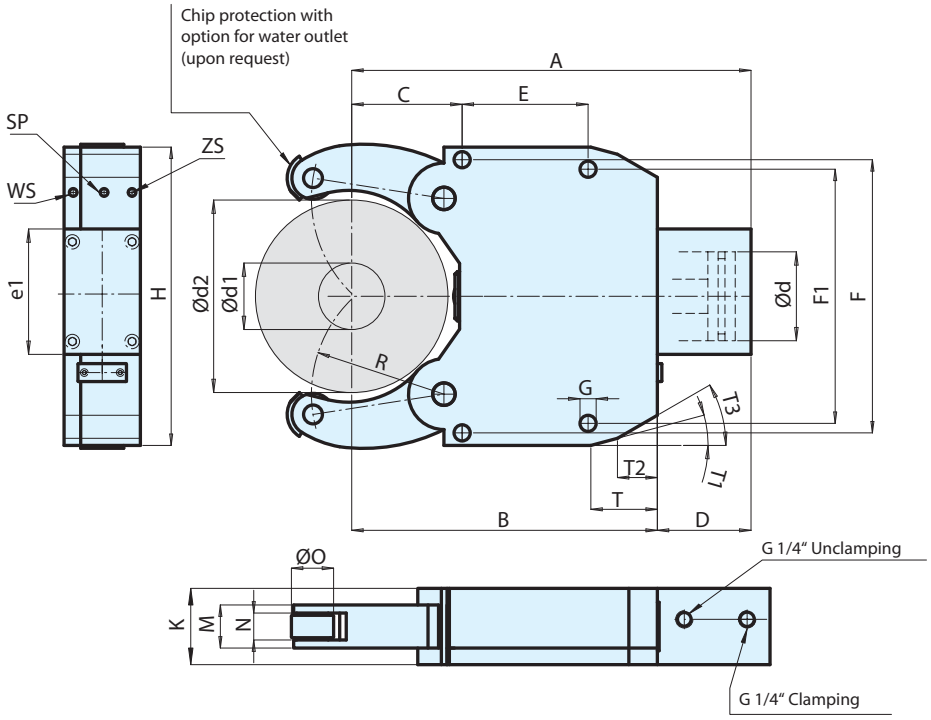
Compact series with extra large clamping ranges.

CUSTOMER BENEFITS

- Extra large clamping range without change elements
- Integrated channels for rinsing the workpiece in the contact area with coolant connection on the rear side
- Operational safety thanks to safety valve, even if pressure drops
- Extremely compact and sturdy design for variable use
- High centering precision and repeatability thanks to proven cam lever system
- Resilient chip protection for optimal workpiece wiping (for version „with chip protection“)
- Purge air connection to prevent penetration of dirt inside the steady rest

TECHNICAL FEATURES

- Central lubrication or manual lubrication possible, depending on the operating conditions
- Standard version available with cylindrical or convex rollers
- Available with and without chip protection
- Prepared for end position check, except SLZ-047 (limit switch not included in the scope of delivery)



SLZC - extremely compact design

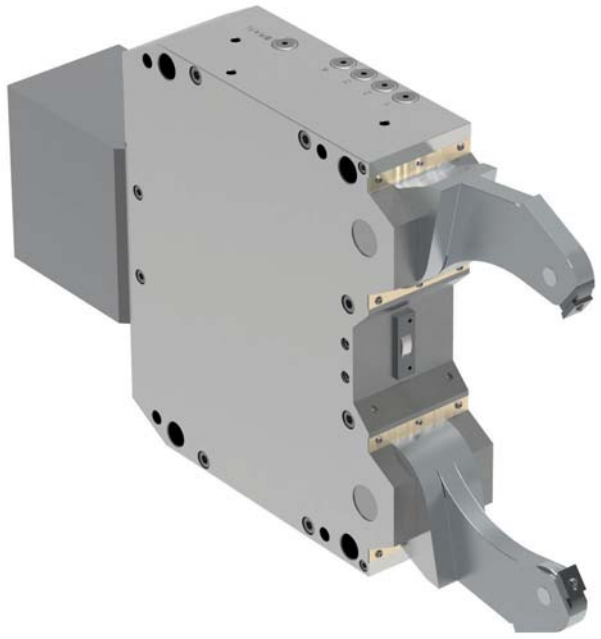
C 15

Self-centering steady rests SLZC - oil or air operated, extremely compact design, developed for minimum mounting dimensions

Clamping ranges type	SLZC 60280	SLZC 80390	SLZC 100410	SLZC 135460	SLZC 215510
Clamping range - without chip protection mm	60-280	80-390	100-410	135-460	215-520
With chip protectors RZ	**1685616** ▲	**1685620** ▲	**1685624** ▲	**1685628** ▲	**1685632** ▲
With chip protectors RB	**1685617** ▲	**1685621** ▲	**1685625** ▲	**1685629** ▲	**1685633** ▲
Without chip protectors RZ	**1685618** ▲	**1685622** ▲	**1685626** ▲	**1685630** ▲	**1685634** ▲
Without chip protectors RB	**1685619** ▲	**1685623** ▲	**1685627** ▲	**1685631** ▲	**1685635** ▲
d1 mm	60	80	100	135	215
d2 mm	280	390	410	460	520
A mm	580	755	763	816	817
B mm	450	607	617	670	685
C mm	168	230	240	215	245
D mm	130	148	146	146	132
E mm	180	240	240	330	300
F mm	360	445	445	640	640
F1 mm	360	445	445	610	610
G mm	23	23	23	27	27
H mm	400	485	485	680	680
K mm	125	150	150	150	150
Clamping arm width M mm	60	75	75	75	75
Roller width N mm	40/35	45/40	45/40	29	29
O mm	52	60	60	80	80
R mm	200	265	275	290	310
d mm	90	100	100	120	120
e1 mm	184	194	194	215	215
T mm	100	130	130	150	150
T1	15°	15°	15°	15°	20°
T2 mm	61	50	50	77	85
T3 mm	30°	30°	30°	30°	30°
Weight kg	85	170	170	390	380
ZS	G 1/8“	G 1/8“	G 1/8“	G 1/8“	G 1/8“
SP	G 1/8“	G 1/8“	G 1/8“	G 1/8“	G 1/8“
WS	G 1/4“	G 1/4“	G 1/4“	G 1/4“	G 1/4“
Operating pressure bar	8-70	8-80	8-80	8-80	8-80
Max. permissible clamping force per roller N	14500	20000	20000	25000	25000
Centering accurancy over the entire clamping range mm	0,05*	0,06*	0,06*	0,06*	0,06*
Repeat accurancy mm	0,007*	0,01*	0,01*	0,01*	0,01*
Max. roller peripheral speed m/min	715	700	700	700	700

*) At constant pressure and clamping force
Water connection (WS) on request

SLZK - slim clamping arms



APPLICATION

Support of slender shafts for rational turning and end machining optimal for crankshafts and cam shafts.

TYPE

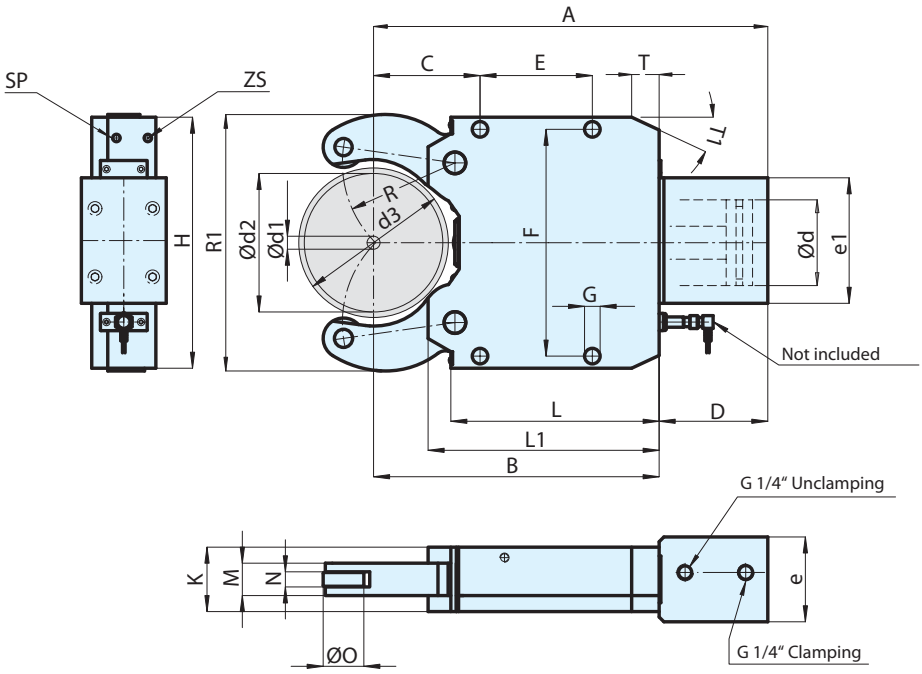
Version with extra slim clamping arms.

CUSTOMER BENEFITS

- Can be flexibly used thanks to support option in narrow in-between spaces
- Large clamping range without change elements
- Operational safety thanks to safety valve, even if pressure drops
- Compact and sturdy design for variable use
- High centering precision and repeatability thanks to proven cam lever system
- Resilient chip protection for optimal workpiece wiping (for version „with chip protection“)
- Purge air connection to prevent penetration of dirt inside the steady rest

TECHNICAL FEATURES

- Central lubrication or manual lubrication possible, depending on the operating conditions
- Standard version available with cylindrical rollers
- Available with and without chip protection
- Prepared for end position check (limit switch not included in the scope of delivery)



SLZK - slim clamping arms

C 15

Self-centering steady rests SLZK - oil or air operated, with slender clamping arms, for machining crankshafts

Clamping ranges type	SLZK 08101-15	SLZK 08101-19	SLZK 08101-22	SLZK 40200-18	SLZK 40200-22	SLZK 325-19	SLZK 325-22	SLZK 325-29
Clamping range - with chip protection mm	16-101	16-101	16-101	30-185	30-185	35-248	35-248	35-248
Clamping range - without chip protection mm	8-105	8-105	8-105	30-185	30-185	35-250	35-250	35-250
With chip protectors RZ	**1685636 ▲**	**1685638 ▲**	**1685640 ▲**	**1685642 ▲**	**1685644 ▲**	**1685646 ▲**	**1685648 ▲**	**1685650 ▲**
Without chip protectors RZ	**1685637 ▲**	**1685639 ▲**	**1685641 ▲**	**1685643 ▲**	**1685645 ▲**	**1685647 ▲**	**1685649 ▲**	**1685651 ▲**
d1 mm	8	8	8	30	30	35	35	35
d2 mm	105	105	105	185	185	250	250	250
d3 mm	106	106	106	190	190	254	254	254
Max. Ø opening range d4sw mm	113	113	113	200	200	263	263	263
A mm	279,5	279,5	279,5	458,5	458,5	617,5	617,5	617,5
B mm	197	197	197	333	333	451	451	451
C mm	70	70	70	138	138	146	146	146
D mm	82,5	82,5	82,5	125,5	125,5	166,5	166,5	166,5
E mm	85	85	85	135	135	240	240	240
F mm	170	170	170	262	262	365	365	365
G mm	14	14	14	18	18	23	23	23
H mm	190	190	190	290	290	400	400	400
K mm	50	50	50	85	85	110	110	110
L mm	143	143	143	223	223	331,5	331,5	331,5
L1 mm	164	164	164	251	251	364	364	364
Clamping arm width M mm	15	18	22	18	22	19	22	29
Roller width N mm	8	10	13	11	13	11	13	16
O mm	35	35	35	47	47	52	52	52
R mm	74,5	74,5	74,5	143,5	143,5	183	183	183
d mm	50	50	50	60	60	60	60	60
e mm	68	68	68	98	98	124	124	124
e1 mm	92	92	92	145	145	156	156	156
T mm	-	-	-	-	-	45	45	45
T1	-	-	-	-	-	30°	30°	30°
R1 mm	190	190	190	320	320	394	394	394
Weight kg	11,5	11,5	11,5	40	40	80	80	80
ZS	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"
SP	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"	G 1/8"
Operating pressure bar	8-32	8-40	8-50	8-60	8-75	8-70	8-80	8-80
Max. permissible clamping force per roller N	2100	2700	3350	5600	7000	6600	7500	7500
Centering accurancy over the entire clamping range mm	0,03*	0,03*	0,03*	0,05*	0,05*	0,06*	0,06*	0,06*
Repeat accurancy mm	0,007*	0,007*	0,007*	0,007*	0,007*	0,01*	0,01*	0,01*
Max. roller peripheral speed m/min	750	750	750	715	715	700	700	700

*) At constant pressure and clamping force

Grinding steady rest SLZV



Grinding steady rest SLZV - with retractable arms

APPLICATION

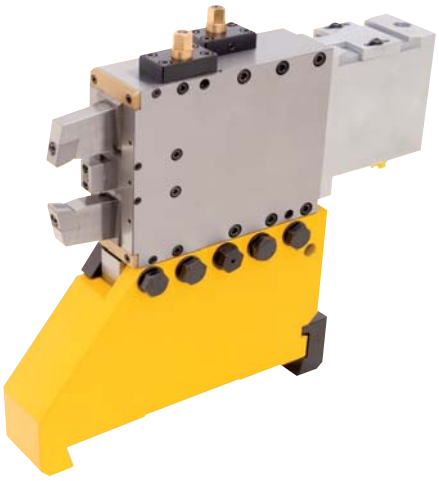
Grinding machining on CNC grinding machines. As support for long shafts, for internal machining or grinding directly on the seat of the steady rest.

TYPE

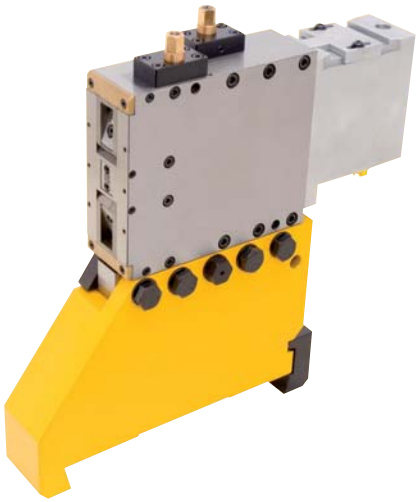
Equipped with fine adjustment in X and Y axes. Standard version with carbide jaws. With PKD (diamond) jaws on request.

CUSTOMER BENEFITS

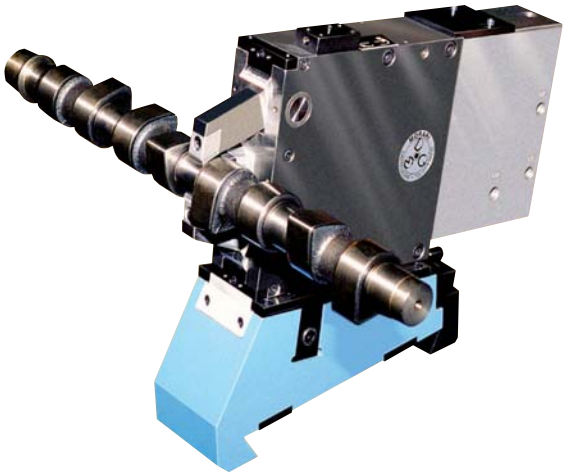
- Free work area and automatic workpiece loading thanks to retractable arms in the steady rest body
- Small dimensions and high positioning accuracy and repeatability by means of fine adjustment in the X and Y axes



Grinding steady rest SLVZ with extended arms

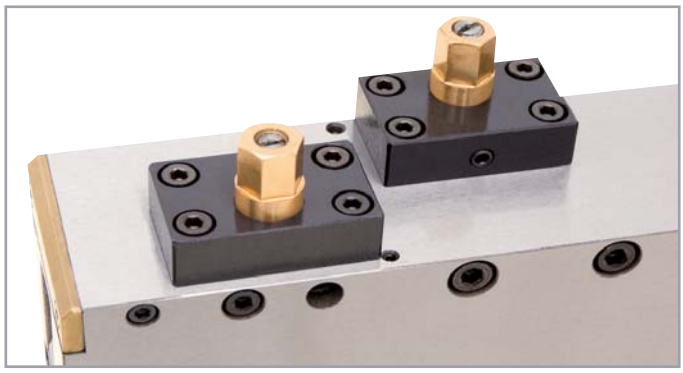


Grinding steady rest SLVZ with retracted arms



Steady rest SLVZ in use

Grinding steady rest SLZV



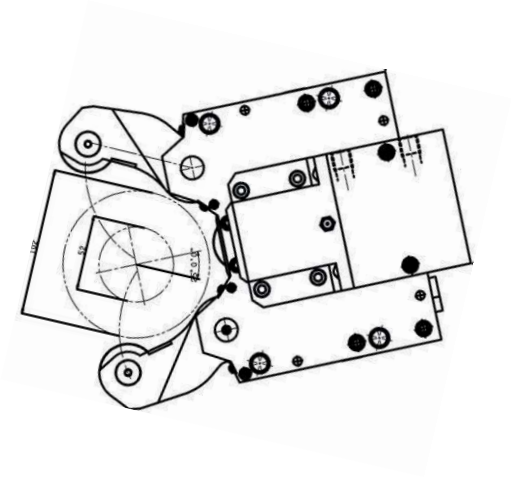
µ-exact fine adjustment for exactly setting up the steady rests. This system allows an easy and quick set-up, if several steady rests are used for the same workpiece. The control system for opening and closing is included in the standard version for all steady rests. The hydraulic or pneumatic connections can be attached according to customer requirements. It is recommended that no pressure changes occur during operation.

Main features:

- Carbide jaws (CBN) or PKD on request (polycrystalline diamond)
- Hydraulic or pneumatic actuation
- High centering precision
- Allows grinding machining on the seat of the steady rest
- High repeatability
- Stroke control for clamping and open positions
- Compact, rigid structure
- Customized versions on request

Steady rest solutions - on request



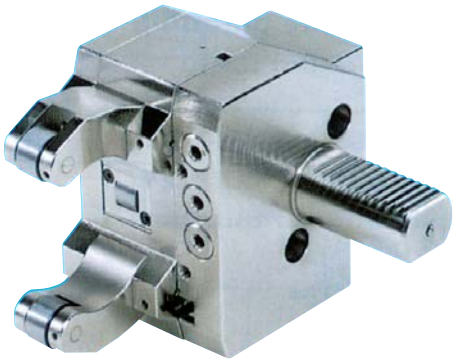


SLZW - One extra opening clamping arm

APPLICATION
For applications where simple loading is decisive.

TYPE
Hydraulically or pneumatically actuated one extra opening clamping arm.

CUSTOMER BENEFITS
- Simple loading of the workpiece



SLZR

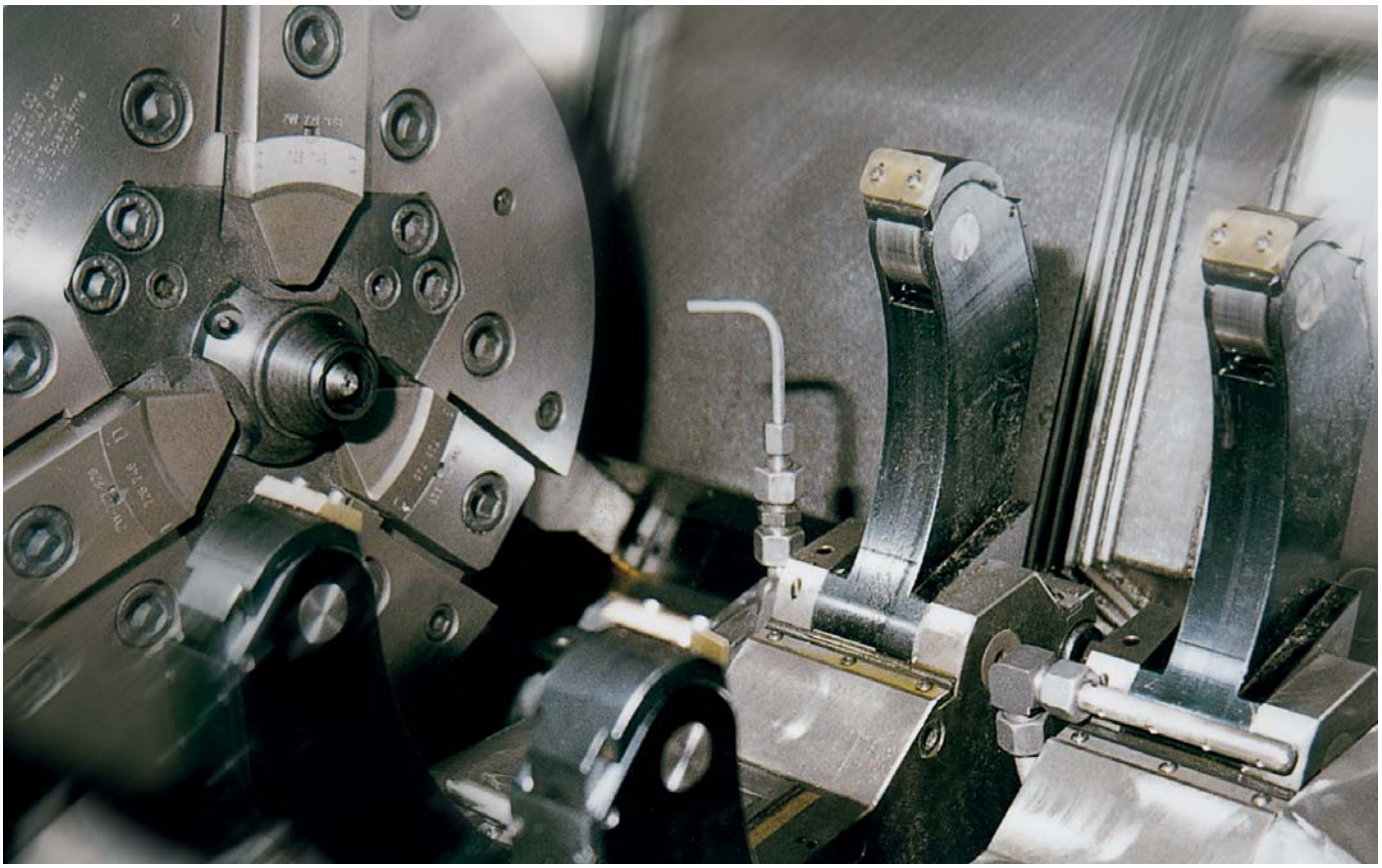
APPLICATION
For turret discs of CNC lathes with 4 axes.

TYPE
Hydraulically or pneumatically actuated. Take-up shaft in acc. with DIN 69880.

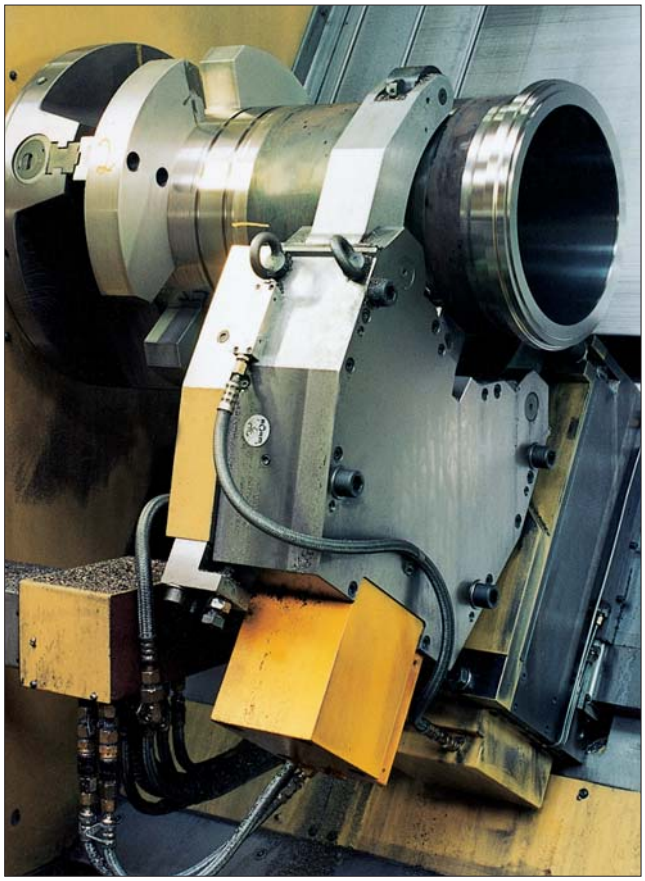
CUSTOMER BENEFITS
- Rational machining of shaft-type components in 4-axis CNC lathes

Mounting examples

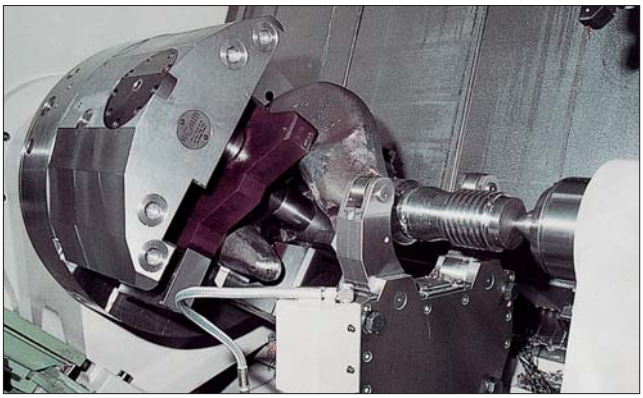
Reaming: crank shafts



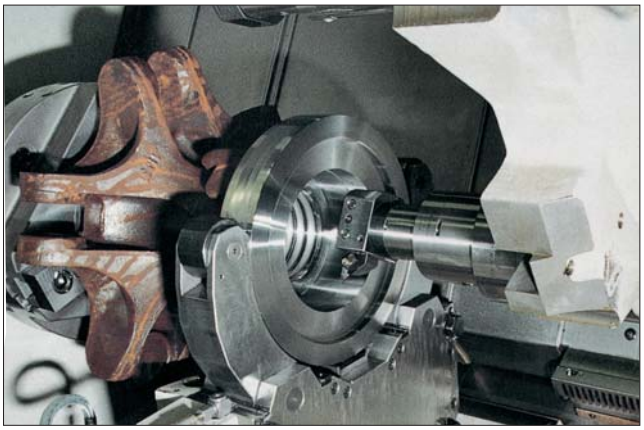
Turning: sleeves



Turning: load hooks



Turning: adaptor cages





IDEAL FOR STATIONARY USE

The stationary power clamping devices from RÖHM are predestined for stationary, centric clamping of round and angular workpieces on milling machines or machining centers or for the rational clamping in automated work sequences.



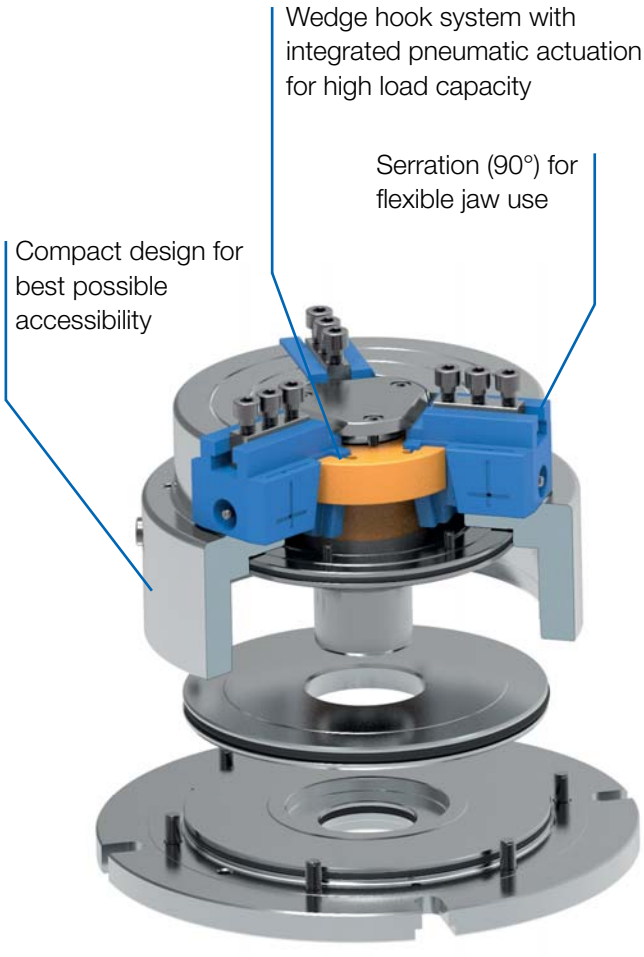
Stationary application

STATIONARY POWER CLAMPING DEVICES

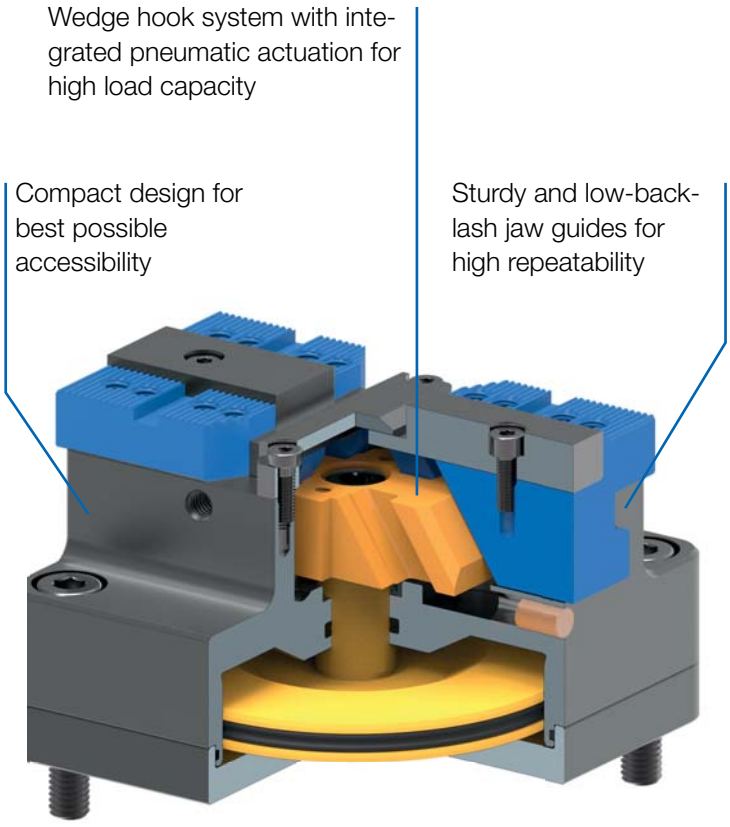
Stationary power clamping devices are characterized by many product advantages, which are essential for stationary, centric clamping on milling machines or machining centers or for the rational clamping in automated work sequences: Compact design for best possible work area utilization, high repeatability and constant clamping force at the same pressure, as well as maximum flexibility thanks to the centric clamping of round and angular workpieces.

ADVANTAGES AT A GLANCE

- High efficiency thanks to automated and fast clamping in stationary use
- Wedge hook system for high load capacity and clamping precision
- Flexible use thanks to centric clamping of angular and round components



Stationary power chuck SSP



Pneumatically-operated centering vice KZS-PG

KZS-P



APPLICATION

Optimally suited for the rational clamping in automated work sequences.

TYPE

Pneumatically actuated centering vice available in standard version.
2-Jaw version.

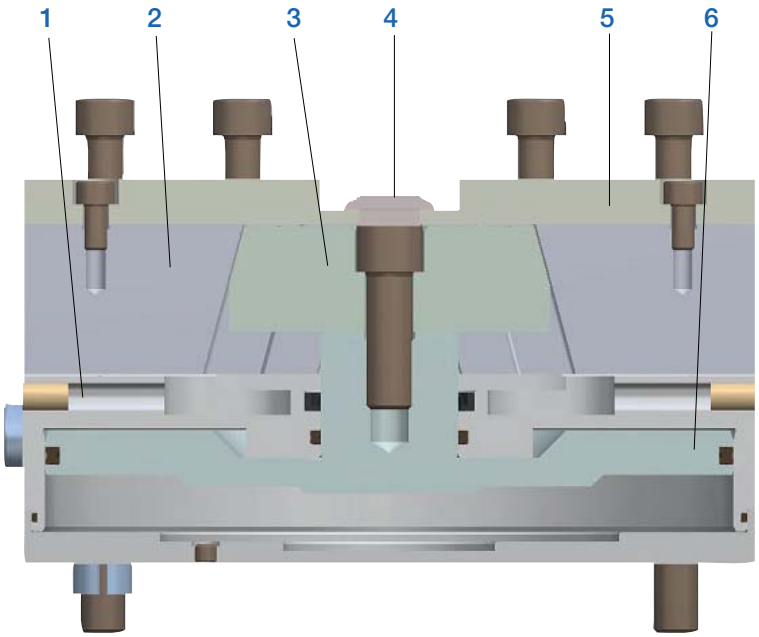
CUSTOMER BENEFITS

- Compact design for best possible work area utilization
- Flexible use thanks to lateral accessibility
- High repeatability thanks to sturdy, low-backlash jaw guides and constant clamping force at same pressure
- Centric clamping of round and angular workpieces possible by using different clamping jaws
- Suitable for internal and external clamping

TECHNICAL FEATURES

- Wedge hook principle with integrated pneumatic actuation
- Clamping force can be regulated by changing the pressure

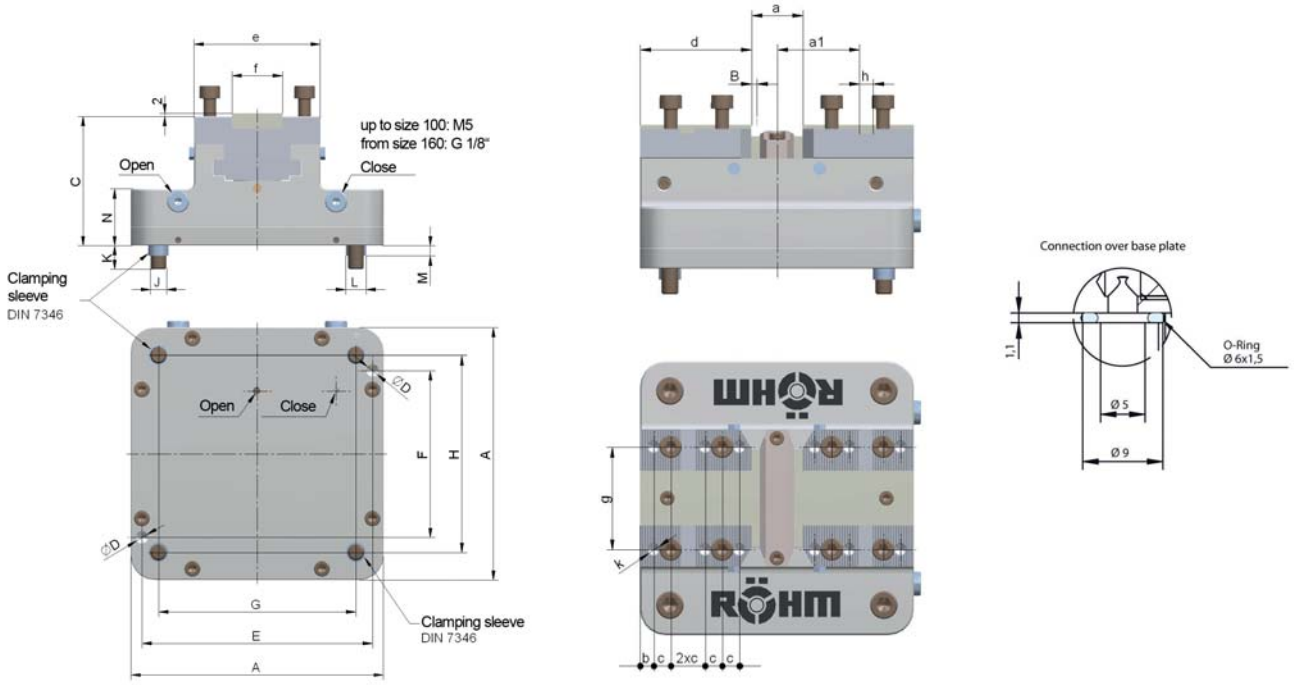
Note:
Hydraulic actuation on request



Componenents:

1. Body
2. Base jaw
3. Piston
4. Cover bridge
5. Guiding rail
6. Piston plate

KZS-P



C 15

Air-operated centering vices KZS-P, base jaws with serration 1,5 x 60° and tongue and groove connection

Item no.	165092	165093	165094	165455 ▲	165095 ▲
Size	64	100	160	200	250
A mm	64	100	160	200	250
Jaw travel B mm	2,2	2,5	3,2	3,5	4
C mm	50,5	69	82	90	98
Ø D mm	4	6	8	8	10
E±0,01 mm	18 from center	90	146	184	230
F±0,01 mm	56	64	106	146	154
G±0,04 mm	50	80	125	160	200
H±0,04 mm	50	80	125	160	200
J (4x)	M6	M8	M10	M10	M12
K mm	8	12	15	15	18
Ø L Clamping sleeve mm	8	11	13	13	16
M mm	2,5	4,5	6,5	6,5	6
N mm	28	35	36	42	52
O mm	17	32	40	50	64
P mm	17	29,5	50	65	75
a min.	12	20	23,6	25	28
a max.	16,4	25	30	32	36
a 1 min.	13	25,5	44,8	54,5	57
a 1 max.	15,2	28	48	58	61
b mm	4	5	8	8	11
c mm	5	7	10	10	12
d mm	23	37,5	65	84	107
e mm	34	55	80	100	125
f g6 mm	14	20	32	40	50
g mm	24	35	60	80	90
h H7 mm	4	6	8	8	10
k	4xM4/6	4xM6/8	5xM8/13	6xM8/13	8xM10/16
Piston area cm2	22	62	175	250	370
Max. operating pressure bar	6	9	9	6	6
Max. total clamping force kN	2,5	13	35	35	50
Weight kg	1	3	9	19	29,5
Air consumption/Double stroke cm^3	31	126	420	650	1300

Jaws KZS-P

C 21
Soft top jaws, 2-jaw set, can be hardened serration 60° - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
166138	64	25	20	34
166140	100	42	25	55
166142	160	60	40	80
166144	200	75	45	100
166146	250	90	50	125

C 21
Soft top jaws, 2-jaw set tongue and groove, high design, material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
166126	64	28,5	35	34
166128	100	47	48	55
166130	160	76	77,5	80
166132	200	96	85	100
166134	250	120	100	125

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

KZS-PG



APPLICATION

Optimally suited for the rational clamping in automated work sequences.

TYPE

Pneumatically actuated centering vice available with a large jaw stroke.
2-jaws version.

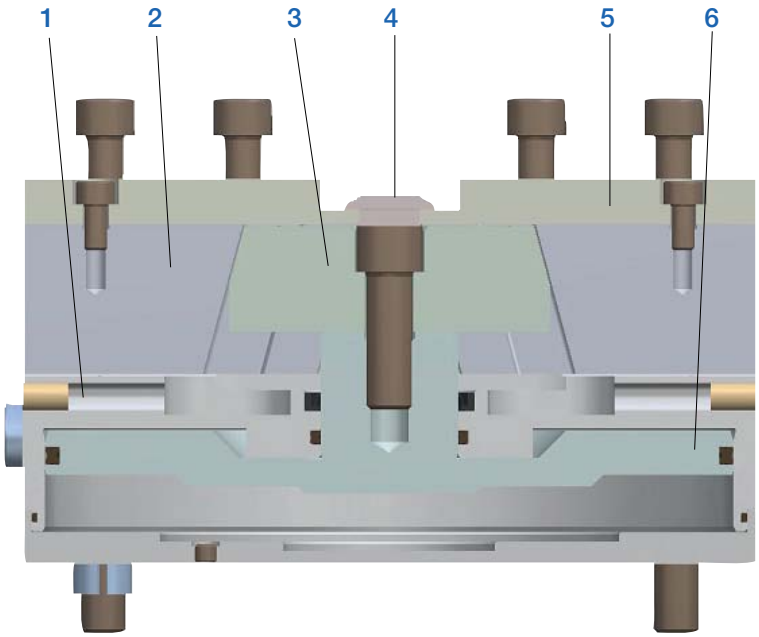
CUSTOMER BENEFITS

- Compact design for best possible work area utilization
- Flexible use thanks to lateral accessibility
- High repeatability thanks to sturdy, low-backlash jaw guides and constant clamping force at same pressure
- Centric clamping of round and angular workpieces possible by using different clamping jaws
- Suitable for internal and external clamping

TECHNICAL FEATURES

- Wedge hook principle with integrated pneumatic actuation
- Clamping force can be regulated by changing the pressure

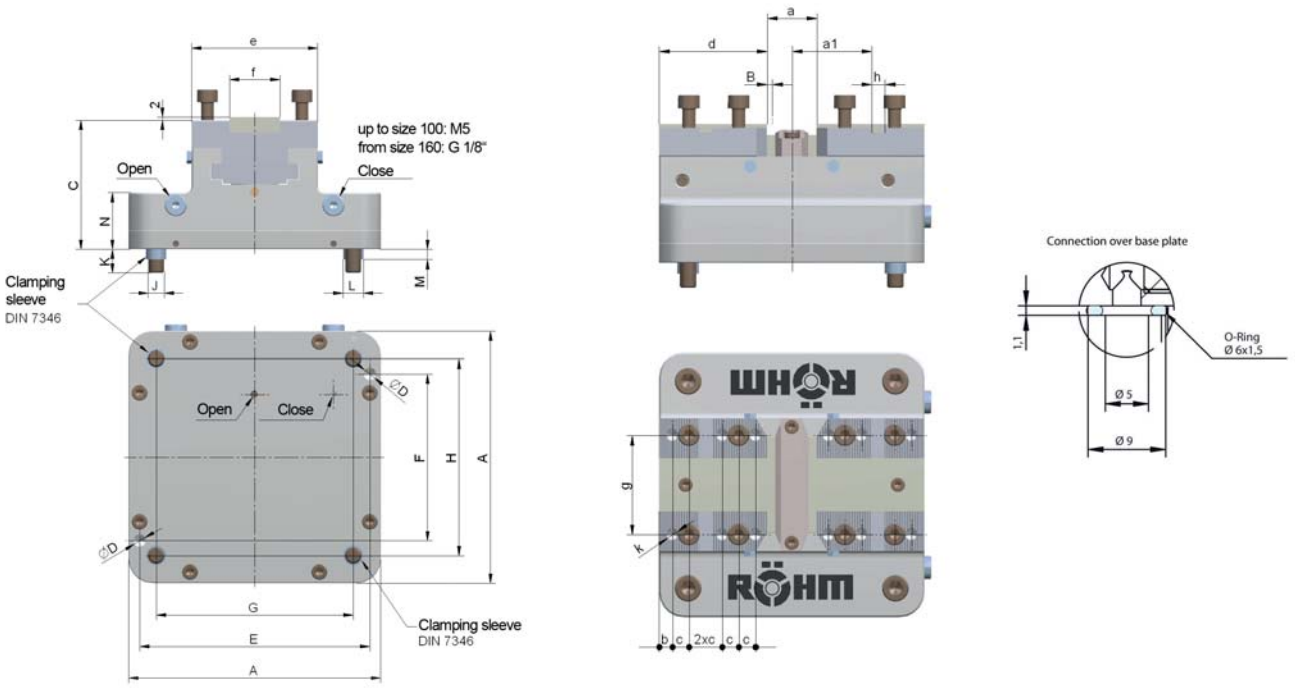
Note:
Hydraulic actuation on request



Components:

1. Body
2. Base jaw
3. Piston
4. Cover bridge
5. Guiding rail
6. Piston disc

KZS-PG



C 15

Air-operated centering vices KZS-PG, large jaw movement Base jaws with serration 1,5 x 60° and tongue and groove connection

Item no.	165340	165341	165456 ▲	165343 ▲
Size	100	160	200	250
A mm	100	160	200	250
Jaw travel B mm	6	7,8	8,5	15
C mm	69	82	90	98
Ø D mm	6	8	8	10
E±0,01 mm	90	146	184	230
F±0,01 mm	64	106	146	154
G±0,04 mm	80	125	160	200
H±0,04 mm	80	125	160	200
J (4x)	M8	M10	M10	M12
K mm	12	15	15	18
Ø L Clamping sleeve mm	11	13	13	16
M mm	4,5	6,5	6,5	6
N mm	35	36	42	52
O mm	32	40	50	64
P mm	29,5	50	65	75
a min.	20	23	25	33
a max.	32	38,6	42	63
a 1 min.	25,5	44,8	54,5	51,5
a 1 max.	31,5	52,6	63	66,5
b mm	5	11,2	11,5	15
c mm	7	10	10	12
d mm	37,5	68,5	87,5	103
e mm	55	80	100	125
f g6 mm	20	32	40	50
g mm	35	60	80	90
h H7 mm	6	8	8	10
k	4xM6/8	5xM8/13	6xM8/13	8xM12/18
Piston area cm2	62	175	250	370
Max. operating pressure bar	6	6	6	6
Max. total clamping force kN	4,2	10,5	14	15
Weight kg	3	9	19	29,5
Air consumption/Double stroke cm3	126	420	650	1300

▲ on request

Jaws KZS-PG

C 21
Soft top jaws, 2-jaw set, can be hardened serration 60° - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
166138		25	20	34
166140	100	42	25	55
166142	160	60	40	80
166144	200	75	45	100
166146		90	50	125

C 21
Soft top jaws, 2-jaw set tongue and groove, high design, material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
166126		28,5	35	34
166128	100	47	48	55
166130	160	76	77,5	80
166132	200	96	85	100
166134		120	100	125

Configure your individual clamping jaws online! www.web2product.biz

SSP



APPLICATION

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

TYPE

Clamping system consisting of a 3-jaw chuck, including an integrated pneumatic cylinder.
Serration 90°

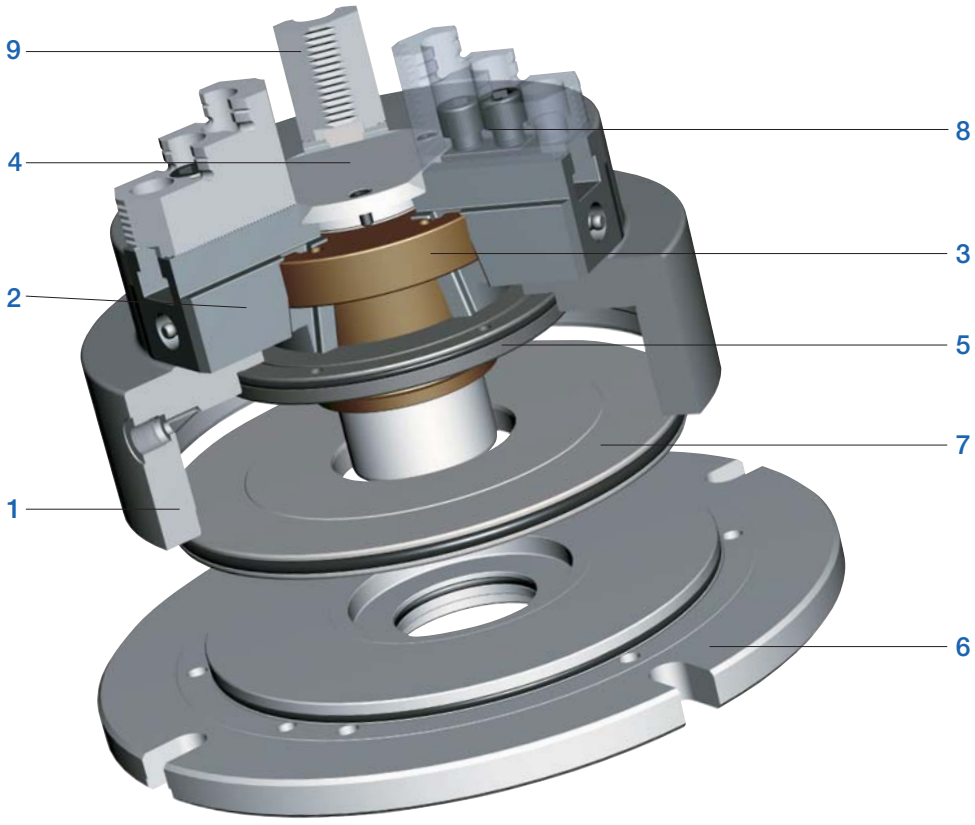
CUSTOMER BENEFITS

- Compact design
- Large variety of applications is possible by using different clamping jaws
- Centric clamping of round and angular workpieces
- High repeatability thanks to sturdy chuck construction and constant clamping force at same pressure
- Purge air connection possible to prevent contamination

TECHNICAL FEATURES

- Wedge hook system with pneumatic actuation
- Clamping force can be regulated by changing the pressure

Note:
Hydraulic actuation on request

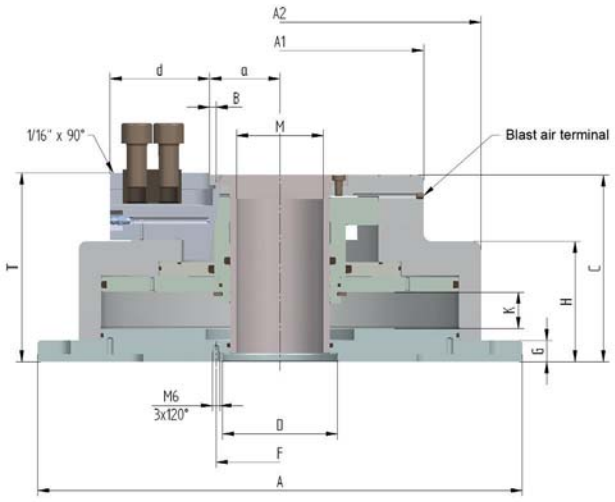


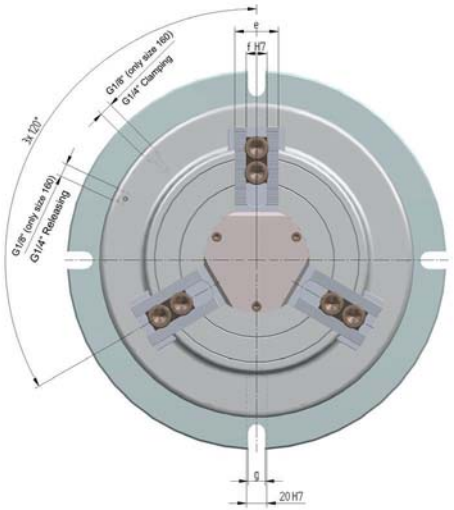
Components:

1. Body
2. Base jaw
3. Piston
4. Protective bushing
5. Intermediate disc
6. Mount
7. Piston disc
8. T-nut
9. Top jaws

▲ on request

SSP





C 15
Stationary power chucks SSP, air operated 3-jaw chucks, without through-hole, serration 1/16“ x 90°

Item no.	161505	161506	161507	161508
Size	160	200	250	315
Number of jaws	3	3	3	3
A mm	260	320	380	415
A1 mm	178	205	255	320
A2 mm	210	255	315	350
Jaw travel B mm	4,2	4,2	5	5
C mm	130,5	134	146	156,5
Mount DH6	55	70	90	110
D	M8	M12	M16	M16
F mm	65	80	100	120
G mm	15	17	17	21,5
H mm	84,5	86	94	104,5
Wedge stroke K mm	24	23,8	28,4	28,4
Possible through-hole M mm	38	52	68	90
T mm	131,5	135,5	147,5	158
U	M8	M12	M16	M16
a min.	31,8	41,2	50	61,5
a max.	36	45,4	55	66,5
c mm	15	19	25	25
d mm	54,5	62	78	99
e mm	32	36	44	44
fH7 mm	12	17	21	21
g mm	13	17	17	17
Piston area cm2	209	323	532	654
Min. operating pressure bar	2	2	2	2
Max. operating pressure bar	8	8	8	8
Max. total clamping force at working pressure - External clamping kN	36 (bei 6 bar)	55 (bei 6 bar)	90 (bei 6 bar)	111 (bei 6 bar)
Max. total clamping force at working pressure - Internal clamping kN	38 (bei 6 bar)	60 (bei 5 bar)	96 (bei 6 bar)	118 (bei 6 bar)
Weight without jaws approx. kg	25	34	54	65

Jaws SSP

C 21
Reversible top jaws, 3-jaw set, hardened serration 90° - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
046404	160	56	37,5	26	1/16“x 90°
118522	200	75	49	36	1/16“x 90°
046414	250/315	103,5	58	50	1/16“x 90°

Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21
Soft top jaws, 3-jaw set, can be hardened serration 90° - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
046403	160	55	38	26,5	1/16“x 90°
133153	200	75	53	36,5	1/16“x 90°
133154	250	95	54,5	45	1/16“x 90°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 12



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
144320	160	66	38	52	1/16“x 90°
144321	160	56	38	34	1/16“x 90°
144322	160	66	38	25	1/16“x 90°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 17



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137031	200	67	45	53	1/16“x 90°
137032	200	65	45	46	1/16“x 90°
137039	200	55	45	40	1/16“x 90°
137034	200	50	45	31	1/16“x 90°
137035	200	55	45	27	1/16“x 90°
137036	200	65	45	19	1/16“x 90°
137037	200	65	45	26	1/16“x 90°
137038	200	55	45	24	1/16“x 90°
137033	200	55	45	39	1/16“x 90°

C 21
Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 21



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137041	250/315	95	50	80	1/16“x 90°
137042	250/315	75	50	60	1/16“x 90°
137043	250/315	60	50	43	1/16“x 90°
137044	250/315	70	50	37	1/16“x 90°
137045	250/315	95	50	25	1/16“x 90°
137046	250/315	80	50	30	1/16“x 90°

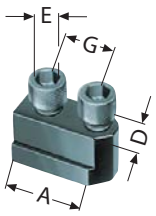
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▲ on request

Accessories SSP

C 15

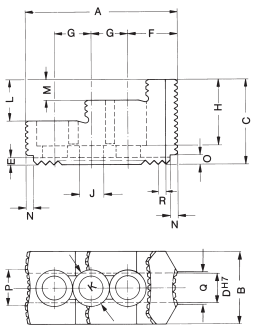
Extended T-nuts
With screw



Item no.	Chuck Size	Con-tents of delivery	D mm	E	G mm
1305178	160	piece	12	M8x25	2x15
1305179	200	piece	17	M12x30	19
1305180	250/315	piece	21	M16x35	25

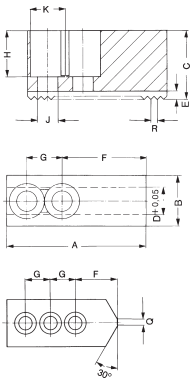
Jaw dimensions SSP

Reversible top jaws UB,
hardened, serration 90°



Chuck size	160	200	250/315
Type	538-02	538-04	538-05
Item no. 3-jaw	**046404**	**118522**	**046414**
A	56	75	103,5
B	26	36	50
C	37,5	49	58
D H7	12	17	21
E	3,5	5	5
F	14	21,5	33,5
G	15	19	25
H	29	37,5	45
J	8,4	13	17
K	13,5	19	25
L	20	24	28
M	10	12	14
N	4	6	6
O	4	7,5	6,5
P	5	18	24,5
Q	5	7	22,5
R	1/16"x90°	1/16"x90°	1/16"x90°
Weight/jaw kg	0,170	0,460	1,130

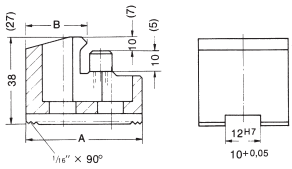
Soft top jaws AB,
Serration 90°,



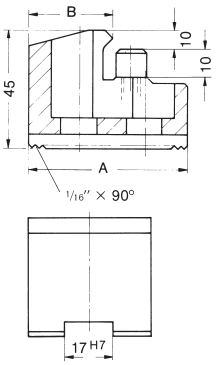
Chuck size	160	200	250/315
Type	538-02	538-03	538-05
Item no. 3-jaw	**046403**	**133152**	**133154**
A	55	66,7	95
B	26,5	36,5	45
C	38	53	54,5
D	12	17	21
E	3,5	5	5
F	31	36	55
G	15	19	25
H	28	43	42,5
J	8,4	13	17
K	13,5	19	25
Q	-	-	-
R	1/16"x90°	1/16"x90°	1/16"x90°
Weight/jaw kg	0,330	0,700	1,400

Jaw dimensions und Chucking capacities SSP

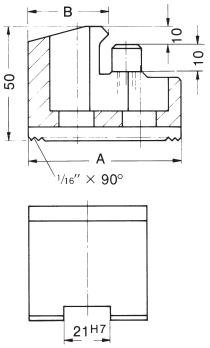
Claw type jaws KB,
Serration 90°



Größe	A	B	160
Item no. Piece			Chucking capacities external
144320	66	52	56-102
144321	56	34	96-152
144322	66	25	138-184
			Chucking capacities internal
144322	66	25	70-116
144321	56	34	112-200
144320	66	52	152-198

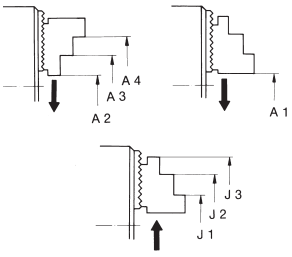


Item no. Piece	A	B	200
			Chucking capacities external
137031	67	53	66-104
137032	65	46	80-118
137039	55	40	106-144
137034	50	31	130-148
137035	55	27	126-164
			Chucking capacities internal
137036	65	19	82-120
137037	65	26	92-130
137038	55	24	110-148
137035	55	27	132-170
137034	50	31	148-184
137039	55	40	134-190
137033	55	39	164-202
137032	65	46	178-216



Item no. Piece	A	B	250	315
			Chucking capacities external	
137041	95	80	54-112	78-186
137042	75	60	94-152	118-226
137043	60	43	128-186	152-260
137044	70	37	158-216	182-290
137045	95	25	238-280	262-330
			Chucking capacities internal	
137045	95	25	72-130	96-204
137046	80	30	110-168	134-242
137044	70	37	152-210	176-284
137043	60	43	182-240	206-314
137042	75	60	216-274	-

Chucking capacities with reversible top jaws UB



Chuck size		160	200	250	315
with reversible jaws	Type	538-02	538-04	538-05	538-05
	Jaw position				
External chucking	A1	28-80	30-115	20-128	41-194
	A2	32-84	44-128	46-154	67-220
	A3	82-132	101-185	128-238	150-303
	A4	118-168	152-236	210-318	231-384
Internal chucking	J1	64-116	80-165	70-188	91-244
	J2	96-148	130-214	146-255	168-320
	J3	140-192	182-266	225-334	246-400

F-senso chuck clamping force measuring device



With F-senso chuck, check both the clamping force as well as the speed behavior of the clamping device
Maximum flexibility through large clamping range from 75-175 mm by means of exchangeable pressure bolts and large measuring range from 0-100 kN per jaw. Suitable for 3-jaw chuck as well as vices. Dynamic clamping force measurement under rotation up to 8250 rpm. For clamping chucks, both the clamping force as well as the speed are measured. The centrifugal force behavior is transferred to the Tablet (included in delivery) in real time via Blue-Tooth and is evaluated with the already-installed software.

Video F-senso chuck

ADVANTAGES AT A GLANCE

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

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



C 15
Clamping force measurement device F-senso chuck

Item no.	179800
Measuring range / Clamping force kN	2 jaws: 0 - 200; 3 jaws: 0 - 300
Measuring range / Rotation speed min-1	0 - 8250
Accuracy	Force <0.5% / Rotation speed ±10 rpm within the complete measuring range
Clamping Ø mm	75 - 175
Dimensions (base unit)	Ø 75/80 x 130

Power-Grip zero-point clamping system





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

ADVANTAGES AT A GLANCE

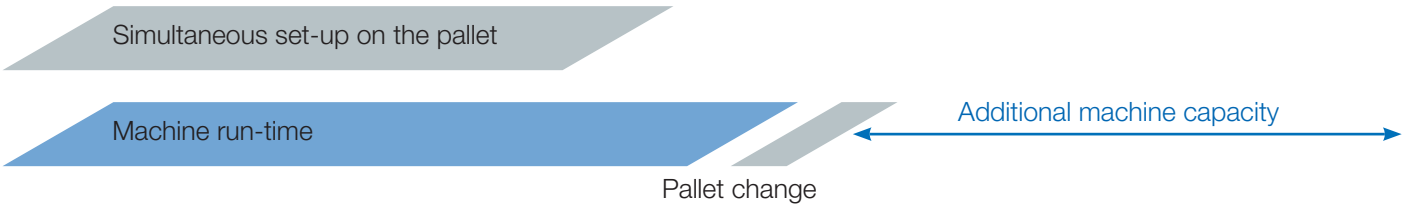
- Increase in productivity thanks to set-up time reduction up to 90 %
- Maximum precision and repeatability of 0.002 mm
- Palletizing and clamping device from one source

SET-UP TIME REDUCTION BY UP TO 90 %

Without palletizing system



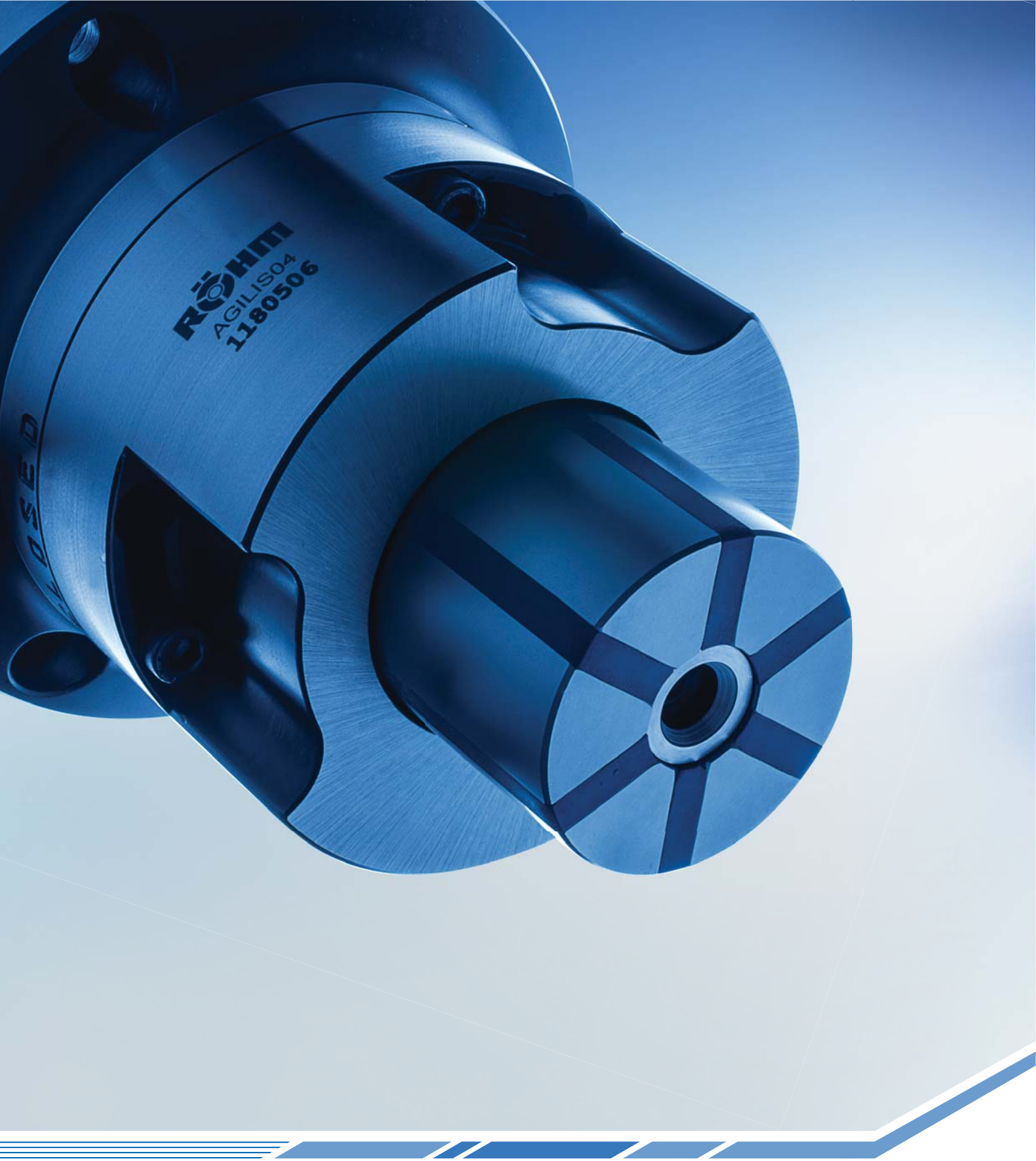
With Power-Grip zero-point clamping system



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driven by technology

Id.-Nr. 1178265 / 0915 AU



MANDRELS
COLLET CHUCKS

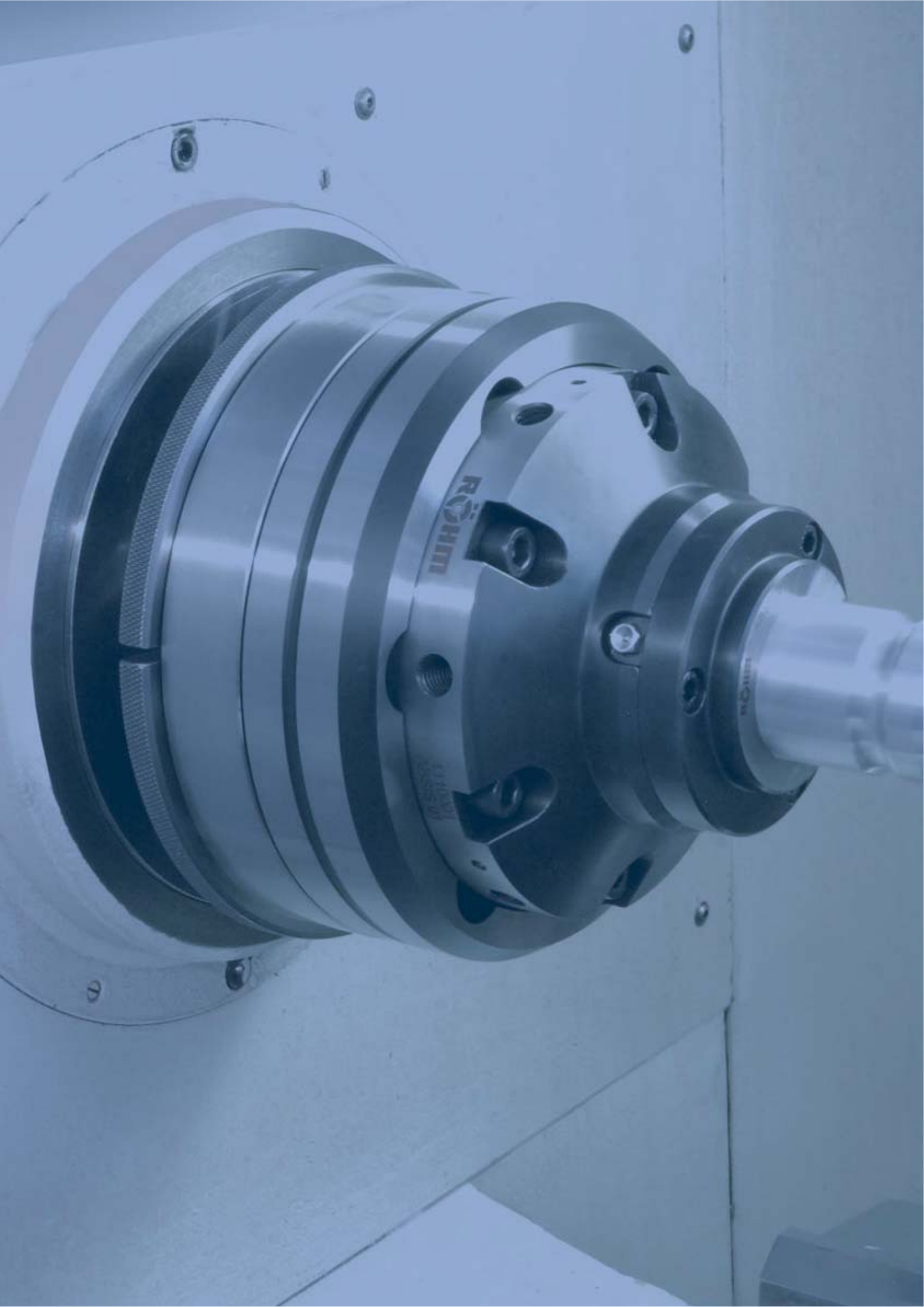
2015/2016

RÖHM
driven by technology

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

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

Dynamism
Variety
Security
Partnership
Globality
Innovation


RÖHM

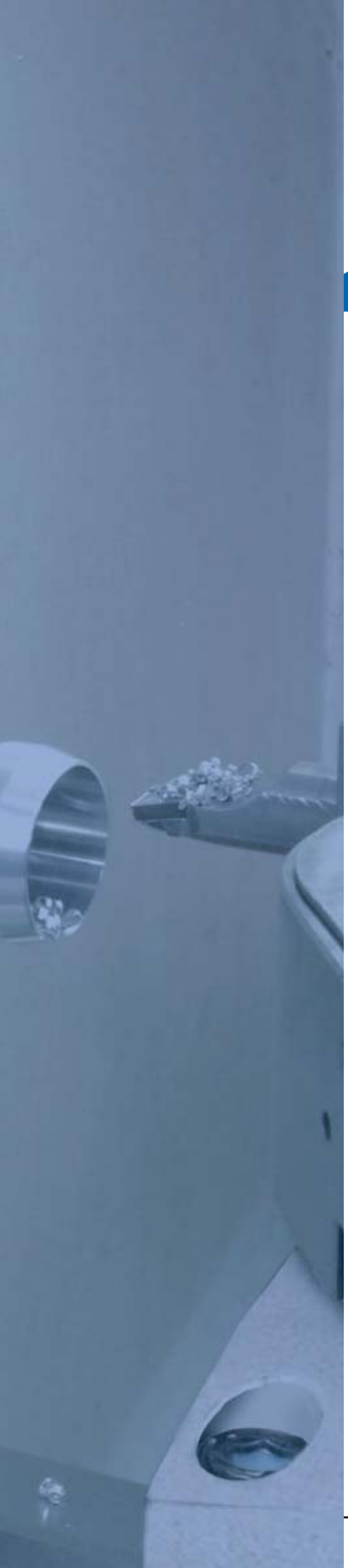


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MANDRELS I COLLET CHUCKS

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MFR-SE	7053

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Special solutions 7074

Errors and corrections are reserved!

Orientation guide



TYPE	KFS/MFS	KFR/MFR	KFB	MZB	MZE	ABSIS	AGILIS	KFR-SE
	Cartridge mandrel					Segment clamping mandrel		
Feature	Stable clamping, suitable for long workpieces or long clamping lengths	Suitable for short clamping lengths with or without a defined axial component	Stable system with high torque transmission for working with small Ø, for short clamping lengths	Stable system with high torque transmission for working with small Ø, for short clamping lengths	Cost-effective system for measuring tasks, high accuracy	High degree of hardness of the clamping sleeve, thereby wear resistant, long service life of the clamping sleeve	Stable system with high torque transmission for working with small Ø, for short clamping lengths, high degree of hardness of the clamping sleeve	Suitable for short clamping lengths with or without a defined axial component
Application	Turning, grinding, milling, gear cutting, balancing, measuring	Turning, grinding, gear cutting, balancing, measuring	Turning, grinding, milling, gear cutting, balancing, measuring	Turning, grinding, measuring	Measuring, grinding	Turning, grinding, milling, gear cutting, balancing, measuring		Turning, grinding, milling, gear cutting, balancing, measuring
Clamping	Internal	Internal	Internal	Internal	Internal	Internal	Internal	Internal
Actuation	✋ ⚙	✋ ⚙	⚙	✋	✋	⚙	⚙	⚙
Clamping surface	Smooth (optionally coated, serrated, toothed, for shape clamping)				Smooth	Smooth (optionally coated, serrated, toothed, for shape clamping)		
Axial component	✓	O	✓	✓	✓	✓	✓	O
Clamping range mm	15 - 140	14,5 - 131	5,5 - 29	5,5 - 78,7	8 - 230	20 - 106	10 -130	14,5 - 131
Workpiece stop possible	✓	✓	✓	✓		✓	✓	✓
Preparation for air sensing	✓	✓				✓	✓	✓
Take-up	Cylindrical take-up mount combined with Intermadiate flange ISO 702-1 (DIN 55028)			Between points or cylindrical take-ups, driving at the shaft possible		Cylindrical take-up mount combined with Intermadiate flange ISO 702-1 (DIN 55028)		
Page	7006 / 7007	7016 / 7018	7027	7030	7033	7042	7047	7052

✓ yes O optional ✋ hand operated ⚙ power operated

Orientation guide





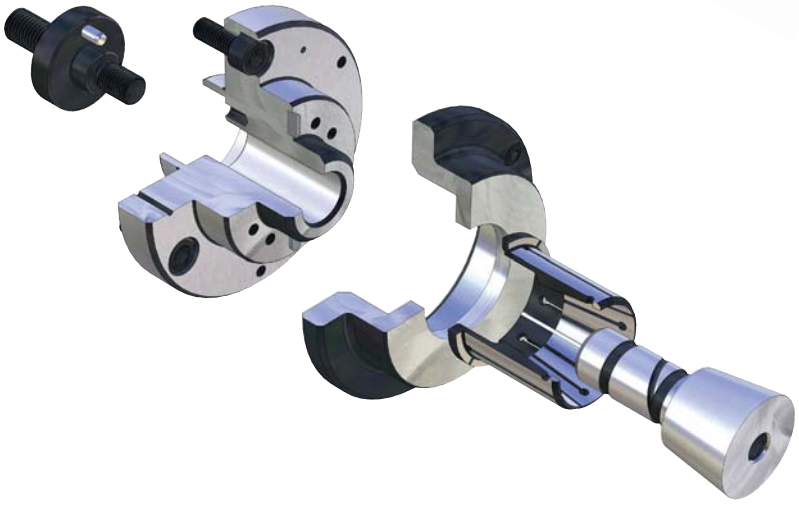




TYPE	CAPTIS-D	CAPTIS-A	CAPTIS-AF	CAPTIS-MS	ABSIS-C	KZF	KZF-S
	Collet chucks						
Feature	Full through-hole, with centering edge, draw-down	Restricted through-hole, optional fixed workpiece stop, draw-down	Restricted through-hole, fixed workpiece stop, stationary collet: without draw-down	Stationary, 3-sided clamped, manually operated	Stable system, for take-up into CAPTIS clamping system, with draw-down	Bayonet quick lock with protection against torsion	Bayonet quick lock, draw-down, actuation by clamping mandrel
Application	Turning, grinding, milling, gear cutting, balancing, measuring	Turning, grinding, milling, gear cutting, balancing, measuring	Turning, grinding, milling, gear cutting, balancing, measuring	Stationary turning, grinding, milling, drilling, measuring	Turning, grinding, milling, gear cutting, balancing, measuring	Turning, grinding, milling, measuring	Turning, grinding, milling, gear cutting
Clamping	External	External	External	External	Internal	External	External
Actuation	⚙	⚙	⚙	✋	✋ ⚙	⚙	⚙
Clamping surface	Longitudinal and cross grooves, cross grooves, smooth, shaped hexagon, square, special contour				Smooth (optionally coated, serrated, toothed, for shape clamping)	Smooth, hexagon, square	Optionally smooth, toothed, coated, serrated
Axial component	✔	✔		✔	✔		✔
Clamping range mm	4 - 120	4 - 120	4 - 120	4 - 120	20 - 106	2 - 80	30 - 180
Workpiece stop possible		✔	✔	✔	✔	✔	✔
Preparation for air sensing							✔
Take-up	Cylindrical take-up			Cylindrical mound, recording on the machine table, mounting via fastening thread	Take-up in CAPTIS clamp system	Cylindrical centering pick-up, short taper mount	Cylindrical take-up
Page	7062	7063	7064	7068	7069	7071	7072

We have already implemented special solutions in all clamping system areas, some of which differ significantly from the values indicated above (for example, clamping surfaces, clamping diameter or precision). Besides these standard clamping systems, we offer a number of special systems, such as HYKS, KFG, centering and face clamping systems or combination clamps. Even unusual special solutions are a part of our focus.

HIGH AXIAL RUN-OUT PRECISION; CONCENTRICITY AND REPEATABILITY



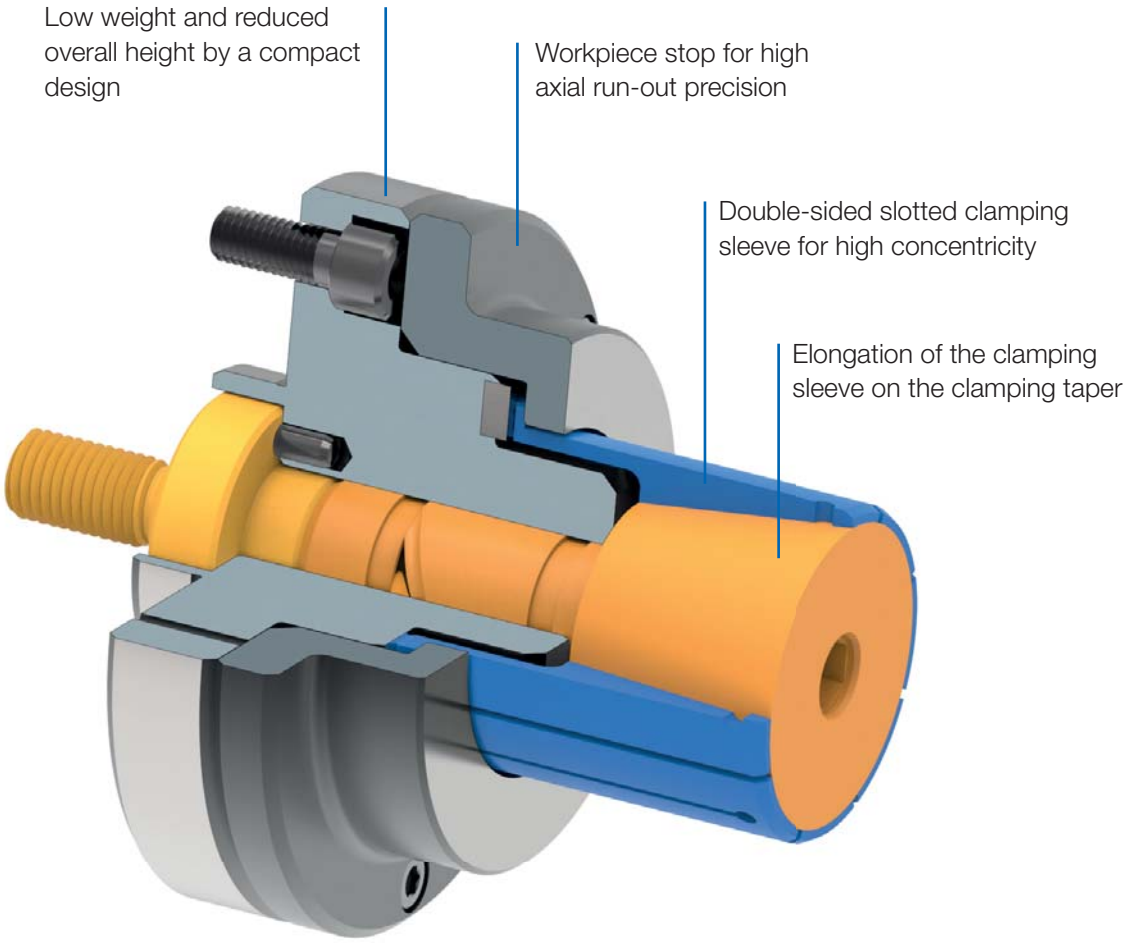
Custom-fit interaction of the individual components enables the highest degree of axial run-out precision, concentricity and repeatability.

CARTRIDGE MANDRELS

The various application areas of the cartridge mandrels require a varied programme which ranges from manual or power-operated versions to versions with and without axial tension. The centric and comprehensive internal clamping of cartridge mandrels are particularly impressive for very small clamping diameters and at low overall heights.

ADVANTAGES AT A GLANCE

- Stable clamping by axial tension against workpiece stop
- Low weight and reduced overall height by a compact design
- High axial run-out precision, concentricity and repeatability



KFS



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring.
Ideal for thin-walled and long workpieces or long clamping lengths.

TYPE

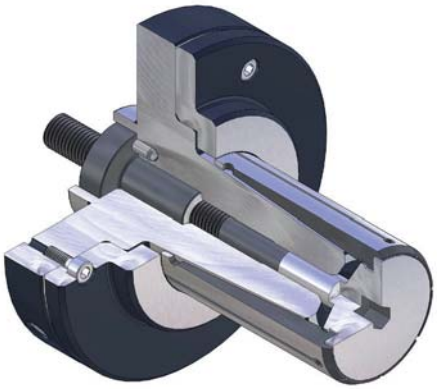
Force-actuated. Clamping sleeves optionally vulcanized.
Convertible to MFS (required new intermediate piece).

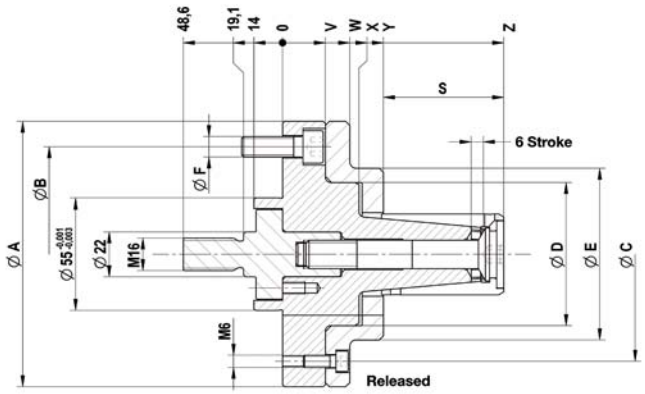
CUSTOMER BENEFITS

- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- High concentricity, axial run-out and repeatability
- Light weight and reduced height thanks to compact design
- High flexibility thanks to modular system
- Fast change of segment sleeves thanks to central clamping screw

TECHNICAL FEATURES

- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared





C18
KFS cartridge mandrel
Consisting of basic mandrel and intermediate piece

	KFS 00	KFS 01	KFS 02	KFS 03	KFS 04	KFS 05	KFS 06	KFS 07	KFS 08	KFS 09	KFS 10	KFS 11
Cartridge Mandrel	**599800**	**599801**	**599802**	**599803**	**599804**	**599805**	**599806**	**599807**	**599808**	**599809**	**599810**	**599811**
Basic mandrel	**599820**	**599821**	**599822**	**599823**	**599824**	**599825**	**599826**	**599827**	**599828**	**599829**	**599830**	**599831**
Adapter power operated	**599833**	**599834**	**599980**	**599981**	**599982**	**599983**	**599984**	**599984**	**599984**	**315456**	**315456**	**315456**
F max, in kN	7	9	12	12	15	15	20	20	25	25	25	25
Min-Ø unclamped from	14,7	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	81,7	100,7	119,7
Min-Ø unclamped to	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	81,7	100,7	119,7	139,7
Clamping-Ø max,	20,7	25,7	30,7	35,7	40,7	45,7	55,7	65,7	82,7	101,7	120,7	140,7
External-Ø A	100	100	100	100	100	130	130	130	160	160	160	160
Pitch diameter B	75	75	75	75	75	105	105	105	130	130	130	130
Pitch diameter C	75	75	75	75	75	105	105	105	130	130	130	149
Ø D mm	40	40	46	46	46	70	70	70	83	91	87	107
Ø E mm	54	54	60	60	60	84	84	84	103	160	160	160
Ø F mm	M10	M10	M10	M10	M10	M10	M10	M10	M12	M12	M12	M12
S mm	31,5	36	45	49	59	59	79	89	99	121	138,9	171
V mm	21	21	21	21	21	21	21	21	23	21	21	25
W mm	33	33	33	33	33	33	33	33	35	21	21	25
X mm	36	36	37	41	36,5	37,5	35,5	35,5	35			
Y mm	47,5	47,5	48	51,5	46	49,5	47	47	47	33	37	57
Z mm	79	83,5	93	100,5	105	108,5	126	136	146	154	176	228

Max. clamping force kN: 3,7-4,7-6,4-6,4-8,0-7,9-10,5-10,5-13,5-13,5-13,5-13,0

▲ on request

MFS



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring.
Ideal for thin-walled and long workpieces or long clamping lengths.

TYPE

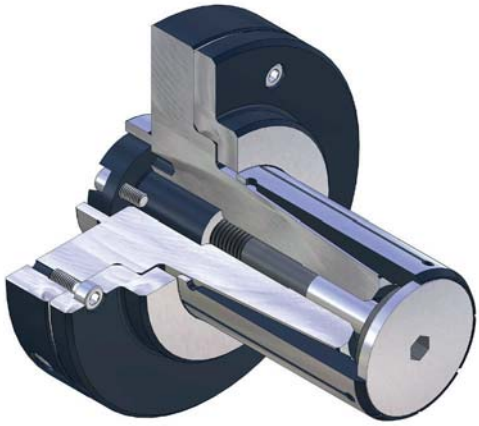
Manually actuated. Clamping sleeves optionally vulcanized.
Convertible to KFS (new adapter required).

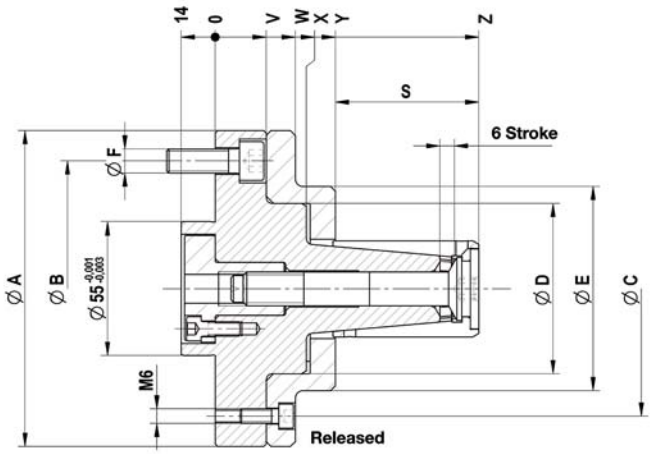
CUSTOMER BENEFITS

- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- High concentricity, axial run-out and repeatability
- Light weight and reduced height thanks to compact design
- High flexibility thanks to modular system
- Fast change of segment sleeves thanks to central clamping screw

TECHNICAL FEATURES

- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared



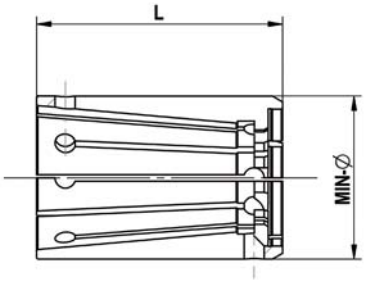


C18
MFS cartridge mandrel
Consisting of basic mandrel and intermediate piece

	MFS 00	MFS 01	MFS 02	MFS 03	MFS 04	MFS 05	MFS 06
Cartridge Mandrel	**1082800**	**1082801**	**1082802**	**1082803**	**1082804**	**1082805**	**1082806**
Basic mandrel	**599820**	**599821**	**599822**	**599823**	**599824**	**599825**	**599826**
Adapter hand-operated	**599985**	**599986**	**599987**	**599988**	**599989**	**599990**	**599991**
Md max, kN	7	12	20	22	30	35	45
Min-Ø unclamped from	14,7	19,7	24,7	29,7	34,7	39,7	44,7
Min-Ø unclamped to	19,7	24,7	29,7	34,7	39,7	44,7	54,7
Clamping-Ø max,	20,7	25,7	30,7	35,7	40,7	45,7	55,7
External-Ø A	100	100	100	100	100	130	130
Pitch diameter B	75	75	75	75	75	105	105
Pitch diameter C	75	75	75	75	75	105	105
Ø D mm	40	40	46	46	46	70	70
Ø E mm	54	54	60	60	60	84	84
Ø F mm	M10	M10	M10	M10	M10	M10	M10
S mm	31,5	36	45	49	59	59	79
V mm	21	21	21	21	21	21	21
W mm	33	33	33	33	33	33	33
X mm	36	36	37	41	36,5	37,5	35,5
Y mm	47,5	47,5	48	51,5	46	49,5	47
Z mm	79	83,5	93	100,5	105	108,5	126

Accessories KFS / MFS





C18

Clamping set KFS/MFS (not vulcanized); consisting of clamping sleeve and clamping screw

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Min-Ø mm	14,7	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	100,7	100,7	119,7
Clamping set	**1086311**	**1086322**	**1086333**	**1086344**	**1086355**	**1086366**	**1086377**	**1086388** ▲	**1086399** ▲	**1086436** ▲	**1086437** ▲	**1086457** ▲
Clamping sleeve	315330	315331	315332	315333	315334	315335	315336	315337 ▲	315338 ▲	650160 ▲	315340 ▲	315302 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599840	599845	599850	599855	599860	599865	599992	599993 ▲	599994 ▲	599925 ▲	599996 ▲	599997 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	15,2	20,2	25,2	30,2	35,2	40,2	45,7	55,7	65,7	81,7	101,7	120,7
Clamping set	**1086312**	**1086323**	**1086334**	**1086345**	**1086356**	**1086367**	**1086378**	**1086389** ▲	**1086400** ▲	**1086417** ▲	**1086438** ▲	**1086458** ▲
Clamping sleeve	650021	650034	650047	650060	650073	650086	650098	650110 ▲	650123 ▲	315339 ▲	650163 ▲	650184 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599870	599880 ▲	599890 ▲	599995 ▲	599926 ▲	599945 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	15,7	20,7	25,7	30,7	35,7	40,7	46,7	56,7	66,7	82,7	102,7	121,7
Clamping set	**1086313**	**1086324**	**1086335**	**1086346**	**1086357**	**1086368**	**1086379**	**1086390** ▲	**1086401** ▲	**1086418** ▲	**1086439** ▲	**1086459** ▲
Clamping sleeve	315341	315342	315343	315344	315345	315346	315347	315348 ▲	315349 ▲	650142 ▲	315351 ▲	315303 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599871	599881 ▲	599891 ▲	599907 ▲	599927 ▲	599946 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,2	21,2	26,2	31,2	36,2	41,2	47,7	57,7	67,7	83,7	103,7	122,7
Clamping set	**1086314**	**1086325**	**1086336**	**1086347**	**1086358**	**1086369**	**1086380**	**1086391** ▲	**1086402** ▲	**1086419** ▲	**1086440** ▲	**1086460** ▲
Clamping sleeve	650023	650036	650049	650062	650075	650088	650100	650112 ▲	650125 ▲	315350 ▲	650165 ▲	650186 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599872	599882 ▲	599892 ▲	599908 ▲	599928 ▲	599947 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,7	21,7	26,7	31,7	36,7	41,7	48,7	58,7	68,7	84,7	104,7	123,7
Clamping set	**1086315**	**1086326**	**1086337**	**1086348**	**1086359**	**1086370**	**1086381**	**1086392** ▲	**1086403** ▲	**1086420** ▲	**1086441** ▲	**1086461** ▲
Clamping sleeve	315352	315353	315354	315355	315356	315357	315358	315359 ▲	315360 ▲	650144 ▲	315362 ▲	315304 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599873	599883 ▲	599893 ▲	599909 ▲	599929 ▲	599948 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,2	22,2	27,2	32,2	37,2	42,2	49,7	59,7	69,7	85,7	105,7	124,7
Clamping set	**1086316**	**1086327**	**1086338**	**1086349**	**1086360**	**1086371**	**1086382**	**1086393** ▲	**1086404** ▲	**1086421** ▲	**1086442** ▲	**1086462** ▲
Clamping sleeve	650025	650038	650051	650064	650077	650090	315369	315370 ▲	315371 ▲	315361 ▲	650167 ▲	650188 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599874	599884 ▲	599894 ▲	599910 ▲	599930 ▲	599949 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,7	22,7	27,7	32,7	37,7	42,7	50,7	60,7	70,7	86,7	106,7	125,7
Clamping set	**1086317**	**1086328**	**1086339**	**1086350**	**1086361**	**1086372**	**1086383**	**1086394** ▲	**1086405** ▲	**1086422** ▲	**1086443** ▲	**1086463** ▲
Clamping sleeve	315363	315364	315365	315366	315367	315368	315380	315381 ▲	315382 ▲	650146 ▲	315373 ▲	315403 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599875	599885 ▲	599895 ▲	599911 ▲	599931 ▲	599950 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,2	23,2	28,2	33,2	38,2	43,2	51,7	61,7	71,7	87,7	107,7	126,7
Clamping set	**1086318**	**1086329**	**1086340**	**1086351**	**1086362**	**1086373**	**1086384**	**1086395** ▲	**1086406** ▲	**1086423** ▲	**1086444** ▲	**1086464** ▲
Clamping sleeve	650027	650040	650053	650066	650079	650092	650104	650116 ▲	650129 ▲	315372 ▲	650169 ▲	650190 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599876	599886 ▲	599896 ▲	599912 ▲	599932 ▲	599951 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,7	23,7	28,7	33,7	38,7	43,7	52,7	62,7	72,7	88,7	108,7	127,7
Clamping set	**1086319**	**1086330**	**1086341**	**1086352**	**1086363**	**1086374**	**1086385**	**1086396** ▲	**1086407** ▲	**1086424** ▲	**1086445** ▲	**1086465** ▲
Clamping sleeve	315374	315375	315376	315377	315378	315379	315385	315386 ▲	315387 ▲	650148 ▲	315384 ▲	315404 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599877	599887 ▲	599897 ▲	599913 ▲	599933 ▲	599952 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	19,2	24,2	29,2	34,2	39,2	44,2	53,7	63,7	73,7	89,7	109,7	128,7
Clamping set	**1086320**	**1086331**	**1086342**	**1086353**	**1086364**	**1086375**	**1086386**	**1086397** ▲	**1086408** ▲	**1086425** ▲	**1086446** ▲	**1086466** ▲
Clamping sleeve	650029	650042	650055	650068	650081	650094	650106	650118 ▲	650131	315383 ▲	650171 ▲	650192 ▲

▲ on request

Accessories KFS / MFS

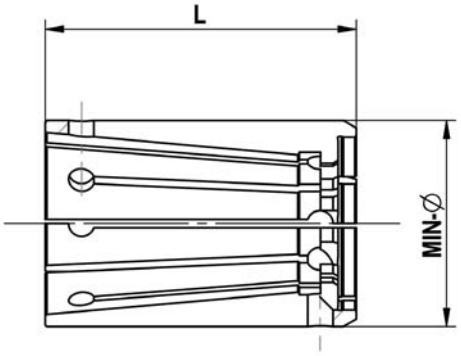
C18

Clamping set KFS/MFS (not vulcanized); consisting of clamping sleeve and clamping screw

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599878	599888 ▲	599898 ▲	599914 ▲	599934 ▲	599953 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	74,7	90,7	110,7	129,7
Clamping set	**1086321**	**1086332**	**1086343**	**1086354**	**1086365**	**1086376**	**1086387**	**1086398** ▲	**1086409** ▲	**1086426** ▲	**1086447** ▲	**1086467** ▲
Clamping sleeve	650030	650043	650056	650069	650082	650095	650107	650119 ▲	315390 ▲	650150 ▲	315389 ▲	315405 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599879	599889 ▲	599899 ▲	599915 ▲	599935 ▲	599954 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									75,7	91,7	111,7	130,7
Clamping set									**1086410** ▲	**1086427** ▲	**1086448** ▲	**1086468** ▲
Clamping sleeve									650133 ▲	315388 ▲	650173 ▲	650194 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599900 ▲	599916 ▲	599936 ▲	599955 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									76,7	92,7	112,7	131,7
Clamping set									**1086411** ▲	**1086428** ▲	**1086449** ▲	**1086469** ▲
Clamping sleeve									315393 ▲	650152 ▲	315392 ▲	315406 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599901 ▲	599917 ▲	599937 ▲	599956 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									77,7	93,7	113,7	132,7
Clamping set									**1086412** ▲	**1086429** ▲	**1086450** ▲	**1086470** ▲
Clamping sleeve									650135 ▲	315391 ▲	650175 ▲	650196 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599902 ▲	599918 ▲	599938 ▲	599957 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									78,7	94,7	114,7	133,7
Clamping set									**1086413** ▲	**1086430** ▲	**1086451** ▲	**1086471** ▲
Clamping sleeve									315396 ▲	650154 ▲	315395 ▲	315407 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599903 ▲	599919 ▲	599939 ▲	599958 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									79,7	95,7	115,7	134,7
Clamping set									**1086414** ▲	**1086431** ▲	**1086452** ▲	**1086472** ▲
Clamping sleeve									650137 ▲	315394 ▲	650177 ▲	650198 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599904 ▲	599920 ▲	599940 ▲	599959 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									80,7	96,7	116,7	135,7
Clamping set									**1086415** ▲	**1086432** ▲	**1086453** ▲	**1086473** ▲
Clamping sleeve									315399 ▲	650156 ▲	315398 ▲	315408 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599905 ▲	599921 ▲	599941 ▲	599960 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									81,7	97,7	117,7	136,7
Clamping set									**1086416** ▲	**1086433** ▲	**1086454** ▲	**1086474** ▲
Clamping sleeve									650139 ▲	315397 ▲	650179 ▲	650200 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599906 ▲	599922 ▲	599942 ▲	599961 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm										98,7	118,7	137,7
Clamping set										**1086434** ▲	**1086455** ▲	**1086475** ▲
Clamping sleeve										650158 ▲	315401 ▲	315409 ▲
Locking bolt										315478 ▲	315479 ▲	599998 ▲
Work stop										599923 ▲	599943 ▲	599962 ▲
Montage mandrel clamping										724185 ▲	724186 ▲	724187 ▲
Min-Ø mm										99,7	119,7	138,7
Clamping set										**1086435** ▲	**1086456** ▲	**1086476** ▲
Clamping sleeve										315400 ▲	650181 ▲	650202 ▲
Locking bolt										315478 ▲	315479 ▲	599998 ▲
Work stop										599924 ▲	599944 ▲	599963 ▲
Montage mandrel clamping										724185 ▲	724186 ▲	724187 ▲
Min-Ø mm												139,7
Clamping set												**1086477** ▲
Clamping sleeve												315410 ▲
Locking bolt												599998 ▲
Work stop												599964 ▲
Montage mandrel clamping												724187 ▲

Accessories KFS / MFS





C18

Clamping set KFS/MFS vulcanized, consisting of clamping sleeve and clamping screw

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Min-Ø mm	14,7	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	100,7	100,7	119,7
Clamping set	**1086511**	**1086522**	**1086533**	**1086544**	**1086555**	**1086566**	**1086577**	**1086588** ▲	**1086599** ▲	**1086636** ▲	**1086637** ▲	**1086657** ▲
Clamping sleeve vulcanized	315730	315731	315732	315733	315734	315735	315736	315737 ▲	315738 ▲	651100 ▲	315740 ▲	315702 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599840	599845	599850	599855	599860	599865	599992	599993 ▲	599994 ▲	599925 ▲	599996 ▲	599997 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	15,2	20,2	25,2	30,2	35,2	40,2	45,7	55,7	65,7	81,7	101,7	120,7
Clamping set	**1086512**	**1086523**	**1086534**	**1086545**	**1086556**	**1086567**	**1086578**	**1086589** ▲	**1086600** ▲	**1086617** ▲	**1086638** ▲	**1086658** ▲
Clamping sleeve vulcanized	650211	650224	650239	650250	650263	650276	650288	651051 ▲	651063 ▲	315739 ▲	651103 ▲	651124 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599870	599880 ▲	599890 ▲	599995 ▲	599926 ▲	599945 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	15,7	20,7	25,7	30,7	35,7	40,7	46,7	56,7	66,7	82,7	102,7	121,7
Clamping set	**1086513**	**1086524**	**1086535**	**1086546**	**1086557**	**1086568**	**1086579**	**1086590** ▲	**1086601** ▲	**1086618** ▲	**1086639** ▲	**1086659** ▲
Clamping sleeve vulcanized	315741	315742	315743	315744	315745	315746	315747	315748 ▲	315749 ▲	651082 ▲	315751 ▲	315703 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599871	599881 ▲	599891 ▲	599907 ▲	599927 ▲	599946 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,2	21,2	26,2	31,2	36,2	41,2	47,7	57,7	67,7	83,7	103,7	122,7
Clamping set	**1086514**	**1086525**	**1086536**	**1086547**	**1086558**	**1086569**	**1086580**	**1086591** ▲	**1086602** ▲	**1086619** ▲	**1086640** ▲	**1086660** ▲
Clamping sleeve vulcanized	650213	650226	650239	650252	650265	650278	650290	651053 ▲	651065 ▲	315750 ▲	651105 ▲	651126 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599872	599882 ▲	599892 ▲	599908 ▲	599928 ▲	599947 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,7	21,7	26,7	31,7	36,7	41,7	48,7	58,7	68,7	84,7	104,7	123,7
Clamping set	**1086515**	**1086526**	**1086537**	**1086548**	**1086559**	**1086570**	**1086581**	**1086592** ▲	**1086603** ▲	**1086620** ▲	**1086641** ▲	**1086661** ▲
Clamping sleeve vulcanized	315752	315753	315754	315755	315756	315757	315758	315759 ▲	315760 ▲	651084 ▲	315762 ▲	315704 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599873	599883 ▲	599893 ▲	599909 ▲	599929 ▲	599948 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,2	22,2	27,2	32,2	37,2	42,2	49,7	59,7	69,7	85,7	105,7	124,7
Clamping set	**1086516**	**1086527**	**1086538**	**1086549**	**1086560**	**1086571**	**1086582**	**1086593** ▲	**1086604** ▲	**1086621** ▲	**1086642** ▲	**1086662** ▲
Clamping sleeve vulcanized	650215	650228	650241	650254	650267	650280	315769	315770 ▲	315771 ▲	315761 ▲	651107 ▲	651128 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599874	599884 ▲	599894 ▲	599910 ▲	599930 ▲	599949 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,7	22,7	27,7	32,7	37,7	42,7	50,7	60,7	70,7	86,7	106,7	125,7
Clamping set	**1086517**	**1086528**	**1086539**	**1086550**	**1086561**	**1086572**	**1086583**	**1086594** ▲	**1086605** ▲	**1086622** ▲	**1086643** ▲	**1086663** ▲
Clamping sleeve vulcanized	315763	315764	315765	315766	315767	315768	315780	315781 ▲	315782 ▲	651086 ▲	315773 ▲	315705 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599875	599885 ▲	599895 ▲	599911 ▲	599931 ▲	599950 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,2	23,2	28,2	33,2	38,2	43,2	51,7	61,7	71,7	87,7	107,7	126,7
Clamping set	**1086518**	**1086529**	**1086540**	**1086551**	**1086562**	**1086573**	**1086584**	**1086595** ▲	**1086606** ▲	**1086623** ▲	**1086644** ▲	**1086664** ▲
Clamping sleeve vulcanized	650217	650230	650243	650256	650269	650282	650294	651057 ▲	651069 ▲	315772 ▲	651109 ▲	651130 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599876	599886 ▲	599896 ▲	599912 ▲	599932 ▲	599951 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,7	23,7	28,7	33,7	38,7	43,7	52,7	62,7	72,7	88,7	108,7	127,7
Clamping set	**1086519**	**1086530**	**1086541**	**1086552**	**1086563**	**1086574**	**1086585**	**1086596** ▲	**1086607** ▲	**1086624** ▲	**1086645** ▲	**1086665** ▲
Clamping sleeve vulcanized	315774	315775	315776	315777	315778	315779	315785	315786 ▲	315787 ▲	651088 ▲	315784 ▲	315706 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599877	599887 ▲	599897 ▲	599913 ▲	599933 ▲	599952 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	19,2	24,2	29,2	34,2	39,2	44,2	53,7	63,7	73,7	89,7	109,7	128,7
Clamping set	**1086520**	**1086531**	**1086542**	**1086553**	**1086564**	**1086575**	**1086586**	**1086597** ▲	**1086608** ▲	**1086625** ▲	**1086646** ▲	**1086666** ▲

▲ on request

Accessories KFS / MFS

C18

Clamping set KFS/MFS vulcanized, consisting of clamping sleeve and clamping screw

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Clamping sleeve vulcanized	650219	650232	650245	650258	650271	650284	650296	651059 ▲	651071 ▲	315783 ▲	651111 ▲	651132 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599878	599888 ▲	599898 ▲	599914 ▲	599934 ▲	599953 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	74,7	90,7	110,7	129,7
Clamping set	**1086521**	**1086532**	**1086543**	**1086554**	**1086565**	**1086576**	**1086587**	**1086598 ▲**	**1086609 ▲**	**1086626**	**1086647 ▲**	**1086667 ▲**
Clamping sleeve vulcanized	650220	650233	650246	650259	650272	650285	650297	651060 ▲	315790 ▲	651090	315789 ▲	315707 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599879	599889 ▲	599899 ▲	599915 ▲	599935 ▲	599954 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									75,7	91,7	111,7	130,7
Clamping set									**1086610 ▲**	**1086627**	**1086648 ▲**	**1086668 ▲**
Clamping sleeve vulcanized									651073 ▲	315788	651113 ▲	651134 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599900 ▲	599916 ▲	599936 ▲	599955 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									76,7	92,7	112,7	131,7
Clamping set									**1086611 ▲**	**1086628**	**1086649 ▲**	**1086669 ▲**
Clamping sleeve vulcanized									651074 ▲	651092	651114 ▲	651135 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599901 ▲	599917 ▲	599937 ▲	599956 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									77,7	93,7	113,7	132,7
Clamping set									**1086612 ▲**	**1086629**	**1086650 ▲**	**1086670 ▲**
Clamping sleeve vulcanized									651075 ▲	651093	651115 ▲	651136 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599902 ▲	599918 ▲	599938 ▲	599957 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									78,7	94,7	114,7	133,7
Clamping set									**1086613 ▲**	**1086630**	**1086651 ▲**	**1086671 ▲**
Clamping sleeve vulcanized									315796 ▲	651094	315795 ▲	315709 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599903 ▲	599919 ▲	599939 ▲	599958 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									79,7	95,7	115,7	134,7
Clamping set									**1086614 ▲**	**1086631**	**1086652 ▲**	**1086672 ▲**
Clamping sleeve vulcanized									651077 ▲	315794	651117 ▲	651138 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599904 ▲	599920 ▲	599940 ▲	599959 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									80,7	96,7	116,7	135,7
Clamping set									**1086615 ▲**	**1086632**	**1086653 ▲**	**1086673 ▲**
Clamping sleeve vulcanized									315799 ▲	651096	315798 ▲	315710 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599905 ▲	599921 ▲	599941 ▲	599960 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									81,7	97,7	117,7	136,7
Clamping set									**1086616 ▲**	**1086633**	**1086654 ▲**	**1086674 ▲**
Clamping sleeve vulcanized									651079 ▲	315797	651119 ▲	651140 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599906 ▲	599922 ▲	599942 ▲	599961 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm										98,7	118,7	137,7
Clamping set										**1086634**	**1086655 ▲**	**1086675 ▲**
Clamping sleeve vulcanized										651098	315801 ▲	315711 ▲
Locking bolt										315478 ▲	315479 ▲	599998 ▲
Work stop										599923 ▲	599943 ▲	599962 ▲
Montage mandrel clamping										724185 ▲	724186 ▲	724187 ▲
Min-Ø mm										99,7	119,7	138,7
Clamping set										**1086635**	**1086656 ▲**	**1086676 ▲**
Clamping sleeve vulcanized										315800	651121 ▲	651142 ▲
Locking bolt										315478 ▲	315479 ▲	599998 ▲
Work stop										599924 ▲	599944 ▲	599963 ▲
Montage mandrel clamping										724185 ▲	724186 ▲	724187 ▲
Min-Ø mm												139,7
Clamping set												**1086677 ▲**
Clamping sleeve vulcanized												315712 ▲
Locking bolt												599998 ▲
Work stop												599964 ▲
Montage mandrel clamping												724187 ▲

Intermadiate flange KFS / MFS



APPLICATION

For adaption of cartridge mandrel KFR/MFR/KFR-SE/MFR-SE or KFS/MFS - on spindle head ISO 702-1 / ISO 702-3 (DIN 55021/55022/55026 and 55027).

TYPE

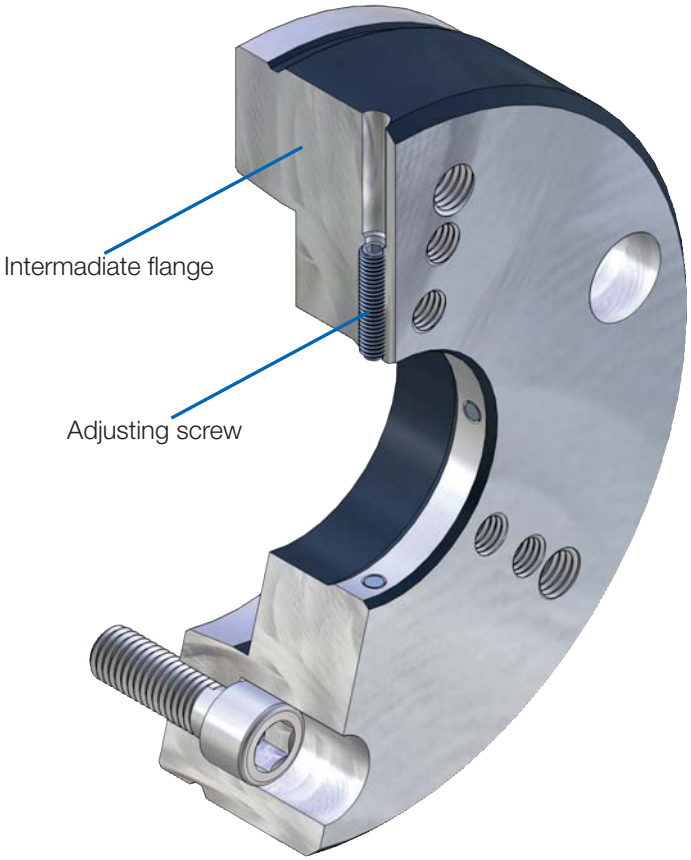
For KFR/MFR/KFR-SE/MFR-SE or KFS/MFS.

CUSTOMER BENEFITS

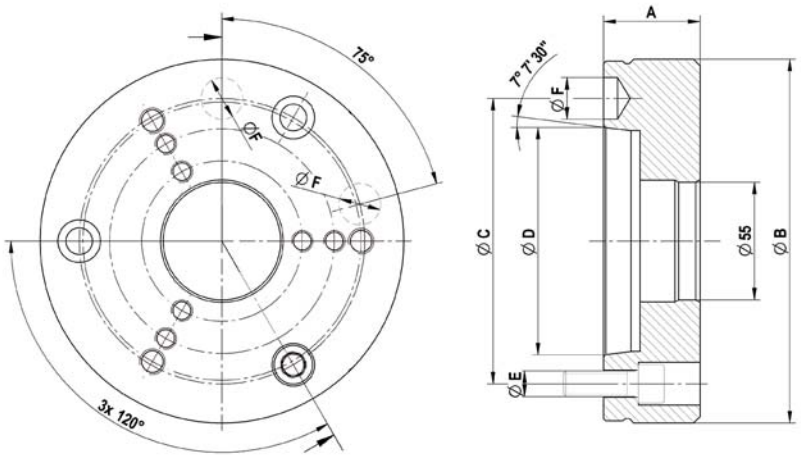
- By replacement of the intermadiate flange, one cartridge mandrel can be used on different machines

TECHNICAL FEATURES

Adaptation of KFR/MFR/KFR-SE/MFR-SE cartridge mandrel or KFS/MFS on spindle head, with or without adjusting screw, with or without performing air sensing. Version acc. to ISO 702-1 (DIN 55028-A) or ISO 702-3 (DIN 55028-C), in size no. 5, no. 6, no. 8, no. 11 or no. 5, no. 6. no. 8 (A5, A6, A8, A11 or C5, C6, C8).



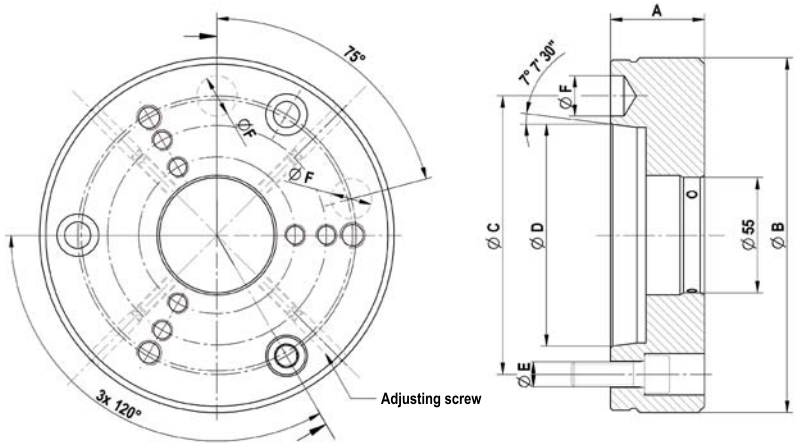
Accessories KFS / MFS



C 18

Intermediate flange ISO 702-1 (DIN 55026/55021) **without adjusting screws**

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	**893975**	**893976**	**893977**	**893978 ▲**
Design	without air-sensing	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50	50
Ø B	165	170	220	282
Ø C mm	104,8	133,4	171,4	235
Ø D mm	82,563	106,375	139,719	196,869
Ø E	M10	M12	M16	M20
Ø F mm	16,3	19,45	24,2	29,4

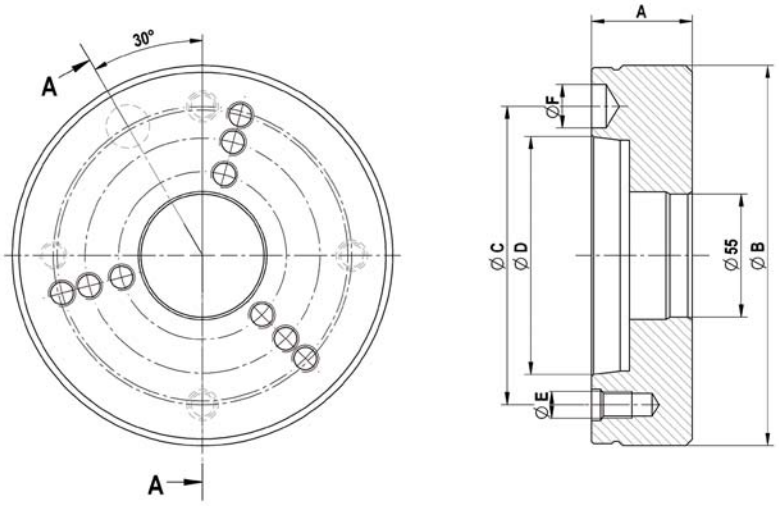


C 18

Intermediate flange ISO 702-1 (DIN 55026/55021) **with adjusting screw**

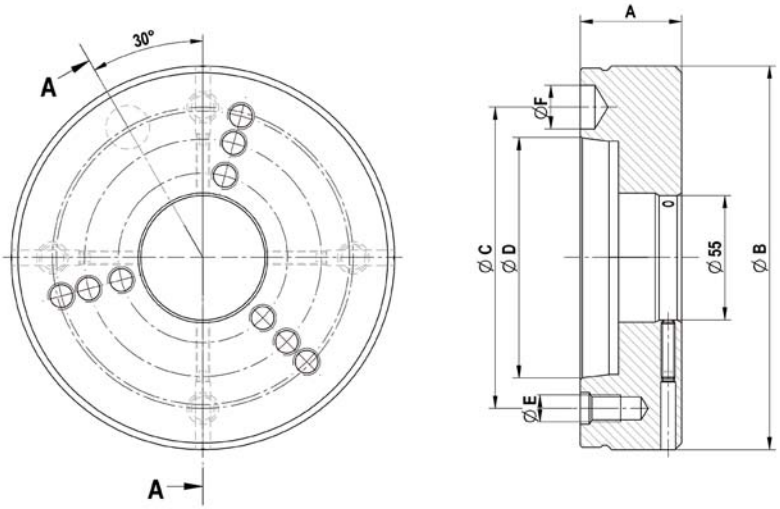
	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)
Intermediate flange	**893979**	**893980**	**893981**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M10	M12	M16
Ø F mm	16,3	19,45	24,2

Accessories KFS / MFS



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) **without adjusting screws**

	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	**893982**	**893983**	**893984**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2

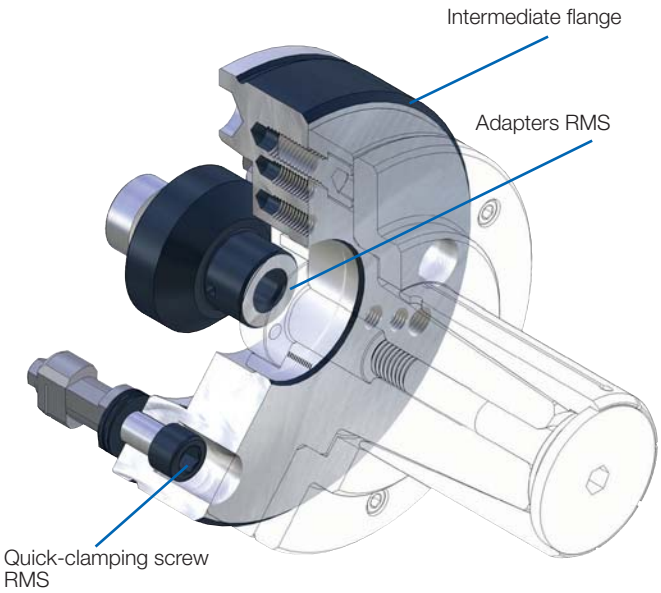


C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) **with adjusting screws**

	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	**893985**	**893986**	**893987**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2

▲ on request

Accessories KFS / MFS



APPLICATION

For manual clamping devices exchange in a minimum of time.

TYPE

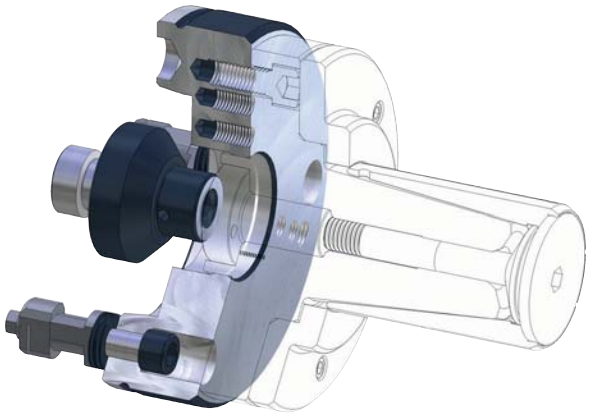
Manual quick-change system for clamping devices. Fits KFR/MFR or KFS/MFS. Central lubrication and / or air sensing control possible.

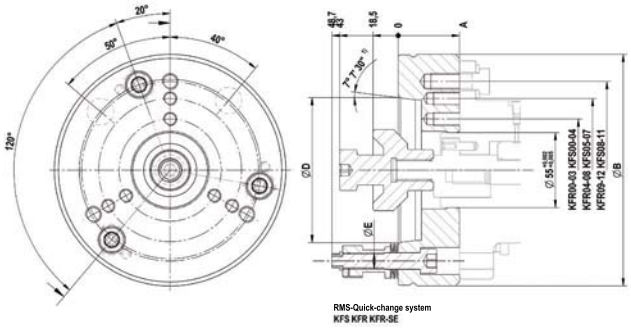
CUSTOMER BENEFITS

- Manual clamping devices change in about 30 seconds
- High repeatability within 0.005 mm
- Quick change of different clamping devices with short time, similar to the automatic or semiautomatic clamping devices changing systems

TECHNICAL FEATURES

- Quick-change system suitable due to recording RMS see quick-change system RMS (Product Group 6)
- Used in conjunction with RÖHM safety clamping cylinder OVS and LVS to the guidelines of the Professional Association





C18

RMS quick-change system

	KK 06	KK 08
RMS - complete (flange incl, Quick-clamping screw)	**1160026 ▲**	**1160027 ▲**
Adapters RMS	**1183310 ▲**	**1183311 ▲**
A	45	50
Ø B	170	220
Ø C	133,4	171,4
Ø D	106,375	139,719
Ø E mm	M12	M16
Ø F mm	55 (+0,003/+0,001)	55 (+0,003/+0,001)

KFR - without axial tightening



APPLICATION

Internal clamping of round workpieces. Turning, grinding and toothing operations, as well as for balancing and measuring.
Ideal for short clamping lengths / workpieces.

TYPE

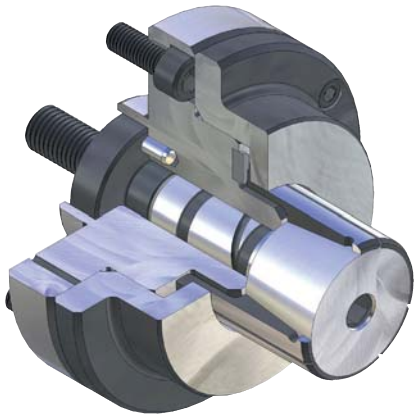
Force-actuated. Clamping sleeves optionally vulcanized.
Convertible to MFR (new intermediate piece required).

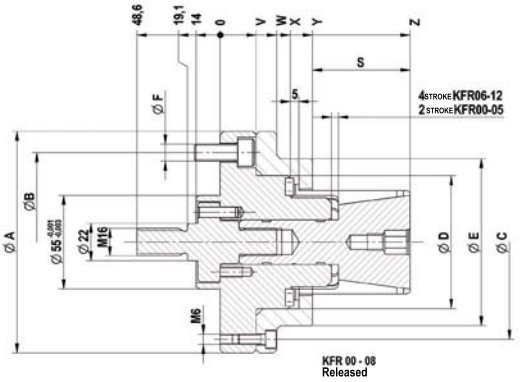
CUSTOMER BENEFITS

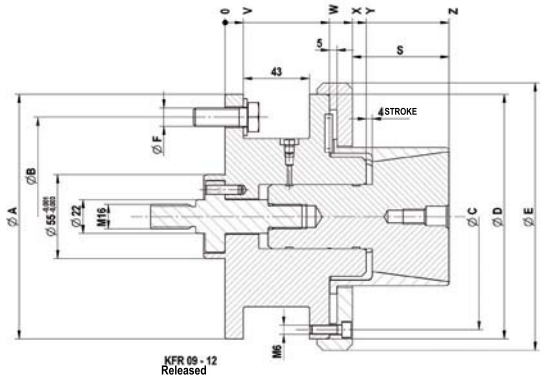
- No workpiece tension thanks to def. axial tension against the workpiece stop
- High concentricity, axial run-out and repeatability
- Low-maintenance

TECHNICAL FEATURES

- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared







C18

KFR cartridge mandrel, power-operated with flanged seat; consisting of basic body, clamping taper, intermediate piece, nut

	KFR 00	KFR 01	KFR 02	KFR 03	KFR 04	KFR 05	KFR 06	KFR 07	KFR 08	KFR 09	KFR 10	KFR 11	KFR 12
Cartridge Mandrel	**893960**	**893961**	**893962**	**893963**	**893964**	**893965**	**893966** ▲	**893967** ▲	**893968** ▲	**893969** ▲	**893970** ▲	**893971** ▲	**893972** ▲
Base bolt	**893800**	**893801**	**893802**	**893803**	**893804**	**893805**	**893806** ▲	**893807** ▲	**893807** ▲	**893809** ▲	**893809** ▲	**893809** ▲	**893809** ▲
Clamping taper	**650340**	**650341**	**650342**	**650343**	**650344**	**650345**	**650346** ▲	**650347** ▲	**650348** ▲	**650349** ▲	**650350** ▲	**650351** ▲	**650352** ▲
Adapter power operated	**893816**	**893817**	**893818**	**893819**	**893820**	**893820**	**893821** ▲	**893822** ▲	**893822** ▲	**893822** ▲	**893822** ▲	**893822** ▲	**893822** ▲
Nut	**893814**	**893814**	**893814**										
F max, in kN	4,65	13,1	19,5	24,4	26,8	33	33	33	33	33	33	33	33
Max, total clamping force							140	140	140	140	140	140	140
Min-Ø unclamped from	14,2	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	90,7	100,7	110,7	120,7
Min-Ø unclamped to	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	90,7	100,7	110,7	120,7	130,7
Clamping-Ø max,	20,2	25,7	35,72	40,7	61,2	61,2	71,7	81,7	91,7	101,7	111,7	121,7	131,7
External-Ø A	100	100	100	100	130	130	130	160	160	160	160	160	160
Pitch diameter B	75	75	75	75	105	105	105	130	130	130	130	130	130
Pitch diameter C	85	85	85	85	114	114	114	145	145	148	148	148	148
Ø C mm							98	130	130	175	175	175	175
Ø D mm	50	50	50	50	78	78	78	100	100	160	160	160	160
Ø E mm	70	70	70	70	98	98	98	130	130	175	175	175	175
Ø F mm	M10	M10	M10	M10	M10	M10	M10	M12	M12	M12	M12	M12	M12
S mm	21	27	27	27	42	42	57	55	55	63	63	63	63
V mm	21	21	21	21	21	21	21	32	32	12	12	12	12
W mm	33	33	33	33	33	33	33	50	50	68	68	68	68
X mm	39	39	39	39	41	41	41	58	58	83	83	83	83
Y mm	50	52	52	52	54	54	54	73	73	92	92	92	92
Z mm	71	79	79	79	96	96	111	128	128	146	146	146	146

Max. clamping force kN: 1,9-5,5-8,3-10,4-11,4-14,0-14,0-14,0-14,0-14,0-14,0-14,0

▲ on request

KFR - with axial tightening



APPLICATION

Internal clamping of round workpieces. Turning, grinding and toothing operations, as well as for balancing and measuring.
Ideal for short clamping lengths / workpieces.

TYPE

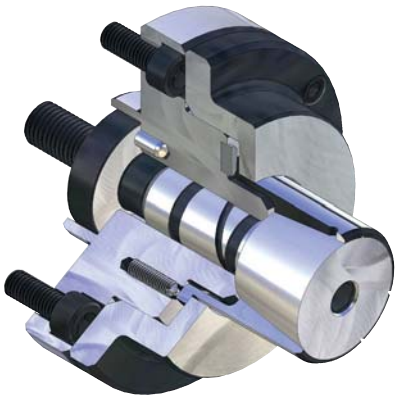
Force-actuated. Sleeve optional vulcanized.
Convertible to MFR (new intermediate piece required).

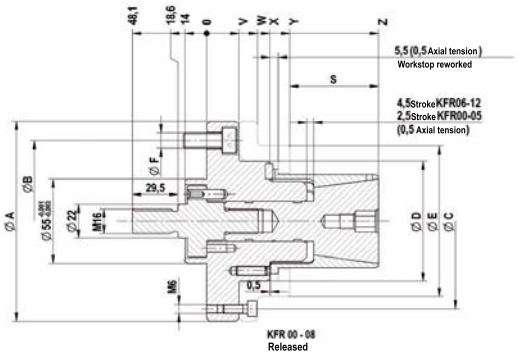
CUSTOMER BENEFITS

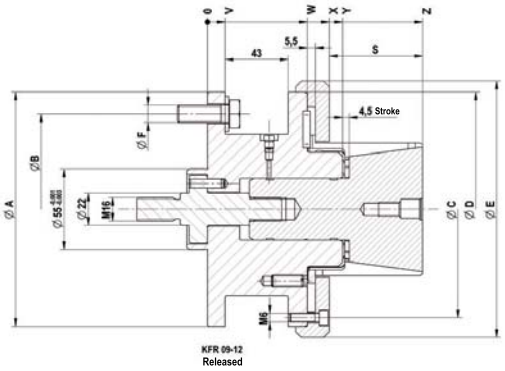
- No workpiece tension thanks to def. axial tension against the workpiece stop
- High concentricity, axial run-out and repeatability
- Low-maintenance

TECHNICAL FEATURES

- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared







C18
KFR cartridge mandrel, power-operated with flanged seat; consisting of basic body, clamping taper, intermediate piece, nut

	KFR 00	KFR 01	KFR 02	KFR 03	KFR 04	KFR 05	KFR 06	KFR 07	KFR 08	KFR 09	KFR 10	KFR 11	KFR 12
Cartridge Mandrel	**1077600**	**1077601**	**1077602**	**1077603**	**1077604**	**1077605**	**1077606 ▲**	**1077607 ▲**	**1077608 ▲**	**1077609 ▲**	**1077610 ▲**	**1077611 ▲**	**1077612 ▲**
Base bolt	**1077620**	**1077621**	**1077622**	**1077623**	**1077624**	**1077625**	**1077626 ▲**	**1077627 ▲**	**1077627 ▲**	**1077628 ▲**	**1077628 ▲**	**1077628 ▲**	**1077628 ▲**
Clamping taper	**650340**	**650341**	**650342**	**650343**	**650344**	**650345**	**650346 ▲**	**650347 ▲**	**650348 ▲**	**650349 ▲**	**650350 ▲**	**650351 ▲**	**650352 ▲**
Adapter power operated	**1061892**	**1061919**	**1077615**	**1061921**	**1050020**	**1050020**	**1050021 ▲**	**1077619 ▲**	**1077619 ▲**	**1077619 ▲**	**1077619 ▲**	**1077619 ▲**	**1077619 ▲**
Nut	**893814**	**893814**	**893814**										
F max, in kN	4,65	13,1	19,5	24,4	26,8	33	33	33	33	33	33	33	33
Max, total clamping force approx, kN	20	56	83	104	114	140	140	140	140	140	140	140	140
Min-Ø unclamped from	14,2	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	90,7	100,7	110,7	120,7
Min-Ø unclamped to	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	90,7	100,7	110,7	120,7	130,7
Clamping-Ø max,	20,2	25,7	35,7	40,7	50,7	61,3	71,7	81,7	91,7	101,7	111,7	121,7	131,7
External-Ø A	100	100	100	100	130	130	130	160	160	160	160	160	160
Pitch diameter B	75	75	75	75	105	105	105	130	130	130	130	130	130
Pitch diameter C	85	85	85	85	114	114	114	145	145	148	148	148	148
Ø D mm	50	50	50	50	78	78	78	100	100	160	160	160	160
Ø E mm	70	70	70	70	98	98	98	130	130	175	175	175	175
Ø F mm	M10	M10	M10	M10	M10	M10	M10	M12	M12	M12	M12	M12	M12
S mm	21,5	27,5	27,5	27,5	42,5	42,5	57,5	55,5	55,5	63,5	63,5	63,5	63,5
V mm	21	21	21	21	21	21	21	32	32	12	12	12	12
W mm	33	33	33	33	33	33	33	50	50	68	68	68	68
X mm	39	39	39	39	41	41	41	58	58	92	92	92	92
Y mm	50	52	52	52	54	54	54	73	73	83	83	83	83
Z mm	71,5	79,5	79,5	79,5	96,5	96,5	111,5	128,5	128,5	146,5	146,5	146,5	146,5

Max. clamping force: 1,9-5,5-8,3-10,4-11,4-14,0-14,0-14,0-14,0-14,0-14,0-14,0-14,0

▲ on request

MFR - without axial tightening



APPLICATION

Internal clamping of round workpieces. Turning, grinding and toothing operations, as well as for balancing and measuring.
Ideal for short clamping lengths / workpieces.

TYPE

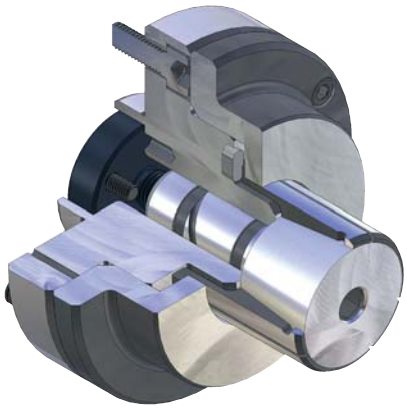
Manually actuated.
Optional vulcanized clamping sleeves/segment sleeves (segment clamping mandrel KFR-SE).

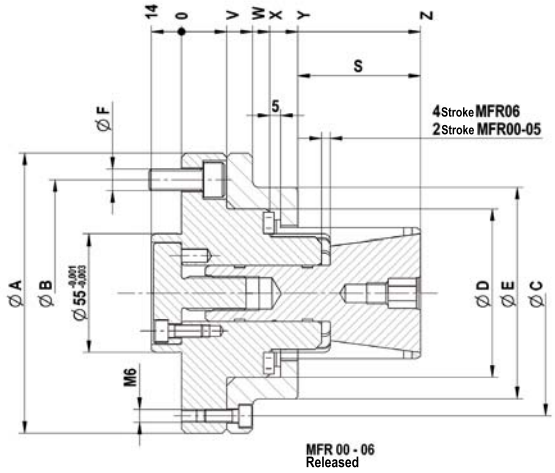
CUSTOMER BENEFITS

- No workpiece tension thanks to def. axial tension against the workpiece stop
- High concentricity, axial run-out and repeatability
- Low-maintenance

TECHNICAL FEATURES

- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared





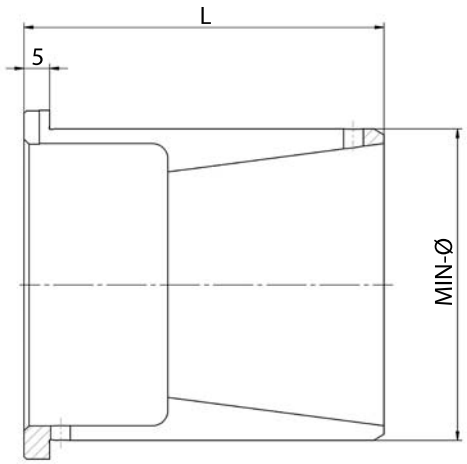
C18
MFR cartridge mandrel
consisting of basic body, clamping taper, intermediate piece

	MFR 00	MFR 01	MFR 02	MFR 03	MFR 04	MFR 05	MFR 06
Cartridge Mandrel	**1077700**	**1077701**	**1077702**	**1077703**	**1077704**	**1077705**	**1077706 ▲**
Base bolt	**893800**	**893801**	**893802**	**893803**	**893804**	**893805**	**893806 ▲**
Clamping taper	**650340**	**650341**	**650342**	**650343**	**650344**	**650345**	**650346 ▲**
Adapter hand-operated	**893823**	**893824**	**893825**	**893826**	**893827**	**893827**	**893828 ▲**
Md max, kN	4	5	40	55	60	75	85
Min-Ø unclamped from	14,2	19,7	25,2	35,2	40,2	50,2	60,7
Min-Ø unclamped to	19,7	25,2	35,2	40,2	50,2	60,7	70,7
Clamping-Ø max,	20,2	25,7	35,7	40,7	50,7	61,2	71,7
External-Ø A	100	100	100	100	130	130	130
Pitch diameter B	75	75	75	75	105	105	105
Pitch diameter C	85	85	85	85	114	114	114
Ø D mm	50	50	50	50	78	78	78
Ø E mm	70	70	70	70	98	98	98
Ø F mm	M10	M10	M10	M10	M10	M10	M10
S mm	21	27	27	27	42	42	57
V mm	21	21	21	21	21	21	21
W mm	33	33	33	33	33	33	33
X mm	39	39	39	39	41	41	41
Y mm	50	52	52	52	54	54	54
Z mm	71	79	79	79	96	96	111

▲ on request

Accessories KFR / MFR





C 18
Clamping sleeve Type R - standard design
(not vulcanized)

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length L	32	40	40	40	55	55	70	70	70	78	78	78	78
Min-Ø mm	14,2	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	100,7	100,7	110,7	120,7
Clamping sleeve	**1015500**	**1015513**	**1015526**	**1015548**	**1015560**	**1015582**	**1015605** ▲	**1015617** ▲	**1015629** ▲	**1015651** ▲	**1015653** ▲	**1015665** ▲	**1015677** ▲
Work stop	893830	893836	893842	893852	893857	893867	893878	893888	893897	893916	893917	893927	893937
Min-Ø mm	14,7	20,2	25,7	35,7	40,7	50,7	61,7	71,7	81,7	90,7	101,7	111,7	121,7
Clamping sleeve	**1015501**	**1015514**	**1015527**	**1015549**	**1015561**	**1015583**	**1015606** ▲	**1015618** ▲	**1015630**	**1015641** ▲	**1015654** ▲	**1015666** ▲	**1015678** ▲
Work stop	893830	893836	893842	893852	893857	893867	893879	893889	893898	893907	893918	893928	893938
Min-Ø mm	15,2	20,7	26,2	36,2	41,2	51,2	62,7	72,7	82,7	91,7	102,7	112,7	122,7
Clamping sleeve	**1015502**	**1015515**	**1015528**	**1015550**	**1015562**	**1015584**	**1015607** ▲	**1015619** ▲	**1015631** ▲	**1015642** ▲	**1015655** ▲	**1015667** ▲	**1015679** ▲
Work stop	893830	893837	893842	893852	893857	893867	893880	893890	893899	893908	893919	893929	893939
Min-Ø mm	15,7	21,2	26,7	36,7	41,7	51,7	63,7	73,7	83,7	92,7	103,7	113,7	123,7
Clamping sleeve	**1015503**	**1015516**	**1015529**	**1015551**	**1015563**	**1015585**	**1015608** ▲	**1015620** ▲	**1015632** ▲	**1015643** ▲	**1015656** ▲	**1015668** ▲	**1015680** ▲
Work stop	893831	893837	893843	893853	893858	893868	893881	893891	893900	893909	893920	893930	893940
Min-Ø mm	16,2	21,7	27,2	37,2	42,2	52,2	64,7	74,7	84,7	93,7	104,7	114,7	124,7
Clamping sleeve	**1015504**	**1015517**	**1015530**	**1015552**	**1015564**	**1015586**	**1015609** ▲	**1015621** ▲	**1015633** ▲	**1015644** ▲	**1015657** ▲	**1015669** ▲	**1015681** ▲
Work stop	893831	893838	893843	893853	893858	893868	893882	893892	893901	893910	893921	893931	893941
Min-Ø mm	16,7	22,2	27,7	37,7	42,7	52,7	65,7	75,7	85,7	94,7	105,7	115,7	125,7
Clamping sleeve	**1015505**	**1015518**	**1015531**	**1015553**	**1015565**	**1015587**	**1015610** ▲	**1015622** ▲	**1015634** ▲	**1015645** ▲	**1015658** ▲	**1015670** ▲	**1015682** ▲
Work stop	893832	893838	893844	893854	893859	893869	893883	893893	893902	893911	893922	893932	893942
Min-Ø mm	17,2	22,7	28,2	38,2	43,2	53,2	66,7	76,7	86,7	95,7	106,7	116,7	126,7
Clamping sleeve	**1015506**	**1015519**	**1015532**	**1015554**	**1015566**	**1015588**	**1015611** ▲	**1015623** ▲	**1015635** ▲	**1015646** ▲	**1015659** ▲	**1015671** ▲	**1015683** ▲
Work stop	893832	893839	893844	893854	893859	893869	893884	893894	893903	893912	893923	893933	893943
Min-Ø mm	17,7	23,2	28,7	38,7	43,7	53,7	67,7	77,7	87,7	96,7	107,7	117,7	127,7
Clamping sleeve	**1015507**	**1015520**	**1015533**	**1015555**	**1015567**	**1015589**	**1015612** ▲	**1015624** ▲	**1015636** ▲	**1015647** ▲	**1015660** ▲	**1015672** ▲	**1015684** ▲
Work stop	893833	893839	893845	893855	893860	893870	893885	893895	893904	893913	893924	893934	893944
Min-Ø mm	18,2	23,7	29,2	39,2	44,2	54,2	68,7	78,7	88,7	97,7	108,7	118,7	128,7
Clamping sleeve	**1015508**	**1015521**	**1015534**	**1015556**	**1015568**	**1015590**	**1015613** ▲	**1015625** ▲	**1015637** ▲	**1015648** ▲	**1015661** ▲	**1015673** ▲	**1015685** ▲
Work stop	893833	893840	893845	893855	893860	893870	893886	893947	893905	893914	893925	893935	893945
Min-Ø mm	18,7	24,2	29,7	39,7	44,7	54,7	69,7	79,7	89,7	98,7	109,7	119,7	129,7
Clamping sleeve	**1015509**	**1015522**	**1015535**	**1015557**	**1015569**	**1015591**	**1015614** ▲	**1015626** ▲	**1015638** ▲	**1015649** ▲	**1015662** ▲	**1015674** ▲	**1015686** ▲
Work stop	893834	893840	893846	893856	893861	893871	893887	893896	893906	893915	893926	893936	893946
Min-Ø mm	19,2	24,7	30,2	40,2	45,2	55,2	70,7	80,7	90,7	99,7	110,7	120,7	130,7
Clamping sleeve	**1015510**	**1015523**	**1015536**	**1015558**	**1015570**	**1015592**	**1015615** ▲	**1015627** ▲	**1015639** ▲	**1015650** ▲	**1015663** ▲	**1015675** ▲	**1015687** ▲
Work stop	893834	893841	893846	893856	893861	893871	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm	19,7	25,2	30,7		45,7	55,7							
Clamping sleeve	**1015511**	**1015524**	**1015537**		**1015571**	**1015593**							
Work stop	893835	893841	893847		893862	893872							
Min-Ø mm			31,2		46,2	56,2							

Different chucking Ø and profiled clamping sleeves on request

Accessories KFR / MFR

C 18
Clamping sleeve Type R - standard design
(not vulcanized)

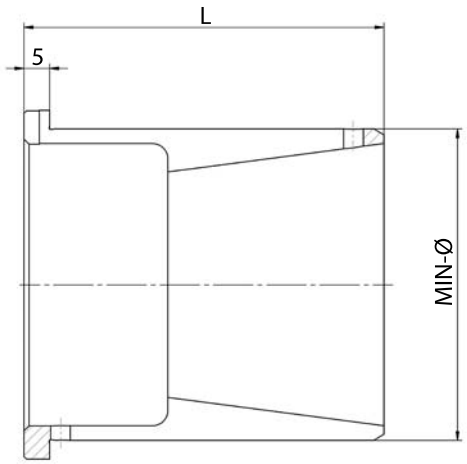
For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length L	32	40	40	40	55	55	70	70	70	78	78	78	78
Clamping sleeve			**1015538**		**1015572**	**1015594**							
Work stop			893847		893862	893872							
Min-Ø mm			31,7		46,7	56,7							
Clamping sleeve			**1015539**		**1015573**	**1015595**							
Work stop			893848		893863	893873							
Min-Ø mm			32,2		47,2	57,2							
Clamping sleeve			**1015540**		**1015574**	**1015596**							
Work stop			893848		893863	893873							
Min-Ø mm			32,7		47,7	57,7							
Clamping sleeve			**1015541**		**1015575**	**1015597**							
Work stop			893849		893864	893874							
Min-Ø mm			33,2		48,2	58,2							
Clamping sleeve			**1015542**		**1015576**	**1015598**							
Work stop			893849		893864	893874							
Min-Ø mm			33,7		48,7	58,7							
Clamping sleeve			**1015543**		**1015577**	**1015599**							
Work stop			893850		893865	893875							
Min-Ø mm			34,2		49,2	59,2							
Clamping sleeve			**1015544**		**1015578**	**1015600**							
Work stop			893850		893865	893875							
Min-Ø mm			34,7		49,7	59,7							
Clamping sleeve			**1015545**		**1015579**	**1015601**							
Work stop			893851		893866	893876							
Min-Ø mm			35,2		50,2	60,2							
Clamping sleeve			**1015546**		**1015580**	**1015602**							
Work stop			893851		893866	893876							
Min-Ø mm						60,7							
Clamping sleeve						**1015603**							
Work stop						893877							

Different chucking Ø and profiled clamping sleeves on request

▲ on request

Accessories KFR / MFR





C 18

Clamping sleeve Type R - vulcanized

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length L	32	40	40	40	55	55	70	70	70	78	78	78	78
Min-Ø mm	14,2	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	100,7	100,7	110,7	120,7
Clamping sleeve	**1015700**	**1015713**	**1015726**	**1015748**	**1015760**	**1015782**	**1015805** ▲	**1015817** ▲	**1015829** ▲	**1015851** ▲	**1015853** ▲	**1015865** ▲	**1015877** ▲
Work stop	893830	893836	893842	893852	893857	893867	893878	893888	893897	893916	893917	893927	893937
Min-Ø mm	14,7	20,2	25,7	35,7	40,7	50,7	61,7	71,7	81,7	90,7	101,7	111,7	121,7
Clamping sleeve	**1015701**	**1015714**	**1015727**	**1015749**	**1015761**	**1015783**	**1015806** ▲	**1015818** ▲	**1015830** ▲	**1015841** ▲	**1015854** ▲	**1015866** ▲	**1015878** ▲
Work stop	893830	893836	893842	893852	893857	893867	893879	893889	893898	893907	893918	893928	893938
Min-Ø mm	15,2	20,7	26,2	36,2	41,2	51,2	62,7	72,7	82,7	91,7	102,7	112,7	122,7
Clamping sleeve	**1015702**	**1015715**	**1015728**	**1015750**	**1015762**	**1015784**	**1015807** ▲	**1015819** ▲	**1015831** ▲	**1015842** ▲	**1015855** ▲	**1015867** ▲	**1015879** ▲
Work stop	893830	893837	893842	893852	893857	893867	893880	893890	893899	893908	893919	893929	893939
Min-Ø mm	15,7	21,2	26,7	36,7	41,7	51,7	63,7	73,7	83,7	92,7	103,7	113,7	123,7
Clamping sleeve	**1015703**	**1015716**	**1015729**	**1015751**	**1015763**	**1015785**	**1015808** ▲	**1015820** ▲	**1015832** ▲	**1015843** ▲	**1015856** ▲	**1015868** ▲	**1015880** ▲
Work stop	893831	893837	893843	893853	893858	893868	893881	893891	893900	893909	893920	893930	893940
Min-Ø mm	16,2	21,7	27,2	37,2	42,2	52,2	64,7	74,7	84,7	93,7	104,7	114,7	124,7
Clamping sleeve	**1015704**	**1015717**	**1015730**	**1015752**	**1015764**	**1015786**	**1015809** ▲	**1015821** ▲	**1015833** ▲	**1015844** ▲	**1015857** ▲	**1015869** ▲	**1015881** ▲
Work stop	893831	893837	893843	893853	893858	893868	893882	893892	893901	893910	893921	893931	893941
Min-Ø mm	16,7	22,2	27,7	37,7	42,7	52,7	65,7	75,7	85,7	94,7	105,7	115,7	125,7
Clamping sleeve	**1015705**	**1015718**	**1015731**	**1015753**	**1015765**	**1015787**	**1015810** ▲	**1015822** ▲	**1015834** ▲	**1015845** ▲	**1015858** ▲	**1015870** ▲	**1015882** ▲
Work stop	893832	893838	893844	893854	893859	893869	893883	893893	893902	893911	893922	893932	893942
Min-Ø mm	17,2	22,7	28,2	38,2	43,2	53,2	66,7	76,7	86,7	95,7	106,7	116,7	126,7
Clamping sleeve	**1015706**	**1015719**	**1015732**	**1015754**	**1015766**	**1015788**	**1015811** ▲	**1015823** ▲	**1015835** ▲	**1015846** ▲	**1015859** ▲	**1015871** ▲	**1015883** ▲
Work stop	893832	893838	893844	893854	893859	893869	893884	893894	893903	893912	893923	893933	893943
Min-Ø mm	17,7	23,2	28,7	38,7	43,7	53,7	67,7	77,7	87,7	96,7	107,7	117,7	127,7
Clamping sleeve	**1015707**	**1015720**	**1015733**	**1015755**	**1015767**	**1015789**	**1015812** ▲	**1015824** ▲	**1015836** ▲	**1015847** ▲	**1015860** ▲	**1015872** ▲	**1015884** ▲
Work stop	893833	893839	893845	893855	893860	893870	893885	893895	893904	893913	893924	893934	893944
Min-Ø mm	18,2	23,7	29,2	39,2	44,2	54,2	68,7	78,7	88,7	97,7	108,7	118,7	128,7
Clamping sleeve	**1015708**	**1015721**	**1015734**	**1015756**	**1015768**	**1015790**	**1015813** ▲	**1015825** ▲	**1015837** ▲	**1015848** ▲	**1015861** ▲	**1015873** ▲	**1015885** ▲
Work stop	893833	893839	893845	893855	893860	893870	893886	893947	893905	893914	893925	893935	893945
Min-Ø mm	18,7	24,2	29,7	39,7	44,7	54,7	69,7	79,7	89,7	98,7	109,7	119,7	129,7
Clamping sleeve	**1015709**	**1015722**	**1015735**	**1015757**	**1015769**	**1015791**	**1015814** ▲	**1015826** ▲	**1015838** ▲	**1015849** ▲	**1015862** ▲	**1015874** ▲	**1015886** ▲
Work stop	893834	893840	893846	893856	893861	893871	893887	893896	893906	893915	893926	893936	893946
Min-Ø mm	19,2	24,7	30,2	40,2	45,2	55,2	70,7	80,7	90,7	99,7	110,7	120,7	130,7
Clamping sleeve	**1015710**	**1015723**	**1015736**	**1015758**	**1015770**	**1015792**	**1015815** ▲	**1015827** ▲	**1015839** ▲	**1015850** ▲	**1015863** ▲	**1015875** ▲	**1015887** ▲
Work stop	893834	893840	893846	893856	893861	893871	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm	19,7	25,2	30,7		45,7	55,7							
Clamping sleeve	**1015711**	**1015724**	**1015737**		**1015771**	**1015793**							
Work stop	893835	893841	893847		893862	893872							
Min-Ø mm			31,2		46,2	56,2							
Clamping sleeve			**1015738**		**1015772**	**1015794**							
Work stop			893847		893862	893872							
Min-Ø mm			31,7		46,7	56,7							

Different chucking Ø and profiled clamping sleeves on request

Accessories KFR / MFR

C 18

Clamping sleeve Type R - vulcanized

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length L	32	40	40	40	55	55	70	70	70	78	78	78	78
Clamping sleeve			**1015739**		**1015773**	**1015795**							
Work stop			893848		893863	893873							
Min-Ø mm			32,2		47,2	57,2							
Clamping sleeve			**1015740**		**1015774**	**1015796**							
Work stop			893848		893863	893873							
Min-Ø mm			32,7		47,7	57,7							
Clamping sleeve			**1015741**		**1015775**	**1015797**							
Work stop			893849		893864	893874							
Min-Ø mm			33,2		48,2	58,2							
Clamping sleeve			**1015742**		**1015776**	**1015798**							
Work stop			893849		893864	893874							
Min-Ø mm			33,7		48,7	58,7							
Clamping sleeve			**1015743**		**1015777**	**1015799**							
Work stop			893850		893865	893875							
Min-Ø mm			34,2		49,2	59,2							
Clamping sleeve			**1015744**		**1015778**	**1015800**							
Work stop			893850		893865	893875							
Min-Ø mm			34,7		49,7	59,7							
Clamping sleeve			**1015745**		**1015779**	**1015801**							
Work stop			893851		893866	893876							
Min-Ø mm			35,2		50,2	60,2							
Clamping sleeve			**1015746**		**1015780**	**1015802**							
Work stop			893851		893866	893876							
Min-Ø mm						60,7							
Clamping sleeve						**1015803**							
Work stop						893877							

Different chucking Ø and profiled clamping sleeves on request

Intermadiate flange KFR / MFR



APPLICATION

For adaption of cartridge mandrel KFR/MFR/KFR-SE/MFR-SE or KFS/MFS - on spindle head ISO 702-1 / ISO 702-3 (DIN 55021/55022/55026 and 55027).

TYPE

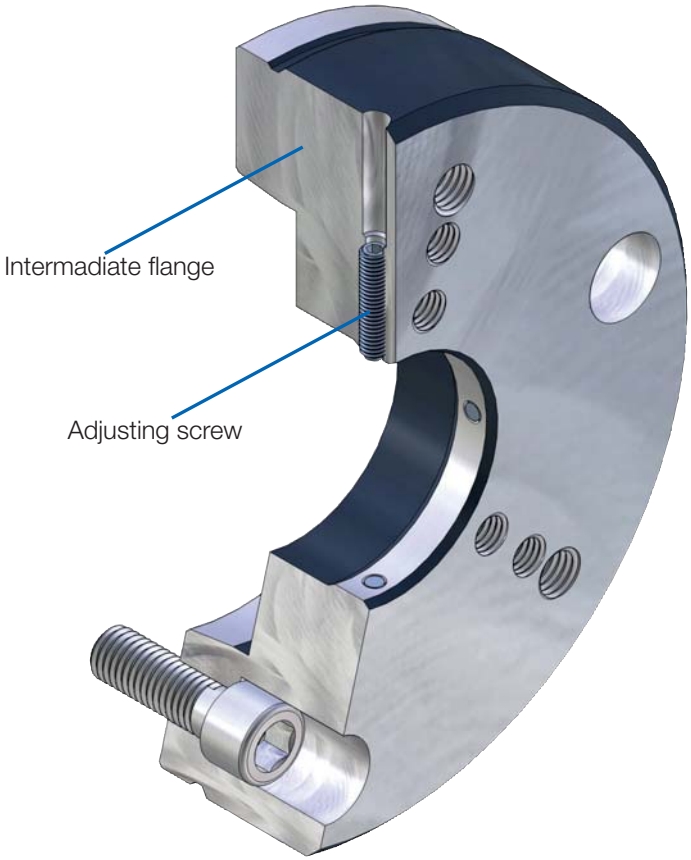
For KFR/MFR/KFR-SE/MFR-SE or KFS/MFS.

CUSTOMER BENEFITS

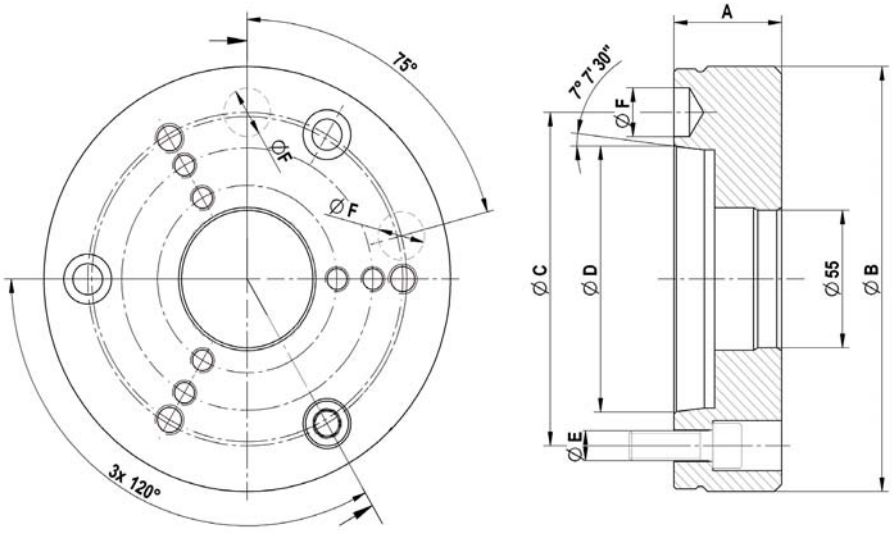
- By replacement of the Intermadiate flange, one cartridge mandrel can be used on different machines

TECHNICAL FEATURES

Adaptation of mandrel KFR / MFR / KFR-SE / MFR SE or KFS / MFS on spindle head, with or without adjustment, with or without operation of air-conditioning control. Execution according to ISO 702-1 (DIN 55028-A) or ISO 702-3 (DIN 55028-C), in size no. 5, no. 6, no. 8, no. 11 or no. 5, no. 6. Nr. 8 (A5, A6, A8, A11 or C5, C6, C8).



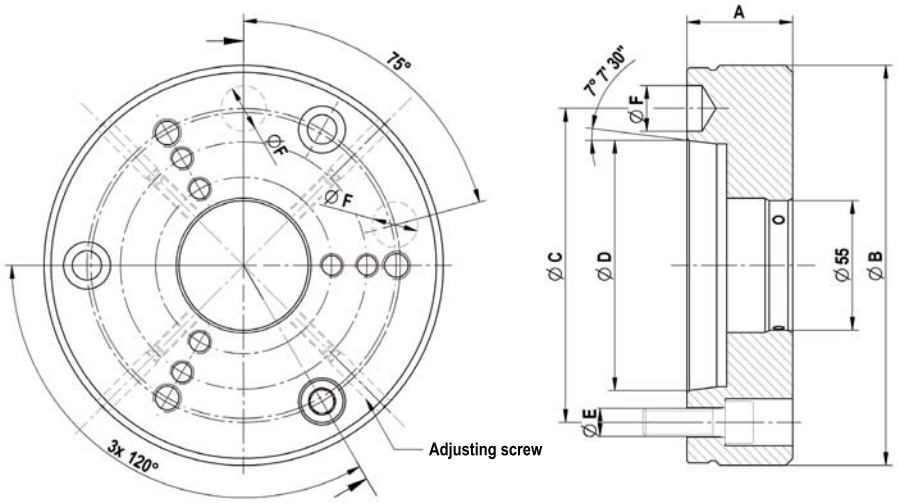
Accessories KFR / MFR



C 18

Intermediate flange ISO 702-1 (DIN 55026/55021) **without adjusting screws**

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	**893975**	**893976**	**893977**	**893978 ▲**
Design	without air-sensing	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50	50
Ø B	165	170	220	282
Ø C mm	104,8	133,4	171,4	235
Ø D mm	82,563	106,375	139,719	196,869
Ø E	M10	M12	M16	M20
Ø F mm	16,3	19,45	24,2	29,4



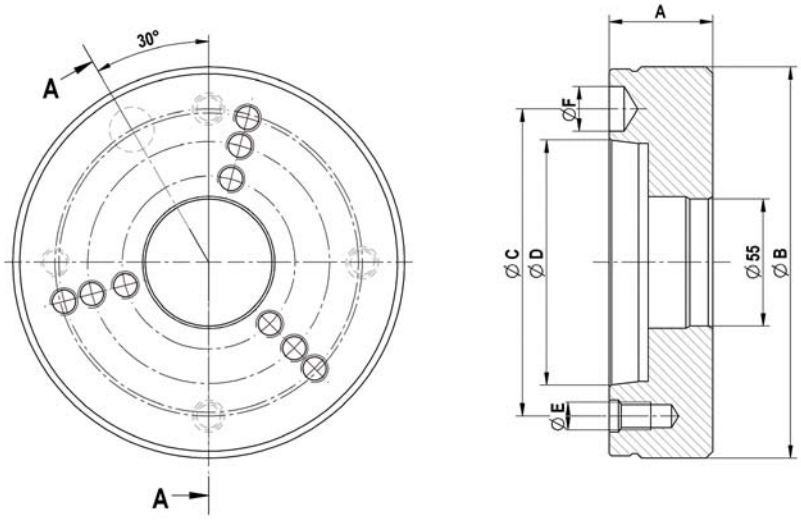
C 18

Intermediate flange ISO 702-1 (DIN 55026/55021) **with adjusting screw**

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)
Intermediate flange	**893979**	**893980**	**893981**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M10	M12	M16
Ø F mm	16,3	19,45	24,2

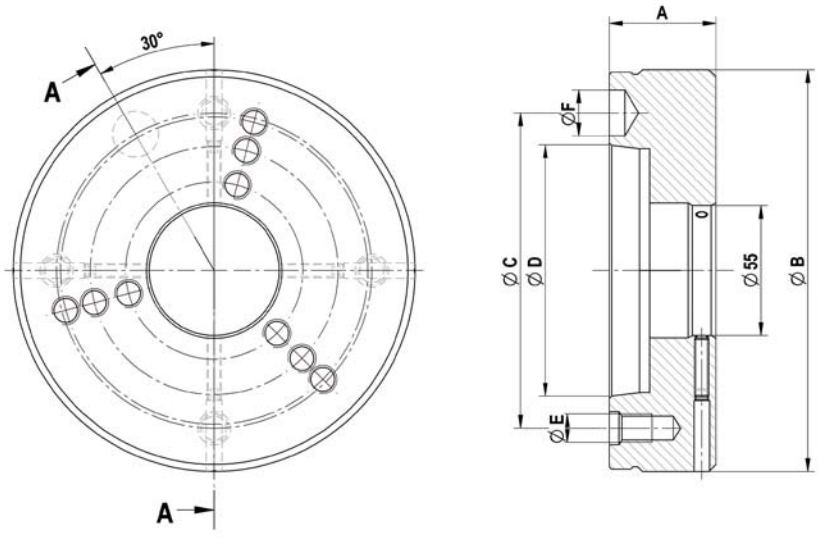
▲ on request

Accessories KFR / MFR



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) **without adjusting screws**

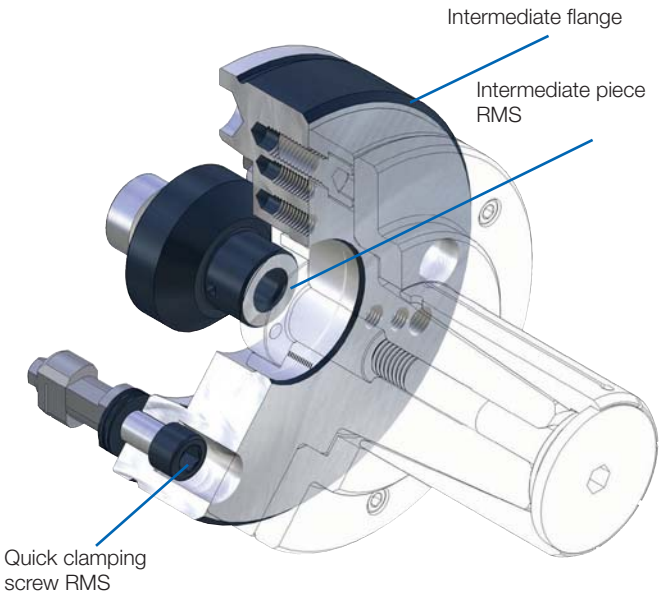
	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	**893982**	**893983**	**893984**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) **with adjusting screws**

	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	**893985**	**893986**	**893987**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2

Accessories KFR / MFR



APPLICATION

For manual clamping devices exchange in a minimum of time.

TYPE

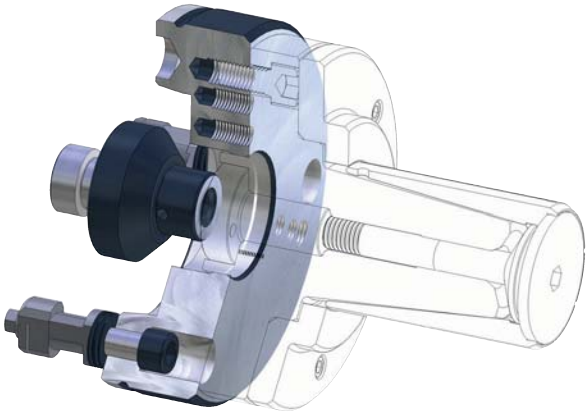
Manual quick-change system for clamping devices. Fits KFR (255-00), KFS (253-00). Central lubrication and / or air sensing control possible.

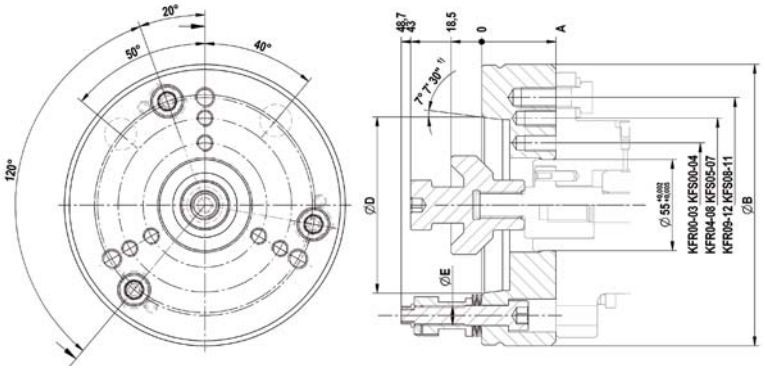
CUSTOMER BENEFITS

- Manual clamping devices change in about 30 seconds
- High repeatability within 0.005 mm
- Quick change of different clamping devices with short time, similar to the automatic or semiautomatic clamping devices changing systems

TECHNICAL FEATURES

- Quick-change system suitable due to recording RMS see quick-change system RMS (Product Group 6)
- Used in conjunction with RÖHM Safety clamping cylinder and OVS LVS the guidelines the Professional Association





C18

RMS quick-change system

	KK 06	KK 08
RMS - complete (flange incl, Quick-clamping screw)	**1160026 ▲**	**1160027 ▲**
Adapters RMS	**1183310 ▲**	**1183311 ▲**
A	45	50
Ø B	170	220
Ø C	133,4	171,4
Ø D	106,375	139,719
Ø E mm	M12	M16
Ø F mm	55 (+0,003/+0,001)	55 (+0,003/+0,001)

▲ on request

KFB



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring.
Ideal for very small clamping diameters starting from Ø 5.5 mm or small workpieces.

TYPE

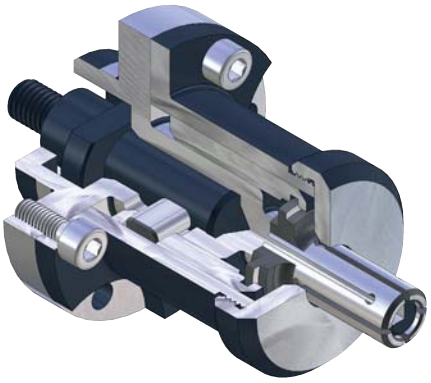
Force-actuated.
Clamping sleeves optionally vulcanized.

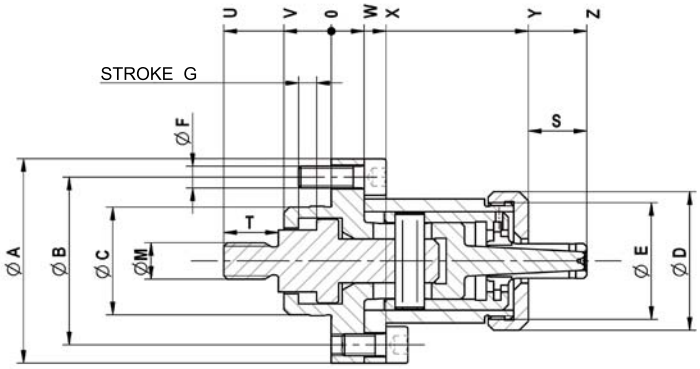
CUSTOMER BENEFITS

- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- High concentricity, axial run-out and repeatability
- Light weight and reduced height thanks to compact design

TECHNICAL FEATURES

- Hardened, low-wear design





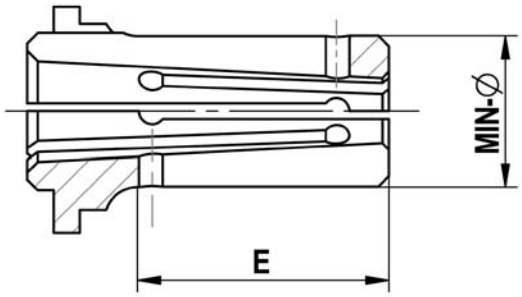
C18
KFB Cartridge mandrel
consisting of basic mandrel, stop sleeve, guide sleeve, cotter, draw bolt

	KFB 00	KFB 01	KFB 02	KFB 03	KFB 04	KFB 05	KFB 06	KFB 07
Cartridge Mandrel	**327586**	**327587**	**327588**	**327589**	**327590**	**327591**	**327592**	**327593** ▲
Basic mandrel	**323521**	**323522**	**323523**	**323524**	**323525**	**323526**	**323527**	**323528** ▲
Stop sleeve	**323474**	**323475**	**323476**	**323477**	**323478**	**323479**	**323480**	**323481** ▲
Guide sleeve	**323461**	**323462**	**323463**	**323464**	**323465**	**323466**	**323467**	**323468** ▲
Cotter	**323508**	**323509**	**323510**	**323511**	**323512**	**323513**	**323514**	**323515** ▲
Draw bolt	**323500**	**323501**	**323502**	**323502**	**323503**	**323504**	**323504**	**323505** ▲
F max, in kN	1,8	2,7	3,6	4,8	5,8	7,5	12	22
Max, total clamping force approx, kN	12	18	24	32	38	50	65	119
Min-Ø unclamped from	5,5	7,5	9,5	12	14,5	19,5	24,7	29,7
Min-Ø unclamped to	7	9	11,5	14,5	19	24,5	28,7	33,7
Clamping-Ø max,	7,5	9,5	12	15	19,5	25	29,7	34,7
External-Ø A	45	50	56	60	72	76	82	95
Pitch diameter B	36	39	46	50	60	64	70	80
Ø Ch6	25	25	30	30	40	40	40	60
Ø D mm	24	31	38	40	52	54	60	66
Ø E mm	M22x1,5	M27x1,5	M32x1,5	M36x1,5	M45x1,5	M48x1,5	M56x1,5	M60x1,5
Ø F mm	M5	M6	M6	M6	M6	M6	M6	M8
Stroke G	5	5	5	5	5	5	6	6
Ø M	M8	M8	M10	M10	M10	M12	M12	M12
S mm	9	13	15	20,5	24	30	36	40
T mm	14	14	15	15	15	18	18	18
U mm	27	27,5	29,5	29,5	30,5	33,5	33,5	36,5
V mm	11,5	12	13	13	14	14	14	17
W mm	7,5	8	9	9	10	10	10	12,5
X mm	12,5	13	15	15	16	16	16	18,5
Y mm	42	46	45	58	66	67	71	74
Z mm	51,5	58,5	70	78,5	90	97	107	114

Max. clamping force kN: 1,1-1,7-2,3-3,1-3,8-4,9-6,4-11,8

Accessories KFB





C 18

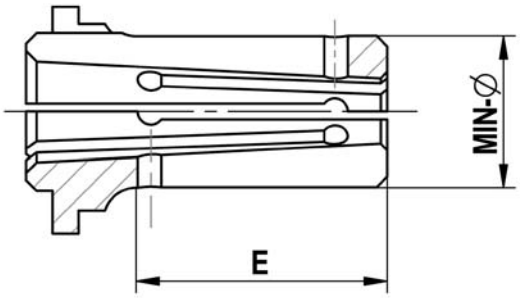
Clamping sleeve Type B - Standard design; (not vulcanized)

For size	KFB 00	KFB 01	KFB 02	KFB 03	KFB 04	KFB 05	KFB 06	KFB 07
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1
Total length E mm	11,5	15	19	20,5	28,5	34	40	43,5
Min-Ø mm	5,5	7,5	10	12	14,5	19,5	24,7	29,7
Clamping sleeve	**315139**	**315140**	**315154**	**315142**	**315143**	**315144**	**315145**	**315146**
Work stop	315126	315127	315128	315129	315130	323444	315132	315133
Min-Ø mm	6	8	10,5	12,5	15	20	25,7	30,7
Clamping sleeve	**315152**	**315153**	**315167**	**315155**	**315156**	**315157**	**315158**	**315159** ▲
Work stop	323421	315127	315128	315129	323436	323445	323453	323460
Min-Ø mm	6,5	8,5	11	13	15,5	20,5	26,7	31,7
Clamping sleeve	**315165**	**315166**	**315180**	**315168**	**315169**	**315170**	**315171**	**315172** ▲
Work stop	315126	315127	315128	315129	315130	315131	323454	315133
Min-Ø mm	7	9	11,5	13,5	16	21	27,7	32,7
Clamping sleeve	**315178**	**315179**	**315191**	**315181**	**315182**	**315183**	**315184**	**315185** ▲
Work stop	315126	315127	315128	323433	315130	323447315131	315132	323541315133
Min-Ø mm			9,5	14	16,5	21,5	28,7	33,7
Clamping sleeve			**315141**	**315192**	**315193**	**315194**	**315195**	**315196** ▲
Work stop			315128	315129	315130	315131	315132	323494
Min-Ø mm				14,5	17	22		
Clamping sleeve				**315202**	**315203**	**315204**		
Work stop				323490	315130	315131		
Min-Ø mm					17,5	22,5		
Clamping sleeve					**315209**	**315210**		
Work stop					323441	323450		
Min-Ø mm					18	23		
Clamping sleeve					**315215**	**315216**		
Work stop					315130	315131		
Min-Ø mm					18,5	23,5		
Clamping sleeve					**315221**	**315222**		
Work stop					323443	315131		
Min-Ø mm					19	24		
Clamping sleeve					**315227**	**315228**		
Work stop					315130	323458		
Min-Ø mm						24,5		
Clamping sleeve						**315233**		
Work stop						315131		

▲ on request

Accessories KFB





C 18

Clamping sleeve Type B - vulcanized (protected against chips and dirt)

For size	KFB 00	KFB 01	KFB 02	KFB 03	KFB 04	KFB 05	KFB 06	KFB 07
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1
Total length E mm	11,5	15	19	20,5	28,5	34	40	43,5
Min-Ø mm	5,5	7,5	10	12	14,5	19,5	24,7	29,7
Clamping sleeve	**323739**	**323740**	**323754**	**323742**	**323743**	**323744**	**323745**	**323746** ▲
Work stop	323420	323423	323427	323430	323435	323444	323452	323459
Min-Ø mm	6	8	10,5	12,5	15	20	25,7	30,7
Clamping sleeve	**323752**	**323753**	**323767**	**323755**	**323756**	**323757**	**323758**	**323759** ▲
Work stop	323421	323424	323428	323431	323436	323445	323453	323460
Min-Ø mm	6,5	8,5	11	13	15,5	20,5	26,7	31,7
Clamping sleeve	**323765**	**323766**	**323780**	**323768**	**323769**	**323770**	**323771**	**323772** ▲
Work stop	323422	323425	323429	323432	323437	323446	323454	323540
Min-Ø mm	7	9	11,5	13,5	16	21	27,7	32,7
Clamping sleeve	**323778**	**323779**	**323791**	**323781**	**323782**	**323783**	**323784**	**323785** ▲
Work stop	323487	323488	323489	323433	323438	323447	323455	323541
Min-Ø mm			9,5	14	16,5	21,5	28,7	33,7
Clamping sleeve			**323741**	**323792**	**323793**	**323794**	**323795**	**323796** ▲
Work stop			323426	323434	323439	323448	323493	323494
Min-Ø mm				14,5	17	22		
Clamping sleeve				**323802**	**323803**	**323804**		
Work stop				323490	323440	323449		
Min-Ø mm					17,5	22,5		
Clamping sleeve					**323809**	**323810**		
Work stop					323441	323450		
Min-Ø mm					18	23		
Clamping sleeve					**323815**	**323816**		
Work stop					323442	323456		
Min-Ø mm					18,5	23,5		
Clamping sleeve					**323821**	**323822**		
Work stop					323443	323457		
Min-Ø mm					19	24		
Clamping sleeve					**323827**	**323828**		
Work stop					323491	323458		
Min-Ø mm						24,5		
Clamping sleeve						**323833**		
Work stop						323492		

Deviating clamping Ø as well as profiled clamping sleeves available on request

MZB



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring.
Ideal for very small clamping diameters starting from Ø 5.5 mm or small workpieces.

TYPE

Manually actuated.
Clamping sleeves optionally vulcanized.

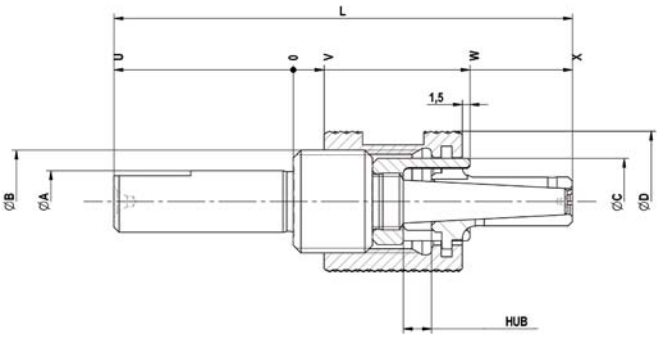
CUSTOMER BENEFITS

- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- High concentricity and repeatability
- Light weight and reduced height thanks to compact design

TECHNICAL FEATURES

- Hardened, low-wear design





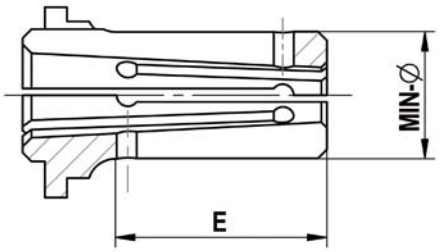
C18
MZB Cartridge Mandrel

	MZB 00	MZB 01	MZB 02	MZB 03	MZB 04	MZB 05	MZB 06	MZB 07	MZB 08	MZB 09	MZB 10	MZB 11	MZB 12
Cartridge Mandrel	**1130361**	**1130362**	**1130363**	**1130364**	**1130365**	**1130366**	**1130367**	**1130368 ▲**	**1130369 ▲**	**1130370 ▲**	**1130371 ▲**	**1130372 ▲**	**1130373 ▲**
Basic mandrel	**315100**	**315101**	**315102**	**315103**	**315104**	**315105**	**315106**	**315107 ▲**	**315108 ▲**	**315109 ▲**	**315110 ▲**	**315111 ▲**	**315112 ▲**
Nut	**315113**	**315114**	**315115**	**315116**	**315117**	**315118**	**315119**	**315120 ▲**	**315121 ▲**	**315122 ▲**	**315123 ▲**	**315124 ▲**	**315125 ▲**
Min-Ø unclamped from	5,5	7,5	9,5	12	14,5	19,5	24,7	29,7	34,7	39,7	44,7	54,7	64,7
Min-Ø unclamped to	7	9	11,5	14,5	19	24,5	28,7	33,7	38,7	43,7	53,7	63,7	78,7
Clamping-Ø max,	7,5	9,5	12	15	19,5	25	29,7	34,7	39,7	44,7	54,7	64,7	79,7
Ø A h6	10	12	12	14	18	20	25	30	40	40	45	50	50
Ø B	M14x1,5	M16x1,5	M20x1,5	M24x1,5	M30x1,5	M36x1,5	M42x1,5	M45x1,5	M52x1,5	M56x1,5	M65x1,5	M75x2	M95x2
Ø C mm	10,8	13	16,8	20,8	26,8	31,8	36,8	41,8	47,8	52,5	61,8	71,8	90,8
Ø D mm	19,5	23	28	31	38	47	54	57,5	66	74	83	93	108
Stroke G	5	5,5	5,5	5,5	5,5	6	6	6	6	6	6	6,5	7
L mm	74,5	79,5	89,5	97,5	102,5	113,5	136	144,5	156	166,5	197	208,5	221,5
U mm	30	30	35	35	35	40	45	50	55	60	67	67	67
V mm	5,5	6	6	6	6	6	7	7	7	7	7	7	7
W mm	29	33,5	34,5	36,5	37,5	37,5	48,5	48,5	48,5	48,5	53,5	56,5	58,5
X mm	44,5	48,5	53,5	61,5	66,5	72,5	89	92,5	99	104,5	128	139,5	152,5

▲ on request

Accessories MZB



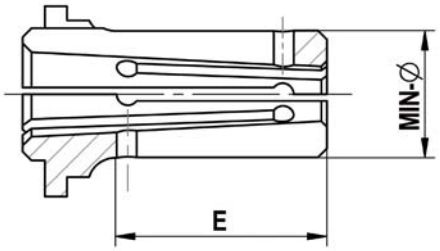


C 18
Clamping sleeve Type B - Standard design
(not vulcanized)

For size	MZB 00	MZB 01	MZB 02	MZB 03	MZB 04	MZB 05	MZB 06	MZB 07	MZB 08	MZB 09	MZB 10	MZB 11	MZB 12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length E mm	11,5	15	19	20,5	28,5	34	40	43,5	50	55,5	74	82,5	93,5
Min-Ø mm	5,5	7,5	10	12	14,5	19,5	24,7	29,7	34,7	39,7	44,7	54,7	64,7
Clamping sleeve	**315139**	**315140**	**315154**	**315142**	**315143**	**315144**	**315145**	**315146**	**315147** ▲	**315148** ▲	**315149** ▲	**315150** ▲	**315151** ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	6	8	10,5	12,5	15	20	25,7	30,7	35,7	40,7	45,7	55,7	65,7
Clamping sleeve	**315152**	**315153**	**315167**	**315155**	**315156**	**315157**	**315158**	**315159** ▲	**315160** ▲	**315161** ▲	**315162** ▲	**315163** ▲	**315164** ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	6,5	8,5	11	13	15,5	20,5	26,7	31,7	36,7	41,7	46,7	56,7	66,7
Clamping sleeve	**315165**	**315166**	**315180**	**315168**	**315169**	**315170**	**315171**	**315172** ▲	**315173** ▲	**315174** ▲	**315175** ▲	**315176** ▲	**315177** ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	7	9	11,5	13,5	16	21	27,7	32,7	37,7	42,7	47,7	57,7	67,7
Clamping sleeve	**315178**	**315179**	**315191**	**315181**	**315182**	**315183**	**315184**	**315185** ▲	**315186** ▲	**315187** ▲	**315188** ▲	**315189** ▲	**315190** ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm			9,5	14	16,5	21,5	28,7	33,7	38,7	43,7	48,7	58,7	68,7
Clamping sleeve			**315141**	**315192**	**315193**	**315194**	**315195**	**315196** ▲	**315197** ▲	**315198** ▲	**315199** ▲	**315200** ▲	**315201** ▲
Work stop			315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm				14,5	17	22					49,7	59,7	69,7
Clamping sleeve				**315202**	**315203**	**315204**					**315205** ▲	**315206** ▲	**315207** ▲
Work stop				315129 ▲	315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					17,5	22,5					50,7	60,7	70,7
Clamping sleeve					**315209**	**315210**					**315211** ▲	**315212** ▲	**315213** ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					18	23					51,7	61,7	71,7
Clamping sleeve					**315215**	**315216**					**315217** ▲	**315218** ▲	**315219** ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					18,5	23,5					52,7	62,7	72,7
Clamping sleeve					**315221**	**315222**					**315223** ▲	**315224** ▲	**315225** ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					19	24					53,7	63,7	73,7
Clamping sleeve					**315227**	**315228**					**315229** ▲	**315230** ▲	**315231** ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm						24,5							74,7
Clamping sleeve						**315233**							**315208** ▲
Work stop						315131							315138 ▲
Min-Ø mm													75,7
Clamping sleeve													**315214** ▲
Work stop													315138 ▲
Min-Ø mm													76,7
Clamping sleeve													**315220** ▲
Work stop													315138 ▲
Min-Ø mm													77,7
Clamping sleeve													**315226** ▲
Work stop													315138 ▲
Min-Ø mm													78,7
Clamping sleeve													**315232** ▲
Work stop													315138 ▲

Accessories MZB





C 18

Clamping sleeve Type B - vulcanized (protected against chips and dirt)

For size	MZB 00	MZB 01	MZB 02	MZB 03	MZB 04	MZB 05	MZB 06	MZB 07	MZB 08	MZB 09	MZB 10	MZB 11	MZB 12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length E mm	11,5	15	19	20,5	28,5	34	40	43,5	50	55,5	74	82,5	93,5
Min-Ø mm	5,5	7,5	10	12	14,5	19,5	24,7	29,7	34,7	39,7	44,7	54,7	64,7
Clamping sleeve	**323739**	**323740**	**323754**	**323742**	**323743**	**323744**	**323745**	**323746** ▲	**323747** ▲	**323748** ▲	**323749** ▲	**323750** ▲	**323751** ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	6	8	10,5	12,5	15	20	25,7	30,7	35,7	40,7	45,7	55,7	65,7
Clamping sleeve	**323752**	**323753**	**323767**	**323755**	**323756**	**323757**	**323758**	**323759** ▲	**323760** ▲	**323761** ▲	**323762** ▲	**323763** ▲	**323764** ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	6,5	8,5	11	13	15,5	20,5	26,7	31,7	36,7	41,7	46,7	56,7	66,7
Clamping sleeve	**323765**	**323766**	**323780**	**323768**	**323769**	**323770**	**323771**	**323772** ▲	**323773** ▲	**323774** ▲	**323775** ▲	**323776** ▲	**323777** ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	7	9	11,5	13,5	16	21	27,7	32,7	37,7	42,7	47,7	57,7	67,7
Clamping sleeve	**323778**	**323779**	**323791**	**323781**	**323782**	**323783**	**323784**	**323785** ▲	**323786** ▲	**323787** ▲	**323788** ▲	**323789** ▲	**323790** ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm			9,5	14	16,5	21,5	28,7	33,7	38,7	43,7	48,7	58,7	68,7
Clamping sleeve			**323741**	**323792**	**323793**	**323794**	**323795**	**323796** ▲	**323797** ▲	**323798** ▲	**323799** ▲	**323800** ▲	**323801** ▲
Work stop			315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm				14,5	17	22					49,7	59,7	69,7
Clamping sleeve				**323802**	**323803**	**323804**					**323805** ▲	**323806** ▲	**323807** ▲
Work stop				315129 ▲	315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					17,5	22,5					50,7	60,7	70,7
Clamping sleeve					**323809**	**323810**					**323811** ▲	**323812** ▲	**323813** ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					18	23					51,7	61,7	71,7
Clamping sleeve					**323815**	**323816**					**323817** ▲	**323818** ▲	**323819** ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					18,5	23,5					52,7	62,7	72,7
Clamping sleeve					**323821**	**323822**					**323823** ▲	**323824** ▲	**323825** ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					19	24					53,7	63,7	73,7
Clamping sleeve					**323827**	**323828**					**323829** ▲	**323830** ▲	**323831** ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm						24,5							74,7
Clamping sleeve						**323833**							**323808** ▲
Work stop						315131							315138 ▲
Min-Ø mm													75,7
Clamping sleeve													**323814** ▲
Work stop													315138 ▲
Min-Ø mm													76,7
Clamping sleeve													**323820** ▲
Work stop													315138 ▲
Min-Ø mm													77,7
Clamping sleeve													**323826** ▲
Work stop													315138 ▲
Min-Ø mm													78,7
Clamping sleeve													**323832** ▲
Work stop													315138 ▲

Deviating clamping Ø as well as profiled clamping sleeves available on request

MZE



APPLICATION

Internal clamping of round workpieces, measuring operations, light grinding operations.
Ideal for long clamping lengths / long workpieces.

TYPE

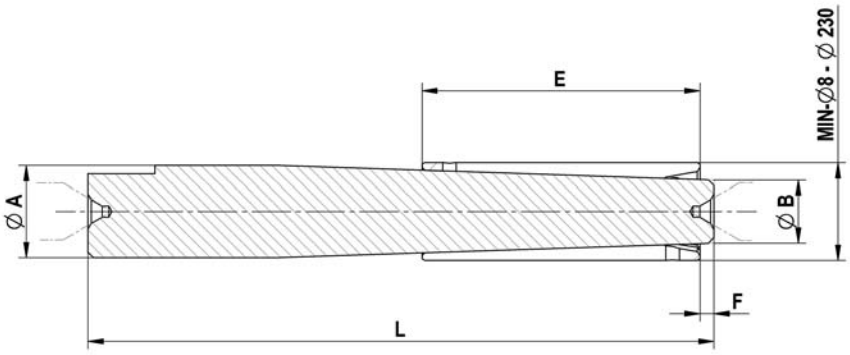
Manually actuated.
Available as clamping mandrel assortment, for various clamping diameters.

CUSTOMER BENEFITS

- Quick change of clamping sleeve without tools
- High concentricity and repeatability
- High flexibility thanks to mount on the shaft or between points
- Short retrofitting times

TECHNICAL FEATURES

- Hardened, low-wear design

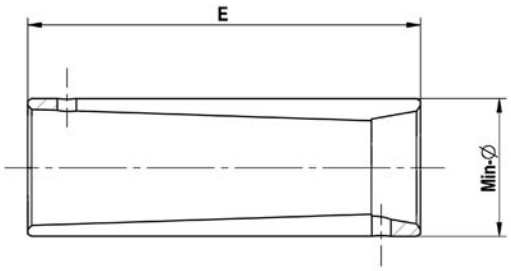


C18
MZE Basic mandrel

	MZE 00	MZE 01	MZE 02	MZE 03	MZE 04	MZE 05	MZE 06	MZE 07	MZE 08	MZE 09	MZE 10	MZE 11	MZE 12	MZE 13	MZE 14	MZE 15
Basic mandrel	**315000**	**315001**	**315002**	**315003**	**315004**	**315005**	**315006**	**315007**	**315008**	**315009**	**315010**	**315011**	**315012**	**315013 ▲**	**315014 ▲**	**315015 ▲**
Min-Ø unclamped from	8	10	12	14	16	19	22	25	35	45	55	68	80	105	135	185
Min-Ø unclamped to	9	11	13	15	18	21	24	34	44	54	65	80	100	135	180	230
Clamping-Ø max,	10,5	12,5	15	17	20	23	26	37	47	59	70	85	105	140	185	235
Ø A	8	10	12	14	16	19	21	25	33	45	53	64	76	99	124	145,5
Ø B	4,1	5,3	5,7	6,9	8,5	10,7	12,2	14,6	22,6	31,1	38	48,2	60,9	80,4	97,4	122,4
E	40	45	60	70	70	80	80	100	100	125	135	150	150	170	180	200
F	3	3	4	4	4	4	4	4	5	5	5	5	5	5	82	63
L	75	110	125	140	150	170	175	225	225	300	330	350	350	400	442	443

Accessories MZE





C 18

Clamping sleeve E - for basic mandrel MZE

For size	MZE 00	MZE 01	MZE 02	MZE 03	MZE 04	MZE 05	MZE 06	MZE 07	MZE 08	MZE 09	MZE 10	MZE 11	MZE 12	MZE 13	MZE 14	MZE 15
Expansion in Ø mm	1,5	1,5	2	2	2	2	2	3	3	5	5	5	5	5	5	5
Total length E mm	40	45	60	70	70	80	80	100	100	125	135	150	150	170	180	200
Min-Ø mm	8	10	12	14	16	19	22	25	35	45	55	68	100	105	135	185
Clamping sleeve	**315016**	**315017**	**315018**	**315019**	**315020**	**315021**	**315022**	**315023**	**315024**	**315025**	**315026**	**315027** ▲	**315074**	**315029** ▲	**315030** ▲	**315031** ▲
Min-Ø mm	9	11	13	15	17	20	23	26	36	48	58	70	80	110	140	190
Clamping sleeve	**315032**	**315033**	**315034**	**315035**	**315036**	**315037**	**315038**	**315039**	**315040**	**315041**	**315042** ▲	**315043**	**315028**	**315045** ▲	**315046** ▲	**315047** ▲
Min-Ø mm					18	21	24	28	38	50	60	72	85	115	145	195
Clamping sleeve					**315048**	**315049**	**315050**	**315051**	**315052**	**315053**	**315054** ▲	**315055**	**315044**	**315057** ▲	**315058** ▲	**315059** ▲
Min-Ø mm								30	40	52	62	75	90	120	150	200
Clamping sleeve								**315060**	**315061**	**315062**	**315063** ▲	**315064**	**315056**	**315066** ▲	**315067** ▲	**315068** ▲
Min-Ø mm								32	42	54	65	78	95	125	155	205
Clamping sleeve								**315069**	**315070**	**315071**	**315072** ▲	**315073**	**315065**	**315075** ▲	**315076** ▲	**315077** ▲
Min-Ø mm								34	44			80		130	160	210
Clamping sleeve								**315078**	**315079**			**315080**		**315081** ▲	**315082** ▲	**315083** ▲
Min-Ø mm														135	165	215
Clamping sleeve														**315084** ▲	**315085** ▲	**315086** ▲
Min-Ø mm															170	220
Clamping sleeve															**315087** ▲	**315088** ▲
Min-Ø mm															175	225
Clamping sleeve															**315089** ▲	**315090** ▲
Min-Ø mm															180	230
Clamping sleeve															**315091** ▲	**315092** ▲

Deviating clamping Ø as well as profiled and vulcanized clamping sleeves available on request

▲ on request

Product ranges MZE cartridge mandrel



Product ranges in wooden box size 1 – ID 315093

CONTENT
Consisting of 5 basic mandrels 02 - 06 and 7 clamping sleeves in the clamping range 12-26, Ø 12-14-16-18-20-22-24 mm



Product range in wooden box size 2 – ID 315094

CONTENT
Consisting of 3 basic mandrels 07 - 09 and 6 clamping sleeves in the clamping range 25-55, Ø 25-30-35-40-45-50 mm

Special solutions KFS



Cartridge mandrel KFS clamping-Ø 22,65 mm

APPLICATION
Turning

Clamping mandrel in special version due to required freedom of the tool. The clamping is done in the root circle of the toothing using a diagonally slotted clamping sleeve. Tilting in the toothing is prevented by the angled slotting.

CUSTOMER BENEFITS
- Optimal clamping of the toothed workpiece
- High concentricity and run-out precision of 0.02 mm



Cartridge mandrel KFS clamping-Ø SW 27,8 mm

APPLICATION
Turning

The clamping is done using a hexagonal clamping sleeve with axial pull via the draw bar against a fixed stop. The workpiece stop is designed of a two-sided loading of the workpiece.

CUSTOMER BENEFITS
- Clamping of special contours is possible
- Concentricity of 0.05 mm



Cartridge mandrel KFS clamping-Ø 34,3 mm

APPLICATION
Turning / Cutting

Cartridge mandrel force-actuated with axial pull and fixed stop. Clamping sleeve profiled for cutting off of the workpieces.

CUSTOMER BENEFITS
- Low-cost production of small parts
- Concentricity of 0.01 mm

Special solutions KFR / MFR



Cartridge mandrel KFR clamping-Ø 45 mm

APPLICATION
Turning of a pressed part

Force-actuated cartridge mandrel actuated via draw bar.
Clamping mandrel is designed for different workpieces.
Fixed stop with damping ring, air sensing and ejector.

CUSTOMER BENEFITS
- Can be easily reconfigured to other clamping diameters by changing of clamping sleeve and/or stop
- Concentricity of 0.01 mm

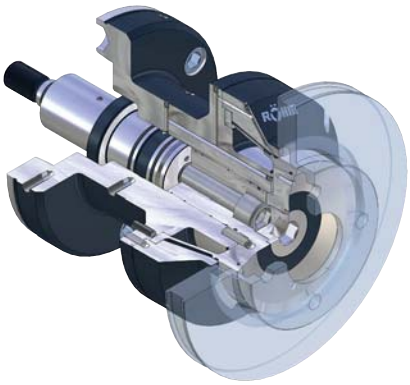


Cartridge mandrel KFR clamping-Ø TK-Ø 90 mm

APPLICATION
Turning

Force-actuated cartridge mandrel with toothed clamping sleeve for clamping in the tooth flanks. Collet with quick change system.

CUSTOMER BENEFITS
- Concentricity for toothing
- Concentricity of 0.03 mm

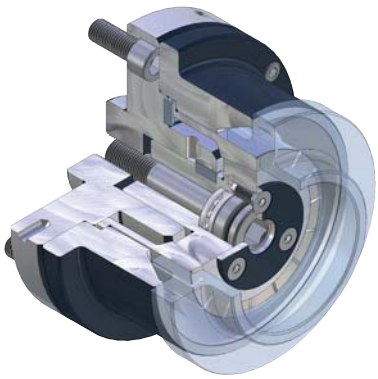


Cartridge mandrel KFR clamping-Ø 136 mm

APPLICATION
Turning of brake discs

Force-actuated cartridge mandrel actuated via draw bar. Sealed against penetration of chips. Fixed stop with air sensing.

CUSTOMER BENEFITS
- Stable version of the clamping mandrel
- Concentricity of 0.02 mm



Cartridge mandrel MFR clamping-Ø 88 mm

APPLICATION
Milling / drilling for stationary use on clamping devices.

Cartridge mandrel in special version with manual actuation.
The actuation is done via the hexagon socket.

CUSTOMER BENEFITS
- Simple actuation by light roller bearing
- Concentricity of 0.015 mm

Special solutions KFB



Cartridge mandrel KFB clamping-Ø 42 mm

APPLICATION
Turning

Clamping of the workpiece with axial tension against the stop. Clamping mandrel is hermetically sealed against penetration by dirt and cooling water. The stop and clamping sleeve can be replaced together using the quick change system.

CUSTOMER BENEFITS
- Fast adjustment to different workpieces thanks to the quick change system
- Concentricity of 0.015 mm



Cartridge mandrel KFB clamping-Ø 114 mm

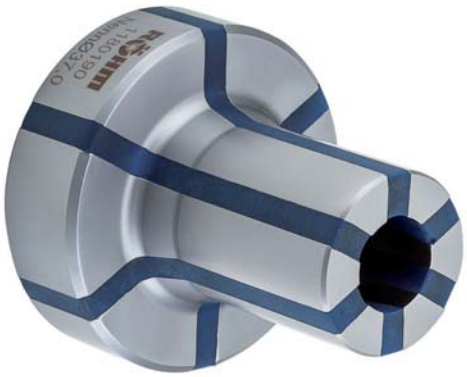
APPLICATION
Turning

Clamping is done via draw bar with axial tension against the fixed stop. Idle stroke enables simpler stroke control in the clamping cylinder. The workpiece stop can be replaced quickly using the bayonet system.

CUSTOMER BENEFITS
- Simple handling
- Stable clamping using axial pull
- Concentricity of 0.01 mm

Notes

INNOVATIVE VULCANISATE IN THE SEGMENT CLAMPING SLEEVE



- Segment clamping sleeve with innovative vulcanisate for great elongation, longest service life and vibration dampening
- Hardened and ground steel segments for high resistance to wear

Video ABSIS

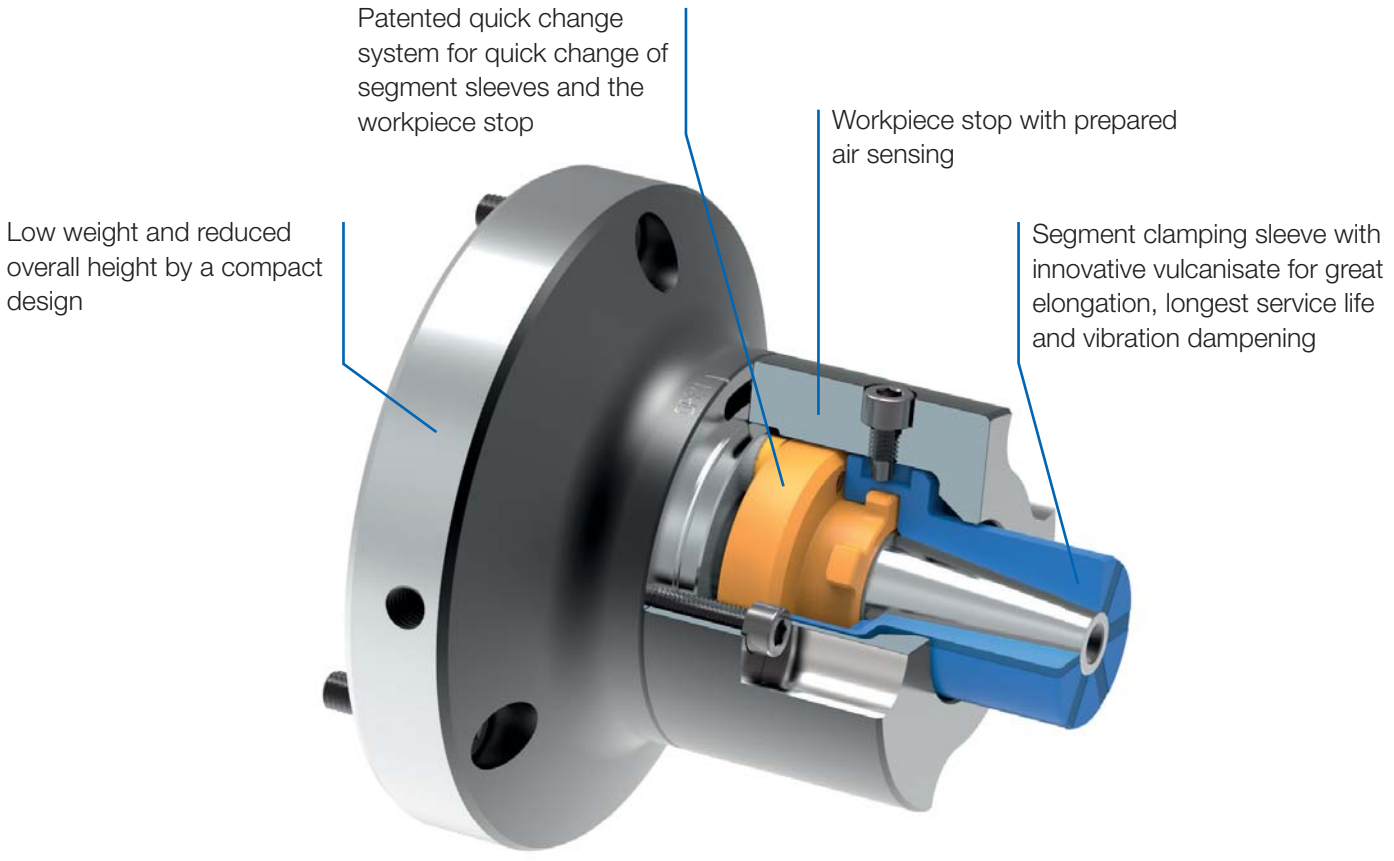
Video AGILIS

SEGMENT CLAMPING MANDREL

Modern manufacturing technology can hardly do without the use of segment clamping mandrels. In the fields of precision machining, turning, grinding, gear cutting and checking, segment clamping mandrels assume important tasks that are associated with challenging conditions. The innovative rubber segments enable a great elongation of the clamping sleeve to 1.2 mm.

ADVANTAGES AT A GLANCE

- Short tooling and non-productive times thanks to the great elongation of the clamping sleeve up to 1.2 mm
- Vibration dampening and long service life thanks to innovative vulcanisate of the clamping sleeves
- Fast replacement of the clamping mandrel thanks to the patented bayonet quick change system



ABSIS



APPLICATION

Internal clamping of round workpieces. Turning, grinding and toothing operations, as well as for balancing and measuring.
Ideal for clamping in through holes.

TYPE

Force-actuated.

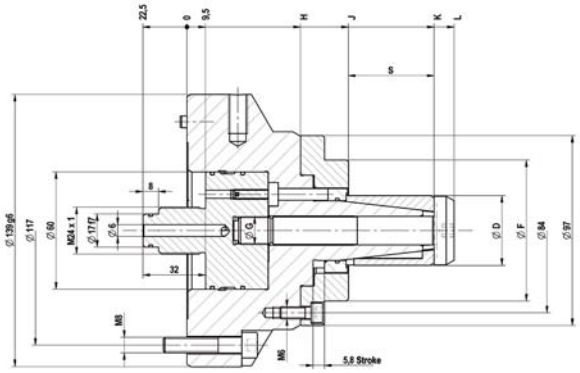
CUSTOMER BENEFITS

- Short setup and non-productive times thanks to great expansion of the segment sleeves
- Vibration damping due to high vulcanized rubber component of the clamping sleeves
- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- Fast change of segment sleeves thanks to central clamping screw
- High concentricity, axial run-out and repeatability

TECHNICAL FEATURES

- Manual lubrication
- Air sensing prepared





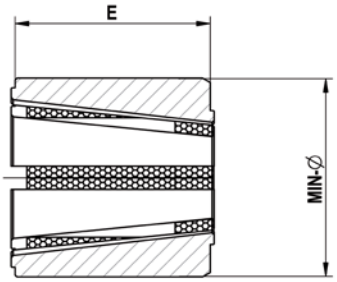
C 18
ABSIS Segment clamping mandrel, power-operated with flanged seat
consists of basic mandrel, adapter, ejector ring, locking belt

	ABSIS 00	ABSIS 01	ABSIS 02	ABSIS 03	ABSIS 04
Segment clamping mandrel	**1110000**	**1110001**	**1110002**	**1110003**	**1110004**
Basic mandrel	**1110100**	**1110101**	**1110102**	**1110103**	**1110104**
Adapter power operated	**1110040**	**1110041**	**1110042**	**1110043**	**1110044**
Ejector ring	**1110020**	**1110021**	**1110022**	**1110023**	**1110024**
Locking bolt	**1110060**	**1110061**	**1110062**	**1110063**	**1110064**
F max, in kN	7	10	20	25	30
Max, total clamping force approx, kN	32	46	92	115	138
D Min-Ø unclamped from	19,7	25,7	35,7	50,7	72,7
D Min-Ø unclamped to	27,7	38,7	54,7	81,7	105,7
Clamping-Ø max,	29	40	56	83	107
S mm	23	27	44	50	60
Ø F mm	58	58	72	90	120
Ø G	M6x0,75	M10x1	M14x1	M18x1	M20x1
H mm	55	55	58	58,5	60
J mm	75	75	82,5	84,5	86
K mm	98	102	126,3	134,5	146
L mm	103,5	108,5	136,5	146,5	160

▲ on request

Accessories ABSIS





C 18
Segment clamping sleeve - standard design

	ABSIS 00	ABSIS 01	ABSIS 02	ABSIS 03	ABSIS 04
Expansion in Ø mm	1,2	1,2	1,2	1,2	1,2
Total length E mm	23	27	44	50	60
Min-Ø mm	19,7	25,7	35,7	50,7	72,7
Segment sleeve	**1111400**	**1111409**	**1111423**	**1111443**	**1111475**
Work stop	1110070	1110071	1110072	1110073	1110074
Min-Ø mm	20,7	26,7	36,7	51,7	73,7
Segment sleeve	**1111401**	**1111410**	**1111424**	**1111444**	**1111476**
Work stop	1110070	1110071	1110072	1110073	1110074
Min-Ø mm	21,7	27,7	37,7	52,7	74,7
Segment sleeve	**1111402**	**1111411**	**1111425**	**1111445**	**1111477**
Work stop	1110070	1110071	1110072	1123341	1123372
Min-Ø mm	22,7	28,7	38,7	53,7	75,7
Segment sleeve	**1111403**	**1111412**	**1111426**	**1111446**	**1111478**
Work stop	1110070	1110071	1110072	1123342	1123373
Min-Ø mm	23,7	29,7	39,7	54,7	76,7
Segment sleeve	**1111404**	**1111413**	**1111427**	**1111447**	**1111479**
Work stop	1110070	1110071	1110072	1123343	1123374
Min-Ø mm	24,7	30,7	40,7	55,7	77,7
Segment sleeve	**1111405**	**1111414**	**1111428**	**1111448**	**1111480**
Work stop	1110070	1110071	1110072	1123344	1123375
Min-Ø mm	25,7	31,7	41,7	56,7	78,7
Segment sleeve	**1111406**	**1111415**	**1111429**	**1111449**	**1111481**
Work stop	1110070	1110071	1110072	1123345	1173376
Min-Ø mm	26,7	32,7	42,7	57,7	79,7
Segment sleeve	**1111407**	**1111416**	**1111430**	**1111450**	**1111482**
Work stop	1123305	1110071	1123327	1123346	1123377
Min-Ø mm	27,7	33,7	43,7	58,7	80,7
Segment sleeve	**1111408**	**1111417**	**1111431**	**1111451**	**1111483**
Work stop	1123306	1123315	1123328	1123347	1123378
Min-Ø mm		34,7	44,7	59,7	81,7
Segment sleeve		**1111418**	**1111432**	**1111452**	**1111484**
Work stop		1123316	1123329	1123348	1123379
Min-Ø mm		35,7	45,7	60,7	82,7
Segment sleeve		**1111419**	**1111433**	**1111453**	**1111485**
Work stop		1123317	1123330	1123349	1123380
Min-Ø mm		36,7	46,7	61,7	83,7
Segment sleeve		**1111420**	**1111434**	**1111454**	**1111486**
Work stop		1123318	1123331	1123350	1123381
Min-Ø mm		37,7	47,7	62,7	84,7
Segment sleeve		**1111421**	**1111435**	**1111455**	**1111487**
Work stop		1123319	1123332	1123351	1123382
Min-Ø mm		38,7	48,7	63,7	85,7
Segment sleeve		**1111422**	**1111436**	**1111456**	**1111488**
Work stop		1123320	1123333	1123352	1123383
Min-Ø mm			49,7	64,7	86,7
Segment sleeve			**1111437**	**1111457**	**1111489**
Work stop			1123334	1123353	1123384
Min-Ø mm			50,7	65,7	87,7
Segment sleeve			**1111438**	**1111458**	**1111490**
Work stop			1123335	1123354	1123385
Min-Ø mm			51,7	66,7	88,7
Segment sleeve			**1111439**	**1111459**	**1111491**
Work stop			1123336	1123355	1123386

Accessories ABSIS

C 18

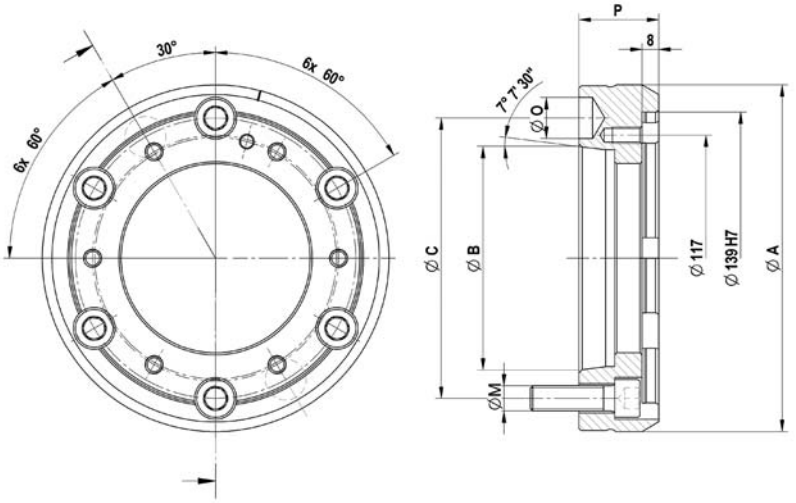
Segment clamping sleeve - standard design

	ABSIS 00	ABSIS 01	ABSIS 02	ABSIS 03	ABSIS 04
Expansion in Ø mm	1,2	1,2	1,2	1,2	1,2
Total length E mm	23	27	44	50	60
Min-Ø mm			52,7	67,7	89,7
Segment sleeve			**1111440**	**1111460**	**1111492**
Work stop			1123337	1123356	1123387
Min-Ø mm			53,7	68,7	90,7
Segment sleeve			**1111441**	**1111461**	**1111493**
Work stop			1123338	1123357	1123388
Min-Ø mm			54,7	69,7	91,7
Segment sleeve			**1111442**	**1111462**	**1111494**
Work stop			1123339	1123358	1123389
Min-Ø mm				70,7	92,7
Segment sleeve				**1111463**	**1111495**
Work stop				1123359	1123390
Min-Ø mm				71,7	93,7
Segment sleeve				**1111464**	**1111496**
Work stop				1123360	1123391
Min-Ø mm				72,7	94,7
Segment sleeve				**1111465**	**1111497**
Work stop				1123361	1123392
Min-Ø mm				73,7	95,7
Segment sleeve				**1111466**	**1111498**
Work stop				1123362	1123393
Min-Ø mm				74,7	96,7
Segment sleeve				**1111467**	**1111499**
Work stop				1123363	1123394
Min-Ø mm				75,7	97,7
Segment sleeve				**1111468**	**1111500**
Work stop				1123364	1123395
Min-Ø mm				76,7	98,7
Segment sleeve				**1111469**	**1111501**
Work stop				1123365	1123396
Min-Ø mm				77,7	99,7
Segment sleeve				**1111470**	**1111502**
Work stop				1123366	1123397
Min-Ø mm				78,7	100,7
Segment sleeve				**1111471**	**1111503**
Work stop				1123367	1123398
Min-Ø mm				79,7	101,7
Segment sleeve				**1111472**	**1111504**
Work stop				1123368	1123399
Min-Ø mm				80,7	102,7
Segment sleeve				**1111473**	**1111505**
Work stop				1123369	1123400
Min-Ø mm				81,7	103,7
Segment sleeve				**1111474**	**1111506**
Work stop				1123370	1123401
Min-Ø mm					104,7
Segment sleeve					**1111507**
Work stop					1123402
Min-Ø mm					105,7
Segment sleeve					**1111508**
Work stop					1123403

▲ on request

Accessories ABSIS

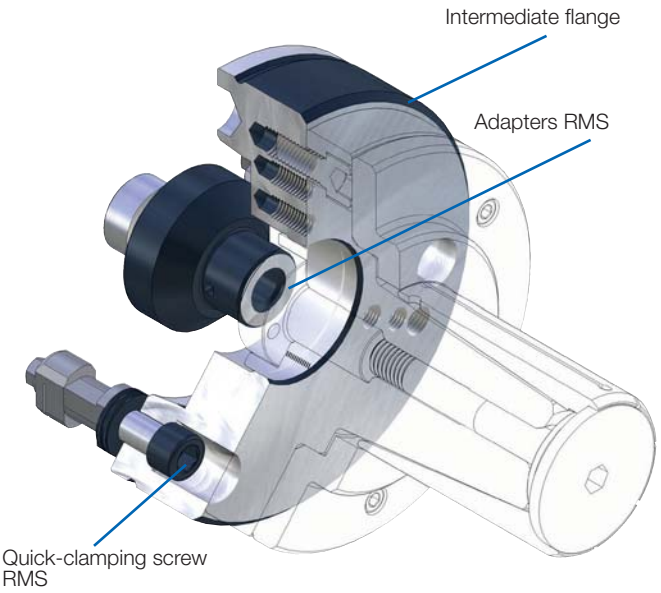




C 18
Intermediate flange ISO 702-1 (DIN 55028)
For size 00-04

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	**1110005**	**1110006**	**1110008**	**1110011 ▲**
Ø A mm	165	170	220	282
Ø B	82,563	106,375	139,719	196,869
Ø C mm	104,8	133,4	171,4	235
Thread-Ø M	M10	M12	M16	M20
Ø O mm	16,3	19,45	24,2	29,4
P mm	36	38	45	45

Accessories ABSIS



APPLICATION

For manual clamping devices exchange in a minimum of time.

TYPE

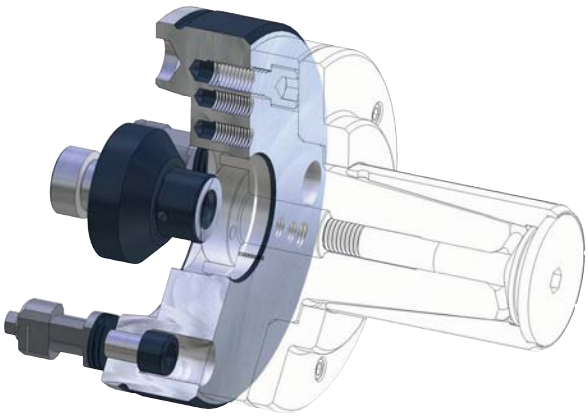
Manual quick-change system for clamping devices. Fits ABSIS (269-00), AGILIS (296-00). Central lubrication and / or air sensing control possible.

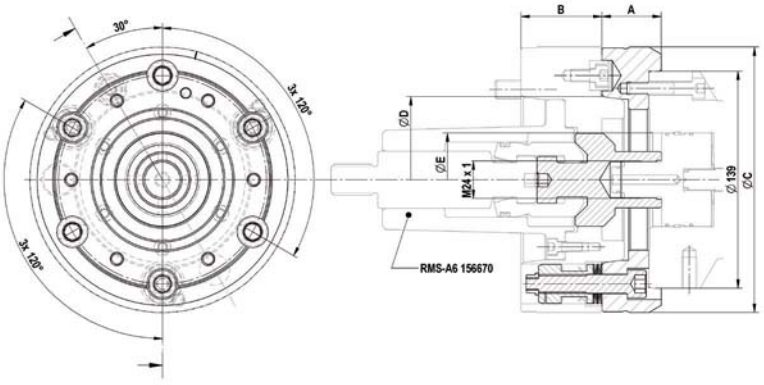
CUSTOMER BENEFITS

- Manual clamping devices change in about 30 seconds
- High repeatability within 0.005 mm
- Quick change of different clamping devices with short time, similar to the automatic or semiautomatic clamping devices changing systems

TECHNICAL FEATURES

- Quick-change system suitable due to recording RMS see quick-change system RMS (Product Group 6)
- Used in conjunction with RÖHM Safety clamping cylinder and OVS LVS the guidelines the Professional Association





C18

RMS quick-change system

	KK 06	KK 08
RMS - complete (flange incl, Quick-clamping screw)	**1160028 ▲**	**1160029 ▲**
Adapters RMS	**1183312 ▲**	**1183313 ▲**
A	38	45
Ø B	170	220
Ø C	133,4	171,4
Ø D	106,375	139,719
Ø E mm	M8	M8
Ø F mm	139 H7	139 H7

AGILIS





APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring. Suitable for short clamping lengths and very small clamping diameters starting from 10 mm.

TYPE

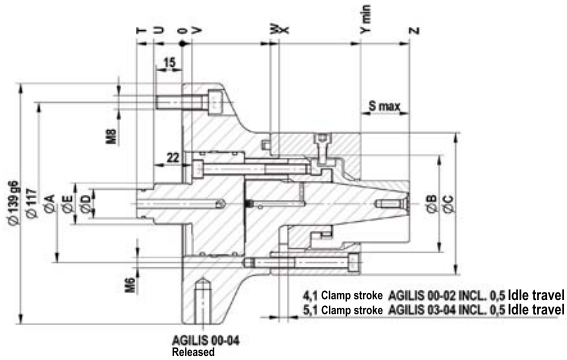
Force-actuated.

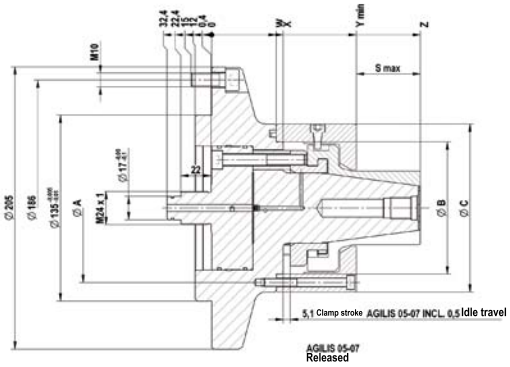
CUSTOMER BENEFITS

- Short setup and non-productive times thanks to great expansion of segment sleeves
- Vibration damping due to high vulcanized rubber component of clamping sleeves
- Sturdy clamping of the workpiece thanks to axial tension against workpiece stop
- Fast change of segment sleeves thanks to central clamping screw
- High concentricity, axial run-out and repeatability

TECHNICAL FEATURES

- Manual lubrication
- Air sensing prepared





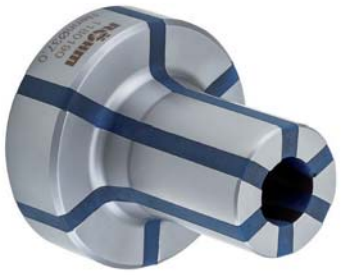
C 18

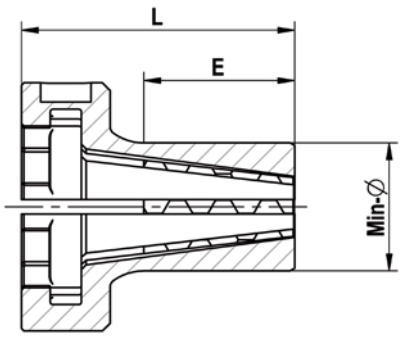
AGILIS Segment clamping mandrel

	AGILIS 00	AGILIS 01	AGILIS 02	AGILIS 03	AGILIS 04	AGILIS 05	AGILIS 06	AGILIS 07
Segment clamping mandrel	**1180000**	**1180001**	**1180002**	**1180003**	**1180004**	**1180005 ▲**	**1180006 ▲**	**1180007 ▲**
Basic mandrel	**1180010**	**1180011**	**1180012**	**1180013**	**1180014**	**1180015**	**1180016**	**1180017**
Adapter power operated	**1180030**	**1180030**	**1180032**	**1180032**	**1180034**	**1180035**	**1180036**	**1180037**
Bolt spacer	**1180060**	**1180060**	**1180062**	**1180063**	**1180064**	**1180065**	**1180066**	**1180066**
Retaining ring	**1180050**	**1180050**	**1180052**	**1180052**	**1180054**	**1180055**	**1180056**	**1180057**
F max, in kN	5	7,5	15	20	25	30	35	35
Max, total clamping force approx, kN	26	39	79	85	106	127	149	149
Min-Ø unclamped from	9,7	13,7	18,7	26,7	36,7	53,7	71,7	94,7
Min-Ø unclamped to	15,7	24,7	34,7	44,7	64,7	84,7	104,7	129,7
Pitch diameter A	54	54	69	69	88	108	127	152
Guide diameter B	42	42	56	56	75	96	114	135
Ø C mm	68	68	82	82	101	122	140	169
Ø D mm	12	12	17	17	17			
Ø E mm	M 16	M 16	M 24x1	M 24x1	M 24x1			
S max, mm	16,8	18,8	23,8	28,1	42,1	46,1	57,1	67,1
T mm	27,7	27,7	25,4	26,4	26,4			
U mm	17,7	17,7	15,4	16,4	16,4			
V mm	4,3	4,3	6,6	5,6	5,6			
W mm	41,5	41,5	52	51	52	47	49	49
X mm	46,5	46,5	57,2	56	57	52	54	54
Y min,	80	80	103	103	108	105	109	109
Z mm	96,8	98,8	126,8	131,1	150,1	151,1	166,1	176,1

▲ on request

Accessories AGILIS





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Segment clamping sleeves AGILIS

	AGILIS 00	AGILIS 01	AGILIS 02	AGILIS 03	AGILIS 04	AGILIS 05	AGILIS 06	AGILIS 07
Expansion in Ø mm	0,6	0,6	0,6	1,2	1,2	1,2	1,2	1,2
Total length L	38	40	52,5	57	76	82	95	105
Min-Ø mm	9,7	13,7	18,7	26,7	36,7	53,7	71,7	94,7
Segment sleeve	**1180100**	**1180120**	**1180140**	**1180170**	**1180190**	**1180220**	**1180250**	**1180290**
Work stop	1180400 ▲	1180420 ▲	1180440 ▲	1180470 ▲	1180490 ▲	1180520 ▲	1180550 ▲	1180590 ▲
Min-Ø mm	10,2	14,2	19,2	27,7	37,7	54,7	72,7	95,7
Segment sleeve	**1180101**	**1180121**	**1180141**	**1180171**	**1180191**	**1180221**	**1180251**	**1180291**
Work stop	1180401 ▲	1180421 ▲	1180441 ▲	1180471 ▲	1180491 ▲	1180521 ▲	1180551 ▲	1180591 ▲
Min-Ø mm	10,7	14,7	19,7	28,7	38,7	55,7	73,7	96,7
Segment sleeve	**1180102**	**1180122**	**1180142**	**1180172**	**1180192**	**1180222**	**1180252**	**1180292**
Work stop	1180402 ▲	1180422 ▲	1180442 ▲	1180472 ▲	1180492 ▲	1180522 ▲	1180552 ▲	1180592 ▲
Min-Ø mm	11,2	15,2	20,2	29,7	39,7	56,7	74,7	97,7
Segment sleeve	**1180103**	**1180123**	**1180143**	**1180173**	**1180193**	**1180223**	**1180253**	**1180293**
Work stop	1180403 ▲	1180423 ▲	1180443 ▲	1180473 ▲	1180493 ▲	1180523 ▲	1180553 ▲	1180593 ▲
Min-Ø mm	11,7	15,7	20,7	30,7	40,7	57,7	75,7	98,7
Segment sleeve	**1180104**	**1180124**	**1180144**	**1180174**	**1180194**	**1180224**	**1180254**	**1180294**
Work stop	1180404 ▲	1180424 ▲	1180444 ▲	1180474 ▲	1180494 ▲	1180524 ▲	1180554 ▲	1180594 ▲
Min-Ø mm	12,2	16,2	21,2	31,7	41,7	58,7	76,7	99,7
Segment sleeve	**1180105**	**1180125**	**1180145**	**1180175**	**1180195**	**1180225**	**1180255**	**1180295**
Work stop	1180405 ▲	1180425 ▲	1180445 ▲	1180475 ▲	1180495 ▲	1180525 ▲	1180555 ▲	1180595 ▲
Min-Ø mm	12,7	16,7	21,7	32,7	42,7	59,7	77,7	100,7
Segment sleeve	**1180106**	**1180126**	**1180146**	**1180176**	**1180196**	**1180226**	**1180256**	**1180296**
Work stop	1180406 ▲	1180426 ▲	1180446 ▲	1180476 ▲	1180496 ▲	1180526 ▲	1180556 ▲	1180596 ▲
Min-Ø mm	13,2	17,2	22,2	33,7	43,7	60,7	78,7	101,7
Segment sleeve	**1180107**	**1180127**	**1180147**	**1180177**	**1180197**	**1180227**	**1180257**	**1180297**
Work stop	1180407 ▲	1180427 ▲	1180447 ▲	1180477 ▲	1180497 ▲	1180527 ▲	1180557 ▲	1180597 ▲
Min-Ø mm	13,7	17,7	22,7	34,7	44,7	61,7	79,7	102,7
Segment sleeve	**1180108**	**1180128**	**1180148**	**1180178**	**1180198**	**1180228**	**1180258**	**1180298**
Work stop	1180408 ▲	1180428 ▲	1180448 ▲	1180478 ▲	1180498 ▲	1180528 ▲	1180558 ▲	1180598 ▲
Min-Ø mm	14,2	18,2	23,2	35,7	45,7	62,7	80,7	103,7
Segment sleeve	**1180109**	**1180129**	**1180149**	**1180179**	**1180199**	**1180229**	**1180259**	**1180299**
Work stop	1180409 ▲	1180429 ▲	1180449 ▲	1180479 ▲	1180499 ▲	1180529 ▲	1180559 ▲	1180599 ▲
Min-Ø mm	14,7	18,7	23,7	36,7	46,7	63,7	81,7	104,7
Segment sleeve	**1180110**	**1180130**	**1180150**	**1180180**	**1180200**	**1180230**	**1180260**	**1180300**
Work stop	1180410 ▲	1180430 ▲	1180450 ▲	1180480 ▲	1180500 ▲	1180530 ▲	1180560 ▲	1180600 ▲
Min-Ø mm	15,2	19,2	24,2	37,7	47,7	64,7	82,7	105,7
Segment sleeve	**1180111**	**1180131**	**1180151**	**1180181**	**1180201**	**1180231**	**1180261**	**1180301**
Work stop	1180411 ▲	1180431 ▲	1180451 ▲	1180481 ▲	1180501 ▲	1180531 ▲	1180561 ▲	1180601 ▲
Min-Ø mm	15,7	19,7	24,7	38,7	48,7	65,7	83,7	106,7
Segment sleeve	**1180112**	**1180132**	**1180152**	**1180182**	**1180202**	**1180232**	**1180262**	**1180302**
Work stop	1180412 ▲	1180432 ▲	1180452 ▲	1180482 ▲	1180502 ▲	1180532 ▲	1180562 ▲	1180602 ▲
Min-Ø mm		20,2	25,2	39,7	49,7	66,7	84,7	107,7
Segment sleeve		**1180133**	**1180153**	**1180183**	**1180203**	**1180233**	**1180263**	**1180303**
Work stop		1180433 ▲	1180453 ▲	1180483 ▲	1180503 ▲	1180533 ▲	1180563 ▲	1180603 ▲
Min-Ø mm		20,7	25,7	40,7	50,7	67,7	85,7	108,7
Segment sleeve		**1180134**	**1180154**	**1180184**	**1180204**	**1180234**	**1180264**	**1180304**
Work stop		1180434 ▲	1180454 ▲	1180484 ▲	1180504 ▲	1180534 ▲	1180564 ▲	1180604 ▲
Min-Ø mm		21,2	26,2	41,7	51,7	68,7	86,7	109,7
Segment sleeve		**1180135**	**1180155**	**1180185**	**1180205**	**1180235**	**1180265**	**1180305**
Work stop		1180435 ▲	1180455 ▲	1180485 ▲	1180505 ▲	1180535 ▲	1180565 ▲	1180605 ▲
Min-Ø mm		21,7	26,7	42,7	52,7	69,7	87,7	110,7
Segment sleeve		**1180136**	**1180156**	**1180186**	**1180206**	**1180236**	**1180266**	**1180306**
Work stop		1180436 ▲	1180456 ▲	1180486 ▲	1180506 ▲	1180536 ▲	1180566 ▲	1180606 ▲

▲ on request

Accessories AGILIS

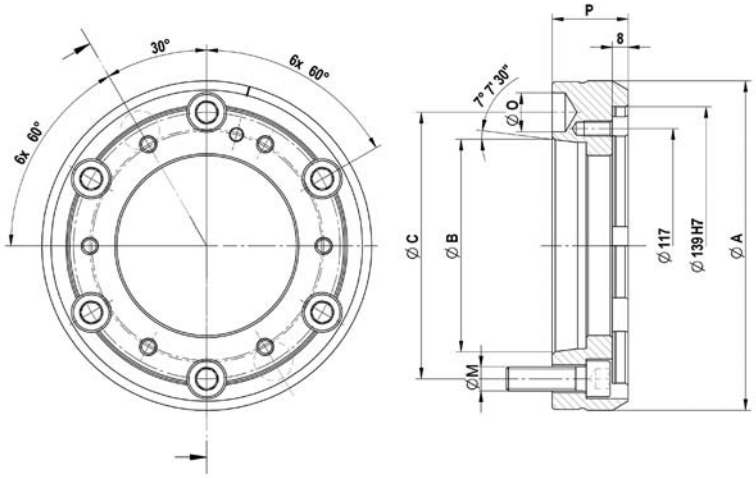
C18

Segment clamping sleeves AGILIS

	AGILIS 00	AGILIS 01	AGILIS 02	AGILIS 03	AGILIS 04	AGILIS 05	AGILIS 06	AGILIS 07
Expansion in Ø mm	0,6	0,6	0,6	1,2	1,2	1,2	1,2	1,2
Total length L	38	40	52,5	57	76	82	95	105
Min-Ø mm		22,2	27,2	43,7	53,7	70,7	88,7	111,7
Segment sleeve		**1180137**	**1180157**	**1180187**	**1180207**	**1180237**	**1180267**	**1180307**
Work stop		1180437 ▲	1180457 ▲	1180487 ▲	1180507 ▲	1180537 ▲	1180567 ▲	1180607 ▲
Min-Ø mm		22,7	27,7	44,7	54,7	71,7	89,7	112,7
Segment sleeve		**1180138**	**1180158**	**1180188**	**1180208**	**1180238**	**1180268**	**1180308**
Work stop		1180438 ▲	1180458 ▲	1180488 ▲	1180508 ▲	1180538 ▲	1180568 ▲	1180608 ▲
Min-Ø mm		23,2	28,2		55,7	72,7	90,7	113,7
Segment sleeve		**1180139**	**1180159**		**1180209**	**1180239**	**1180269**	**1180309**
Work stop		1180439 ▲	1180459 ▲		1180509 ▲	1180539 ▲	1180569 ▲	1180609 ▲
Min-Ø mm		23,7	28,7		56,7	73,7	91,7	114,7
Segment sleeve		**1180350**	**1180160**		**1180210**	**1180240**	**1180270**	**1180310**
Work stop		1180630 ▲	1180460 ▲		1180510 ▲	1180540 ▲	1180570 ▲	1180610 ▲
Min-Ø mm		24,2	29,2		57,7	74,7	92,7	115,7
Segment sleeve		**1180351**	**1180161**		**1180211**	**1180241**	**1180271**	**1180311**
Work stop		1180631 ▲	1180461 ▲		1180511 ▲	1180541 ▲	1180571 ▲	1180611 ▲
Min-Ø mm		24,7	29,7		58,7	75,7	93,7	116,7
Segment sleeve		**1180352**	**1180162**		**1180212**	**1180242**	**1180272**	**1180312**
Work stop		1180632 ▲	1180462 ▲		1180512 ▲	1180542 ▲	1180572 ▲	1180612 ▲
Min-Ø mm			30,2		59,7	76,7	94,7	117,7
Segment sleeve			**1180163**		**1180213**	**1180243**	**1180273**	**1180313**
Work stop			1180463 ▲		1180513 ▲	1180543 ▲	1180573 ▲	1180613 ▲
Min-Ø mm			30,7		60,7	77,7	95,7	118,7
Segment sleeve			**1180164**		**1180214**	**1180244**	**1180274**	**1180314**
Work stop			1180464 ▲		1180514 ▲	1180544 ▲	1180574 ▲	1180614 ▲
Min-Ø mm			31,2		61,7	78,7	96,7	119,7
Segment sleeve			**1180165**		**1180215**	**1180245**	**1180275**	**1180315**
Work stop			1180465 ▲		1180515 ▲	1180545 ▲	1180575 ▲	1180615 ▲
Min-Ø mm			31,7		62,7	79,7	97,7	120,7
Segment sleeve			**1180166**		**1180216**	**1180246**	**1180276**	**1180316**
Work stop			1180466 ▲		1180516 ▲	1180546 ▲	1180576 ▲	1180616 ▲
Min-Ø mm			32,2		63,7	80,7	98,7	121,7
Segment sleeve			**1180167**		**1180217**	**1180247**	**1180277**	**1180317**
Work stop			1180467 ▲		1180517 ▲	1180547 ▲	1180577 ▲	1180617 ▲
Min-Ø mm			32,7		64,7	81,7	99,7	122,7
Segment sleeve			**1180168**		**1180218**	**1180248**	**1180278**	**1180318**
Work stop			1180468 ▲		1180518 ▲	1180548 ▲	1180578 ▲	1180618 ▲
Min-Ø mm			33,2			82,7	100,7	123,7
Segment sleeve			**1180169**			**1180249**	**1180279**	**1180319**
Work stop			1180469 ▲			1180549 ▲	1180579 ▲	1180619 ▲
Min-Ø mm			33,7			83,7	101,7	124,7
Segment sleeve			**1180360**			**1180370**	**1180280**	**1180320**
Work stop			1180640 ▲			1180650 ▲	1180580 ▲	1180620 ▲
Min-Ø mm			34,2			84,7	102,7	125,7
Segment sleeve			**1180361**			**1180371**	**1180281**	**1180321**
Work stop			1180641 ▲			1180651 ▲	1180581 ▲	1180621 ▲
Min-Ø mm			34,7				103,7	126,7
Segment sleeve			**1180362**				**1180282**	**1180322**
Work stop			1180642 ▲				1180582 ▲	1180622 ▲
Min-Ø mm							104,7	127,7
Segment sleeve							**1180283**	**1180323**
Work stop							1180583 ▲	1180623 ▲
Min-Ø mm								128,7
Segment sleeve								**1180324**
Work stop								1180624 ▲
Min-Ø mm								129,7
Segment sleeve								**1180325**
Work stop								1180625 ▲

Accessories AGILIS

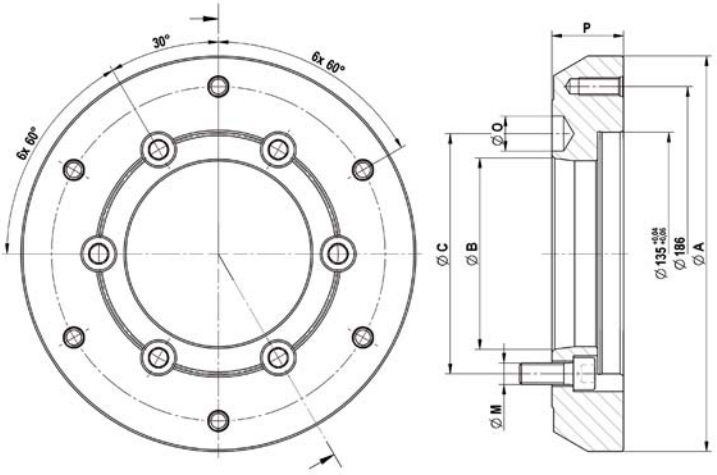




C 18
Intermediate flange ISO 702-1 (DIN 55028)
For size 00-04

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	**1110005**	**1110006**	**1110008**	**1110011 ▲**
Ø A mm	165	170	220	282
Ø B	82,563	106,375	139,719	196,869
Ø C mm	104,8	133,4	171,4	235
Thread-Ø M	M10	M12	M16	M20
Ø O mm	16,3	19,45	24,2	29,4
P mm	36	38	45	45



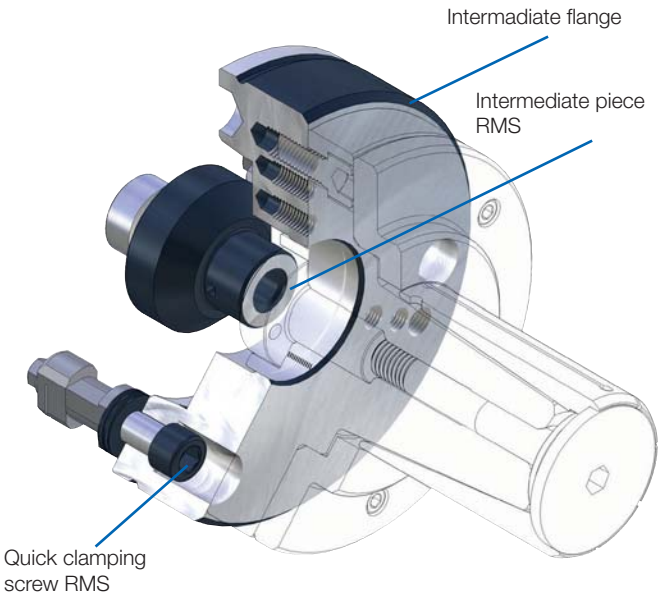


C 18
Intermediate flange ISO 702-1 (DIN 55028)

	Nr. 5 (A5)	Nr. 6 (A6)	Nr. 8 (A8)
Intermediate flange	**1072115**	**1072117**	**1072119**
For	KZF-S 80/AGILIS 05-07	KZF-S 120/AGILIS 05-07	KZF-S 120/AGILIS 05-07
Short-taper-Ø B	82,563	106,375	139,719
Short-taper pitch circle Ø C	104,8	133,4	171,4
Flange outer-Ø A	220	220	220
Ø D	135	135	135
Ø F mm	186	186	186
Ø O mm	16,3	19,45	24,2
Thread-Ø M	M10	M12	M16
Total length flange P	40	40	40

▲ on request

Accessories AGILIS



APPLICATION

For manual clamping devices exchange in a minimum of time.

TYPE

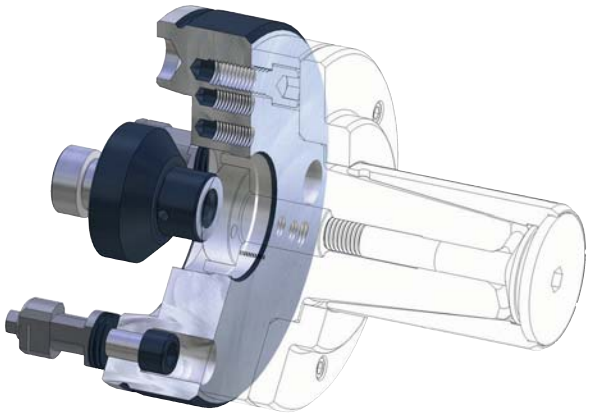
Manual quick-change system for clamping devices. Fits ABSIS (269-00), AGILIS (296-00). Central lubrication and / or air sensing control possible.

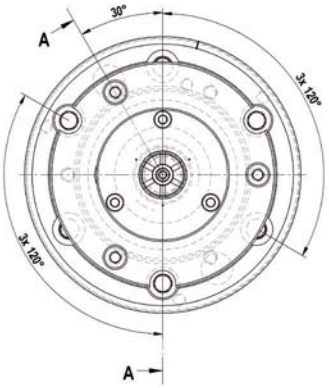
CUSTOMER BENEFITS

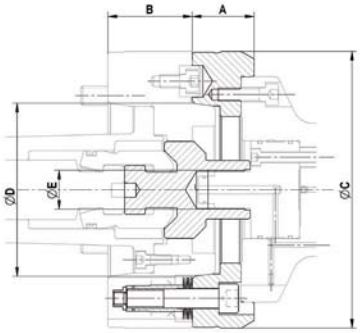
- Manual clamping devices change in about 30 seconds
- High repeatability within 0.005 mm
- Quick change of different clamping devices with short time, similar to the automatic or semiautomatic clamping devices changing systems

TECHNICAL FEATURES

- Quick-change system suitable due to recording RMS see quick-change system RMS (Product Group 6)
- Used in conjunction with RÖHM Safety clamping cylinder and OVS LVS the guidelines the Professional Association







C18

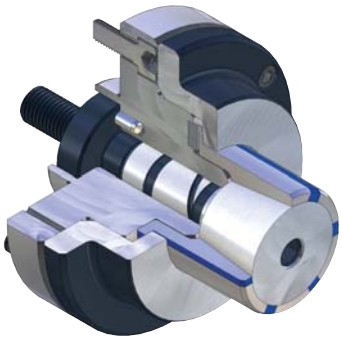
RMS quick-change system

	A 06	A 08
For	AGILIS 00-04 296-00	AGILIS 00-04 296-00
RMS - complete (flange incl, quick-clamping screw)	**1180340 ▲**	**1180342 ▲**
Adapters RMS	**look Type 296-00 AGILIS**	**look Type 296-00 AGILIS**
A	38	45
Ø B	170	215
Ø C	133,4	171,4
Ø D	106,375	139,719
Ø E mm	M12	M16
Ø F mm	139 H7	139 H7

Matching intermediate pieces RMS KK6 and RMS KK8 can be found directly in the product table of the segment clamping mandrel AGILIS type 296-00

KFR-SE





APPLICATION

Internal clamping of round workpieces. Turning, grinding and toothing operations, as well as for balancing and measuring.

TYPE

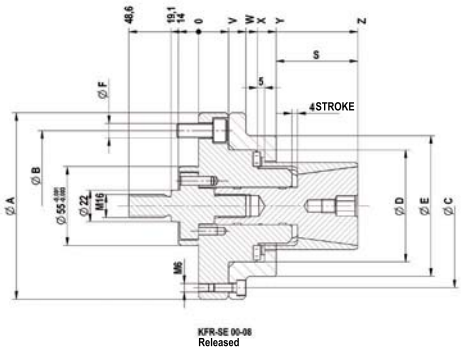
Force-actuated.Ideal for short clamping lengths / workpieces.

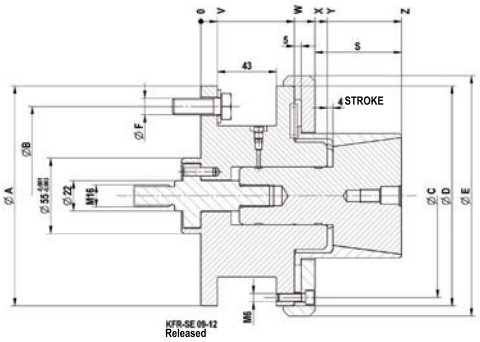
CUSTOMER BENEFITS

- Short setup and non-productive times thanks to great expansion of segment sleeves
- Vibration damping due to high vulcanized rubber component of the clamping sleeves
- No workpiece tension thanks to def. axial tension against the workpiece stop
- High concentricity, axial run-out and repeatability

TECHNICAL FEATURES

- Integrated lubrication
- Air sensing prepared





C18

KFR segment clamping mandrel, power-operated with flanged seat

consisting of basic body, clamping taper, intermediate piece, nut

	KFR 00	KFR 01	KFR 02	KFR 03	KFR 04	KFR 05	KFR 06	KFR 07	KFR 08	KFR 09	KFR 10	KFR 11	KFR 12
Segment clamping mandrel	**1171410**	**1171411**	**1171412**	**1171413**	**1171414**	**1171415**	**893966 ▲**	**893967 ▲**	**893968 ▲**	**893969 ▲**	**893970 ▲**	**893971 ▲**	**893972 ▲**
Base bolt	**893800**	**893801**	**893802**	**893803**	**893804**	**893805**	**893806 ▲**	**893807 ▲**	**893807 ▲**	**893809 ▲**	**893809 ▲**	**893809 ▲**	**893809 ▲**
Clamping taper	**1171436**	**1171437**	**1171438**	**1171439**	**1171440**	**1171441**	**650346 ▲**	**650347 ▲**	**650348 ▲**	**650349 ▲**	**650350 ▲**	**650351 ▲**	**650352 ▲**
Adapter power operated	**1199848**	**1199849**	**1199850**	**893819**	**893820**	**893820**	**893821**	**893822**	**893822**	**893822**	**893822**	**893822**	**893822**
Nut	**893814**	**893814**	**893814**										
F max, in kN	4,65	13,1	19,5	24,4	26,8	33	33	33	33	33	33	33	33
Max, total clamping force	20	56	83	104	114	140	140	140	140	140	140	140	140
Min-Ø unclamped from	14,2	19,7	24,7	35,7	40,7	50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7
Min-Ø unclamped to	19,7	24,7	35,7	40,7	50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7	130,7
Clamping-Ø max,	20,7	25,7	36,7	41,7	51,7	61,7	71,7	81,7	91,7	101,7	111,7	121,7	131,7
External-Ø A	100	100	100	100	130	130	130	160	160	160	160	160	160
Pitch diameter B	75	75	75	75	105	105	105	130	130	130	130	130	130
Pitch diameter C	85	85	85	85	114	114	114	145	145	148	148	148	148
Ø D mm	50	50	50	50	78	78	78	100	100	160	160	160	160
Ø E mm	70	70	70	70	98	98	98	130	130	175	175	175	175
Ø F mm	M10	M10	M10	M10	M10	M10	M10	M12	M12	M12	M12	M12	M12
S mm	21	27	27	27	42	42	57	55	55	63	63	63	63
V mm	21	21	21	21	21	21	21	32	32	12	12	12	12
W mm	33	33	33	33	33	33	33	50	50	68	68	68	68
X mm	39	39	39	39	41	41	41	58	58	83	83	83	83
Y mm	50	52	52	52	54	54	54	73	73	92	92	92	92
Z mm	71	79	79	79	96	96	111	128	128	146	146	146	146

▲ on request

MFR-SE



APPLICATION

Internal clamping of round workpieces. Turning, grinding and toothing operations, as well as for balancing and measuring.
Ideal for short clamping lengths / workpieces.

TYPE

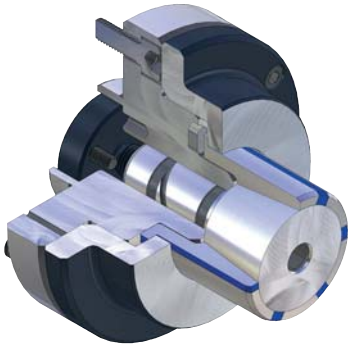
Manually actuated.
With vulcanized clamping sleeves / segment sleeves

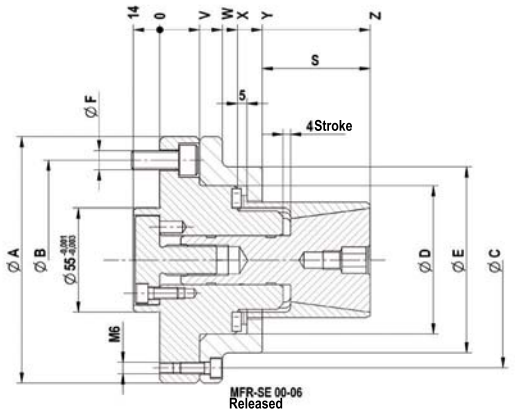
CUSTOMER BENEFITS

- No workpiece tension thanks to def. axial tension against the workpiece stop
- High concentricity, axial run-out and repeatability
- Low-maintenance

TECHNICAL FEATURES

- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared



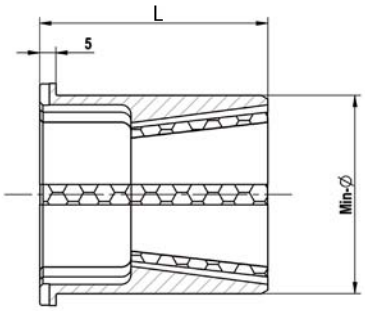


C18
MFR segment clamping mandrel, hand-operated with flanged seat
consisting of basic body, clamping taper, intermediate piece

	MFR 00	MFR 01	MFR 02	MFR 03	MFR 04	MFR 05	MFR 06
Segment clamping mandrel	**1171423**	**1171424**	**1171425**	**1171426**	**1171427**	**1171428**	**1077706 ▲**
Base bolt	**893800**	**893801**	**893802**	**893803**	**893804**	**893805**	**893806 ▲**
Clamping taper	**1171436**	**1171437**	**1171438**	**1171439**	**1171440**	**1171441**	**650346 ▲**
Adapter hand-operated	**893823**	**893824**	**893825**	**893826**	**893827**	**893827**	**893828**
Md max, kN	4	5	20	40	55	60	85
Min-Ø unclamped from	14,7	19,7	24,7	35,7	40,7	50,7	60,7
Min-Ø unclamped to	19,7	24,7	35,7	40,7	50,7	60,7	70,7
Clamping-Ø max,	20,7	25,7	36,7	41,7	51,7	61,7	71,7
External-Ø A	100	100	100	100	130	130	130
Pitch diameter B	75	75	75	75	105	105	105
Pitch diameter C	85	85	85	85	114	114	114
Ø D mm	50	50	50	50	78	78	78
Ø E mm	70	70	70	70	98	98	98
Ø F mm	M10	M10	M10	M10	M10	M10	M10
S mm	21	27	27	27	42	42	57
V mm	21	21	21	21	21	21	21
W mm	33	33	33	33	33	33	33
X mm	39	39	39	39	41	41	41
Y mm	50	52	52	52	54	54	54
Z mm	71	79	79	79	96	96	111

Accessories KFR-SE / MFR-SE





C18
Segment sleeve KFR / MFR

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1	1
Total length	32	40	40	40	55	55	70	70	70	78	78	78	78
Min-Ø mm	14,7	19,7	24,7	35,7	40,7	50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7
Segment sleeve	**1171000** ▲	**1171006** ▲	**1171012** ▲	**1171024** ▲	**1171030** ▲	**1171041** ▲	**1171052** ▲	**1171063** ▲	**1171074** ▲	**1171085** ▲	**1171096** ▲	**1171107** ▲	**1171118** ▲
Work stop	893830	893836	893842	893852	893857	893867	893878	893888	893897	893907	893917	893927	893937
Min-Ø mm	15,7	20,7	25,7	36,7	41,7	51,7	61,7	71,7	81,7	91,7	101,7	111,7	121,7
Segment sleeve	**1171001** ▲	**1171007** ▲	**1171013** ▲	**1171025** ▲	**1171031** ▲	**1171042** ▲	**1171053** ▲	**1171064** ▲	**1171075** ▲	**1171086** ▲	**1171097** ▲	**1171108** ▲	**1171119** ▲
Work stop	893831	893837	893842	893853	893858	893868	893879	893889	893898	893908	893918	893928	893938
Min-Ø mm	16,7	21,7	26,7	37,7	42,7	52,7	62,7	72,7	82,7	92,7	102,7	112,7	122,7
Segment sleeve	**1171002** ▲	**1171008** ▲	**1171014** ▲	**1171026** ▲	**1171032** ▲	**1171043** ▲	**1171054** ▲	**1171065** ▲	**1171076** ▲	**1171087** ▲	**1171098** ▲	**1171109** ▲	**1171120** ▲
Work stop	893832	893838	893843	893854	893859	893869	893880	893890	893899	893909	893919	893929	893939
Min-Ø mm	17,7	22,7	27,7	38,7	43,7	53,7	63,7	73,7	83,7	93,7	103,7	113,7	123,7
Segment sleeve	**1171003** ▲	**1171009** ▲	**1171015** ▲	**1171027** ▲	**1171033** ▲	**1171044** ▲	**1171055** ▲	**1171066** ▲	**1171077** ▲	**1171088** ▲	**1171099** ▲	**1171110** ▲	**1171121** ▲
Work stop	893833	893839	893844	893855	893860	893870	893881	893891	893900	893910	893920	893930	893940
Min-Ø mm	18,7	23,7	28,7	39,7	44,7	54,7	64,7	74,7	84,7	94,7	104,7	114,7	124,7
Segment sleeve	**1171004** ▲	**1171010** ▲	**1171016** ▲	**1171028** ▲	**1171034** ▲	**1171045** ▲	**1171056** ▲	**1171067** ▲	**1171078** ▲	**1171089** ▲	**1171100** ▲	**1171111** ▲	**1171122** ▲
Work stop	893834	893840	893845	893856	893861	893871	893882	893892	893901	893911	893921	893931	893941
Min-Ø mm	19,7	24,7	29,7	40,7	45,7	55,7	65,7	75,7	85,7	95,7	105,7	115,7	125,7
Segment sleeve	**1171005** ▲	**1171011** ▲	**1171017** ▲	**1171029** ▲	**1171035** ▲	**1171046** ▲	**1171057** ▲	**1171068** ▲	**1171079** ▲	**1171090** ▲	**1171101** ▲	**1171112** ▲	**1171123** ▲
Work stop	893835	893841	893846	893856	893862	893872	893883	893893	893902	893912	893922	893932	893942
Min-Ø mm			30,7		46,7	56,7	66,7	76,7	86,7	96,7	106,7	116,7	126,7
Segment sleeve			**1171018** ▲		**1171036** ▲	**1171047** ▲	**1171058** ▲	**1171069** ▲	**1171080** ▲	**1171091** ▲	**1171102** ▲	**1171113** ▲	**1171124** ▲
Work stop			893847		893863	893873	893884	893894	893903	893913	893923	893933	893943
Min-Ø mm			31,7		47,7	57,7	67,7	77,7	87,7	97,7	107,7	117,7	127,7
Segment sleeve			**1171019** ▲		**1171037** ▲	**1171048** ▲	**1171059** ▲	**1171070** ▲	**1171081** ▲	**1171092** ▲	**1171103** ▲	**1171114** ▲	**1171125** ▲
Work stop			893848		893864	893874	893885	893895	893904	893914	893924	893934	893944
Min-Ø mm			32,7		48,7	58,7	68,7	78,7	88,7	98,7	108,7	118,7	128,7
Segment sleeve			**1171020** ▲		**1171038** ▲	**1171049** ▲	**1171060** ▲	**1171071** ▲	**1171082** ▲	**1171093** ▲	**1171104** ▲	**1171115** ▲	**1171126** ▲
Work stop			893849		893865	893875	893886	893947	893905	893915	893925	893935	893945
Min-Ø mm			33,7		49,7	59,7	69,7	79,7	89,7	99,7	109,7	119,7	129,7
Segment sleeve			**1171021** ▲		**1171039** ▲	**1171050** ▲	**1171061** ▲	**1171072** ▲	**1171083** ▲	**1171094** ▲	**1171105** ▲	**1171116** ▲	**1171127** ▲
Work stop			893850		893866	893876	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm			34,7		50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7	130,7
Segment sleeve			**1171022** ▲		**1171040** ▲	**1171051** ▲	**1171062** ▲	**1171073** ▲	**1171084** ▲	**1171095** ▲	**1171106** ▲	**1171117** ▲	**1171128** ▲
Work stop			893851		893867	893877	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm			35,7										
Segment sleeve			**1171023** ▲										
Work stop			893852										

▲ on request

Intermadiate flange KFR-SE / MFR-SE



APPLICATION

For adaption of cartridge mandrel KFR/MFR/KFR-SE/MFR-SE or KFS/MFS - on spindle head ISO 702-1 / ISO 702-3 (DIN 55021/55022/55026 and 55027).

TYPE

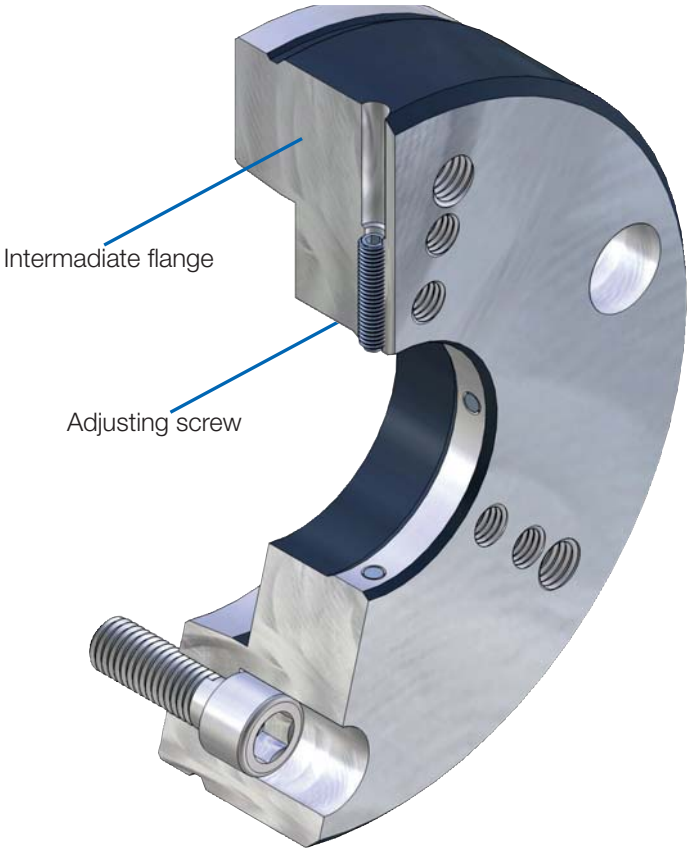
For KFR/MFR/KFR-SE/MFR-SE or KFS/MFS.

CUSTOMER BENEFITS

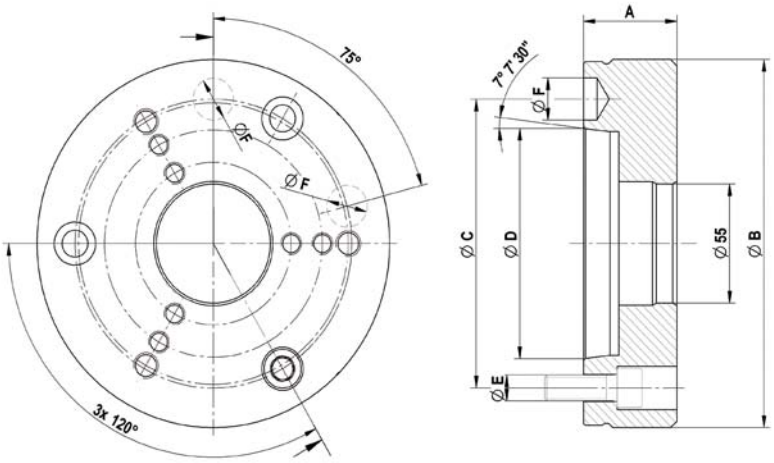
- By replacement of the Intermadiate flange, one cartridge mandrel can be used on different machines

TECHNICAL FEATURES

Adaptation of mandrel KFR / MFR / KFR-SE / MFR SE or KFS / MFS on spindle head, with or without adjustment, with or without operation of air-conditioning control. Execution according to ISO 702-1 (DIN 55028-A) or ISO 702-3 (DIN 55028-C), in size no. 5, no. 6, no. 8, no. 11 or no. 5, no. 6. Nr. 8 (A5, A6, A8, A11 or C5, C6, C8).

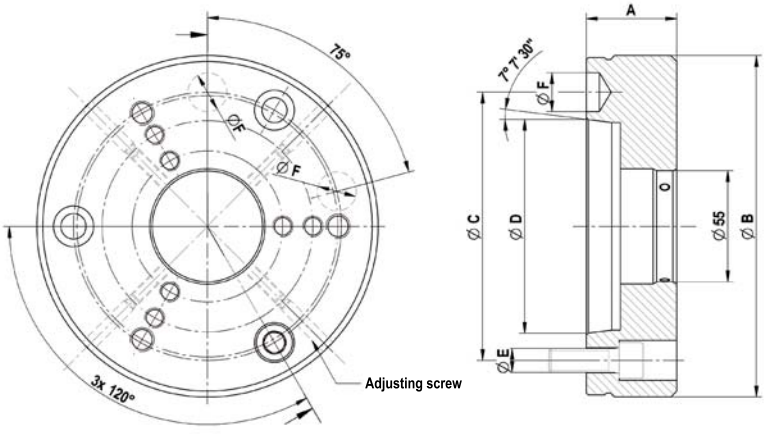


Accessories KFR-SE / MFR-SE



C 18
Intermediate flange ISO 702-1 (DIN 55026/55021) **without adjusting screw**

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	**893975**	**893976**	**893977**	**893978 ▲**
Design	without air-sensing	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50	50
Ø B	165	170	220	282
Ø C mm	104,8	133,4	171,4	235
Ø D mm	82,563	106,375	139,719	196,869
Ø E	M10	M12	M16	M20
Ø F mm	16,3	19,45	24,2	29,4

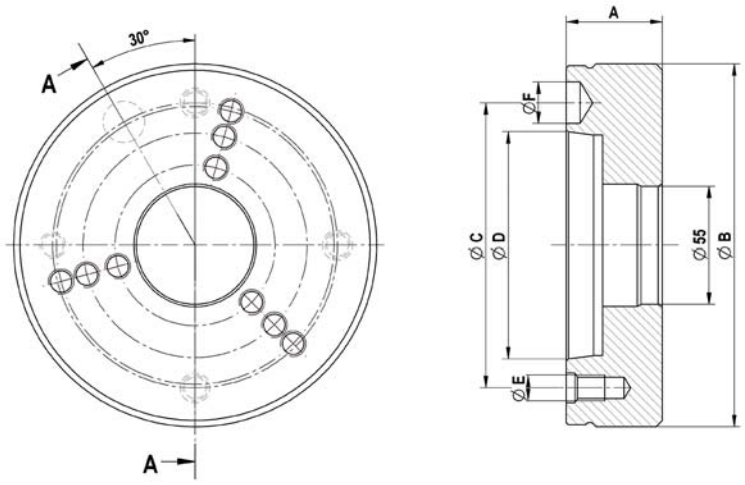


C 18
Intermediate flange ISO 702-1 (DIN 55026/55021) **with adjusting screw**

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)
Intermediate flange	**893979**	**893980**	**893981**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M10	M12	M16
Ø F mm	16,3	19,45	24,2

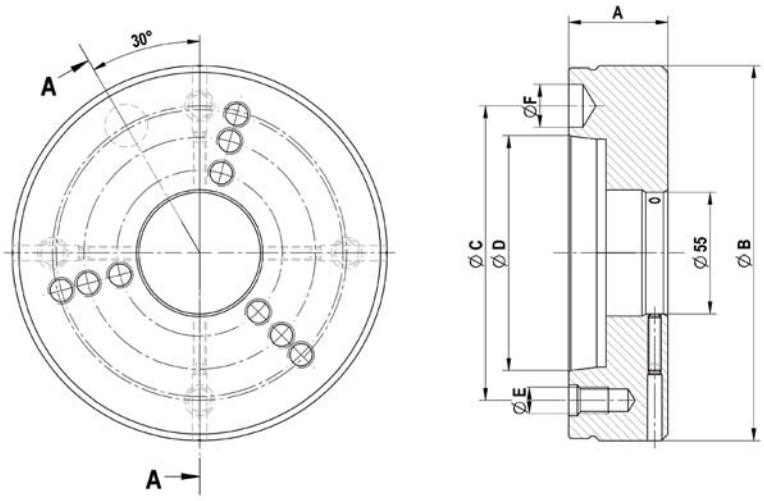
▲ on request

Accessories KFR-SE / MFR-SE



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) **without adjusting screws**

	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	**893982**	**893983**	**893984**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) **with adjusting screws**

	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	**893985**	**893986**	**893987**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2

Special solutions ABSIS

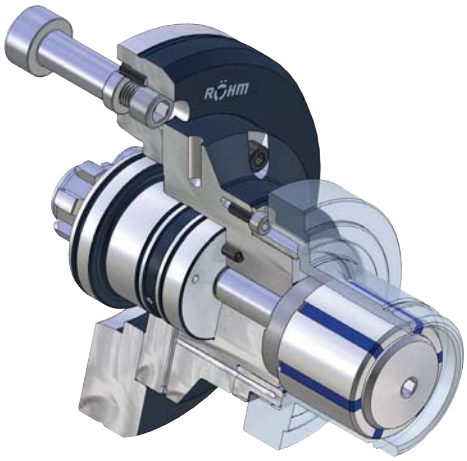


ABSIS Segment clamping mandrel - nominal 38,43 mm

APPLICATION
Cutting, Turning

ABSIS clamping mandrel for clamping on a toothing machine. The centering is done by the segment clamping sleeve; the clamping by the pendulum bell. Clamping mandrel with quick change system on the basic take-up.

CUSTOMER BENEFITS
- Stable clamping using axial pull
- Concentricity of 0.01 mm
- A lot of freedom of the tool (milling coasting)
- Designed for wet machining



ABSIS Segment clamping mandrel - nominal 60,5 mm

APPLICATION
Turning

ABSIS clamping mandrel for clamping on a lathe. Clamping mandrel with quick change system on the basic take-up. Fixed workpiece stop with air sensing. Clamping screw sunk in the segment clamping sleeve to ensure the freedom of the tool. Different clamping mandrel sizes of clamping diameters 25 mm to diameter 105 mm (ABSIS size 00 to size 04).

CUSTOMER BENEFITS
- Stable clamping using axial pull
- Concentricity of 0.01 mm
- Simple changing of the workpiece stop as well as the clamping sleeves
- A lot of freedom of the tool

Special solutions ABSIS

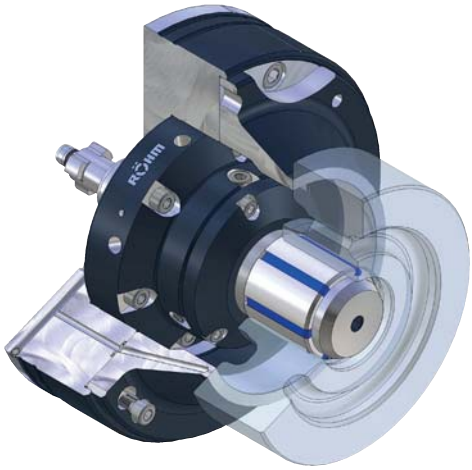


ABSIS Segment clamping mandrel TK-Ø 88 mm

APPLICATION
Turning

ABSIS clamping mandrel for clamp in the toothing. The toothed segment clamping sleeve clamps the workpiece exactly in the tooth flanks. The centering disc helps during loading of the workpiece. Workpiece stop can be pulled back using draw bar with air sensing.

CUSTOMER BENEFITS
- Freedom of tool by stop that can be pulled back
- Concentricity of 0.01 mm



ABSIS Segment clamping mandrel Ø 55,33 mm

APPLICATION
Turning of a gear wheel blank

Force-actuated ABSIS standard clamping mandrel with quick change system. The stop diameter is far beyond the clamping diameter. Workpiece stop with air sensing attached on the intermadiate flange.

CUSTOMER BENEFITS
- Stable clamping using axial pull
- Concentricity of 0.01 mm
- Low-cost thanks to standard components



FAST CHANGING WITHIN THE MODULAR SYSTEM



As a consistent modular system, it is possible to combine the individual components such as CAPTIS collet chuck, CAPTIS collet and ABSIS-C clamping mandrel depending on use.



Collet replacing
Fast and easy collet replacement in 15 seconds reduces the set-up times.

Changing collets and clamping mandrel
Innovative and patent-pending quick changing function for fast conversion from outer to inner clamping in less than one minute.

COLLET CHUCKS

The new and modular CAPTIS clamping system is impressive in both rotary applications in lathes and in stationary use in drilling, milling and machining centres and measuring machines. The conversion from outer to inner clamping can be done in less than 1 minute with the innovative and patent-pending quick changing function. The encompassing clamping enables precise concentricity and repeatability of 0.005 mm without deforming the workpiece.

ADVANTAGES AT A GLANCE

- Highest flexibility due to modular construction
- Precise concentricity and repeatability of 0.005 mm
- Compact and weight-reduced construction for a larger work area



Video CAPTIS-D



Video CAPTIS-MS

CAPTIS-D, CAPTIS-A, CAPTIS-AF

- Modular construction for highest flexibility
- Compact construction for more work space
- Many combination and conversion possibilities

CAPTIS-MS

- Simple handling: a turn of the wrench by a maximum of 180° en enough to clamp the collet or the clamping mandrel
- Can be clamped from three sides; can be optionally fitted with a with workpiece stop



ABSIS-C CLAMPING MANDREL

- Innovative and patent-pending quick changing function to convert from outer to inner clamping in less than one minute
- Stable and precise clamping by axial tension against the workpiece stop



CAPTIS COLLET CHUCKS

- Replaceable rubber segments made of innovative rubber mixture for the longest service life
- Clamping range of ± 0,5 mm
- Hardened and ground steel segments for high resistance to wear

CAPTIS-D



APPLICATION

For use on lathes.
Ideal for bars and pipe machining on the main spindle.

TYPE

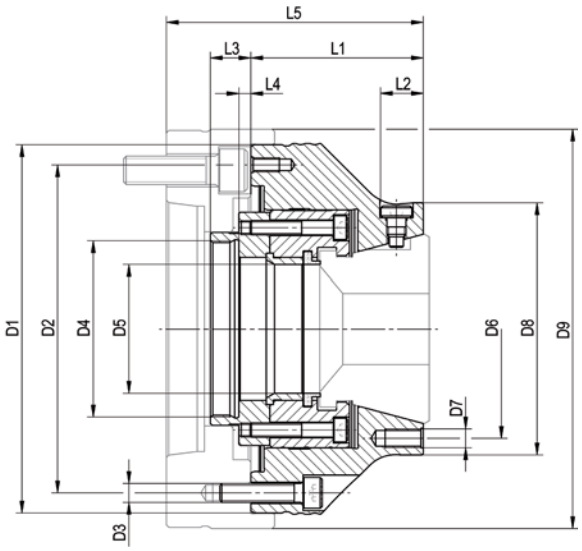
Force-actuated.
With through-hole for bar and pipe machining.
With axial tension.

CUSTOMER BENEFITS

- Maximum flexibility thanks to modular design and versatile combination and retrofitting options
- Low weight and low height thanks to compact design for more work area in the machine
- Short setup and non-productive times thanks to fast collect chuck change as well as great expansion of the collet chucks
- Fast retrofitting from external to internal clamping thanks to optionally available segment clamping mandrel ABSIS-C

TECHNICAL FEATURES

- Manual lubrication
- Collet chucks with exchangeable and oil-resistant vulcanized rubber



C15
CAPTIS-D collet chucks Axial pull

Size	32	42	52	65	80	100	120
Collet chucks	**1283101**	**1283102**	**1283103**	**1283104**	**1283105 ▲**	**1283106 ▲**	**1283107**
D1 mm	137	137	155	155	215	215	250
D2 mm	100	120	138	138	190	190	225
D3	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D4 mm	M54x1,5	M54x1,5	M74x1,5	M74x1,5	M94x1,5	M120x1,5	M132x1,5
D5	34	44	54	68	82	102	122
D6	70	92	92	110	132	190	225
D7	3x M8	3x M8	3x M8	3x M8	3x M10	3x M12	3x M12
D8	84	106	106	122	152	215	250
L1 mm	70,5	69	72,5	78	85	102	102
L2 mm	18	18	18	26	19	-	-
L3 mm	17	17	17	17	20	20	20
L4 min	1,5	1,5	1,5	1,5	-0,5	0,5	-0,5
L4 max	7,5	7,5	7,5	7,5	5,5	5,5	5,5
Total stroke mm	6	6	6	6	6	6	6
Maximum draw bar pull kN	25	35	40	45	50	65	70
Total clamping force kN	60	70	80	90	100	130	140
Speed max, min-1	8000	7000	6500	6000	5500	5000	4000
Chucking capacity mm	4-32	4-42	4-52	4-65	5-80	16-100	62-120
Clamping device manual	1283285	1283286	1283287	1283288	-	-	-
Clamping device air operated	431955	6898	436285	6898	1124	6352	6901
Conversion kit to CAPTIS-A	1283256	1283257	1283258	1283259	1283260	1283261	1283262
Turning fixture for soft collets	497314	497315	1053342	497316	497317	497318	497319

▲ on request

CAPTIS-A



APPLICATION

External clamping of round workpieces, as well as square and hexagon profiles.
Turning, milling, grinding operations as well as for measuring.
Ideal for machining insertion parts on the main spindle.

TYPE

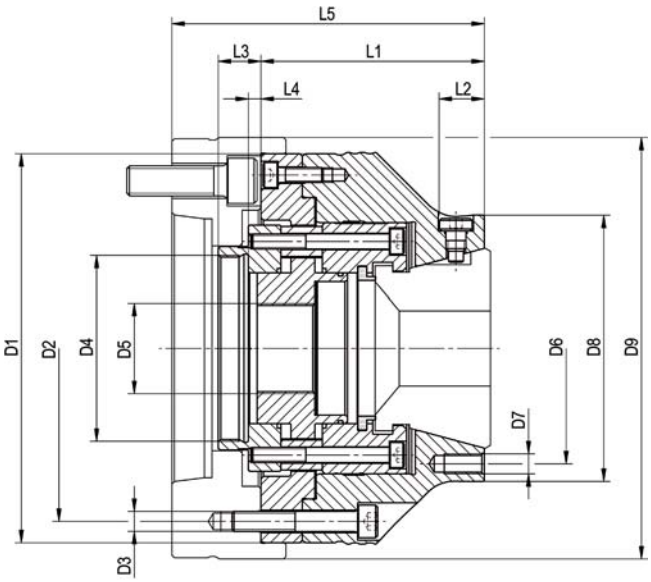
Force-actuated.
Optional through-hole for bar machining by removing the internal workpiece stop.
With axial tension against workpiece stop.

CUSTOMER BENEFITS

- Maximum flexibility thanks to modular design and versatile combination and retrofitting options
- Low weight and low height thanks to compact design for more work area in the machine
- Short setup and non-productive times thanks to fast collect chuck change as well as great expansion of the collet chucks
- Fast retrofitting from external to internal clamping thanks to optionally available segment clamping mandrel ABSIS-C
- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- Prepared for internal workpiece stop and front stop

TECHNICAL FEATURES

- Manual lubrication
- Collet chucks with exchangeable and oil-resistant vulcanized rubber



C 15

CAPTIS-A Collet chuck - With axial tension against workpiece stop

Size	32	42	52	65	80	100	120
Collet chucks	**1283108**	**1283109**	**1283110**	**1283111**	**1283112 ▲**	**1283113 ▲**	**1283114**
D1 mm	137	137	155	155	215	215	250
D2 mm	100	120	138	138	190	190	225
D3	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D4 mm	M54x1,5	M54x1,5	M74x1,5	M74x1,5	M94x1,5	M120x1,5	M132x1,5
D6	70	92	92	110	132	190	225
D7	3x M8	3x M8	3x M8	3x M8	3x M10	3xM12	3x M12
D8	84	106	106	122	152	215	250
L1 mm	84	82,5	89	94,5	103	122	122
L2 mm	18	18	18	16	19	-	-
L3 mm	17	17	17	17	20	20	20
L4 min	1,5	1,5	1,5	1,5	-0,5	-0,5	-0,5
L4 max	7,5	7,5	7,5	7,5	5,5	5,5	5,5
Total stroke mm	6	6	6	6	6	6	6
Maximum draw bar pull kN	25	35	40	45	50	65	70
Total clamping force kN	60	70	80	90	100	130	140
Speed max, min-1	8000	7000	6500	6000	5500	5000	4000
Chucking capacity mm	4-32	4-42	4-52	4-65	5-80	16-100	62-120
Clamping device manual	1283285	1283286	1283287	1283288	-	-	-
Clamping device air operated	431955	6898	436285	6898	1124	6352	6901
Conversion kit to CAPTIS-A	1283249	1283250	1283251	1283252	1283253	1283254	1283255
Turning fixture for soft collets	497314	497315	1053342	497316	497317	497318	497319

CAPTIS-AF



APPLICATION

External clamping of round workpieces, as well as square and hexagon profiles.
Turning, milling, grinding operations as well as for measuring.
Ideal for machining insertion parts on the main spindle.

TYPE

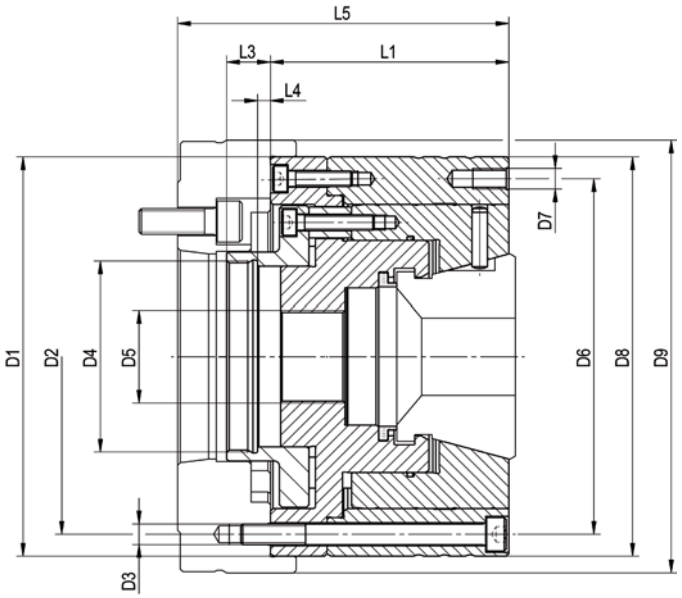
Force-actuated.
Optional through-hole for bar machining by removing the internal workpiece stop.
Axially stationary collect chuck, no axial tension against internal workpiece stop.

CUSTOMER BENEFITS

- Maximum flexibility thanks to modular design and versatile combination and retrofitting options
- Low weight and low height thanks to compact design for more work area in the machine
- Short setup and non-productive times thanks to fast collect chuck change as well as great expansion of the collet chucks
- No damage, impressions on workpieces due to axially stationary collect chuck
- Prepared for internal workpiece stop and front stop

TECHNICAL FEATURES

- Manual lubrication
- Collet chucks with exchangeable and oil-resistant vulcanized rubber

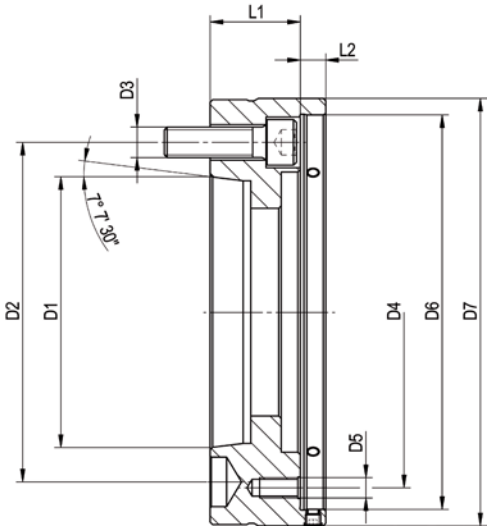


C 15
CAPTIS-AF collet chuck - Axially stationary collect chuck, no axial tension against internal workpiece stop

Size	32	42	52	65	80	100	120
Collet chucks	**1285001**	**1285002**	**1285003**	**1285004**	**1285005 ▲**	**1285006 ▲**	**1285007**
D1 mm	137	137	155	155	215	215	250
D2 mm	120	120	138	138	190	190	225
D3	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D4 mm	M48x1,5	M54x1,5	M74x1,5	M74x1,5	M120x1,5	M120x1,5	M132x1,5
D6	94	120	138	138	190	190	225
D7	3x M6	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8
D8	105	137	155	155	215	215	250
L1 mm	80,5	81	92,5	92,5	102	102	122
L2 mm	34,7	-	-	-	-	-	-
L3 mm	15,5	16	17	17	18,5	18,5	18,5
L4 min	-4	-2,5	2,5	2,5	-1	-1	-1
L4 max	2	3,5	8,5	8,5	5	5	5
Total stroke mm	6	6	6	6	6	6	6
Maximum draw bar pull kN	25	35	40	45	50	65	70
Total clamping force kN	60	70	80	90	100	130	140
Speed max, min-1	8000	7000	6500	6000	5500	5000	4000
Chucking capacity mm	4-32	4-42	4-52	4-65	5-80	16-100	62-120
Clamping device manual	1283285	1283286	1283287	1283288	-	-	-
Clamping device air operated	431955	6898	436285	6898	1124	6352	6901
Turning fixture for soft collets	497314	497315	1053342	497316	497317	497318	497319

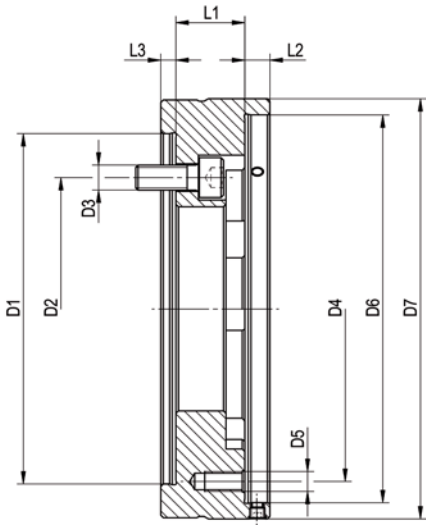
▲ on request

CAPTIS intermediate flange



Intermediate flange ISO 702-1 (DIN 55026/55021) **with adjusting screw**

Size	32/42-A5	32/42-A6	52/56-A5	52/65-A6	52/65-A8	80/100-A6	80/100-A8	120-A8	120-A11
Intermediate flange	**1283194**	**1283195**	**1283198**	**1283199**	**1283200**	**1283203 ▲**	**1283204 ▲**	**1283207**	**1283209**
D1 mm	82,563	106,375	82,563	106,375	139,719	106,375	139,719	139,719	196,869
D2 mm	104,8	133,4	104,8	133,4	171,4	133,4	171,4	171,4	235
D3	6x M10	3x M12	6x M10	3x M12	3x M16	6x M12	3x M16	6x M16	3x M20
D4 mm	100/120	100/120	138	138	138	190	190	225	225
D5	6x M8	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12	6x M12
D6	137	137	155	155	155	215	215	250	250
D7 mm	150	165	168	168	210	230	230	270	280
L1 mm	34,5	35,5	36	35,5	42	47	40	55	40
L2 mm	10	10	10	10	10	10	10	12	12



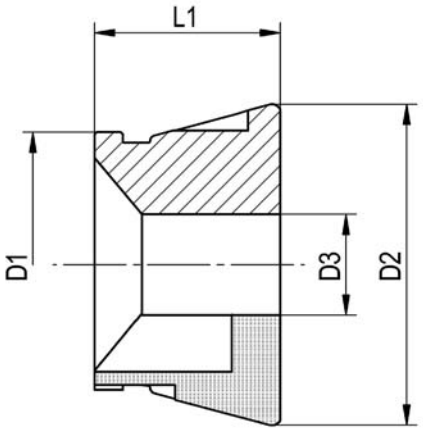
Intermediate flange cylindrical centre mount **with adjusting screw**

Size	32/42-Z140	52/65-Z140	52/65-Z170	80/100-Z170	80/100-Z220	120-Z220
Intermediate flange	**1283196**	**1283201**	**1283202**	**1283205 ▲**	**1283206 ▲**	**1283208**
D1 mm	140	140	170	170	220	220
D2 mm	104,8	104,8	133,4	133,4	171,4	171,4
D3	6x M10	6x M10	6x M12	6x M12	6x M16	6x M16
D4 mm	100/120	138	138	190	190	225
D5	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D6	137	155	155	215	215	250
D7 mm	150	168	180	230	230	270
L1 mm	19,5	27,5	22,5	47	40	55
L2 mm	10	10	10	10	10	12
L3 mm	6	6	6	6	6	6

▲ on request

CAPTIS collet chucks





(G): Smooth — from 4-7 mm smooth
(LQ): Longitudinal and transverse grooves — from 8-10 mm with trans. grooves
(Q): Transverse grooves — caused by production
(W): Soft
* Please specify clamping diameters D3 in the order, valid for collet chucks type LQ + Q

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
32	46,2	57,7	47	X				8-32mm			1	CAPTIS-32-47-RLQ / D3*
32	46,2	57,7	47		X				7-27mm		1	CAPTIS-32-47-SQ / D3*
32	46,2	57,7	47		X					7-22mm	1	CAPTIS-32-47-VQ / D3*

Clamping of unmachined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
32	46,2	57,7	44			X		4-32mm			1	CAPTIS-32-44-RG / D3*
32	46,2	57,7	44				X	5,15,20mm			1	CAPTIS-32-44-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
42	54	79,5	47	X				8-42mm			0,5	CAPTIS-42-47-RLQ / D3*
42	54	79,5	47		X				7-36mm		1	CAPTIS-42-47-SQ / D3*
42	54	79,5	47		X					7-30mm	1	CAPTIS-42-47-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
42	54	79,5	42			X		4-42mm			0,5	CAPTIS-42-42-RG / D3*
42	54	79,5	42				X	8,15,30mm			0,5	CAPTIS-42-42-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
52	65,7	79,5	46	X				8-52mm			0,5	CAPTIS-52-46-RLQ / D3*
52	65,7	79,5	46		X				7-45mm		1	CAPTIS-52-46-SQ / D3*
52	65,7	79,5	46		X					8-36mm	1	CAPTIS-52-46-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
52	65,7	79,5	46			X		4-52mm			0,5	CAPTIS-52-46-RG / D3*
52	65,7	79,5	46				X	8,15,30mm			0,5	CAPTIS-52-46-WG / D3*

▲ on request

CAPTIS collet chucks

(G): Smooth — from 4-7 mm smooth
(LQ): Longitudinal and transverse grooves — from 8-10 mm with trans. grooves
(Q): Transverse grooves — caused by production
(W): Soft
* Please specify clamping diameters D3 in the order, valid for collet chucks type LQ + Q

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
65	80	99,5	58	X				8-65mm			0,5	CAPTIS-65-58-RLQ / D3*
65	80	99,5	58		X				7-56mm		1	CAPTIS-65-58-SQ / D3*
65	80	99,5	58		X					7-46mm	1	CAPTIS-65-58-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
65	80	99,5	53			X		8-65mm			0,5	CAPTIS-65-53-RG / D3*
65	80	99,5	53				X	8,20,40mm			0,5	CAPTIS-65-53-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
80	94,5	114,5	53	X				5-80mm			1	CAPTIS-80-53-RLQ / D3*
80	94,5	114,5	53		X				7-68mm		1	CAPTIS-80-53-SQ / D3*
80	94,5	114,5	53		X					8-42mm	1	CAPTIS-80-53-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
80	94,5	114,5	53			X		5-80mm			1	CAPTIS-80-53-RG / D3*
80	94,5	114,5	53				X	20,30,40, 60mm			1	CAPTIS-80-53-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
100	121	144,5	59	X				42-100mm			1	CAPTIS-100-59-RLQ / D3*
100	121	144,5	59		X				50-86mm		1	CAPTIS-100-59-SQ / D3*
100	121	144,5	59		X					50-70mm	1	CAPTIS-100-59-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
100	121	144,5	59			X		42-100mm			1	CAPTIS-100-59-RG / D3*
100	121	144,5	59				X	30,45,65, 90mm			1	CAPTIS-100-59-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
120	141,8	180	61	X				62-120mm			1	CAPTIS-120-61-RLQ / D3*
120	141,8	180	61		X				50-104mm		1	CAPTIS-120-61-SQ / D3*
120	141,8	180	61		X					50-85mm	1	CAPTIS-120-61-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
120	141,8	180	61			X		62-120mm			1	CAPTIS-120-61-RG/ D3*
120	141,8	180	61				X	65,90,110mm			1	CAPTIS-120-61-WG / D3*

CAPTIS-MS



APPLICATION

Manual/stationary external clamping of round workpieces, as well as square and hexagon profiles. Turning, milling, grinding operations as well as for measuring. Ideal for 5-sided machining.

TYPE

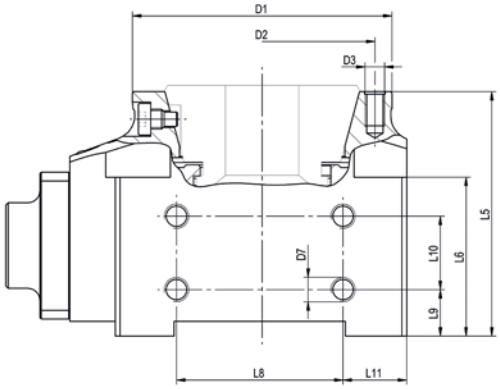
Manually actuated.
With axial tension against workpiece stop (as an option).

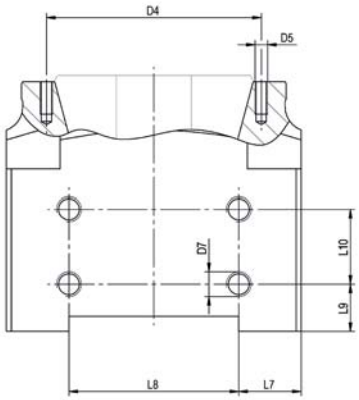
CUSTOMER BENEFITS

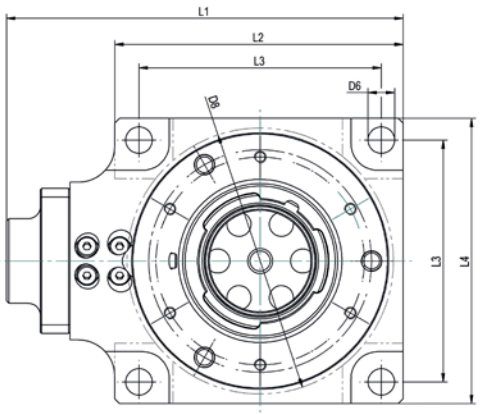
- Maximum flexibility thanks to modular design and versatile combination and retrofitting options
- Low weight and low height thanks to compact design for more work area in the machine
- Short setup and non-productive times thanks to fast collect chuck change as well as great expansion of the collet chucks
- Maximum clamping stroke/expansion by 180° rotation of the actuation key
- Prepared for internal workpiece stop and front stop
- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- Sensitive manual clamping with actuation key

TECHNCAL FEATURES

- Collet chucks with exchangeable and oil-resistant vulcanized rubber







C 15

CAPTIS-MS stationary power chuck

Size	32	42	52	65
Stationary power chucks	**1284189**	**1284190**	**1284191**	**1284192**
D1 mm	84	106	106	122
D2 mm	70	92	92	110
D3	M8	M8	M8	M8
D4 mm	66	86	86	107
D5	M5	M5	M5	M5
D6	11	11	11	11
L1 mm	145	162	162	176
L2 mm	105	117,5	117,5	130
L3 mm	80	100	100	112
L4 mm	100	118	118	130
L5	100	100	100	104
L6 mm	65	65	65	57

▲ on request

ABSIS-C



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring.
Rotational machining with adaptation to CAPTIS-D, CAPTIS-A.
Stationary machining with adaptation to CAPTIS-MS.
Ideal for clamping in through-holes.

TYPE

Manual with adaptation to CAPTIS-MS.
Force-actuation with adaptation to CAPTIS-D, CAPTIS-A.

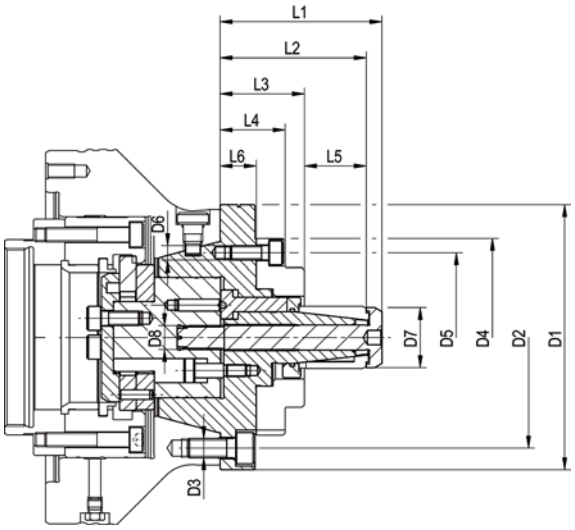
CUSTOMER BENEFITS

- Short setup and non-productive times thanks to great expansion of the segment sleeves
- Vibration damping due to high vulcanized rubber component of the clamping sleeves
- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- Fast change of segment sleeves thanks to central clamping screw
- High concentricity, axial run-out and repeatability
- Innovative quick-change function for fast retrofitting from external to internal clamping

TECHNICAL FEATURES

- Identical change parts as for standard segment clamping mandrel ABSIS

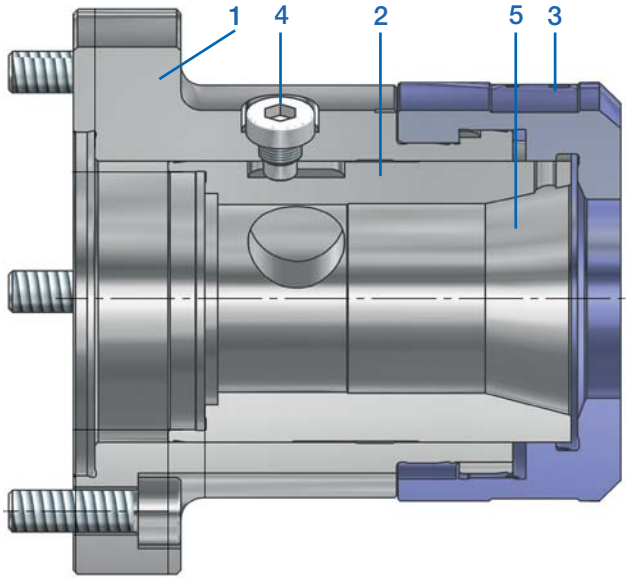




C 15
ABSIS-C Clamping mandrel

Size	ABSIS 00	ABSIS 00	ABSIS 00	ABSIS 00	ABSIS 01	ABSIS 01	ABSIS 01	ABSIS 01	ABSIS 02	ABSIS 02	ABSIS 02	ABSIS 03
Segment clamping mandrel	**1286200**	**1286201**	**1286202**	**1286203**	**1286204**	**1286205**	**1286206**	**1286207**	**1286208**	**1286209**	**1286210**	**1286211**
For	CAPTIS 32	CAPTIS 42	CAPTIS 52	CAPTIS 65	CAPTIS 32	CAPTIS 42	CAPTIS 52	CAPTIS 65	CAPTIS 42	CAPTIS 52	CAPTIS 65	CAPTIS 65
D Min-Ø unclamped from	19,7	19,7	19,7	19,7	25,7	25,7	25,7	25,7	35,7	35,7	35,7	50,7
D Min-Ø unclamped to	27,7	27,7	27,7	27,7	38,7	38,7	38,7	38,7	54,7	54,7	54,7	81,7
D1	88	108	110	128	88	108	110	128	110	110	128	128
D2	70	90	92	110	70	90	92	110	90	92	110	110
D3	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3xM8	3x M8	3x M8	3x M8
D4	82	82	82	82	82	82	82	82	97	97	97	102
D5	70	70	70	70	70	70	70	70	84	84	84	89
D6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6
D7	19	19	19	19	25	25	25	25	35	35	35	48
D8	M6x0,75	M6x0,75	M6x0,75	M6x0,75	M10x1	M10x1	M10x1	M10x1	M14x1	M14x1	M14x1	M18x1
L1	62,2	62,2	62,2	62,2	67,2	67,2	67,2	67,2	95,2	95,2	95,2	105,2
L2	56,7	56,7	56,7	56,7	60,7	60,7	60,7	60,7	85	85	85	93,2
L3	35	35	35	35	35	35	35	35	42,5	42,5	42,5	44,5
L4	25	25	25	25	27	27	27	27	30,25	30,25	30,25	31,5
L5	21,7	21,7	21,7	21,7	25,7	25,7	25,7	25,7	42,5	42,5	42,5	48,7
L6	15	15	15	15	15	15	15	15	18	18	18	18,5

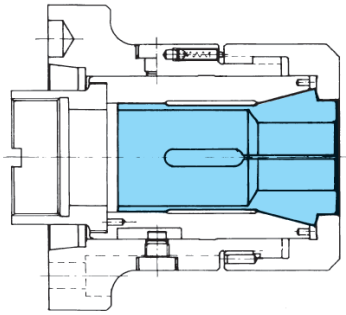
KZF



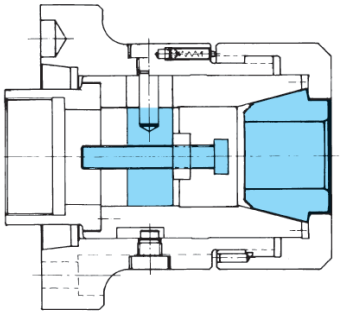
1. Body
2. Thrust sleeve for steel collets and segment collets. By replacing the thrust sleeve, duo-segment collets can be used
3. Union nut with bayonet lock
4. Protection against torsion for thrust sleeve

- Adapter fitting must be ordered separately. Suitable for existing draw tube, glue into thrust sleeve
- Special accessories; are not part of the scope of delivery. The workpiece stop can only be used for segment collets. Order separately: Cap screw or stud bolt with locknut acc. to DIN 55027.

5. Protection against torsion for collet



Hollow clamping with steel collet
DIN 6343



Clamping with segment pliers and
workpiece stop

KZF



APPLICATION

External clamping of round workpieces, as well as square and hexagon profiles.
Turning, milling, grinding operations as well as for measuring.
Ideal for bars and pipe machining on the main spindle. For using standardized DIN collet chucks or segment collet chucks.

TYPE

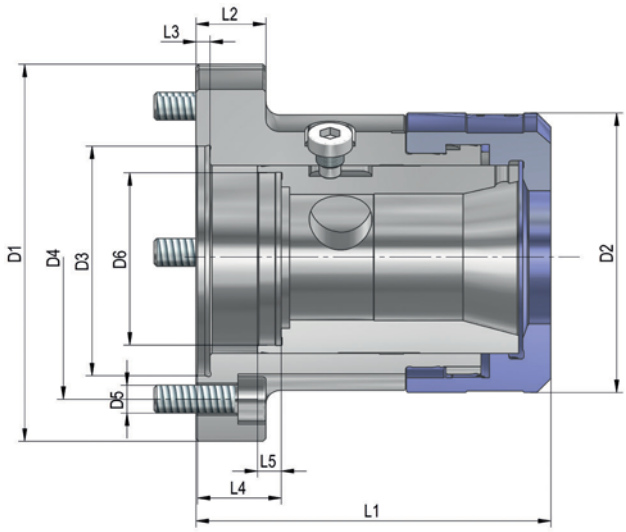
Force-actuated.
Internal workpiece stop. Optional in conjunction with segment collet.

CUSTOMER BENEFITS

- Light weight and reduced height thanks to compact design
- Short setup times thanks to quick change of collet chuck
- High flexibility thanks to modular system
- Quick retrofitting to other workpieces by changing the collect chuck
- Axially stationary collect chuck, no axial tension against internal workpiece stop

TECHNICAL FEATURES

- Hardened, low-wear design
- Either DIN steel or segment collet chucks



C 15
Power-operated collet chuck KZF, with quick-acting bayonet catch, without collet
Cylindrical center mount / short taper mount - Draw tube adapter available on request

Item no.	439989	439990	439991	439992	439993	439994	439995	439996	439997	439998
Size	40	40	40	40	60	60	60	60	80	80
Mount	Z-140	Z-88	KK 5	KK 6	Z-115	Z-170	KK 6	KK 8	Z-130	KK 8
D1	160	135	170	170	157	190	210	210	187	210
D2	100	100	100	100	122	122	122	122	150	150
D3	140	88	82,563	106,375	115	170	106,375	139,719	130	139,719
D4	104,8	115	104,8	133,4	136	133,4	133,4	171,4	166	171,4
D5	4xM10	6xM8	4xM10	4xM12	8xM8	6xM12	4xM12	4xM16	8xM8	4xM16
D6	M66x1,5	M66x1,5	M66x1,5	M66x1,5	M88x1,5	M88x1,5	M88x1,5	M88x1,5	M88x1,5	M114x1,5
L1	116	116	127	128	132	132	144	146	156	170
L2	25	25	25	25	25	25	25	25	30	30
L3	5	5	16	18	5	5	18	22	5	22
L4 min	16	16	32	33	16	16	33	35	17	36
L4 max	8,5	8,5	24,5	25,5	8,5	8,5	25,5	27,5	9,5	28,5
L5	8,5	8,5	8,5	8,5	8,5	8,5	8,5	8,5	12,5	12,5
Total stroke mm	7,5	7,5	7,5	7,5	7,5	7,5	7,5	7,5	7,5	7,5
Maximum draw bar pull kN	25	25	25	25	30	30	30	30	35	35
Total clamping force kN	50	50	50	50	60	60	60	60	70	70
Adm. speed min-1	8000	8000	8000	8000	5000	5000	5000	5000	4000	4000
Chucking capacity mm	2-42	2-42	2-42	2-42	4-60	4-60	4-60	4-60	20-80	20-80
Moment of inertia J kgm2	0,029	0,029	0,029	0,029	0,038	0,038	0,038	0,038	0,108	0,108
Weight without collet kg	7,1	5,3	7,5	7,5	9,2	9,2	10,2	14	17,5	18

Anti-Rotation device optionally available Id.-Nr. 701331

KZF-S



APPLICATION

External clamping of round workpieces with smooth or toothed outer geometry for turning, milling, grinding and measuring operations.
Optimal on the clamping device/clamping adapted to the workpiece/machining process. Ideal for short clamping lengths.

TYPE

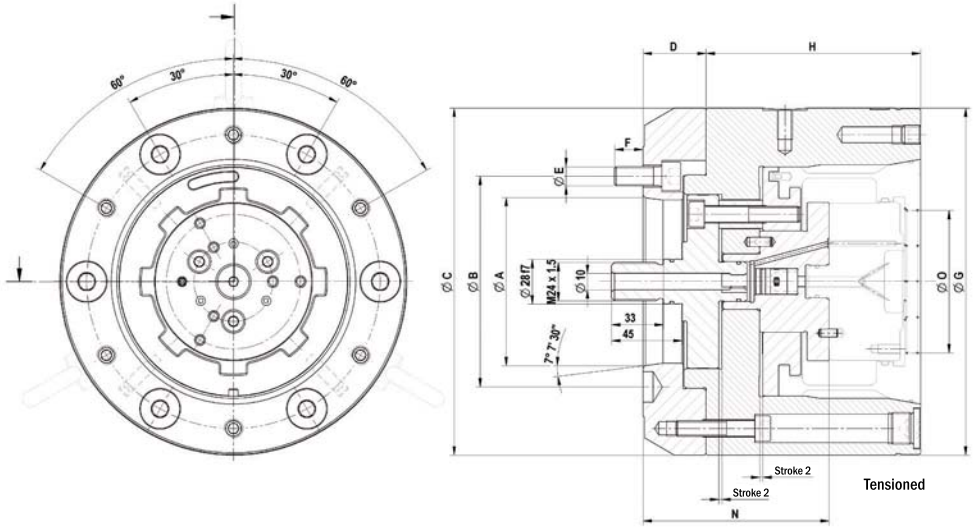
Force-actuated.

CUSTOMER BENEFITS

- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- Quick change of collet chuck by bayonet lock
- High concentricity, axial run-out and repeatability
- High flexibility thanks to modular system

TECHNICAL FEATURES

- Manual lubrication/low-maintenance
- Prepared for internal media feed-through, e.g. air and coolant
- Prepared for internal workpiece stop
- Collet chucks can be individually adapted to the workpiece
- Sealing against chips



C 18
Power operated collet chuck KZF-S for external clamping

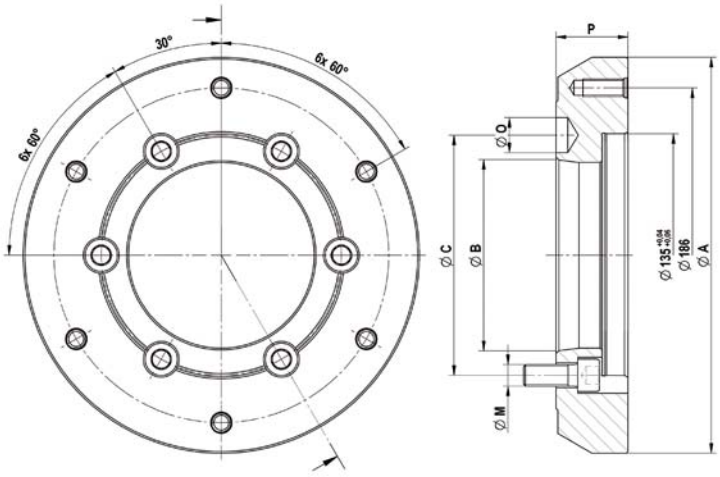
	KZF 80	KZF 120	KZF 180
Body collet	**1117832 ▲**	**1117830 ▲**	**1125403 ▲**
Base bolt	**1117833**	**1072101**	**1125404**
Draw piece	**1117837**	**1117827**	**1125408**
Fastening plate	**1117835**	**1072105**	**1125406**
Bolt spacer	**1117836**	**1072103**	**1072103**
Ground stop for reverse valve cartridge	**1117839**	**1072113**	**1125410**
Ground stop for ermeto pipe	**1117841**	**1117824**	**1125412**
Reverse valve cartridge 1 Bar	**756641**	**863134**	**863134**
Reverse valve cartridge 3 Bar	**843866**	**889894**	**889894**
A	82,563	106,37	139,719
B	104,8	133,4	171,4
C/G	170	220	258
D	35	40	45
E	M10	M12	M16
F Max, in daN	30	40	40
H	125	136	136
N	103	118	123
O	30-80	60-120	100-180
Speed max, min-1	6000	5000	3500
Stroke mm	4	4	4
Clamping dia, min,	30	60	100
Clamping dia, max,	80	120	180
Expansion in Ø mm	1,4	1,4	1,4
Ø G	170	220	285
H mm	125	136	136

Info: kzf@roehm.biz

▲ on request

Accessories KZF-S





C 18
Intermediate flange ISO 702-1 (DIN 55028)

	A 05	Nr. 5 (A5)	A 05	Nr. 6 (A6)	A 06	A 08	Nr. 8 (A8)	A 08
Intermediate flange	**1117843 ▲**	**1072115**	**1117845 ▲**	**1072117**	**1125416 ▲**	**1117847 ▲**	**1072119**	**1125418 ▲**
For	KZF-S 80	KZF-S 80/AGILIS 05-07	KZF-S 81	KZF-S 120/ AGILIS 05-07	KZF-S 180	KZF-S 82	KZF-S 120/ AGILIS 05-07	KZF -S 180
Short-taper-Ø B	82,563	82,563	106,375	106,375	106,375	139,719	139,719	139,719
Short-taper pitch circle Ø C	104,8	104,8	133,4	133,4	133,4	171,4	171,4	171,4
Flange outer-Ø A	170	220	170	220	285	210	220	285
Ø D	105	135	105	135	200	105	135	200
Ø F mm	143	186	143	186	250	143	186	250
Ø O mm	16,3	16,3	19,45	19,45	19,45	24,2	24,2	24,2
Thread-Ø M	M10	M10	M12	M12	M12	M16	M16	M16
Total length flange P	35	40	35	40	45	35	40	45

Special solutions KFG

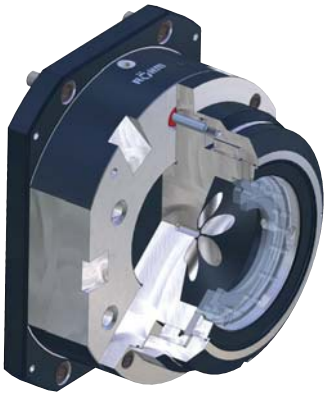


Sliding clamping mandrel KFG clamping-Ø 30 mm

APPLICATION
Turning of a differential housing

Clamping of a differential housing in two clamping planes. Diameter difference between the clamping planes are compensated. The workpiece stop is equipped with an air sensing. The entire clamping mandrel is sealed with purge air.

CUSTOMER BENEFITS
- Two compensating clamping planes
- Concentricity of 0.02 mm



Sliding clamping mandrel KFG clamping-Ø 155 mm / clamping-Ø 161 mm

APPLICATION
Drilling of two workpieces with different diameters

Clamping of two clamping planes that are very close together. Clamping of both clamping planes is done using springs. Pneumatic unclamping via a cylinder in the basic take-up. Compact, space-saving construction. Drain boreholes for coolant.

CUSTOMER BENEFITS
- Overall height less than 200 mm
- Concentricity of 0.03 mm



Sliding clamping mandrel KFG clamping range from 98-113 mm

APPLICATION
Turning of clamping cylinder liners, raw part

Left clamping plane force-actuated by draw bar. Right clamping plane spring-actuated; to compensate for workpiece tolerances. Stop can be pulled back. Different workpiece diameters can be clamped by changing the top jaws.

CUSTOMER BENEFITS
- Large clamping range elongation of 7 mm
- Large torque transmission from corrugation of the top jaws

Special solutions KFG



Sliding clamping mandrel KFG with intermediate sleeves Ø 104-120 mm

APPLICATION
Turning of clamping cylinder liners, final machining

Left clamping plane force-actuated by draw bar; right clamping plane force-actuated by tailstock. Stop can be pulled by with air sensing. Different workpiece diameters can be clamped by changing the intermediate sleeve.

CUSTOMER BENEFITS
- Intermediate sleeve can be changed
- High concentricity of 0.015 mm



Sliding clamping mandrel KFG clamping-Ø 39 mm / clamping-Ø 40 mm

APPLICATION
Turning

The clamping in clamping zone 1 is done by the draw bar with serrated jaws for high torque transmission. Clamping zone 2 is actuated by springs and is equipped with an intermediate sleeve.

CUSTOMER BENEFITS
- Intermediate sleeve protects the workpiece surface
- Concentricity of 0.01 mm

Special solution HYKS







Hydraulically actuated clamping mandrel for internal and external clamping

APPLICATION

Grinding, turning, milling, measuring

The hydraulic medium is put under pressure by a piston or by system pressure. The elongation can be up to 0.3 % (up to 1 % for special materials) of the diameter of the extension sleeve. Clamping directly by extension sleeve or indirectly by a slotted intermediate sleeve.

CUSTOMER BENEFITS

- Cylindrical and round elongation over the entire clamping range for a maximum concentricity tolerance of 0.003 mm
- Very high clamping force in the clamping zone
- Optimum damping, extremely quiet machining and significantly higher service life of the tool due to precisely fitted clamping sleeve

TECHNICAL FEATURES

Force-actuated or manual actuation. Wear-resistant surface.
The clamping systems can be put under pressure by hydraulic or pneumatic cylinders, by the machine hydraulics directly or even manually by using a screw. Different stops (optional): fixed, withdrawable, external, oscillating, etc.

Special solutions



Special mandrels

APPLICATION
Grinding, milling

Basic take-up with different replaceable head for clamping of pistons. Face clamping using internal draw piece. Position orientation using centering forks. An insertion securing device prevents incorrect loading. The actuation is done using OVS70 RÖHM clamping cylinders. The entire external contour can be machined.

CUSTOMER BENEFITS
- Clamping head with quick change system
- Concentricity of 0.005 mm



Clamping fixture

APPLICATION
Milling, drilling

Clamping device with three basic units. Pneumatically release clamping via spring force. Two basic units equipped with KFR clamping mandrels. A basic unit equipped with a power chuck.

CUSTOMER BENEFITS
- Basic units can be equipped with different clamping systems

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driven by technology

Id.-Nr. 1178267 / 0915 AU



TOOL CLAMPING SYSTEMS

2015/2016

RÖHM
driven by technology

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

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

Dynamism
Variety
Security
Partnership
Globality
Innovation

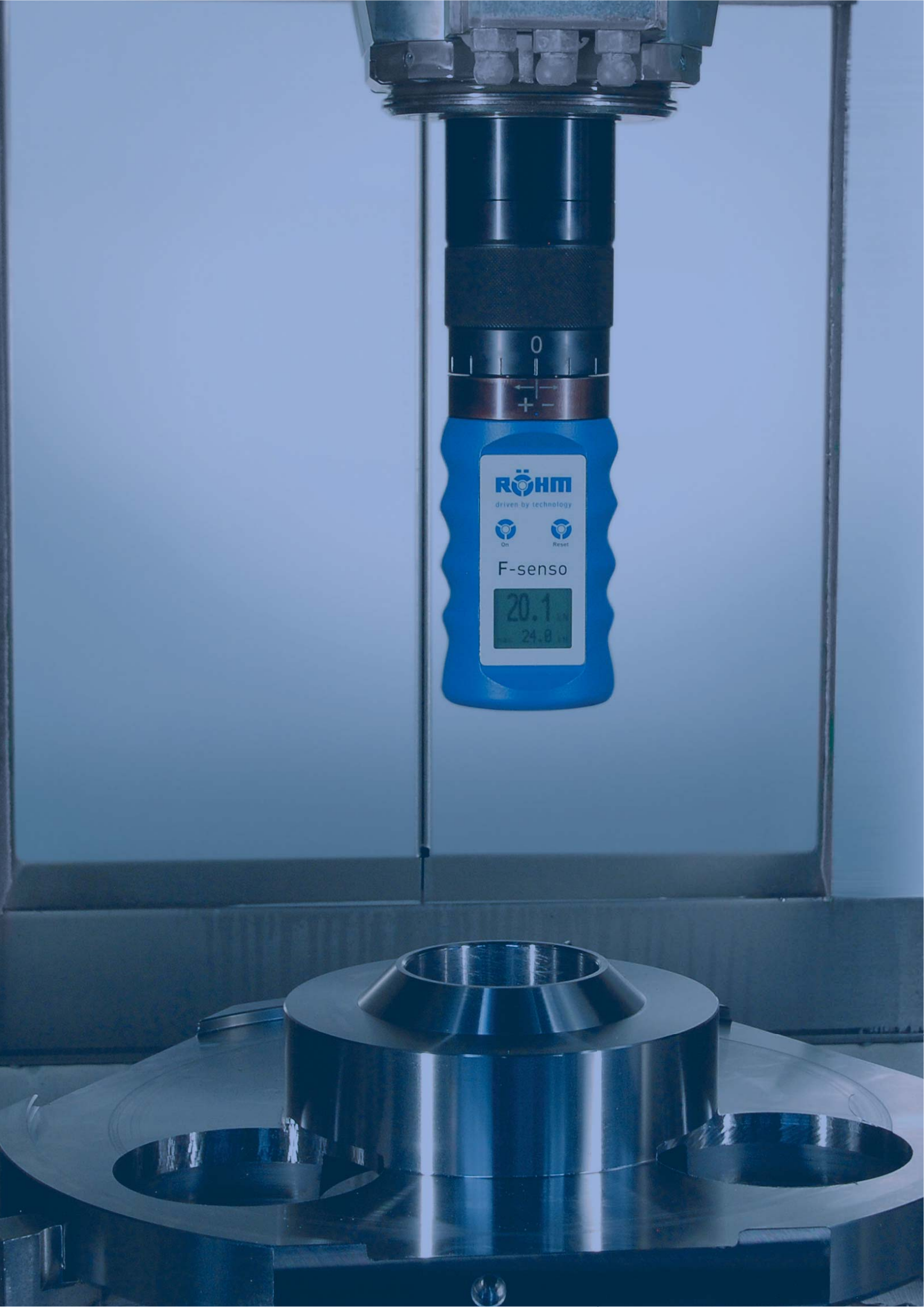

0
ROHM
driven by technology
On
Reset
F-senso
20.1
24.8



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Built-in clamping head RESK

Built-in clamping head RESK	8042

Errors and corrections are reserved!

Operation guide






TYP	HSK - Automatic clamping set	HSK - SUPER-LOCK	HSK - Manual clamping set	SK - Automatic tool clamping set
	Tool clamping system			
Interface	HSK	HSK	HSK	SK
Actuation				
Energy store				
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TYP	F-senso spindle	Clamping heads SPK	Built-in clamping head RESK
	Clamping force measuring device	Pallet clamping	For machine components
Interface	suitable for HSK, SK and SPK	SPK taper	universal interface
Actuation	-		
Energy store	-		
Page	8030	8036	8042

hydraulic

pneumatic

manual

hydraulic pressure

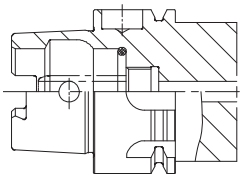
spring

self-locking interlock

Designs

Positive taper lock for automatic tool change

Form A / T

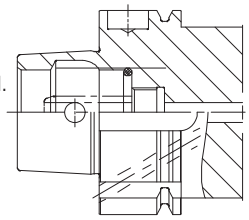


Positive taper lock (version A)
automatically-changeable tool adapter, torque transmission on positive taper lock, small square face with gripping channel.

Applications:
Machine tools (e.g. lathes, drilling and milling machines), high speed range, conventional material machining, torque transmission via milled driver within the spindle adapter.

Design T analog to desgin A, but limited backlash of the driver.

Form B

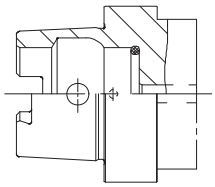


Positive taper lock (version B)
automatically-changeable tool adapter, torque transmission on collar via grooves, large square face with gripping channel.

Applications:
Machine tools (e.g. lathes, drilling and milling machines), medium speed range, heavy-duty material machining, torque transmission via driver keys, suitable for heavy-duty material machining (cutter heads).

Positive taper lock for manual tool change

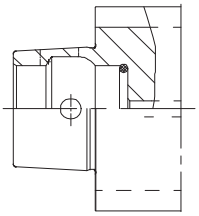
Form C



Positive taper lock (version C)
manually-changeable tool adapter, torque transmission on positive taper lock, small square face without gripping channel.

Applications:
Machine tools (e.g. lathes, drilling and milling machines), high speed range, conventional material machining, torque transmission via milled driver within the spindle adapter.

Form D

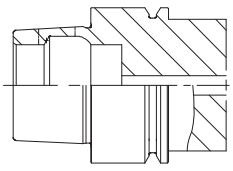


Positive taper lock (version D)
manually-changeable tool adapter, torque transmission on collar via grooves, large square face without gripping channel.

Applications:
Machine tools (e.g. lathes, drilling and milling machines), medium speed range, heavy-duty material machining, torque transmission via driver keys, suitable for heavy-duty material machining (cutter heads).

Positive taper lock for automatic tool change and for high speeds (HSC)

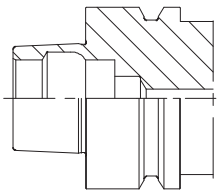
Form E



Positive taper lock (version E)
automatically-changeable tool adapter, torque transmission via collar and spherical surface, small square face with gripping channel.

Applications:
Machine tools (e.g. lathes, drilling and grinding machines), extremely high speed range (depending on diameter size), grinding work, wood machining, suitable for HSC, utilised for minimal material removal.

Form F



Positive taper lock (version F)
automatically-changeable tool adapter, torque transmission via collar and spherical surface, large square face with gripping channel.

Applications:
Machine tools (e.g. lathes, drilling and grinding machines), extremely high speed range (depending on diameter size), grinding work, wood machining, suitable for HSC, utilised for minimal material removal.



CONVINCING ACROSS THE BOARD

- - 27 % shorter installation length of clamping set for lower space requirement
- - 27 % shorter distance of plane face to clamping shoulder for compact force flow
- - 33 % lower spring force required for clamping
- + 39 % higher clamping force for safe and reliable clamping of the tools

- Standard DLC coating for longer service life
- Simple and fast installation of clamping sets due to connected segments
- Safe release and ejection due to forced guidance of clamping segments without additional spring elements

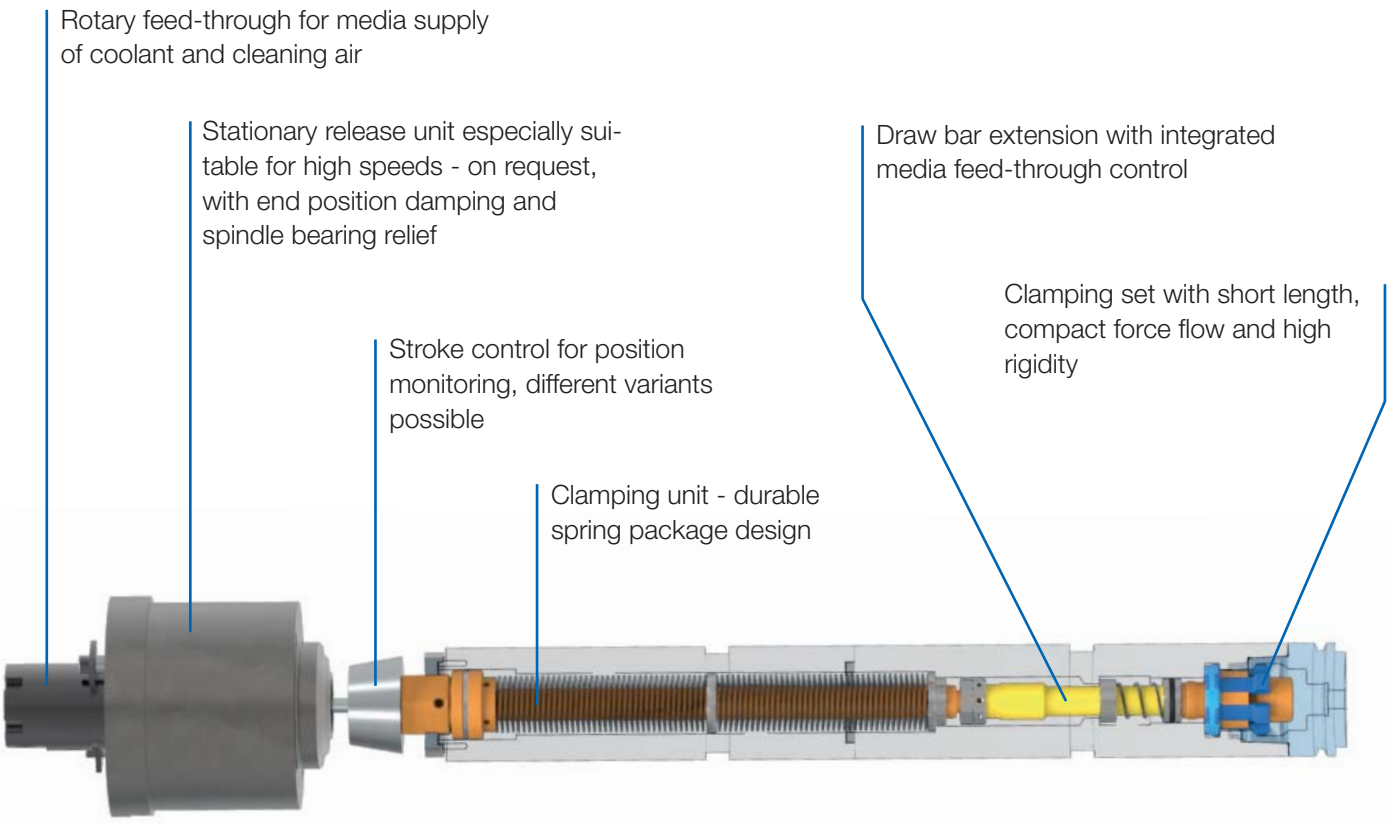
(Compared to the usual clamping systems of size HSK-A 63)

HSK - AUTOMATIC CLAMPING SET

Reliability, safety and long service life are the main requirements for a tool clamping system. It is also important for clamping systems to be able to be individually adapted to the customer requirements. Many years of experience as well as technical dominance in all areas allow RÖHM to meet these requirements exactly.

ADVANTAGES AT A GLANCE

- Proven functional principle for safe clamping and release of the tools
- 39 % higher clamping force than required in the standard
- Individual adaptation to customer-specific requirements



Technical data

For automatic tool clamping system of positive taper lock tools HSK to DIN 69893

ADVANTAGES:

- Steady clamping force due to the symmetric clamping surfaces of the clamping segments
- Compact power flow resulting in high static and dynamic rigidity of the tool joint
- High power amplification by transmission of the clamping set
- Self-locking effect via the clamping bolt in the clamping set
- Force controlled release of the collet
- Automatic ejection of the tool by the clamping bolt during release
- Sealed central coolant supply system
- Perfect suitable to be built into the spindles of machine tools and machining centers

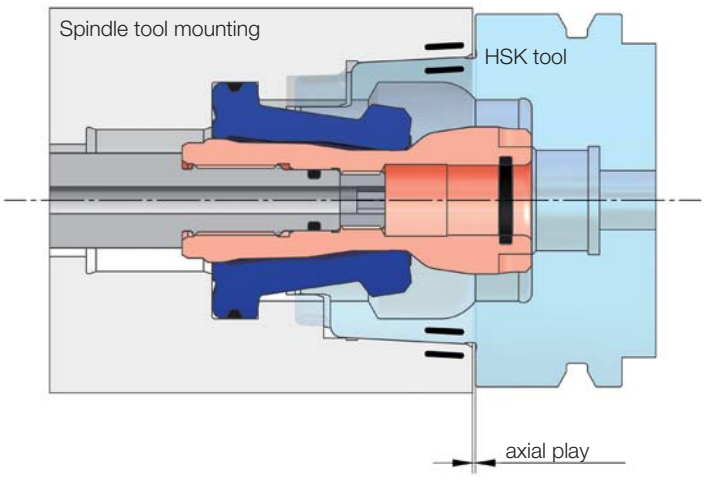
TECHNICAL FEATURES

The advantages of the positive taper lock system originates in the combination of defined radial pretensioned taper and tool face stop. A safe transmission of the torque is archieved by the elastic deformation of the taper resulting in a gap-free connection with the tool. High interchanging and repeating accuracy is leading to increased production quality during the machining compared with the traditional machining.

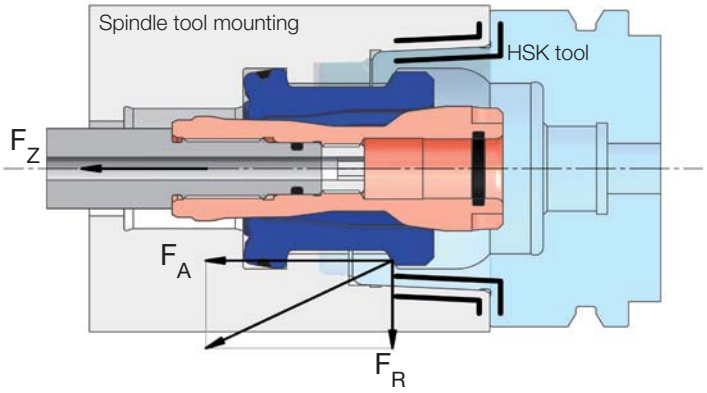
The clamping process is started by the springs and the movement is transmitted to the clamping set by the draw bar, in direction FZ. The clamping segments of the collet are pushed to the outside by the clamping bolt. The clamping forces are multiple amplified by the angled arrangement of the contact areas. The produced axial forces FA and radial forces FR result in a pretension of the positive taper on the entire taper area and, the axial contact area. The proportion of the axial contact force is over 80 % of the total clamping force. This explains the importance of the size of the axial contact area concerning the critical load and rigidity of the taper and hollow shank joint.
See also DIN 69893 - Hollow taper shanks types B, D and F. Hollow taper shanks types A and C have two additional positive drive grooves at the end of the taper which interlock with the tool mounting and produce a form-locking, orientated radial positioning.

During the release the tool will be positively unlocked and ejected from the tool spindle by the multifunctional clamping bolt and taper sleeve.

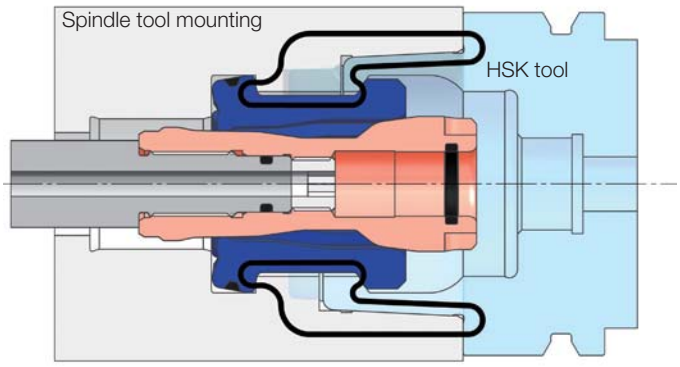
Joining position with locating surface



Clamping situation with locating surface



Clamping situation with compact power flow



Clamping set - High Speed



APPLICATION

Clamping set for HSK clamping systems is specially suited for high speeds.

TYPE

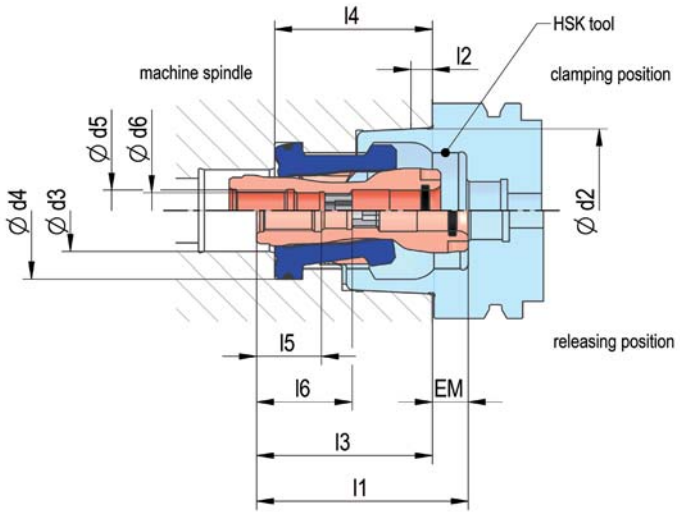
High Speed version for higher speeds due to exact guidance of the clamping segments.

CUSTOMER BENEFITS

- DLC coating guarantees a longer service life of the clamping set
- Short length for compact force flow and high rigidity
- High force amplification due to transmission in the clamping set
- Safe clamping and release of the tools
- High balancing quality maintained due to exact distribution and guidance of the collet chuck

TECHNICAL FEATURES

- Connected collet segments simplify installation



C 15

Automatic HSK-Clamping set with guided collet

Due to the exact guidance of the collet chuck segments, this clamping set is especially suitable for **higher speeds.**

Item no.	594332	1035347	1011063	1037501	1015151	474917	462324
Size HSK-A/C/E/T	25	32	40	50	63	80	100
Size HSK-B/D/F	32	40	50	63	80	100	125
Total stroke	7	9	13	15	14	17	18
Pull-out stroke AM	0,2	0,3	0,5	0,5	0,5	0,5	0,8
Taper Ø d2	19	24	30	38	48	60	75
d3	10	12	15	18	24	32	40
d4	17	21	25,5	32	40	50	63
d5	M4	M6x0,75	M8x1	M10x1	M12x1	M16x1,5	M20x1,5
d6	4,2	6,5	6,4	8	10,5	14,3	17,5
l1	28,8	35,1	42,5	50	62	80	98,5
l2	2,5	3,2	4	5	6,3	8	10
l3	22,6	26,7	34	39,5	51,5	67	85,2
l4	20,3	24,5	31,9	37,2	46,2	59,7	73
l5	9,5	12,5	13	17	19	30	34,5
l6	2,5	3	20	26	28	42	51
Adjusting size EM	6,2	8,3	8,5	10,5	10,5	13	13,3
Draw bar pull kN	0,7	1	2	3	4	7,5	10
Clamping force kN	3,5	5	10	15	25	37,5	50
Max. application speed min^{-1}	120000	80000	60000	50000	40000	30000	24000

Clamping set - Standard



APPLICATION

Standard clamping set for HSK clamping systems.

TYPE

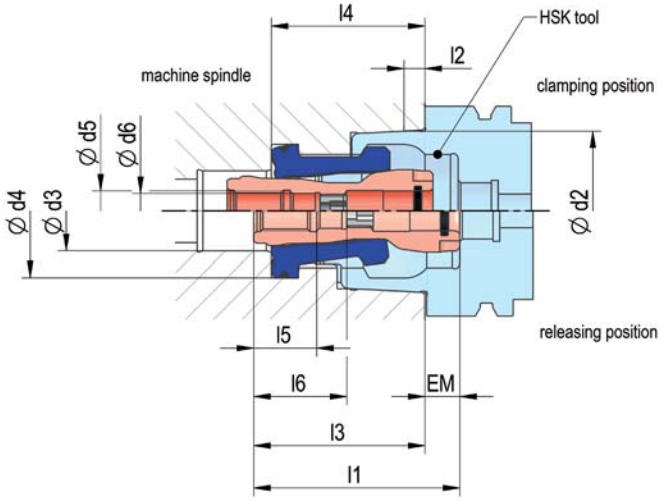
Standard version in compact design.

CUSTOMER BENEFITS

- DLC coating guarantees a longer service life of the clamping set
- Short length for compact force flow and high rigidity
- High force amplification due to transmission in the clamping set
- Safe clamping and release of the tools

TECHNICAL FEATURES

- Connected collet segments simplify installation



C 15

Automatic HSK-Clamping set - Standard in compact design

Item no.	1037445	1037446	1037447	1037448	1037449	1037450	1037451	1037452
Size HSK-A/C/E/T	25	32	40	50	63	80	100	125
Size HSK-B/D/F	32	40	50	63	80	100	125	160
Total stroke	7	9	13	15	14	17	18	20
Pull-out stroke AM	0,2	0,3	0,5	0,5	0,5	0,5	0,8	0,8
Taper Ø d2	19	24	30	38	48	60	75	94,996
d3	10	12	15	18	24	32	40	46
d4	17	21	25,5	32	40	50	63	80
d5	M4	M6x0,75	M8x1	M10x1	M12x1	M16x1,5	M20x1,5	M24x1,5
d6	4,2	6,5	6,4	8	10,5	14,3	17,5	20
l1	28,8	35,1	42,5	50	62	80	98,5	121,2
l2	2,5	3,2	4	5	6,3	8	10	12,5
l3	22,6	26,7	34	39,5	51,5	67	85,2	104,4
l4	20,3	24,5	31,9	37,2	46,2	59,7	73	96,9
l5	9,5	12,5	13	17	19	30	34,5	40
l6	2,5	3	20	26	28	42	51	60
Adjusting size EM	6,2	8,3	8,5	10,5	10,5	13	13,3	16,8
Draw bar pull kN	0,7	1	2	3	4	7,5	10	15
Clamping force kN	3,5	5	10	15	25	37,5	50	70
Max. application speed min^{-1}	70000	48000	36000	30000	24000	18000	14000	10000

▲ on request

Clamping set - With retaining collet



APPLICATION

Clamping set for HSK clamping systems with holding function for shorter tool changing times.

TYPE

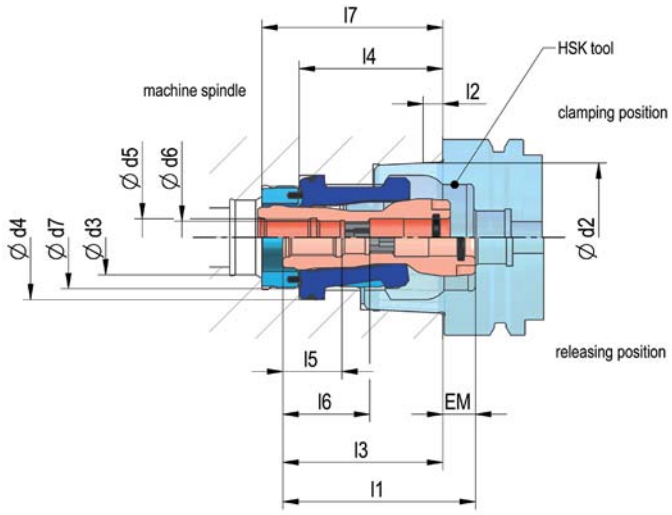
With the clamping set with retaining collet, time is saved during the tool change because several sequence steps take place in the same time window.

CUSTOMER BENEFITS

- DLC coating guarantees a longer service life of the clamping set
- Short length for compact force flow and high rigidity
- High force amplification due to transmission in the clamping set
- Safe clamping and release of the tools

TECHNICAL FEATURES

- DLC coating guarantees a longer service life of the clamping set



C 15

Automatic HSK-Clamping set with retaining collet With the clamping set with retaining collet, time is saved during the tool change because several sequence steps take place in the same time window.

Item no.	1024067	1019609	1024145	1015265	1004827
Size HSK-A/C/E/T	40	50	63	80	100
Size HSK-B/D/F	50	63	80	100	125
Total stroke	13	15	16	17	18
Pull-out stroke AM	0,5	0,5	0,5	0,5	0,8
Taper Ø d2	30	38	48	60	75
d3	15	18	24	27	40
d4	25,5	32	40	50	63
d5	M8x1	M10x1	M12x1	M16x1,5	M20x1,5
d6	6,4	8	10,5	14,3	17,5
d7	M20x1	M25x1	M33x1	M40x1	M53x1,5
l1	42,5	50	62	80	98,5
l2	4	5	6,3	8	10
l3	34	39,5	51,5	67	85,2
l4	31,85	37,15	46,2	59,7	73
l5	13	17	19	30	34,5
l6	20	26	28	42	51
l7	38	41,5	58,2	75	106
Adjusting size EM	8,5	10,5	10,5	13	13,3
Draw bar pull kN	2	3	4	7,5	10
Clamping force kN	10	15	25	37,5	50
Max. application speed min^{-1}	48000	40000	32000	24000	20000

Clamping set - For spindle revision



APPLICATION

Clamping set for HSK clamping systems after taper repair measures.

TYPE

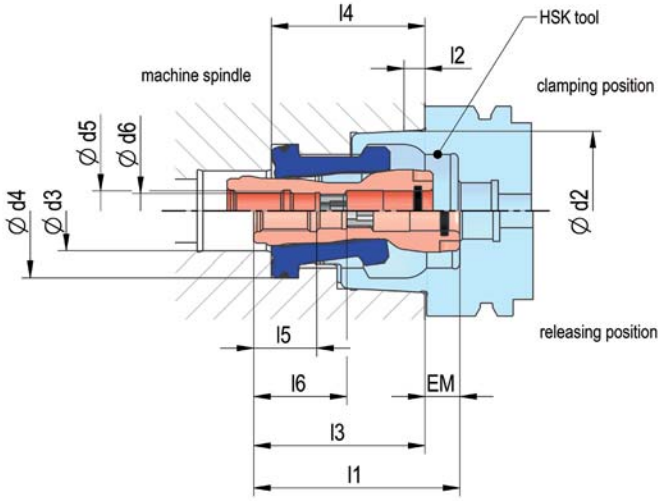
Clamping set for spindle overhauls to compensate the removed material from rework on the spindle of the HSK taper.

CUSTOMER BENEFITS

- DLC coating guarantees a longer service life of the clamping set
- Short length for compact force flow and high rigidity
- High force amplification due to transmission in the clamping set
- Safe clamping and release of the tools

TECHNICAL FEATURES

- Connected collet segments simplify installation



C 15

Automatic HSK clamping set for spindle revision

Item no.	891068	891070	891072
Size HSK-A/C/E/T	63	63	63
Size HSK-B/D/F	80	80	80
Underdimension (material removal from plane face) mm	-0,3	-0,5	-0,8
Necessary material removal from driver grooves, min. mm	-	-0,2	-0,5
Total stroke	14	14	14
Pull-out stroke AM	0,5	0,5	0,5
Taper Ø d2	48	48	48
d3	24	24	24
d4	40	40	40
d5	M12x1	M12x1	M12x1
d6	10,5	10,5	10,5
l1	62	62	62
l2	6,3	6,3	6,3
l3	51,5	51,5	51,5
l4	45,9	45,7	45,4
l5	19	19	19
l6	28	28	28
Adjusting size EM	10,5	10,5	10,5
Draw bar pull kN	4	4	4
Clamping force kN	25	25	25
Max. application speed min^{-1}	24000	24000	24000

Further sizes on request

▲ on request

Automatic clamping units and draw bar extension



APPLICATION

Actuation unit for HSK clamping systems.

TYPE

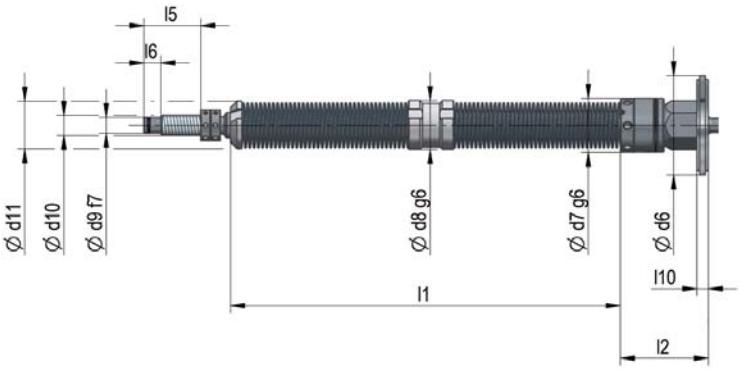
Spring-actuated clamping unit.
Individually adapted draw bar extension.

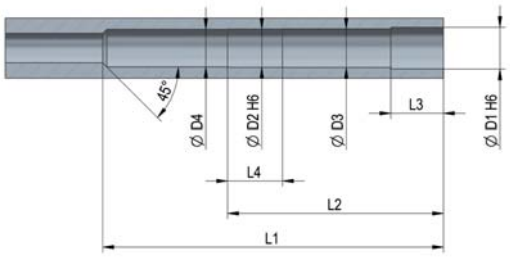
CUSTOMER BENEFITS

- Energy stored in the spring package
- Slender design
- Reliable function due to sturdy design

TECHNICAL FEATURES

- Clamping system is designed individually for the spindle





C 15

HSK-Clamping system with stationary release unit

Clamping unit HSK	32	40	50	63	80	100
d7	20	25	35	38	42	50
d8	18,5	22,5	30	35	38	42,5
d9	6,5	8,5	10	11	13	14,5
d10	M8x1	M10x1	M12x1,5	M14x1,5	M16x1,5	M18x1,5
d11	18	21,5	29	34	37	41,5
D1	20	25	35	38	42	50
D2	18,5	22,5	30	35	38	42,5
D3	19	23	30,5	35,4	38,5	43
D4	18,5	22	29,5	34,5	37,5	42,5
l1	150	190	225	274	282	350
l2	52	50	60	61,8	74	90
l5	22	26	32	40	40	45
l6	8	9	10	12	13	15
l10	8	8	8	8	8	8
L1	190	240	270	311	325	396
L2	115	150	180	197	210	250
L3	34	40	48	48	56	70
L4	38	42	50	50	58	65
Pull-in-force kN	5	10	15	25	35	50
Total stroke	9	13	15	16	18	20

Individual clamping systems available on request

Stationary release unit



APPLICATION

Stationary release unit for tool clamping systems.

TYPE

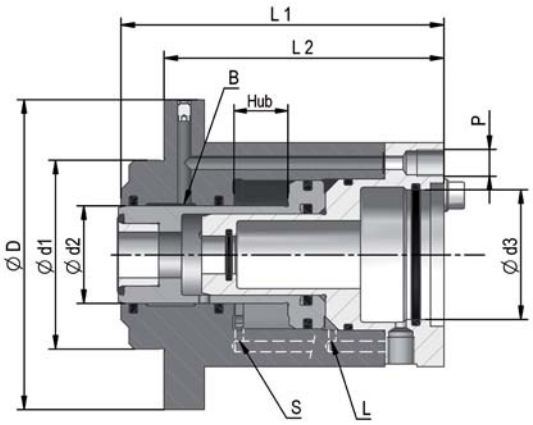
Hydraulic or pneumatic design, stationary attachment.

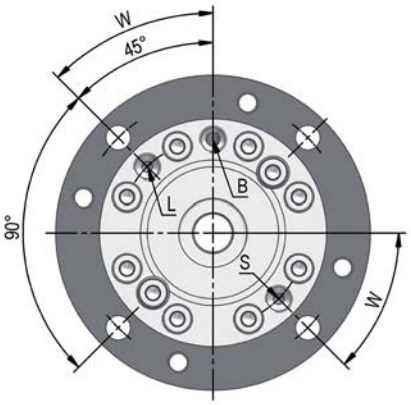
CUSTOMER BENEFITS

- Clamping system and release piston are separated from one another during the spindle rotation
- No oil supply required in the rotating spindle part
- Low-wear operation

TECHNICAL FEATURES

- Release system designed individually for the spindle





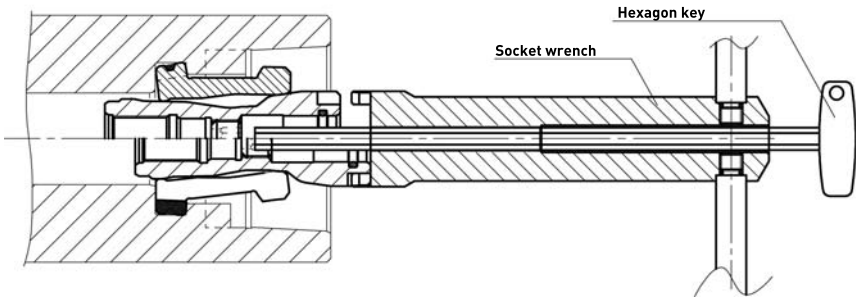
C 15
Stationary release unit
This stationary release unit allows a fast stroke movement
- Speed-independent
- Passage for cleaning air in release position
- Mount for rotary feed-through

Piston surface (release) cm²	49,7	16,7	62,6
Max. release pressure L bar	80	150	80
Max. clamping pressure S bar	80	150	80
Max. cleaning air B bar	10	10	10
Stroke	20	20	22
D	122	115	165
L1	120	117	121
L2	104	104	109
P	G 1/4	M10x1	M10x1
W	20°	-45°	45°
d1	70	70	100
d2	40	36	56
d3	48	48	48

Other technical data on request

Accessories

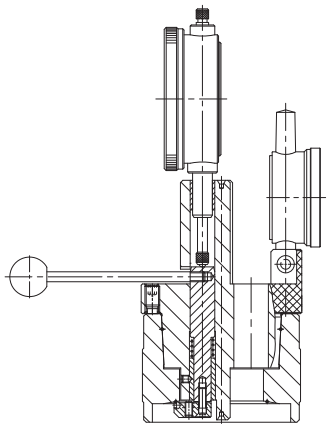




C 15
Wrench for pressure piece screw-in assembly

Item no. Socket wrench	Size HSK-A/C/E/T	Size HSK-B/D/F	Item no. Hexagon wrench	L	Key-width SW
830252	32	40	**830253**	Drehstift	-
831296	40	50	**863494**	200	3
831291	50	63	**817262**	200	4
831274	63	80	**844250**	200	5
831289	80	100	**756660**	200	6
831434	100	125	**381601**	200	8
812550	125	160	**698938**	200	10





C 15
Measuring device - For measuring the installation contour (clamping shoulder) for automatic HSK clamping sets

Item no.	Size HSK-A/C/E/T	Size HSK-B/D/F
1181005	25	32
1156601	32	40
1179168	40	50
1201360	50	63
1149877	63	80
1233614	80	100
1233553	100	125
1233615	125	160



50 % SHORTER LENGTH THAN CLAMPING SYSTEMS WITH SPRINGS

HSK clamping system with SUPER-LOCK



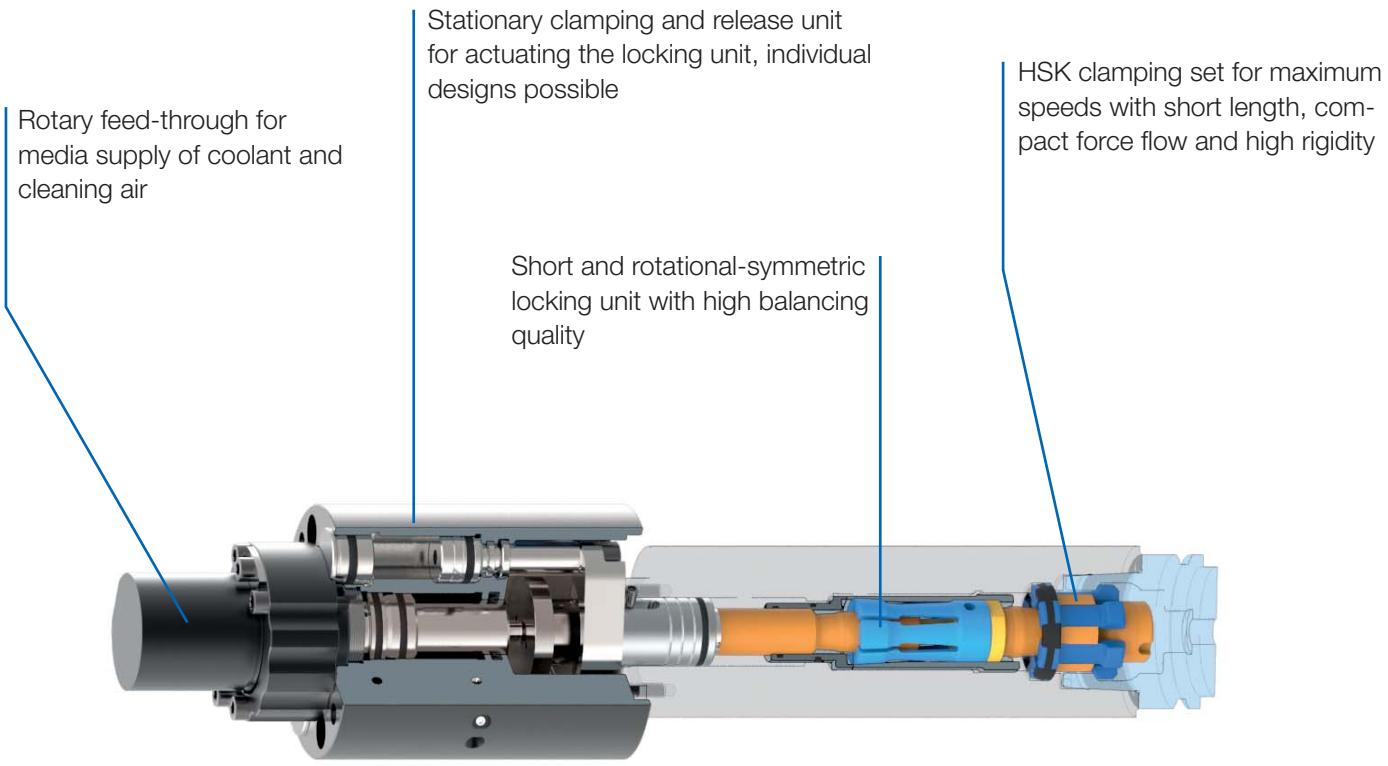
HSK clamping system with spring package

HSK - SUPER-LOCK

The trend toward modern milling machines involves two requirements with regard to the automatic clamping systems. In the area of High Speed Cutting (HSC), increasingly higher speeds and therefore higher balancing qualities are required. Due to higher machining forces during High Performance Cutting (HPC), interfaces must additionally be more rigid. SUPER-LOCK meets these requirements, and with an approx. 50 % shorter length as compared with conventional clamping systems with springs.

ADVANTAGES AT A GLANCE

- Compact and extremely short design
- Optimally suited for maximum speeds and machining forces
- Lower force introduced into the spindle as compared to spring clamping systems



Clamping unit



APPLICATION

For HSK clamping systems.
Can be used universally, preferably for maximum speeds.

TYPE

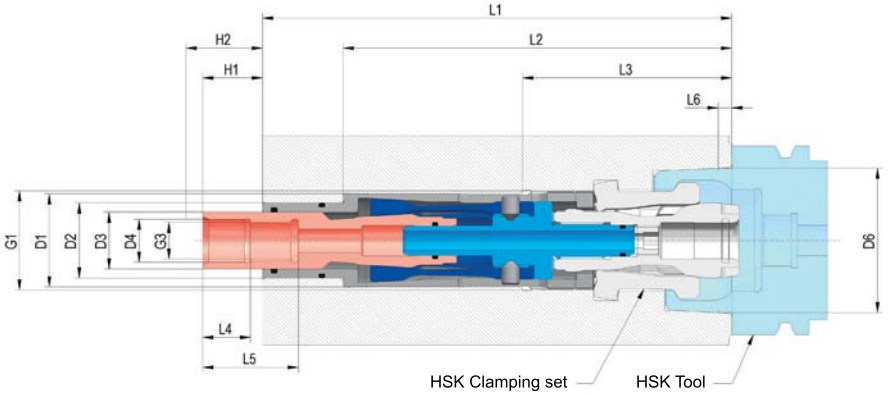
Locking unit with HSK clamping set.

CUSTOMER BENEFITS

- Without springs - clamping force is maintained with self-locking
- Short and compact design
- Low force transmission during releasing

TECHNICAL FEATURES

- For actuation, a clamping and release unit are required



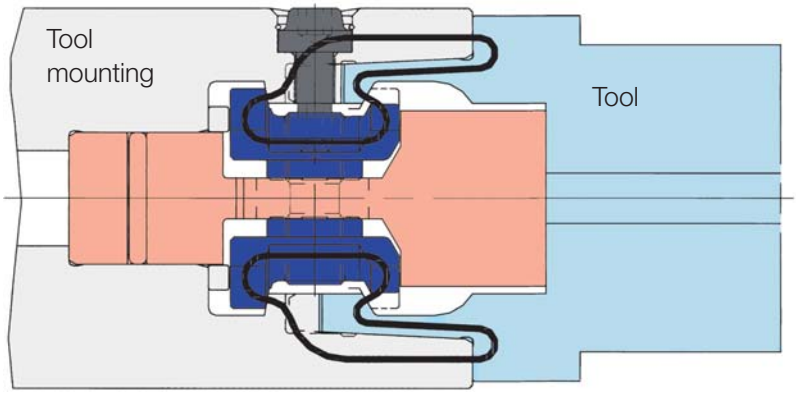
C 15
Clamping unit SUPER-LOCK Self-locking mechanism **without springs** for automatic tool clamping

Item no.	1122572	1122574	1122718	1122725	1122569	1122731	1122581
Size HSK-A/C/E/T	25	32	40	50	63	80	100
Size HSK-B/D/F	32	40	50	63	80	100	125
D1	13,2	15,1	18,6	23,6	31	39	49
D2	11	12,5	16,4	20,4	25	31,2	40
D3	8	10	13	16	19	24	31
D4	6,2	8,2	10,3	12,5	14,4	17	21
D6 mm	19	24	30	38	48	60	75
G1 mm	M14x0,5	M16x0,75	M20x1	M25x1	M33x1	M42x1,5	M52x2
G3	M6x0,75	M8x0,75	M10x1	M12x1,25	M14x1,5	M16x1,5	M20x2
H1 mm	10,8	13,6	17,8	19,9	20	27,3	30,8
H2	15,6	18,9	22,8	26,3	28	38,3	42,4
L1	71,4	83,5	106,4	127,7	157	201,3	262
L2	56	69	86	104	130	167	207
L3	32,25	36,7	45,9	57	70	88	110
L4	6,3	8	10	12,5	16	20	25
L5 mm	12,5	16	20	25	32	40	50
L6	2,5	3,2	4	5	6,3	8	10
Clamping set	**594332**	**1035347**	**1011063**	**1037501**	**1015151**	**474917**	**462324**
Draw bar pull N	700	1000	2000	3000	5000	7500	10000
Clamping force N	3500	5000	10000	15000	25000	37500	50000
Max. application speed min^{-1}	120000	80000	60000	50000	40000	30000	24000

▲ on request

Notes

COMPACT FORCE FLOW WITHOUT INFLUENCING THE HSK TAPER



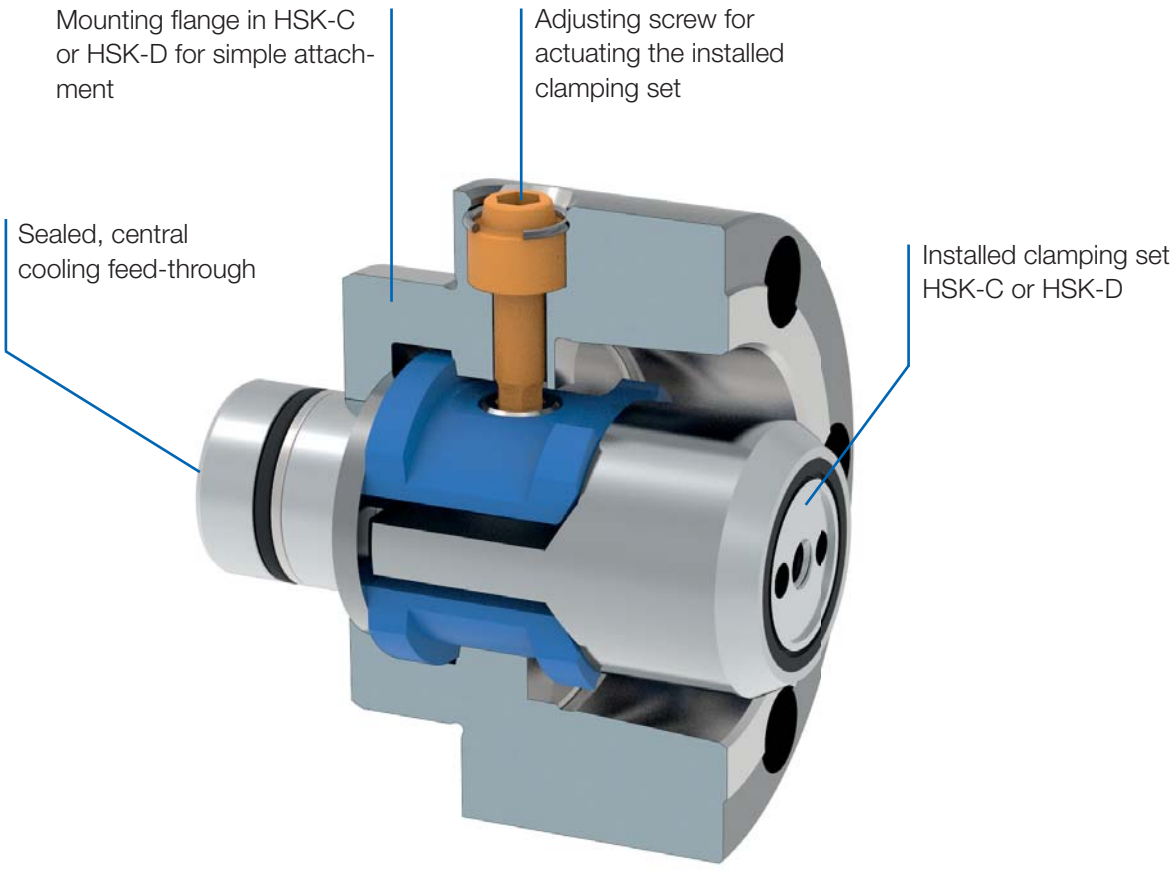
RÖHM HSK system for manual force clamping with compact force flow.

HSK - MANUAL CLAMPING SET

A critical factor for the HSK interface with manual tool change in lathes or turrets as well as milling machines is the rigidity and change precision. Manual clamping systems from RÖHM achieve this via the compact force flow within a minimum amount of space.

ADVANTAGES AT A GLANCE

- Convincingly simple construction for high reliability and simple installation
- Safe ejection of tools during release by means of the guide bolt
- No negative influence of the HSK taper, since the actuation screw lies in the driver area



HSK-C clamping set



APPLICATION

Manual clamping of HSK tools.

TYPE

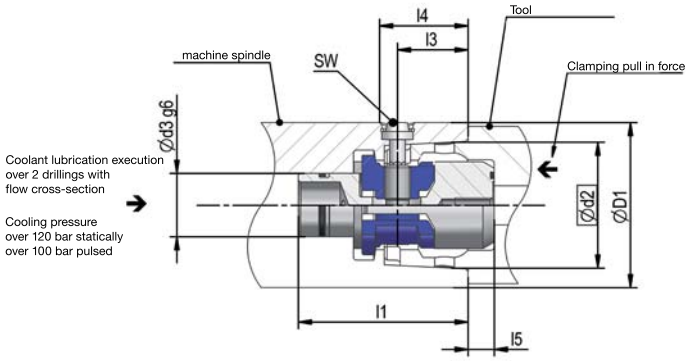
HSK-C for tool shafts A/C/T.

CUSTOMER BENEFITS

- Convincingly simple construction for high reliability and simple installation
- Safe ejection of tools during release by means of the guide bolt
- No negative influence of the HSK taper, since the actuation screw lies in the driver area.

TECHNICAL FEATURES

- Central coolant supply (exept size 25)



C 15

Clamping set HSK-C with coolant supply through the centre (except size 25) for tool holders with internal drivers HSK-A/C

Item no.	760530 ▲	784603	812617	831435	586214	475170	475172	483213 ▲	831306 ▲
Size HSK-A/C/E/T	25	32	40	50	63	80	100	125	160
D1	25	32	40	50	63	80	100	125	160
Taper Ø d2	19	24	30	38	48	60	75	95	120
d3H7g6	10	12	15	18	24	32	40	48	60
l1	28	34	45	55	65	80	97,5	124	160
l3	11,4	14	17,5	21,5	27	34	42	53	68
l4	15	18,5	22	27	34	42	53	67	85
l5	6	8	8	10	10	12,5	12,5	16	16
Key SW	2,5	2,5	3	4	5	6	8	10	12
Tightening torque Nm	1,8	2,5	3,5	8	14	25	42	80	100
Clamping force kN	3,5	5	6,8	11	18	30	45	70	115
Flow cross section mm^2	-	6,3	10,6	14,1	27,7	56,5	100,5	100,5	157
Adjusting screw complete Item no.	**760628**	**1176471**	**760463**	**760464**	**760465**	**760466**	**760467**	**812815**	**831311**

Built-in clamping set HSK-D on request

HSK-C clamping set with adaptor



APPLICATION

For attachment to spindles, turrets, etc.

TYPE

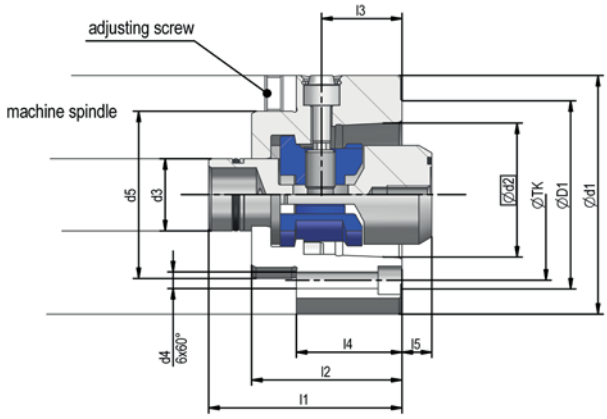
HSK-C for tool shafts A/C/T.

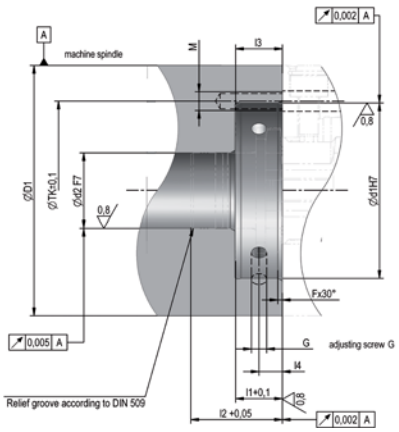
CUSTOMER BENEFITS

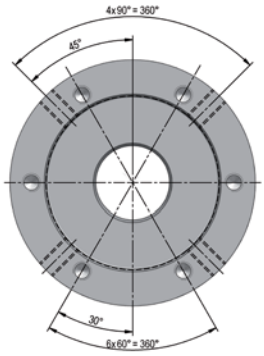
- Convincingly simple construction for high reliability and simple installation
- Safe ejection of tools during release by means of the guide bolt
- No negative influence of the HSK taper, since the actuation screw lies in the driver area.

TECHNICAL FEATURES

- Balancing quality G 2.5
- Central coolant supply







C 15

Adaptors with clamping set HSK-C balanced and with coolant supply through the centre (except size 25)

Item no.	850322 ▲	820802	820803	820804	820805	820806	820807
Initial size D1	25	32	40	50	63	80	100
d1	37	40	50	63	80	100	123
Taper Ø d2	19	24	30	38	48	60	75
d3F7g6	10	12	15	18	24	32	40
d4	3,4	3,4	4,5	5,5	6,5	9	11
d5g6	24	27	33,5	42	56	68	84
Ø-TK	29	32	40,5	52	66	82	102
l1	26	34	45	55	65	80	97,5
l2	22	26	34	41	50	64	76
l3	11,4	14	17,5	21,5	27	34	42
l4	15,5	19	23	28	35	44	54
l5	6	8	8	10	10	12,5	12,5
Adjusting screw complete Item no.	**870022**	**870023**	**870024**	**870025**	**870026**	**870027**	**870028**

dyn. balanced: G 2,5 DIN ISO 1940

Accessories

C 15

Measuring device For measuring the installation contour (clamping shoulder) for manual clamping sets

Item no.	Size HSK-A/C/E/T	Size HSK-B/D/F
1233617	25	32
1195813	32	40
1233618	40	50
1195814	50	63
1233619	63	80
1233554	80	100
1233620	100	125
1233621	125	160
1233616	160	

▲ on request

THE RIGHT FUNCTIONAL PRINCIPLE FOR EVERY APPLICATION



Stationary tool clamping
Stationary release unit is disconnected from the rotating system during spindle rotation and is therefore especially suited for higher speeds.



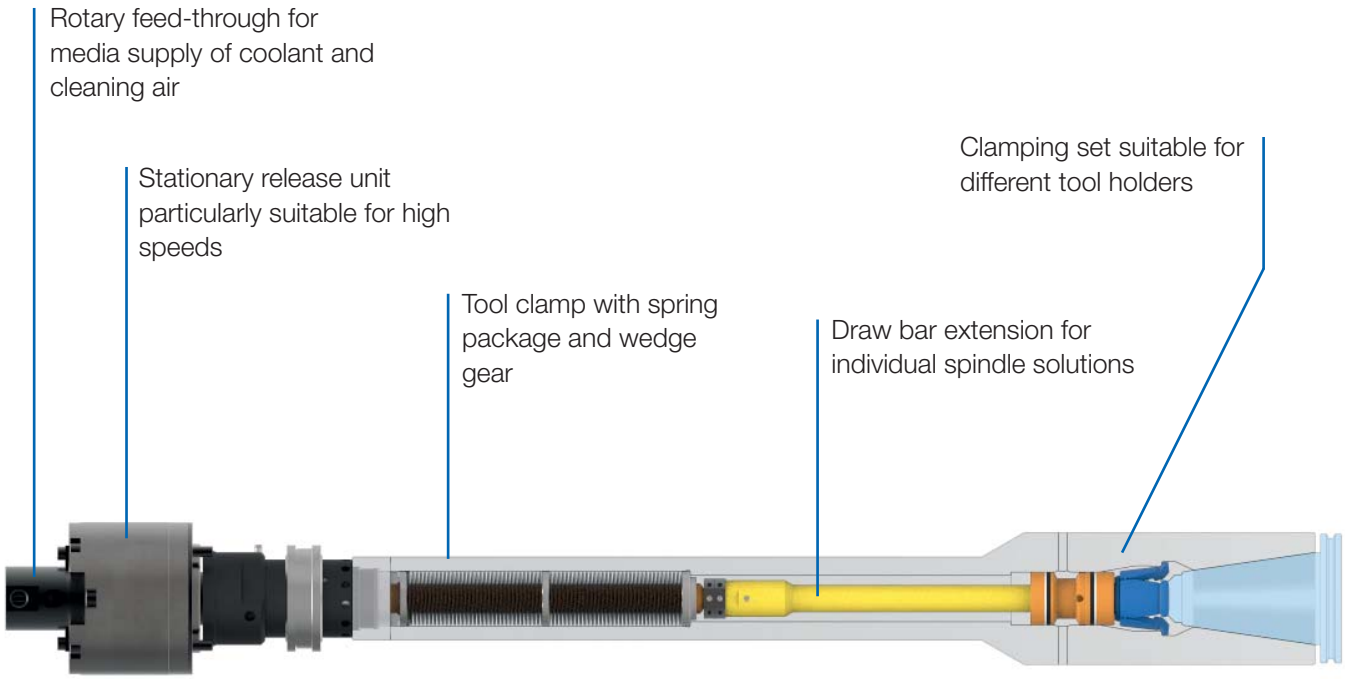
Integrated tool clamping
Hydraulic release mechanics are attached/installed on the spindle shaft. No force acts on the spindle bearing during the tool change.

SK - AUTOMATIC TOOL CLAMPING SET

For the automatic clamping of steep-taper tools, reliability, safety and long service life are essential basic requirements. Particularly for machine tools with a rotating working spindle, high rotational frequencies and high clamping forces. Due to many years of experience in this area, RÖHM can specifically see to customized requirements, thereby meeting this requirement.

ADVANTAGES AT A GLANCE

- Safe clamping and release of the steep-taper tools by using proven components
- High variant variety for a wide range of installation situations
- Individual adaptation to customer-specific requirements



SK-clamping sets



APPLICATION

For the automatic clamping of steep-taper tools.

TYPE

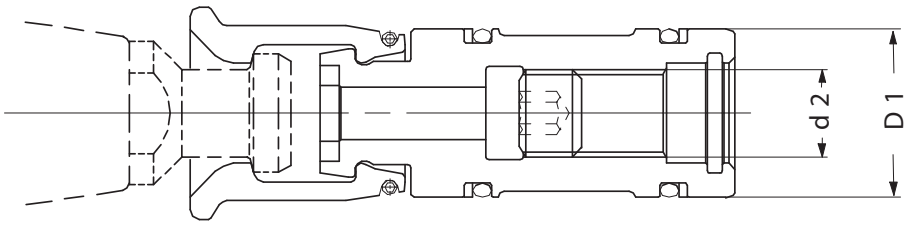
Available in different versions to match the respective tool.

CUSTOMER BENEFITS

- Proven construction and high-quality processing
- Safe clamping and release of the tools

TECHNICAL FEATURES

- Optional with internal coolant supply



C 15

Clamping sets type DIN 69871/72

Item no.	Design	D1	d 2	Pull-in force max. N
490968 ▲	SK 30 - IKZ	19	M10x1,5	7500
756340	SK 40 - IKZ	27	M 14x1,5	15000
760391	SK 50 - IKZ	40	M 16 x1,5	26000
760390 ▲	SK 60	52	M 30x1,5	80000

IKZ = with internal coolant supply
further designs available on request

C 15

Clamping sets type MAS BT 45°

Item no.	Design	D1	d 2	Pull-in force max. N
1070315 ▲	SK 30	19	M10x1,5	6000
861930 ▲	SK 40 - IKZ	27	M14x1,5	15000
795390 ▲	SK 50 - IKZ	40	M16x1,5	26000

IKZ = with internal coolant supply
further designs available on request

C 15

Clamping sets type ANSI 5.50-78

Item no.	Design	D1	d 2	Pull-in force max. N
890828 ▲	SK 30 - IKZ	19	M10x1,5	6000
766334 ▲	SK 40 - IKZ	27	M14x1,5	15000
831393 ▲		40	M16x1,5	26000

IKZ = with internal coolant supply
further designs available on request

Clamping set with stationary release unit



APPLICATION

Suitable for SK spindles in higher speed range.

TYPE

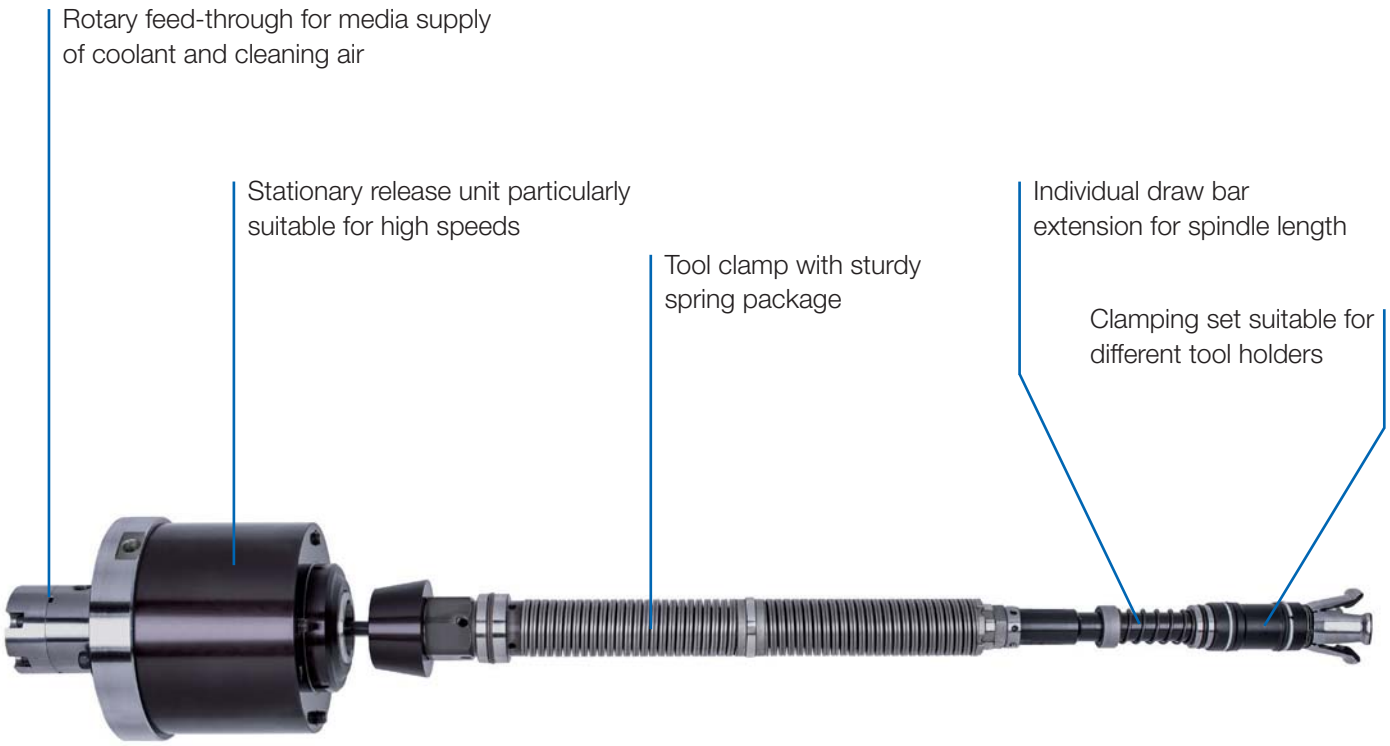
Spring package with or without transmission gears and stationary release unit.

CUSTOMER BENEFITS

- Slender design
- No oil supply required in the rotating spindle part
- Stationary release unit decoupled from spindle rotation, therefore low-wear

TECHNICAL FEATURES

- Release system designed individually for the spindle



Clamping set with integrated release unit



APPLICATION

For SK spindles with compact design.

TYPE

Spring package with transmission gear and installed release hydraulics.

CUSTOMER BENEFITS

- No force acts on spindle bearing during the tool change
- Compact design and high pull-in forces due to integrated wedge gear

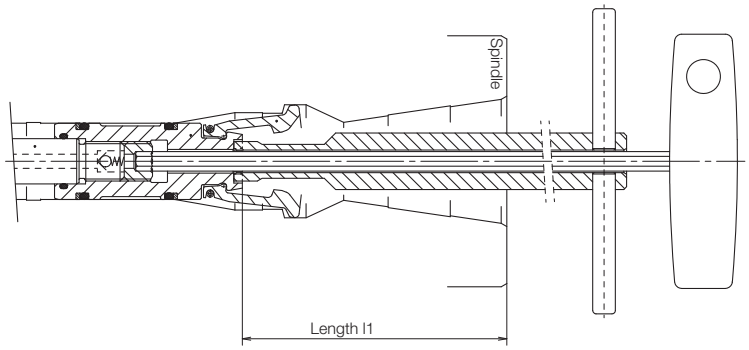
TECHNICAL FEATURES

- Release system designed individually for the spindle



Accessories





C 15
Socket wrench with through-hole

Item no. **Socket wrench**	Size	**Item no.** Hexagon wrench	Length l1 mm	Key-width SW
772214	SK 30	**367665**	183	4
756393	SK 40	**802094**	350	6
756396	SK 40	-	-	-
760229	SK 50	**769078**	400	8
747337	SK 60	**769078**	400	8



EXCHANGEABLE MEASURING ADAPTER FOR HSK, SK AND SPK



F-SENSO SPINDLE PULL-IN FORCE MEASURING DEVICE

Ensuring consistently high machining quality has top priority. Due to the regular check of the tool clamping system with the pull-in force measuring device, F-senso spindle, changes in the clamping force are detected even before it has an effect on the machining quality.

ADVANTAGES AT A GLANCE

- Maximum flexibility due to exchangeable measuring adapter for all HSK and SK sizes
- Best user-friendliness due to intuitive operation and delivery in a practical case
- Simulation of the tool and spindle tolerances possible by a scaled ring



F-senso spindle 0-15 kN



APPLICATION

Measuring device for SK and HSK spindles of size SK 30; HSK (A) 20, 25, 32, 40.

TYPE

Measuring range 0-15 kN.

CUSTOMER BENEFITS

- Maximum flexibility due to exchangeable adapters for all HSK and steep-taper sizes
- High user-friendliness due to intuitive operation and delivery in a practical case
- Simulation of the tool and spindle tolerances possible by a scaled ring

Delivery includes:
- F-senso spindle force measurement device
- Case with space for adapter
- Mounting bar
- Battery

C 15
Pull-in force measurement device F-senso spindle 0-15 kN



Item no.	1266341
Measuring range / Clamping force kN	0-15 kN
Piattaforma in acciaio SPS Art. 499-40	0,25% (f.s.)
Dimensions (base unit)	ca. Ø66mm; L=172 mm

C 15
Adaptor for HSK taper



Item no.	Size HSK-A/C/E/T	Size HSK-B/D/F
1269725 ▲	20	-
1255735	25	32
1255736	32	40
1255737	40	50

C 15
Adaptor for steep taper shank



Item no.	Matching adapter
1255743	SK 30

A 34
Draw-in bolts



Item no. SK 30	Design
698582	Draw-in bolt DIN 69872 A
698583	Draw-in bolt DIN 69872 B
1297449 ▲	Draw-in bolt ISO 7388/II-B
1297435 ▲	Draw-in bolt MAS BT 1 (45°)
1297436 ▲	Draw-in bolt MAS BT 2 (30°)
1297450 ▲	Draw-in bolt ANSI B5.50

C 15
Calibration services F-senso spindle (including test certificate)

Item no.	Design
1295776	Calibration including test certificate (Recommendation: Annually)

F-senso spindle 10-100 kN



APPLICATION

Measuring device for SK and HSK clamping systems of sizes SK 40, 50, 60; HSK (A) 50, 63, 80, 100, 125 and clamping head SPK.

TYPE

Measuring range 10-100 kN.

CUSTOMER BENEFITS

- Maximum flexibility due to exchangeable adapters for all HSK and steep-taper sizes
- High user-friendliness due to intuitive operation and delivery in a practical case
- Simulation of the tool and spindle tolerances possible by a scaled ring

Delivery includes:
- F-senso spindle force measurement device
- Case with space for adapter
- Mounting bar
- Battery

C 15
Pull-in force measurement device F-senso spindle 10-100 kN



Item no.	1255729
Measuring range / Clamping force kN	10-80 kN
Piattaforma in acciaio SPS Art. 499-40	0,25% (f.s.)
Dimensions (base unit)	ca. Ø66mm; L=189 mm

C 15
Adaptor for HSK taper



Item no.	Size HSK-A/C/E/T	Size HSK-B/D/F
1255738	50	63
1255739	63	80
1255740	80	100
1255741	100	125
1255742 ▲	125	160

C 15
Adaptor for steep taper shank



Item no.	Matching adapter
1255744	SK 40
1255745	SK 50
1255746 ▲	SK 60

A 34
Draw-in bolts



	SK 40	SK 50	SK 60
Draw-in bolt DIN 69872 A	347325	367316	1297443 ▲
Draw-in bolt DIN 69872 B	698584	698586	1234433 ▲
Draw-in bolt ISO 7388/II-B	367569	698588	1297444 ▲
Draw-in bolt MAS BT 1 (45°)	1297437 ▲	698594	1297445 ▲
Draw-in bolt MAS BT 2 (30°)	1297438 ▲	698591	1297446 ▲
Draw-in bolt ANSI B5.50	620770	620771	1297447 ▲

F-senso spindle 10-100 kN

A 34C 15
Adaptor for clapming heads



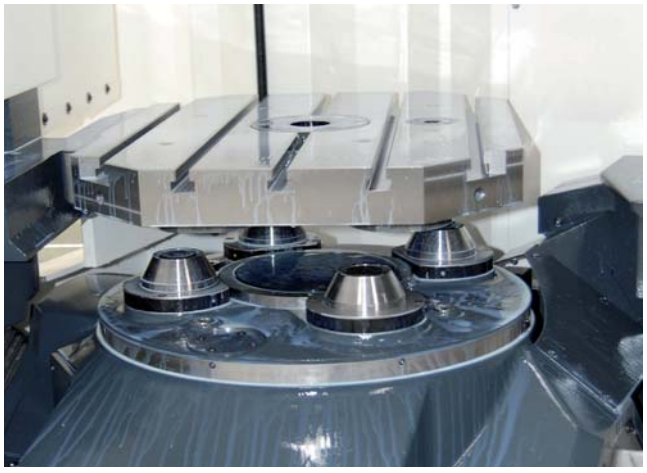
Item no.	Matching adapter
1296094	SPK 110 (1154382)
1288317	SPK 100 (1154381)
1288319	SPK 125 (1256149)
1288320	SPK 140 (1262302)

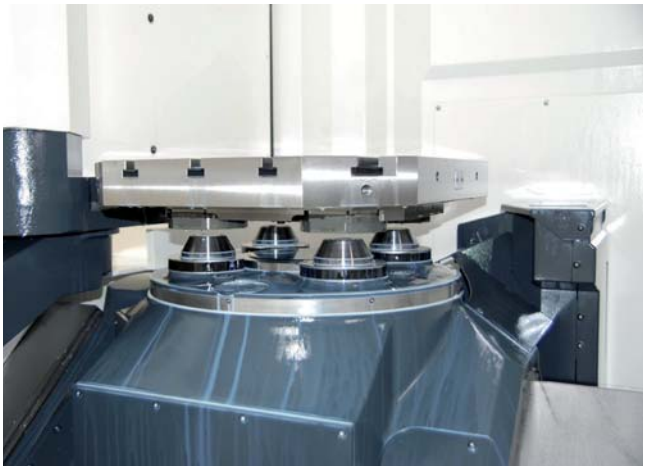
C 15
Calibration services F-senso spindle (including test certificate)

Item no.	Design
1295776	Calibration including test certificate (Recommendation: Annually)

Notes

CLAMPING HEADS IN USE





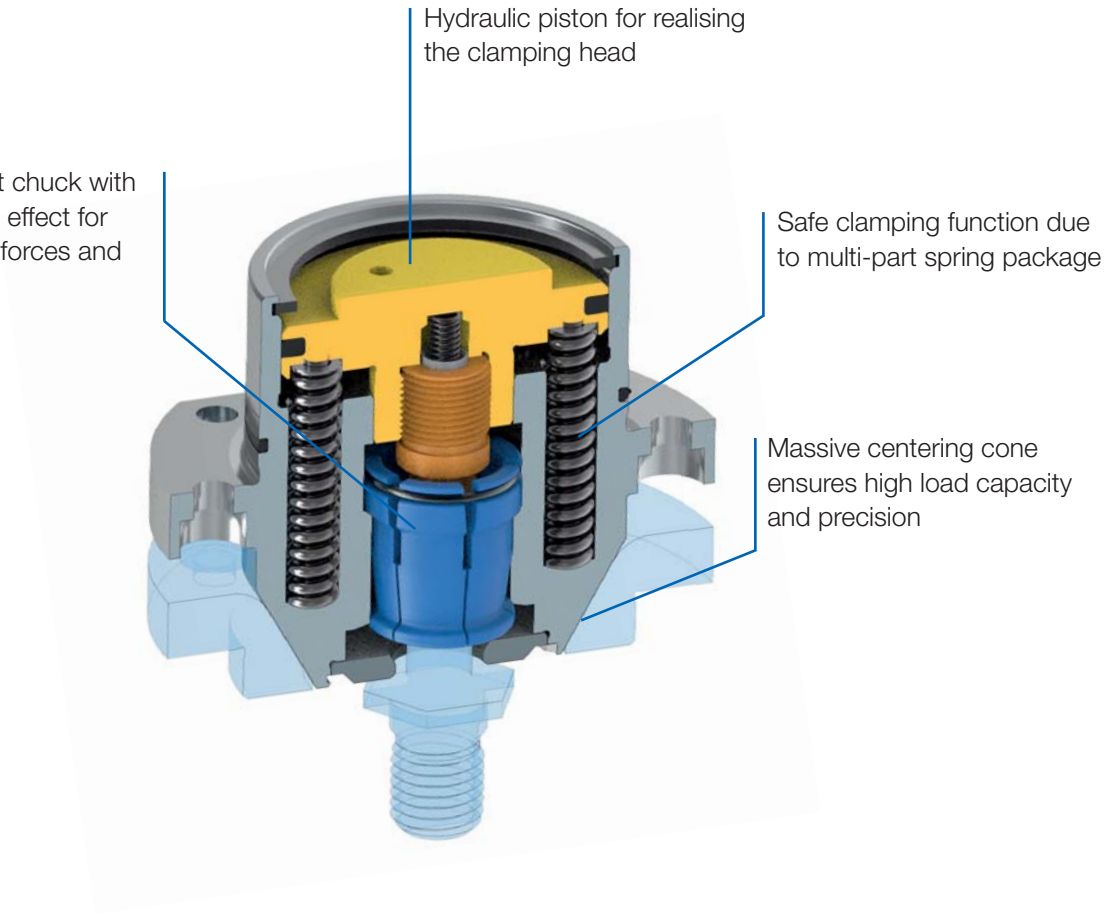
RÖHM clamping heads are especially suited for applications with pallet clamping, which require very high change precisions, such as machining centers and transfer lines.

CLAMPING HEADS SPK

RÖHM clamping heads can be used for all existing pallet clamps. They are particularly suitable for applications which require very high change precisions, such as machining centers or transfer lines. Integrated in the machine table, the clamping heads clamp workpiece pallets in a minimum amount of space with high precision in the axial run-out and positioning for maximum efficiency.

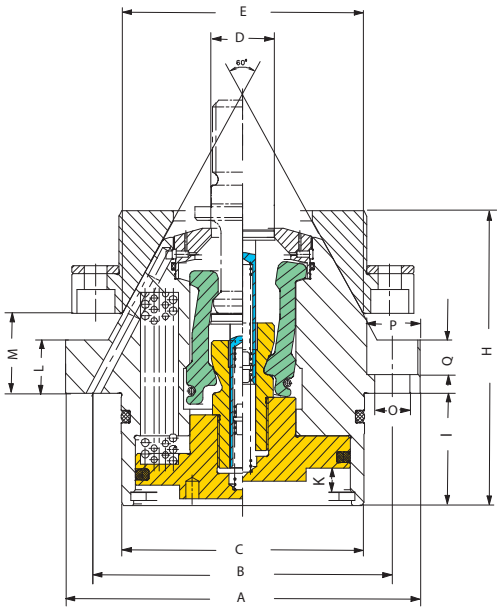
ADVANTAGES AT A GLANCE

- High change precision due to exact positioning of the pallet on the clamping tapers
- Force amplification of the collet chucks results in high clamping forces and high system rigidity
- Clamping force applied over long time period due to integrated spring package



Spring operated clamping head





APPLICATION

On machine tables, when secure clamping of the pallet must be guaranteed, even without hydraulic pressure applied.

TYPE

Spring-actuated clamping - hydraulic release.

CUSTOMER BENEFITS

- High system rigidity due to stable design due to the connecting ribs between the individual spring packages
- Hydraulic pressure is only required for release
- Pull-out safety device without additional elements
- Spring-actuated locking cover

TECHNICAL FEATURES

- Compact design
- More powerful effect of the collet chuck
- Air sensing possible

C 15

Spring operated clamping head For clamping pallets

Item no.	1154381	1154382	1256149	1262302
Size A	100	110	125	140
Contents of delivery	set	set	set	set
B mm	86	92	105	118
C mm	70	76	85	96
D mm	19	19	20	25
E mm	70	75	85	95
H mm	90	96	93	104
I mm	43	49	43	42
K mm	-	9,5	9,5	9,5
L mm	11	15	15	20
M mm	22	23	25	30
O mm	6,6	9	9	14
P mm	14	15	15	20
Q mm	7	8,5	8,5	13
Piston area: releasing cm^2	28,3	33,18	44,1	56,7
Min. release pressure bar	-	50	40	40
Pull-in-force N	15000	20000	20000	40000
Blast-air pressure bar	10	10	10	10
Weight kg	2,5	3	4	6

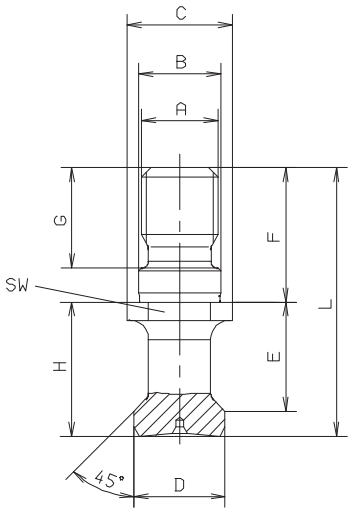
Sets can be aligned in height on request

Accessories spring operated clamping head

A 34
Draw-in bolts for clamping heads



Item no.	For clamping head size	Size A	Contents of delivery	B mm	C mm	D mm	E mm	F mm	G mm	H mm	L mm	Key-width SW
1243664	100	M18x1,5	piece	19	25,4	15,5	23,7	21	19	28,2	49	22
1243665	110	M18x1,5	piece	19	25,4	19	25,1	23	20	30,3	53	22
850094	125	M20	piece	21	34	19	29	30	23	35	65	30
1116394	140	M24	piece	25	38	23	34,7	40	32	40	80	30

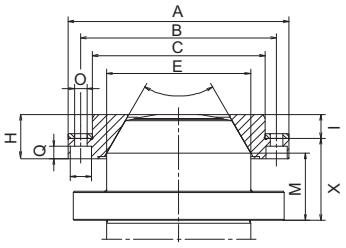


C 15
Mounting flange for clamping heads



Item no.	For clamping head size	Size A	Contents of delivery	B mm	C mm	C	E mm	H mm	I mm	M mm	O mm	P mm	Q mm	X mm
1176444	100	105	set	90	80	6x60°	64	20	9	27,2	6,6	11	6,8	33
1176382	110	110	set	96	85	6x60°	68	20	7,5	29,06	6,6	11	6,8	35,5
1296089	125	125	set	106	88	4x90°	85	32,5	18,5	25	9	15	9	39
1296090	140	135	set	116	98	-	95	38,5	23,5	30	9	15	9	45

Further details on request



Hydraulic clamping head



APPLICATION

The hydraulic operated clamping device may be suitable for all existing sorts of pallet clampings.

TYPE

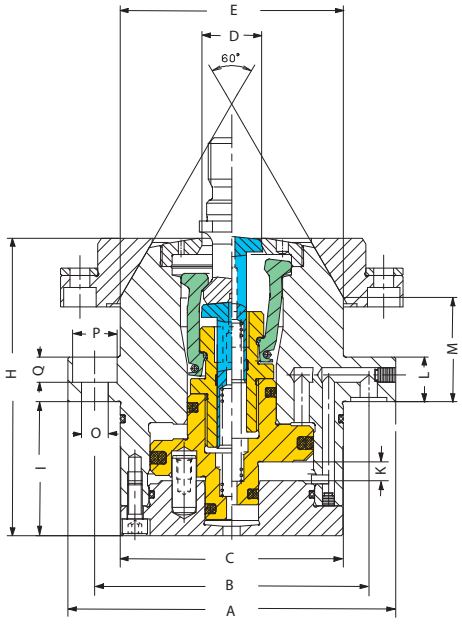
Clamping and release are hydraulic.

CUSTOMER BENEFITS

- High system rigidity due to stable design due to the connecting ribs between the individual spring packages
- Simple, reliable design
- Spring-actuated locking cover

TECHNICAL FEATURES

- Compact design
- More powerful effect of the collet chuck
- Air sensing possible



C 15

Hydraulic clamping head for clamping pallets

Item no.	486816	850092	869832	489556
Size A	110	125	140	148
Contents of delivery	piece	piece	piece	piece
B mm	92	105	118	125
C mm	75	85	96	106
D mm	20	20	29,5	29,5
E mm	75	85	98	100
H mm	100	106,5	121,5	131
I mm	45	55	58	63
K mm	6,3	6,3	6,8	6,5
L mm	15	15	20	22
M mm	35	25	30	39,9
O mm	9	9	11	11
P mm	15	15	18	18
Q mm	8,5	8,5	11	11
Piston area: clamping cm2	16,7	24	37	28,9
Piston area: releasing cm2	23,7	31,2	44,2	33,3
Max. operating pressure bar	130	85	80	130
Pull-in-force N	21700	20400	29600	37500
Blast-air pressure bar	10	10	10	10
Weight kg	4	6	8	9

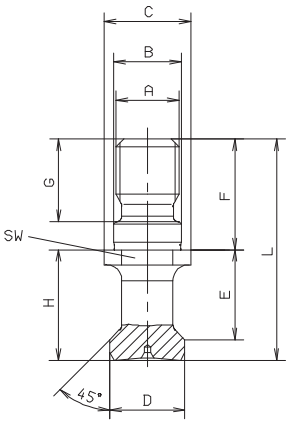
Sets can be aligned in height on request

Accessories hydraulic clamping head

A 34
Draw-in bolts for clamping heads



Item no.	For clamping head size	Size A	Contents of delivery	B mm	C mm	D mm	E mm	F mm	G mm	H mm	L mm	Key-width SW
586393	110	M16	piece	17	21,9	18,95	22,75	28	21	28	56	19
850094	125	M20	piece	21	34	19	29	30	23	35	65	30
869859	140	M24	piece	25	41,5	27,5	34	40	33,5	40	80	36
586394	148	M24	piece	25	41,5	27,5	34	40	33,5	40	80	36

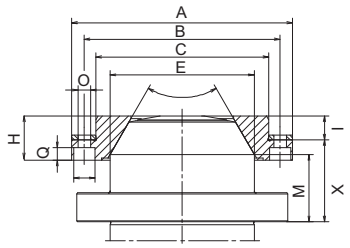


C 15
Mounting flange for clamping heads



Item no.	For clamping head size	Size A	Contents of delivery	B mm	Partition	C mm	E mm	H mm	I mm	M mm	O mm	P mm	Q mm	X mm
1128288 ▲	110	115	piece	102	90	75	23	4x90°	12,5	35	6,6	11	6,3	42,5
497213 ▲	125	125	piece	106	4x90°	88	85	32,5	18,5	25	9	15	9	39
497214 ▲	140	135	piece	116	6x60°	98	98	38,5	23,5	30	9	15	9	45
489557 ▲	148	160	piece	140	6x60°	120	100	38	23,5	39,9	9	15	9	50,5

Further details on request



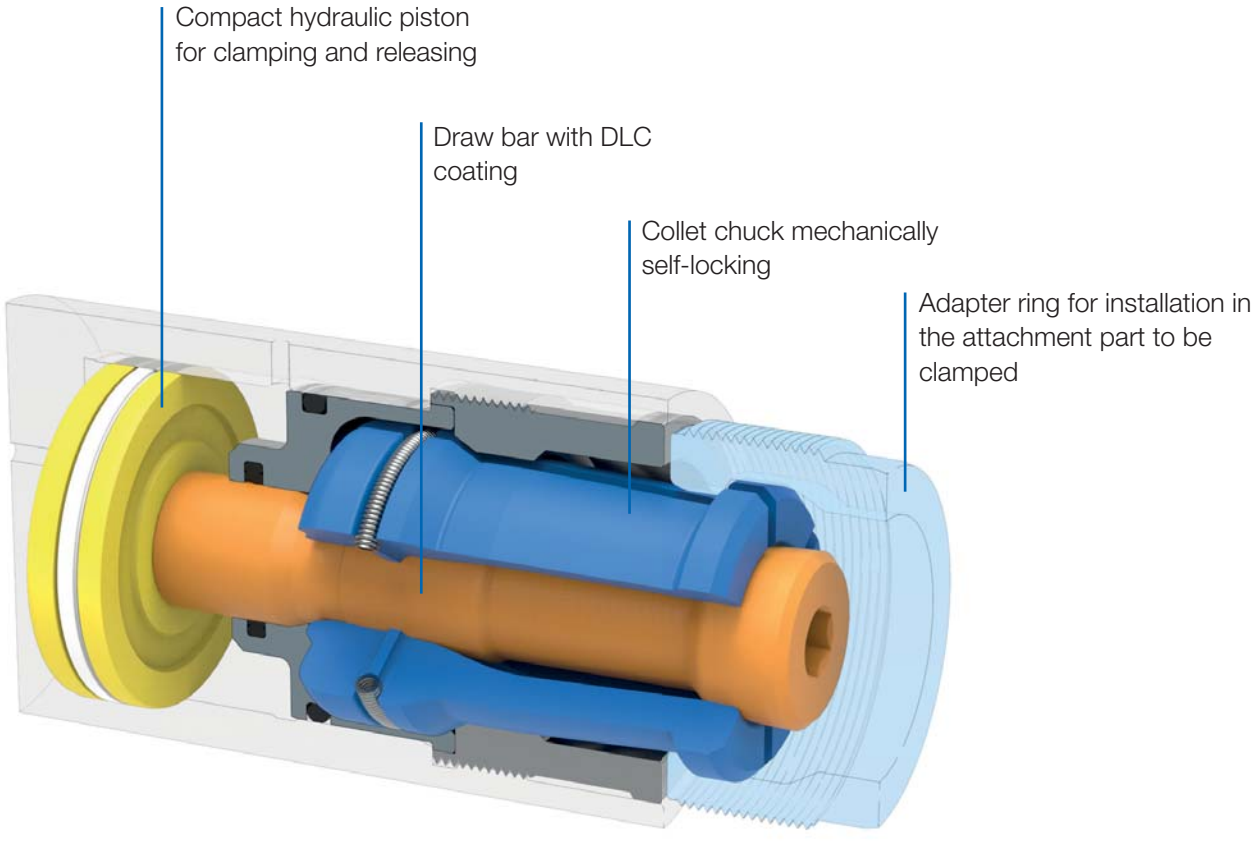

1191063
1516

BUILT-IN CLAMPING HEAD RESK

The built-in clamping head RESK is a universally usable interface for the easy and quick connection of machine components in a minimum amount of space, such as milling heads, machine tables and forming tools. It will convince you with its high pull-in forces and extremely compact design, as well as its process reliability.

ADVANTAGES AT A GLANCE

- Superior process reliability due to innovative design
- High pull-in forces with extremely compact design due to power transmission in the clamping set
- Integrated locking system maintains the clamping force without applied hydraulic pressure



Built-in clamping head RESK



APPLICATION

Change interface for machine components

TYPE

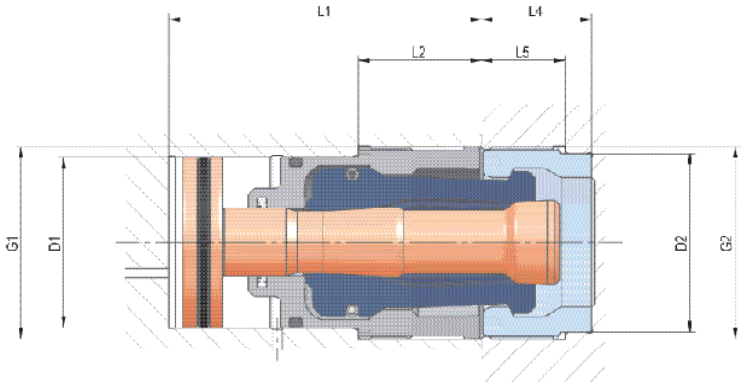
Clamping and release are hydraulic.
Mechanically locking.
After clamping, the system remains securely locked, even without hydraulic pressure.

CUSTOMER BENEFITS

- Maximum process reliability due to innovative design without wedge gear
- High pull-in forces with extremely compact design due to power transmission in the clamping set
- Integrated locking system maintains the clamping force, even without hydraulic pressure applied

TECHNICAL FEATURES

- Centering must be ensured with additional elements, if required



C 15
Built-in clamping head - Change interface for machine components

Item no.	1191061 ▲	1191063 ▲
Size	30	50
D1 mm	Ø 36	Ø 55,5
D2 mm	Ø 38	Ø 58
G1	M42x1,5	M62x1,5
G2	M42x1,5	M62x1,5
L1 mm	69,6	101
L2 mm	29	40
L4 mm	21	35,5
L5 mm	16	27
Clamping force kN	30	50
Operating pressure bar	100	80

Accessories built-in clamping head RESK



C 15
Adaptor ring

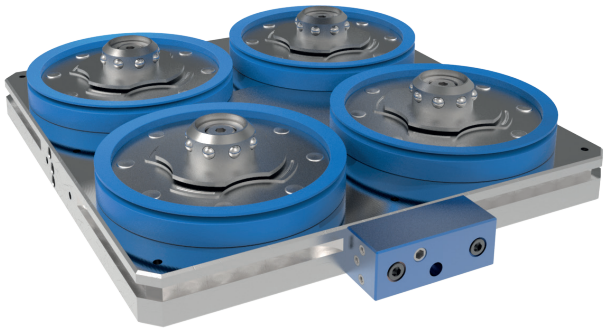
Item no.	Size	D2 mm	G2	L2 mm	L4 mm
1196524 ▲	30	Ø 38	M42x1,5	16	21
1195390 ▲	50	Ø 58	M62x1,5	27	35,5

C 15
Installation wrench

Item no.	Size
1296114 ▲	30
1296115 ▲	50

Power-Grip zero-point clamping system





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

ADVANTAGES AT A GLANCE

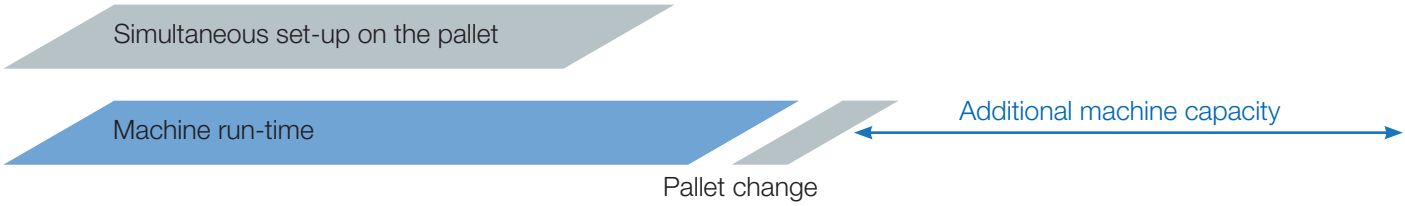
- Increase in productivity thanks to set-up time reduction up to 90 %
- Maximum precision and repeatability of 0.002 mm
- Palletizing and clamping device from one source

SET-UP TIME REDUCTION BY UP TO 90 %

Without palletizing system



With Power-Grip zero-point clamping system



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