RÖHM eShop
First B2B eShop of the clamping technology industry

The first B2B eShop of the clamping technology industry provides you with the comprehensive range of RÖHM catalogue products. In addition the customer receives extensive product information. Possibility to order in the eShop as an existing customer as well as a guest customer by credit card or bank transfer.

- Buy RÖHM products online 24/7
- Order as a guest customer without registration
- Intuitive search and filter function

The first B2B eShop of the clamping technology industry provides you with the comprehensive range of RÖHM catalogue products. In addition the customer receives extensive product information. Possibility to order in the eShop as an existing customer as well as a guest customer by credit card or bank transfer.

www.eshop.roehm.biz
# Table of contents

## VICES

### NC-Compact vices
- RKE 4012
- RKE-LV 4024
- RKK 4030

### NC-Compact twin vices
- RKD 4040
- RKD-M 4046

### NC-Compact self centering vices
- RZM 4056
- RKZ 4060
- RKZ-M 4066

### Machine vices
- RB-K - Orange Line 4076
- RB-M - Orange Line 4082
- RBA 4088
- RBAW 4094
- MSR 4100
- RS 4102
- UZ 4106

### Drilling machine vices
- BSS 4112
- BOF 4112
- BSH 4113
- DPV 4114
- DPV-3-W 4114

### Grinding and inspection vice
- PL-S micro 4118
- PL-S 4118
- PLF 4119
- PL-G 4119
- PS-SV 4120
- PS-ZD 4120

Errors and corrections are reserved!
## Operation guide

### Vices

<table>
<thead>
<tr>
<th>TYPE</th>
<th>RKE</th>
<th>RKE-LV</th>
<th>RKK</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>NC-Compact vices</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Features</td>
<td>- Highest clamping precision</td>
<td>- Very good accessibility for 5-axis machining</td>
<td>- Designed to resist deformation for the highest clamping precision</td>
</tr>
<tr>
<td></td>
<td>- Clamping force presetting</td>
<td>- Clamping force presetting</td>
<td>- Greatest repeatability</td>
</tr>
<tr>
<td></td>
<td>- Precise, wear-resistant body</td>
<td>- Large clamping range</td>
<td>- Clamping force presetting</td>
</tr>
<tr>
<td>Clamping system</td>
<td>mechanical-mechanical size 92: mechanical-hydraulic</td>
<td>mechanical-mechanical size 92: mechanical-hydraulic</td>
<td>mechanical-mechanical size 92: mechanical-hydraulic</td>
</tr>
<tr>
<td>Force amplification</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>Set-up options</td>
<td>3-Side Duo-Tower Quattro-Tower</td>
<td>Base</td>
<td>3-Side Duo-Tower Quattro-Tower</td>
</tr>
<tr>
<td>Machining centers with high working accuracy</td>
<td>✔ ✔ ✔</td>
<td>✔ ✔ ✗</td>
<td>✔ ✔ ✔</td>
</tr>
<tr>
<td>Universal milling machines with high working accuracy</td>
<td>✔ ✔ ✔</td>
<td>✔ ✔ ✔</td>
<td>✔ ✔ ✔</td>
</tr>
<tr>
<td>Universal milling machines standard version</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>Jig boring machines</td>
<td>✔ ✔ ✔</td>
<td>✔ ✔ ✔</td>
<td>✔ ✔ ✔</td>
</tr>
<tr>
<td>5-axis machining</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>Grinding machines</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>Series production</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>For limited space</td>
<td>✔</td>
<td>✔</td>
<td>✔</td>
</tr>
</tbody>
</table>

| Jaw width mm | 92 | 125 | 160 | 200 | 92 | 113 | 113 | 135 | 160 | 200 |
| 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 heighted stepped jaws
**Operation guide**

<table>
<thead>
<tr>
<th>TYPE</th>
<th>RKD</th>
<th>RKD-M</th>
<th>RZM</th>
<th>RKZ</th>
<th>RKZ-M</th>
</tr>
</thead>
</table>
| 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  
- Clamping force presetting  | - Double clamping  
- 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  | - High  
- Greatest average precision and repeatability  
- Minimum collision contour  | - 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  |  
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  
1)  | 125  
1)  | 50  
1)  | 70  
1)  | 92  
1)  | 125  
1)  | 125  
1)  |
| Clamping range (max.) | 127  
1)  | 127  
1)  | 127  
1)  | 127  
1)  | 127  
1)  | 127  
1)  | 127  
1)  | 127  
1)  | 127  
1)  | 127  
1)  | 127  
1)  |
| Length (opened) mm | 500  
1)  | 667  
1)  | 490  
1)  | 617  
1)  | 298  
1)  | 218  
1)  | 565  
1)  | 157  
1)  | 209  
1)  | 283  
1)  | 353  
1)  | 353  
1)  |
| Width mm | 94  
1)  | 126  
1)  | 94  
1)  | 126  
1)  | 125  
1)  | 125  
1)  | 125  
1)  | 125  
1)  | 125  
1)  | 125  
1)  | 125  
1)  | 125  
1)  |
| Height mm | 117  
1)  | 145  
1)  | 117  
1)  | 145  
1)  | 196,5  
1)  | 196,5  
1)  | 170  
1)  | 75  
1)  | 95  
1)  | 117  
1)  | 145  
1)  | 165  
1)  |
| Clamping force (max.) kN | 25  
1)  | 40  
1)  | 25  
1)  | 40  
1)  | 25  
1)  | 25  
1)  | 25  
1)  | 25  
1)  | 25  
1)  | 25  
1)  | 25  
1)  | 25  
1)  |
| Weight kg | 24  
1)  | 53  
1)  | 24  
1)  | 52  
1)  | 17,4  
1)  | 20,3  
1)  | 50,5  
1)  | 3,5  
1)  | 7  
1)  | 18  
1)  | 32,5  
1)  | 35  
1)  |
| Page | 4040  | 4046  | 4056  | 4060  | 4066  |

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

---

*www.eshop.roehm.biz*
**Operation guide**

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

---

**Page**

4076  4082  4088  4094
**Operation guide**

<table>
<thead>
<tr>
<th>TYPE</th>
<th>MSR</th>
<th>RS</th>
<th>UZ</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine vices</td>
<td>- Fast clamping range adjustment using the pin system</td>
<td>- Made of special steel casting for flexible application</td>
<td>- Centric clamping - Spindle covered in the working area</td>
</tr>
<tr>
<td>Features</td>
<td>- Made of special steel casting for flexible application</td>
<td>- Entire clamping range can be reached by turning the crank</td>
<td></td>
</tr>
<tr>
<td>Clamping system</td>
<td>mechanical</td>
<td>mechanical</td>
<td>mechanical</td>
</tr>
<tr>
<td>Set-up options</td>
<td>Base</td>
<td>Base</td>
<td>Base</td>
</tr>
<tr>
<td>Machining centers with high working accuracy</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>Universal milling machines with high working accuracy</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>Universal milling machines standard version</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>Jig boring machines</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5-axis machining</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Grinding machines</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>Series production</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>For limited space</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>Jaw width mm</td>
<td>125 150 150 175 92 135 160 200 113 135 160 200 250</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Clamping range (max.)</td>
<td>150 200 300 400 85 105 125 145 185 110 140 180 300 400</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Length (opened) mm</td>
<td>401 435 487 510 701 850 1050 1300 1600 1850 2000 2300 2900 4000</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Width mm</td>
<td>95 125 125 145 160 160 200 240 280 132 152 180 200 220</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Height mm</td>
<td>80 100 100 118 79,6 89,6 103,6 119,6 144,6 92,6 105,1 123,6 141,6 147,6</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Clamping force (max.) kN</td>
<td>30 50 50 60 18 25 35 45 55 15 22 24 25 28</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Weight kg</td>
<td>12,7 25,6 29,5 51,2 12 13,5 25 40 65 12,4 19 31 52 71</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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

## Drilling machine vices

<table>
<thead>
<tr>
<th>TYPE</th>
<th>BSS</th>
<th>BOF</th>
<th>BSH</th>
<th>DPV</th>
<th>DPV 3-W</th>
</tr>
</thead>
</table>
| **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 | - 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**

<table>
<thead>
<tr>
<th>Jaw width mm</th>
<th>110</th>
<th>135</th>
<th>90</th>
<th>110</th>
<th>135</th>
<th>160</th>
<th>65</th>
<th>80</th>
<th>100</th>
<th>80</th>
<th>100</th>
<th>120</th>
<th>140</th>
<th>80</th>
<th>100</th>
<th>120</th>
<th>150</th>
<th>100</th>
</tr>
</thead>
<tbody>
<tr>
<td>Clamping range (max.) mm</td>
<td>100</td>
<td>160</td>
<td>90</td>
<td>130</td>
<td>160</td>
<td>220</td>
<td>65</td>
<td>85</td>
<td>80</td>
<td>80</td>
<td>95</td>
<td>110</td>
<td>150</td>
<td>70</td>
<td>92</td>
<td>110</td>
<td>125</td>
<td>93</td>
</tr>
<tr>
<td>Length (opened) mm</td>
<td>510</td>
<td>587</td>
<td>195</td>
<td>315</td>
<td>365</td>
<td>445</td>
<td>125</td>
<td>150</td>
<td>170</td>
<td>200</td>
<td>215</td>
<td>260</td>
<td>300</td>
<td>154</td>
<td>175</td>
<td>225</td>
<td>238</td>
<td>189</td>
</tr>
<tr>
<td>Width mm</td>
<td>175</td>
<td>205</td>
<td>145</td>
<td>175</td>
<td>205</td>
<td>245</td>
<td>105</td>
<td>130</td>
<td>175</td>
<td>140</td>
<td>175</td>
<td>215</td>
<td>220</td>
<td>142</td>
<td>152</td>
<td>180</td>
<td>198</td>
<td>159</td>
</tr>
<tr>
<td>Height mm</td>
<td>72,5</td>
<td>80,5</td>
<td>60</td>
<td>72,5</td>
<td>80,5</td>
<td>95,5</td>
<td>43</td>
<td>46</td>
<td>47</td>
<td>70</td>
<td>75</td>
<td>85</td>
<td>85</td>
<td>58</td>
<td>63,5</td>
<td>63,5</td>
<td>65</td>
<td>65</td>
</tr>
<tr>
<td>Clamping force (max.) kN</td>
<td>10</td>
<td>10</td>
<td>8</td>
<td>10</td>
<td>12</td>
<td>15</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Weight kg</td>
<td>9,5</td>
<td>13,5</td>
<td>5,5</td>
<td>9,5</td>
<td>13,5</td>
<td>25</td>
<td>1,2</td>
<td>1,7</td>
<td>4,2</td>
<td>5</td>
<td>7</td>
<td>11</td>
<td>12,5</td>
<td>3,6</td>
<td>4,3</td>
<td>6,3</td>
<td>8,1</td>
<td>5,1</td>
</tr>
</tbody>
</table>

**Page**

4112 | 4112 | 4113 | 4114 | 4114
# Vices

## Operation guide

**Grinding and inspection vice**

<table>
<thead>
<tr>
<th>TYPE</th>
<th>PL-S micro</th>
<th>PL-S</th>
<th>PLF</th>
<th>PL-G</th>
<th>PS-SV</th>
<th>PS-ZD</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Features</strong></td>
<td></td>
<td>- Draw-down effect</td>
<td>- Draw-down effect</td>
<td>- Clamping and releasing with threaded spindle</td>
<td>- Made of alloyed tool steel, hardened and finely ground</td>
<td>- Positive locking in any desired angular position</td>
</tr>
<tr>
<td></td>
<td>- Simple clamping and releasing with allen key</td>
<td>- Made of alloyed tool steel, hardened and finely ground</td>
<td>- Horizontal and vertical ground prism</td>
<td>- Made of alloyed tool steel, hardened and finely ground</td>
<td>- Bearing and location pins hardened and ground with a precision of 0.001 mm</td>
<td>- Can be rotated 360°</td>
</tr>
<tr>
<td></td>
<td>- Clamping jaw adjustable in steps; engages automatically</td>
<td>- No spindle which could become dirty during erosion</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Clamping system</strong></td>
<td>mechanical, manually operated</td>
<td>mechanical, manually operated</td>
<td>mechanical, manually operated</td>
<td>mechanical, manually operated</td>
<td>mechanical, manually operated</td>
<td>mechanical, manually operated</td>
</tr>
<tr>
<td><strong>Force amplification</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Set-up options</strong></td>
<td>Base</td>
<td>Base</td>
<td>Base</td>
<td>Base</td>
<td>Base</td>
<td>Base</td>
</tr>
<tr>
<td></td>
<td>Machining centers with high working accuracy</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Universal milling machines with high working accuracy</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Universal milling machines standard version</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Jig boring machines</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>5-axis machining</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Grinding machines</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Series production</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>For limited space</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Jaw width mm</td>
<td>34</td>
<td>45</td>
<td>70</td>
<td>90</td>
<td>120</td>
<td>50</td>
</tr>
<tr>
<td>Clamping range (max.)</td>
<td>25</td>
<td>50</td>
<td>80</td>
<td>120</td>
<td>150</td>
<td>65</td>
</tr>
<tr>
<td>Length (opened) mm</td>
<td>75</td>
<td>110</td>
<td>160</td>
<td>210</td>
<td>280</td>
<td>140</td>
</tr>
<tr>
<td>Width mm</td>
<td>34</td>
<td>45</td>
<td>70</td>
<td>90</td>
<td>120</td>
<td>50</td>
</tr>
<tr>
<td>Height mm</td>
<td>35</td>
<td>45</td>
<td>62</td>
<td>80</td>
<td>90</td>
<td>50</td>
</tr>
<tr>
<td>Clamping force (max.) kN</td>
<td>2</td>
<td>2</td>
<td>2.5</td>
<td>3</td>
<td>4</td>
<td>1.6</td>
</tr>
<tr>
<td>Weight kg</td>
<td>0.35</td>
<td>1</td>
<td>3</td>
<td>5.8</td>
<td>13.5</td>
<td>1.4</td>
</tr>
<tr>
<td><strong>Page</strong></td>
<td>4118</td>
<td>4119</td>
<td>4119</td>
<td>4120</td>
<td>4120</td>
<td>4120</td>
</tr>
</tbody>
</table>

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

[www.eshop.roehm.biz](http://www.eshop.roehm.biz)
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.

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.

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

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.
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.

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!

CENTRIC CLAMPING

The two movable clamping jaws are brought to the workpiece by clockwise turning of the spindle with the hand-crank (left-hand/ right-hand thread). Turning the hand-crank further in clockwise direction all the way exceeds the release torque of the coupling pin and initiates mechanical power transmission of the toggle lever. The accumulating pressure is distributed evenly over the push-and-draw spindle on the clamping jaws. Form-fitted racks in the lower area of the main jaw mesh towards the center into a centrally mounted gear. This connection effects the synchronous, respectively simultaneous centrical motion of the movable clamping jaw over the entire clamping stroke, regardless of clamping force and clamping span.
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.
NC-compact vices are particularly suited for use on machining centers, milling machines and are ideal for 5-axis machining. These premium vices are very impressive with their stable and compact design for maximum clamping accuracy and optimal workpiece accessibility. By simply turning the clamping force presetting, a clamping force of up to 60 kN can be achieved. With workpieces that are sensitive to deformation, the force amplification can be disabled.

ADVANTAGES AT A GLANCE

- Large clamping range and precise positioning due to fixed clamping jaw
- The compact design resists deformation for the greatest possible clamping precision
- Consistent clamping force and maximum repeatability of 0.01 mm
APPLICATION
Particularly suitable for use on machining centers.

TYPE
Size 92 - clamping system mechanical-hydraulic with power transmitter, manually operated.
Size 125, 160 and 200 - clamping system mechanical-mechanical with power transmitter, manually operated.

CUSTOMER BENEFITS
- 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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>178411</th>
<th>178412</th>
<th>178413</th>
<th>178414</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jaw width A mm</td>
<td>92</td>
<td>125</td>
<td>160</td>
<td>200</td>
</tr>
<tr>
<td>Jaw design</td>
<td>stepped jaws</td>
<td>stepped jaws</td>
<td>stepped jaws</td>
<td>stepped jaws</td>
</tr>
<tr>
<td>B2 mm</td>
<td>0 - 138</td>
<td>0 - 216</td>
<td>0 - 320</td>
<td>0 - 315</td>
</tr>
<tr>
<td>B3 mm</td>
<td>71 - 208</td>
<td>97 - 312</td>
<td>131 - 451</td>
<td>131 - 451</td>
</tr>
<tr>
<td>C mm</td>
<td>32</td>
<td>40</td>
<td>50</td>
<td>60</td>
</tr>
<tr>
<td>D mm</td>
<td>330</td>
<td>463</td>
<td>618</td>
<td>618</td>
</tr>
<tr>
<td>E mm</td>
<td>112</td>
<td>140</td>
<td>185</td>
<td>175</td>
</tr>
<tr>
<td>F mm</td>
<td>276</td>
<td>400</td>
<td>530</td>
<td>530</td>
</tr>
<tr>
<td>G - 0.02 mm</td>
<td>80</td>
<td>100</td>
<td>115</td>
<td>115</td>
</tr>
<tr>
<td>H2 mm</td>
<td>80</td>
<td>112.5</td>
<td>130</td>
<td>135</td>
</tr>
<tr>
<td>H3 mm</td>
<td>41</td>
<td>56.5</td>
<td>64</td>
<td>64</td>
</tr>
<tr>
<td>J2 mm</td>
<td>56</td>
<td>70</td>
<td>97</td>
<td>97</td>
</tr>
<tr>
<td>K/mm</td>
<td>94</td>
<td>126</td>
<td>162</td>
<td>162</td>
</tr>
<tr>
<td>L2 mm</td>
<td>64</td>
<td>94</td>
<td>98</td>
<td>103</td>
</tr>
<tr>
<td>M/mm</td>
<td>25</td>
<td>40</td>
<td>34</td>
<td>39</td>
</tr>
<tr>
<td>M'/mm</td>
<td>25</td>
<td>30</td>
<td>32.5</td>
<td>32.5</td>
</tr>
<tr>
<td>N - 0.1 mm</td>
<td>16</td>
<td>20</td>
<td>25</td>
<td>25</td>
</tr>
<tr>
<td>U mm</td>
<td>20</td>
<td>20</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>V mm</td>
<td>12</td>
<td>12</td>
<td>12</td>
<td>12</td>
</tr>
<tr>
<td>W mm</td>
<td>68</td>
<td>1x108</td>
<td>2x102.5</td>
<td>2x102.5</td>
</tr>
<tr>
<td>X/mm</td>
<td>10</td>
<td>10</td>
<td>10</td>
<td>10</td>
</tr>
<tr>
<td>Y/mm</td>
<td>15</td>
<td>15</td>
<td>15</td>
<td>15</td>
</tr>
<tr>
<td>Z/mm</td>
<td>70</td>
<td>109</td>
<td>117</td>
<td>117</td>
</tr>
<tr>
<td>a mm</td>
<td>63</td>
<td>80</td>
<td>100</td>
<td>125</td>
</tr>
<tr>
<td>b mm</td>
<td>13.6</td>
<td>15.6</td>
<td>19.6</td>
<td>24.6</td>
</tr>
<tr>
<td>c1</td>
<td>M 6x14</td>
<td>M 8x14</td>
<td>M 8x14</td>
<td>M 10x15</td>
</tr>
<tr>
<td>c2</td>
<td>M 5x9</td>
<td>M 5x10</td>
<td>M 5x9</td>
<td>M 5x10</td>
</tr>
<tr>
<td>c3</td>
<td>M 10x16</td>
<td>M 10x18</td>
<td>M 10x18</td>
<td>M 14x20</td>
</tr>
<tr>
<td>d mm</td>
<td>48</td>
<td>60</td>
<td>80</td>
<td>110</td>
</tr>
<tr>
<td>e mm</td>
<td>8</td>
<td>12</td>
<td>12</td>
<td>12</td>
</tr>
<tr>
<td>f mm</td>
<td>14</td>
<td>18</td>
<td>20</td>
<td>25</td>
</tr>
<tr>
<td>g mm</td>
<td>70</td>
<td>96</td>
<td>125</td>
<td>125</td>
</tr>
<tr>
<td>Ø k</td>
<td>M10x18</td>
<td>M12x22</td>
<td>M16x25</td>
<td>M16x25</td>
</tr>
<tr>
<td>l mm</td>
<td>140</td>
<td>240</td>
<td>200</td>
<td>200</td>
</tr>
<tr>
<td>m2 ± 0.02 mm</td>
<td>60</td>
<td>127.5</td>
<td>70</td>
<td>65</td>
</tr>
<tr>
<td>n± 0.02 mm</td>
<td>99</td>
<td>183.5</td>
<td>136</td>
<td>136</td>
</tr>
<tr>
<td>y± 0.01 mm</td>
<td>40</td>
<td>47.5</td>
<td>57.5</td>
<td>57.5</td>
</tr>
<tr>
<td>z mm</td>
<td>72</td>
<td>100</td>
<td>135</td>
<td>135</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>25</td>
<td>40</td>
<td>80</td>
<td>85</td>
</tr>
<tr>
<td>Weight kg</td>
<td>15</td>
<td>41</td>
<td>79</td>
<td>85</td>
</tr>
</tbody>
</table>
## Accessories RKE

### Standard top jaws SA, reversible

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>162628</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
</tr>
<tr>
<td>162629</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>50</td>
</tr>
<tr>
<td>162984</td>
<td>set</td>
<td>200</td>
<td>200</td>
<td>60</td>
</tr>
</tbody>
</table>

### Stepped jaws SB, reversible

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>178776</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>178230</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
</tr>
<tr>
<td>178754</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>50</td>
</tr>
<tr>
<td>178937</td>
<td>set</td>
<td>200</td>
<td>200</td>
<td>60</td>
</tr>
</tbody>
</table>

### Double stepped jaws DSB, “smooth”

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>168698</td>
<td>set</td>
<td>92</td>
<td>50</td>
<td>48</td>
</tr>
<tr>
<td>168693</td>
<td>set</td>
<td>125</td>
<td>62</td>
<td>60</td>
</tr>
<tr>
<td>175387</td>
<td>set</td>
<td>160</td>
<td>95</td>
<td>75</td>
</tr>
</tbody>
</table>

### Carrier jaws TB, without swivelling claw inserts

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>165856</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>20</td>
</tr>
<tr>
<td>166218</td>
<td>set</td>
<td>160/200</td>
<td>160</td>
<td>25</td>
</tr>
</tbody>
</table>

### Carrier jaws, without claw inserts

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>169383</td>
<td>set</td>
<td>92</td>
<td>115</td>
<td>20</td>
</tr>
<tr>
<td>165861</td>
<td>set</td>
<td>125</td>
<td>160</td>
<td>20</td>
</tr>
<tr>
<td>166223</td>
<td>set</td>
<td>160/200</td>
<td>200</td>
<td>25</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Ø A mm</th>
<th>Ø J mm</th>
<th>C mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>165854</td>
<td>piece</td>
<td>92/125</td>
<td>28</td>
<td>20</td>
</tr>
<tr>
<td>166216</td>
<td>piece</td>
<td>160/200</td>
<td>30</td>
<td>22</td>
</tr>
</tbody>
</table>
## Accessories RKE

### A37

**Tensioner** for carrier jaws 743-72

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Ø A mm</th>
<th>Ø J mm</th>
<th>C mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>169389</td>
<td>piece</td>
<td>92/125</td>
<td>28</td>
<td>20</td>
<td>10</td>
</tr>
<tr>
<td>169391</td>
<td>piece</td>
<td>160/200</td>
<td>30</td>
<td>22</td>
<td>10</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>160352</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>60</td>
</tr>
<tr>
<td>160353</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>70</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>152752</td>
<td>piece</td>
<td>92</td>
<td>92</td>
<td>31,6</td>
</tr>
<tr>
<td>178112</td>
<td>piece</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
<tr>
<td>152755</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>152759</td>
<td>piece</td>
<td>200</td>
<td>200</td>
<td>62,6</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163218</td>
<td>piece</td>
<td>92</td>
<td>92</td>
<td>31,6</td>
</tr>
<tr>
<td>180679</td>
<td>piece</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
<tr>
<td>150179</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>150198</td>
<td>piece</td>
<td>200</td>
<td>200</td>
<td>62,6</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166514</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>14</td>
</tr>
<tr>
<td>166520</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
<tr>
<td>166522</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>50</td>
<td>18</td>
</tr>
</tbody>
</table>
Accessories RKE

A37
Claw jaws without step, universal for clamping depth > 2.5 mm

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166661</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>166667</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
</tr>
<tr>
<td>166669</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>50</td>
</tr>
</tbody>
</table>

A37
Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Web height A mm</th>
<th>Jaw width B mm</th>
<th>Rail height H mm</th>
<th>Guiding width C mm</th>
<th>Spare clamp (Set = 4 pieces)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1269621</td>
<td>48</td>
<td>92</td>
<td>10/16/18/20/22/24/26/28/30/32</td>
<td>94</td>
<td>1269624</td>
</tr>
<tr>
<td>1269622</td>
<td>68</td>
<td>125</td>
<td>10/15/20/25/28/30/33/35/36/37</td>
<td>126</td>
<td>1269625</td>
</tr>
<tr>
<td>1269623</td>
<td>83</td>
<td>160/200</td>
<td>10/15/20/25/30/35/40/43/45/47</td>
<td>162</td>
<td>1269626</td>
</tr>
</tbody>
</table>

A37
V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN, only suitable for double clamping

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>128770</td>
<td>piece</td>
<td>92</td>
<td>31,6</td>
<td>3-13</td>
</tr>
<tr>
<td>082363</td>
<td>piece</td>
<td>125</td>
<td>39,6</td>
<td>4-20</td>
</tr>
<tr>
<td>082364</td>
<td>piece</td>
<td>160</td>
<td>49,6</td>
<td>5-29</td>
</tr>
<tr>
<td>082365</td>
<td>piece</td>
<td>200</td>
<td>62,6</td>
<td>6-37</td>
</tr>
</tbody>
</table>

A37
Normal jaw SGN A, with movable workpiece stop, hardened and ground, only suitable for double clamping

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150740</td>
<td>piece</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>150741</td>
<td>piece</td>
<td>160</td>
<td>49,6</td>
</tr>
</tbody>
</table>

A37
Draw-down jaws SNF, with spring plate, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077105</td>
<td>set</td>
<td>125</td>
<td>39,6</td>
</tr>
<tr>
<td>077106</td>
<td>set</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>077107</td>
<td>set</td>
<td>200</td>
<td>62,6</td>
</tr>
</tbody>
</table>

A37
V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>317260</td>
<td>set</td>
<td>135</td>
<td>39,8</td>
<td>3-13</td>
</tr>
<tr>
<td>317261</td>
<td>set</td>
<td>160</td>
<td>49,8</td>
<td>5-22</td>
</tr>
</tbody>
</table>
## Accessories RKE

### A37
**Draw-down jaws RNG**, with two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155237</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>159227</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39.5</td>
</tr>
<tr>
<td>155240</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>50</td>
</tr>
<tr>
<td>163782</td>
<td>set</td>
<td>200</td>
<td>200</td>
<td>60</td>
</tr>
</tbody>
</table>

### A37
**Standard insert RNS**, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155242</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>159232</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
<tr>
<td>155245</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>50</td>
<td>30</td>
</tr>
<tr>
<td>163783</td>
<td>set</td>
<td>200</td>
<td>200</td>
<td>60</td>
<td>34</td>
</tr>
</tbody>
</table>

### A37
**Standard insert finely checkered RNSf**, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163270</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>163267</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
<tr>
<td>163273</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>50</td>
<td>30</td>
</tr>
<tr>
<td>163784</td>
<td>set</td>
<td>200</td>
<td>200</td>
<td>60</td>
<td>34</td>
</tr>
</tbody>
</table>

### A37
**Claw insert RNK**, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155247</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>159235</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
<tr>
<td>155250</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>50</td>
<td>30</td>
</tr>
<tr>
<td>163785</td>
<td>set</td>
<td>200</td>
<td>200</td>
<td>60</td>
<td>34</td>
</tr>
</tbody>
</table>

*www.eshop.roehm.biz*
### Accessories RKE

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>156190</td>
<td>piece</td>
<td>92</td>
<td>113</td>
<td>32</td>
<td>36</td>
</tr>
<tr>
<td>156191</td>
<td>piece</td>
<td>125</td>
<td>135</td>
<td>40</td>
<td>40</td>
</tr>
<tr>
<td>156192</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>50</td>
<td>45</td>
</tr>
<tr>
<td>156193</td>
<td>piece</td>
<td>200</td>
<td>200</td>
<td>63</td>
<td>55</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Hexagon</th>
<th>A mm</th>
<th>L mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>134198</td>
<td>piece</td>
<td>92</td>
<td>12</td>
<td>60</td>
<td>90</td>
</tr>
<tr>
<td>134600</td>
<td>piece</td>
<td>125/160/200</td>
<td>14</td>
<td>104</td>
<td>160</td>
</tr>
</tbody>
</table>

**A37**

**Angle drive 90°**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>A mm</th>
<th>B mm</th>
<th>C mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>154185</td>
<td>piece</td>
<td>92</td>
<td>113,5</td>
<td>90</td>
<td>83,5</td>
</tr>
<tr>
<td>158339</td>
<td>piece</td>
<td>125</td>
<td>133</td>
<td>106</td>
<td>98</td>
</tr>
<tr>
<td>158888</td>
<td>piece</td>
<td>160/200</td>
<td>166</td>
<td>111</td>
<td>98</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x55</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x60</td>
</tr>
<tr>
<td>149124</td>
<td>piece</td>
<td>18</td>
<td>M16x60</td>
</tr>
<tr>
<td>158722</td>
<td>piece</td>
<td>20</td>
<td>M16x65</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x65</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014825</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014829</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>
Accessories RKE / RKK

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

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

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

A37
Standard basic plate GP for DUO-Tower, for NC-compact vices

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

---

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>178418</th>
<th>178419</th>
<th>178420</th>
<th>178421</th>
<th>178422</th>
<th>178423</th>
</tr>
</thead>
<tbody>
<tr>
<td>For</td>
<td>RKE 125</td>
<td>RKE 125</td>
<td>RKE 125</td>
<td>RKE 160</td>
<td>RKE 160</td>
<td>RKE 160</td>
</tr>
<tr>
<td>D</td>
<td>463</td>
<td>463</td>
<td>463</td>
<td>618</td>
<td>618</td>
<td>618</td>
</tr>
<tr>
<td>F</td>
<td>100</td>
<td>200</td>
<td>400</td>
<td>190</td>
<td>295</td>
<td>530</td>
</tr>
<tr>
<td>G</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>115</td>
<td>115</td>
<td>115</td>
</tr>
<tr>
<td>L</td>
<td></td>
<td></td>
<td></td>
<td>240</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>M</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>200</td>
</tr>
<tr>
<td>N</td>
<td>68</td>
<td>160</td>
<td>364</td>
<td>150</td>
<td>253</td>
<td>493</td>
</tr>
<tr>
<td>O</td>
<td>24</td>
<td>24</td>
<td>24</td>
<td>30</td>
<td>30</td>
<td>30</td>
</tr>
<tr>
<td>B1</td>
<td>0-215</td>
<td>0-215</td>
<td>0-215</td>
<td>0-320</td>
<td>0-320</td>
<td>0-320</td>
</tr>
<tr>
<td>B3 mm</td>
<td>97-312</td>
<td>97-312</td>
<td>97-312</td>
<td>131-451</td>
<td>131-451</td>
<td>131-451</td>
</tr>
<tr>
<td>B8</td>
<td></td>
<td></td>
<td>238-422</td>
<td>-</td>
<td>-</td>
<td>290-605</td>
</tr>
<tr>
<td>B9</td>
<td>121-335</td>
<td>213-427</td>
<td>416-630</td>
<td>215-535</td>
<td>318-638</td>
<td>560-875</td>
</tr>
<tr>
<td>B10</td>
<td>-</td>
<td>-</td>
<td>306-520</td>
<td>-</td>
<td>-</td>
<td>421-736</td>
</tr>
<tr>
<td>B11</td>
<td>218-432</td>
<td>310-524</td>
<td>514-728</td>
<td>346-666</td>
<td>449-769</td>
<td>681-1006</td>
</tr>
<tr>
<td>H8</td>
<td></td>
<td></td>
<td></td>
<td>302</td>
<td>-</td>
<td>370</td>
</tr>
<tr>
<td>H9</td>
<td>95</td>
<td>98</td>
<td>94</td>
<td>105</td>
<td>107</td>
<td>102</td>
</tr>
<tr>
<td>H10</td>
<td></td>
<td></td>
<td></td>
<td>248</td>
<td>-</td>
<td>304</td>
</tr>
<tr>
<td>H11</td>
<td>41</td>
<td>44</td>
<td>40</td>
<td>39</td>
<td>41</td>
<td>36</td>
</tr>
<tr>
<td>Weight kg</td>
<td>6,5</td>
<td>13</td>
<td>26</td>
<td>14</td>
<td>27</td>
<td>49</td>
</tr>
</tbody>
</table>

---

**www.eshop.roehm.biz**
NC-Compact vices

Duo and Quattro clamping towers RKE

Duo-clamping towers (on request)

Quattro-clamping towers (on request)

<table>
<thead>
<tr>
<th>Technical data</th>
<th>Size</th>
<th>RKE 125</th>
<th>RKE 160</th>
<th>RKE 200</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jaw width</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>A</td>
<td>250</td>
<td>350</td>
<td></td>
<td></td>
</tr>
<tr>
<td>B</td>
<td>250</td>
<td>350</td>
<td></td>
<td></td>
</tr>
<tr>
<td>C</td>
<td>45</td>
<td>45</td>
<td></td>
<td></td>
</tr>
<tr>
<td>D</td>
<td>528</td>
<td>663</td>
<td></td>
<td></td>
</tr>
<tr>
<td>E</td>
<td>200</td>
<td>230</td>
<td></td>
<td></td>
</tr>
<tr>
<td>F</td>
<td>578</td>
<td>741</td>
<td></td>
<td></td>
</tr>
<tr>
<td>G*</td>
<td>110,5</td>
<td>130</td>
<td></td>
<td></td>
</tr>
<tr>
<td>H</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>J*</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>K*</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>L*</td>
<td>105</td>
<td>200</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

* On inquiry insert dimensions please

Technical data

<table>
<thead>
<tr>
<th>Size</th>
<th>RKE 125</th>
<th>RKE 160</th>
<th>RKE 200</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jaw width</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>A</td>
<td>350</td>
<td>400</td>
<td></td>
</tr>
<tr>
<td>B</td>
<td>350</td>
<td>400</td>
<td></td>
</tr>
<tr>
<td>C</td>
<td>45</td>
<td>45</td>
<td></td>
</tr>
<tr>
<td>D</td>
<td>528</td>
<td>663</td>
<td></td>
</tr>
<tr>
<td>E</td>
<td>325</td>
<td>392</td>
<td></td>
</tr>
<tr>
<td>F</td>
<td>578</td>
<td>741</td>
<td></td>
</tr>
<tr>
<td>G*</td>
<td>110,5</td>
<td>130</td>
<td></td>
</tr>
<tr>
<td>H</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>J*</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>K*</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>L*</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>kg</td>
<td>210</td>
<td>375</td>
<td></td>
</tr>
</tbody>
</table>

* On inquiry insert dimensions please

www.eshop.roehm.biz
## NC-Compact vices

### Clamping range RKE

<table>
<thead>
<tr>
<th></th>
<th>Standard jaws</th>
<th>Stepped jaws</th>
<th>Carrier jaws with pronged inserts</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>H1</td>
<td>B1</td>
<td>H2</td>
</tr>
</tbody>
</table>

### Clamping jaw dimensions for NC-Compact vices

#### Standard top jaws - set

<table>
<thead>
<tr>
<th></th>
<th>125</th>
<th>160</th>
<th>200</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jaw width</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Id.-Nr.</td>
<td>162828</td>
<td>162829</td>
<td>162844</td>
</tr>
<tr>
<td>B</td>
<td>92</td>
<td>100</td>
<td>105</td>
</tr>
<tr>
<td>C</td>
<td>40</td>
<td>50</td>
<td>60</td>
</tr>
<tr>
<td>D</td>
<td>58</td>
<td>65</td>
<td>65</td>
</tr>
<tr>
<td>E&lt;sub&gt;2&lt;/sub&gt;</td>
<td>24</td>
<td>30</td>
<td>30</td>
</tr>
<tr>
<td>F</td>
<td>78</td>
<td>100</td>
<td>100</td>
</tr>
<tr>
<td>G&lt;sub&gt;1&lt;/sub&gt;</td>
<td>51</td>
<td>65</td>
<td>65</td>
</tr>
<tr>
<td>J&lt;sub&gt;1&lt;/sub&gt;</td>
<td>24</td>
<td>30</td>
<td>30</td>
</tr>
<tr>
<td>a</td>
<td>80</td>
<td>100</td>
<td>125</td>
</tr>
<tr>
<td>b</td>
<td>15,6</td>
<td>19,6</td>
<td>24,6</td>
</tr>
<tr>
<td>c&lt;sub&gt;1&lt;/sub&gt;</td>
<td>M8</td>
<td>M6</td>
<td>M6</td>
</tr>
<tr>
<td>c&lt;sub&gt;2&lt;/sub&gt;</td>
<td>M8</td>
<td>M6</td>
<td>M6</td>
</tr>
<tr>
<td>c&lt;sub&gt;3&lt;/sub&gt;</td>
<td>M14</td>
<td>M10</td>
<td>M10</td>
</tr>
<tr>
<td>d</td>
<td>60</td>
<td>80</td>
<td>110</td>
</tr>
<tr>
<td>e</td>
<td>12</td>
<td>12</td>
<td>12</td>
</tr>
<tr>
<td>f</td>
<td>18</td>
<td>20</td>
<td>25</td>
</tr>
</tbody>
</table>

#### Stepped jaws - set

<table>
<thead>
<tr>
<th></th>
<th>125</th>
<th>160</th>
<th>200</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jaw width</td>
<td>92</td>
<td>125</td>
<td>160</td>
</tr>
<tr>
<td>Id.-Nr.</td>
<td>162851</td>
<td>162843</td>
<td>162830</td>
</tr>
<tr>
<td>B</td>
<td>64</td>
<td>94</td>
<td>98</td>
</tr>
<tr>
<td>C</td>
<td>92</td>
<td>100</td>
<td>105</td>
</tr>
<tr>
<td>D</td>
<td>42</td>
<td>60</td>
<td>65</td>
</tr>
<tr>
<td>E&lt;sub&gt;2&lt;/sub&gt;</td>
<td>20</td>
<td>24</td>
<td>30</td>
</tr>
<tr>
<td>F</td>
<td>56</td>
<td>70</td>
<td>97</td>
</tr>
<tr>
<td>G</td>
<td>38</td>
<td>47</td>
<td>63,5</td>
</tr>
<tr>
<td>H&lt;sub&gt;H&lt;/sub&gt;</td>
<td>25/25</td>
<td>40/30</td>
<td>34/32,5</td>
</tr>
<tr>
<td>J&lt;sub&gt;1&lt;/sub&gt;</td>
<td>20</td>
<td>24</td>
<td>30</td>
</tr>
<tr>
<td>a</td>
<td>63</td>
<td>80</td>
<td>100</td>
</tr>
<tr>
<td>b</td>
<td>13,6</td>
<td>15,6</td>
<td>19,6</td>
</tr>
<tr>
<td>c&lt;sub&gt;1&lt;/sub&gt;</td>
<td>M6</td>
<td>M8</td>
<td>M8</td>
</tr>
<tr>
<td>c&lt;sub&gt;2&lt;/sub&gt;</td>
<td>M6</td>
<td>M8</td>
<td>M8</td>
</tr>
<tr>
<td>c&lt;sub&gt;3&lt;/sub&gt;</td>
<td>M14</td>
<td>M10</td>
<td>M10</td>
</tr>
<tr>
<td>d</td>
<td>48</td>
<td>60</td>
<td>80</td>
</tr>
<tr>
<td>e</td>
<td>8</td>
<td>12</td>
<td>12</td>
</tr>
<tr>
<td>f</td>
<td>14</td>
<td>18</td>
<td>20</td>
</tr>
</tbody>
</table>
NC-Compact vices

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, inc. swivellable claw inserts. For round and rectangular workpieces
- Clamping ranges carrier jaws:
  - Rectangular workpieces: 35 - 215 mm
  - Circular workpieces: 65 - 225 mm

<table>
<thead>
<tr>
<th>Item</th>
<th>Jaw width A mm</th>
<th>Jaw design</th>
<th>Item</th>
<th>Jaw width A mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>180464</td>
<td>125</td>
<td>stepped jaws</td>
<td>180465</td>
<td>125</td>
</tr>
<tr>
<td>125</td>
<td>stepped jaws</td>
<td>125</td>
<td>carrier jaws</td>
<td></td>
</tr>
<tr>
<td>0.96</td>
<td>35-215</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>90-192</td>
<td>65-225</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>40</td>
<td>20</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>385</td>
<td>385</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>140</td>
<td>130</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>280</td>
<td>280</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>100</td>
<td>100</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>70</td>
<td>78</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>126</td>
<td>126</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>145</td>
<td>146</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>94</td>
<td>105</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>40</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>30</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>20</td>
<td>20</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>30</td>
<td>30</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>53.5</td>
<td>53.5</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>87.5</td>
<td>87.5</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>20</td>
<td>20</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>40</td>
<td>40</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>13</td>
<td>13</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>60</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>15.6</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>M10</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>M8</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>M5</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>80</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>12</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>18</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>27.5</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>83.5</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>30</td>
<td>30</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>120</td>
<td>120</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>46</td>
<td>46</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>95</td>
<td>95</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>M12x20</td>
<td>M12x20</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>40</td>
<td>40</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>-</td>
<td>28</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>-</td>
<td>26.5</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>10</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>38</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>17</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>22</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>15</td>
<td>-</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>29</td>
<td>29</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><a href="http://www.eshop.roehm.biz">www.eshop.roehm.biz</a></td>
<td>- on request</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
Accessories RKE-LV

A37
Standard base plate GP

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>165852</td>
<td>piece</td>
<td>125</td>
<td>280</td>
<td>126</td>
<td>90</td>
<td>24</td>
</tr>
</tbody>
</table>

A37
Standard top jaws SA, reversible

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>162628</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>160352</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>60</td>
</tr>
</tbody>
</table>

A37
Stepped jaws SB, reversible

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>178230</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
</tr>
</tbody>
</table>

A37
Double stepped jaws DSB, “smooth”

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>168693</td>
<td>set</td>
<td>125</td>
<td>62</td>
<td>60</td>
</tr>
</tbody>
</table>

A37
Carrier jaws TB, without swiveling claw inserts

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>165856</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>20</td>
</tr>
</tbody>
</table>
## Accessories RKE-LV

### A37
**Carrier jaws, without claw inserts**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>165861</td>
<td>set</td>
<td>125</td>
<td>160</td>
<td>20</td>
</tr>
</tbody>
</table>

### A37
**Swivelling claw inserts, for carrier jaws 743-72**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Ø A mm</th>
<th>Ø J mm</th>
<th>C mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>165854</td>
<td>piece</td>
<td>92/125</td>
<td>28</td>
<td>20</td>
<td>10</td>
</tr>
</tbody>
</table>

### A37
**Tensioner for carrier jaws 743-72**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Ø A mm</th>
<th>Ø J mm</th>
<th>C mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>169389</td>
<td>piece</td>
<td>92/125</td>
<td>28</td>
<td>20</td>
<td>10</td>
</tr>
</tbody>
</table>

### A37
**Claw jaws with fine step, 2.5 mm clamping depth**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166520</td>
<td>set</td>
<td>160</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>

### A37
**Claw jaws without step, universal for clamping depth >2.5 mm**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166667</td>
<td>set</td>
<td>160</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>
NC-Compact vices

Accessories RKE-LV

**A37**
**Support rails Cliparc**, set with 10 different pairs of rails and 4 clamps in wooden box

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>1269622</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
</tbody>
</table>

**A37**
**Standard jaws SGN**, one side smooth, one side grooved, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>158897</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163225</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
</tbody>
</table>

**A37**
**V-jaw SPR**, with vertically and horizontally ground-in prisms, hardened, for combination with SGN

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>082363</td>
<td>piece</td>
<td>125</td>
<td>135</td>
<td>39,6</td>
<td>4-20</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>6-40</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150740</td>
<td>piece</td>
<td>125</td>
<td>135</td>
<td>39,6</td>
</tr>
</tbody>
</table>

**A37**
**Draw-down jaws SNF**, with spring plate, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077105</td>
<td>set</td>
<td>125</td>
<td>135</td>
<td>39,6</td>
</tr>
</tbody>
</table>
Accessories RKE-LV

A37
V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>317260</td>
<td>set</td>
<td>125</td>
<td>135</td>
<td>39,8</td>
<td>3-13 6-40</td>
</tr>
</tbody>
</table>

A37
Hand crank, turnable handle, hexagon socket

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Hexagon</th>
<th>A mm</th>
<th>L mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>134600</td>
<td>piece</td>
<td>125/160/200</td>
<td>14</td>
<td>104</td>
</tr>
</tbody>
</table>

A37
90° Angle drive

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>A mm</th>
<th>B mm</th>
<th>C mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>158339</td>
<td>piece</td>
<td>125</td>
<td>133</td>
<td>106</td>
<td>98</td>
</tr>
</tbody>
</table>

A37
Single clamp SPE, for mounting vices on end and on the base.

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x50</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x50</td>
</tr>
<tr>
<td>149124</td>
<td>piece</td>
<td>18</td>
<td>M12x50</td>
</tr>
<tr>
<td>155722</td>
<td>piece</td>
<td>20</td>
<td>M16x55</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x55</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014824</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014828</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>
**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, 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

### Item no.

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

\(^1\) With stepped jaws
## Accessories RKK

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>149233</td>
<td>set 2a</td>
<td></td>
<td>109</td>
<td>39</td>
</tr>
<tr>
<td>149236</td>
<td>set 3</td>
<td></td>
<td>132</td>
<td>49</td>
</tr>
<tr>
<td>149373</td>
<td>set 4</td>
<td></td>
<td>157</td>
<td>60</td>
</tr>
<tr>
<td>149374</td>
<td>set 5</td>
<td></td>
<td>197</td>
<td>70</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>149239</td>
<td>set 2a</td>
<td></td>
<td>108</td>
<td>49</td>
</tr>
<tr>
<td>149240</td>
<td>set 3</td>
<td></td>
<td>133</td>
<td>53</td>
</tr>
<tr>
<td>149375</td>
<td>set 4</td>
<td></td>
<td>158</td>
<td>67</td>
</tr>
<tr>
<td>149376</td>
<td>set 5</td>
<td></td>
<td>198</td>
<td>67</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>146687</td>
<td>set 2a</td>
<td></td>
<td>110</td>
<td>25</td>
</tr>
<tr>
<td>147748</td>
<td>set 3</td>
<td></td>
<td>135</td>
<td>30</td>
</tr>
<tr>
<td>146688</td>
<td>set 4</td>
<td></td>
<td>160</td>
<td>30</td>
</tr>
<tr>
<td>149384</td>
<td>set 5</td>
<td></td>
<td>200</td>
<td>30</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Ø J mm</th>
<th>C mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>146070</td>
<td>piece 3/4/5/2a</td>
<td></td>
<td>30</td>
<td>20</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166514</td>
<td>set 125</td>
<td>92</td>
<td>32</td>
<td>14</td>
<td></td>
</tr>
<tr>
<td>166520</td>
<td>set 160</td>
<td>125</td>
<td>40</td>
<td>16</td>
<td></td>
</tr>
<tr>
<td>166522</td>
<td>set 200</td>
<td>160</td>
<td>50</td>
<td>18</td>
<td></td>
</tr>
</tbody>
</table>
Accessories RKK

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166661</td>
<td>set</td>
<td>125</td>
<td>92</td>
<td>32</td>
<td>14</td>
</tr>
<tr>
<td>166667</td>
<td>set</td>
<td>160</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
<tr>
<td>166669</td>
<td>set</td>
<td>200</td>
<td>160</td>
<td>50</td>
<td>18</td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>152752</td>
<td>piece</td>
<td>92</td>
<td>92</td>
<td>31,6</td>
</tr>
<tr>
<td>152753</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>152754</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>152755</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>152759</td>
<td>piece</td>
<td>200</td>
<td>200</td>
<td>62,6</td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163218</td>
<td>piece</td>
<td>92</td>
<td>92</td>
<td>31,6</td>
</tr>
<tr>
<td>156195</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>156196</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>156197</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>156198</td>
<td>piece</td>
<td>200</td>
<td>200</td>
<td>62,6</td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm Horizontal</th>
<th>Vertical</th>
</tr>
</thead>
<tbody>
<tr>
<td>128770</td>
<td>piece</td>
<td>92</td>
<td>92</td>
<td>31,6</td>
<td>3-13</td>
<td>5-32</td>
</tr>
<tr>
<td>082362</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
<td>3-13</td>
<td>5-32</td>
</tr>
<tr>
<td>082363</td>
<td>piece</td>
<td>125</td>
<td>135</td>
<td>39,6</td>
<td>4-20</td>
<td>6-40</td>
</tr>
<tr>
<td>082364</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
<td>5-29</td>
<td>7-48</td>
</tr>
<tr>
<td>082365</td>
<td>piece</td>
<td>200</td>
<td>200</td>
<td>62,6</td>
<td>6-37</td>
<td>8-56</td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077104</td>
<td>set</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>077105</td>
<td>set</td>
<td>125</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>077106</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>077107</td>
<td>set</td>
<td>200</td>
<td>200</td>
<td>62,6</td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm Horizontal</th>
<th>Vertical</th>
</tr>
</thead>
<tbody>
<tr>
<td>317259</td>
<td>set</td>
<td>2a</td>
<td>110</td>
<td>31,8</td>
<td>3-12</td>
<td>5-32</td>
</tr>
<tr>
<td>317260</td>
<td>set</td>
<td>125</td>
<td>135</td>
<td>39,8</td>
<td>3-13</td>
<td>6-40</td>
</tr>
<tr>
<td>317261</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>49,8</td>
<td>5-22</td>
<td>7-48</td>
</tr>
</tbody>
</table>
Accessories RKK

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150739</td>
<td>piece 2a</td>
<td>113</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>150740</td>
<td>piece 125</td>
<td>130</td>
<td>39,6</td>
<td></td>
</tr>
<tr>
<td>150741</td>
<td>piece 4</td>
<td>160</td>
<td>49,6</td>
<td></td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>147953</td>
<td>set 2a</td>
<td>110</td>
<td>49</td>
<td>36</td>
<td></td>
</tr>
<tr>
<td>147954</td>
<td>set 3</td>
<td>135</td>
<td>53</td>
<td>40</td>
<td></td>
</tr>
<tr>
<td>147955</td>
<td>set 4</td>
<td>160</td>
<td>67</td>
<td>50</td>
<td></td>
</tr>
<tr>
<td>158823</td>
<td>set 5</td>
<td>200</td>
<td>67</td>
<td>50</td>
<td></td>
</tr>
</tbody>
</table>

A37
Standard inserts finely checkered NCSf, with small surface area to increase the specific surface clamping (higher holding forces)

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163227</td>
<td>set 2a</td>
<td>110</td>
<td>49</td>
<td>36</td>
<td></td>
</tr>
<tr>
<td>163228</td>
<td>set 3</td>
<td>135</td>
<td>53</td>
<td>40</td>
<td></td>
</tr>
<tr>
<td>163229</td>
<td>set 4</td>
<td>160</td>
<td>67</td>
<td>50</td>
<td></td>
</tr>
<tr>
<td>163230</td>
<td>set 5</td>
<td>200</td>
<td>67</td>
<td>50</td>
<td></td>
</tr>
</tbody>
</table>

A37
Claw inserts NCK, hardened and ground, for unmachined workpieces

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>148916</td>
<td>set 2a</td>
<td>110</td>
<td>49</td>
<td>24</td>
<td></td>
</tr>
<tr>
<td>148917</td>
<td>set 3</td>
<td>135</td>
<td>53</td>
<td>24</td>
<td></td>
</tr>
<tr>
<td>148918</td>
<td>set 4</td>
<td>160</td>
<td>67</td>
<td>45</td>
<td></td>
</tr>
<tr>
<td>159447</td>
<td>set 5</td>
<td>200</td>
<td>67</td>
<td>45</td>
<td></td>
</tr>
</tbody>
</table>
Accessories RKK

**A37**
**Hand crank**, turnable handle, hexagon socket

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Hexagon</th>
<th>A</th>
<th>L</th>
</tr>
</thead>
<tbody>
<tr>
<td>134198</td>
<td>piece</td>
<td>92</td>
<td>12</td>
<td>60</td>
<td>90</td>
</tr>
<tr>
<td>134600</td>
<td>piece</td>
<td>125/160/200</td>
<td>14</td>
<td>104</td>
<td>160</td>
</tr>
</tbody>
</table>

**A37**
**90° Angle drive**, for RKK 92 / RKE-L 92, for fastening NC-compact vices, advantageous for front-sided set-up or for large machine tables

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>A</th>
<th>B</th>
<th>C</th>
</tr>
</thead>
<tbody>
<tr>
<td>154185</td>
<td>piece</td>
<td>92</td>
<td>113,5</td>
<td>90</td>
<td>83,5</td>
</tr>
</tbody>
</table>

**A37**
**90° Angle drive**, for RKK 2-5

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>A</th>
<th>B</th>
<th>C</th>
</tr>
</thead>
<tbody>
<tr>
<td>151650</td>
<td>piece</td>
<td>2/2a</td>
<td>154</td>
<td>93,5</td>
<td>98</td>
</tr>
<tr>
<td>151651</td>
<td>piece</td>
<td>3</td>
<td>161</td>
<td>101</td>
<td>98</td>
</tr>
<tr>
<td>151652</td>
<td>piece</td>
<td>4/5</td>
<td>174</td>
<td>111</td>
<td>98</td>
</tr>
</tbody>
</table>

**A37**
**Single clamp SPE**, for mounting vices on end and on the base

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x50</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x60</td>
</tr>
<tr>
<td>149124</td>
<td>piece</td>
<td>18</td>
<td>M16x60</td>
</tr>
<tr>
<td>150722</td>
<td>piece</td>
<td>20</td>
<td>M16x65</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x65</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014825</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014829</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>
Duo and Quattro clamping towers RKK

Duo-clamping towers (on request)

Quattro-clamping towers (on request)

Technical data

<table>
<thead>
<tr>
<th>Size</th>
<th>RKK 92</th>
<th>RKK 113</th>
<th>RKK 135</th>
<th>RKK 160</th>
<th>RKK 200</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Jaw width</strong></td>
<td>92</td>
<td>113</td>
<td>135</td>
<td>160</td>
<td>200</td>
</tr>
<tr>
<td>A</td>
<td>250</td>
<td>250</td>
<td>290</td>
<td>350</td>
<td>350</td>
</tr>
<tr>
<td>B</td>
<td>250</td>
<td>250</td>
<td>290</td>
<td>350</td>
<td>350</td>
</tr>
<tr>
<td>C</td>
<td>45</td>
<td>45</td>
<td>45</td>
<td>45</td>
<td>45</td>
</tr>
<tr>
<td>D</td>
<td>375</td>
<td>469</td>
<td>528</td>
<td>663</td>
<td>663</td>
</tr>
<tr>
<td>E</td>
<td>190</td>
<td>200</td>
<td>240</td>
<td>240</td>
<td>240</td>
</tr>
<tr>
<td>F</td>
<td>435</td>
<td>549</td>
<td>606</td>
<td>744</td>
<td>744</td>
</tr>
<tr>
<td>G*</td>
<td>73</td>
<td>100</td>
<td>110,5</td>
<td>130</td>
<td>130</td>
</tr>
<tr>
<td>H</td>
<td>73</td>
<td>100</td>
<td>110,5</td>
<td>130</td>
<td>130</td>
</tr>
<tr>
<td>J*</td>
<td>50</td>
<td>80</td>
<td>125</td>
<td>260</td>
<td>260</td>
</tr>
<tr>
<td>K*</td>
<td>50</td>
<td>80</td>
<td>125</td>
<td>260</td>
<td>260</td>
</tr>
</tbody>
</table>

*On inquiry insert dimensions please

Technical data

<table>
<thead>
<tr>
<th>Size</th>
<th>RKK 92</th>
<th>RKK 113</th>
<th>RKK 135</th>
<th>RKK 160</th>
<th>RKK 200</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Jaw width</strong></td>
<td>92</td>
<td>113</td>
<td>135</td>
<td>160</td>
<td>200</td>
</tr>
<tr>
<td>A</td>
<td>320</td>
<td>350</td>
<td>400</td>
<td>500</td>
<td>500</td>
</tr>
<tr>
<td>B</td>
<td>320</td>
<td>350</td>
<td>400</td>
<td>500</td>
<td>500</td>
</tr>
<tr>
<td>C</td>
<td>45</td>
<td>45</td>
<td>45</td>
<td>45</td>
<td>45</td>
</tr>
<tr>
<td>D</td>
<td>375</td>
<td>469</td>
<td>528</td>
<td>663</td>
<td>663</td>
</tr>
<tr>
<td>E</td>
<td>254</td>
<td>315</td>
<td>350</td>
<td>445</td>
<td>445</td>
</tr>
<tr>
<td>F</td>
<td>435</td>
<td>549</td>
<td>606</td>
<td>744</td>
<td>744</td>
</tr>
<tr>
<td>G*</td>
<td>73</td>
<td>100</td>
<td>110,5</td>
<td>130</td>
<td>130</td>
</tr>
<tr>
<td>H</td>
<td>73</td>
<td>100</td>
<td>110,5</td>
<td>130</td>
<td>130</td>
</tr>
<tr>
<td>J*</td>
<td>100</td>
<td>180</td>
<td>250</td>
<td>530</td>
<td>530</td>
</tr>
<tr>
<td>K*</td>
<td>100</td>
<td>180</td>
<td>250</td>
<td>530</td>
<td>530</td>
</tr>
</tbody>
</table>

*On inquiry insert dimensions please
With stepped jaws, reversible

<table>
<thead>
<tr>
<th>Size</th>
<th>1</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>90</td>
</tr>
<tr>
<td>B</td>
<td>60</td>
</tr>
<tr>
<td>C</td>
<td>100</td>
</tr>
<tr>
<td>D</td>
<td>200</td>
</tr>
<tr>
<td>E</td>
<td>500</td>
</tr>
<tr>
<td>F</td>
<td>800</td>
</tr>
<tr>
<td>G</td>
<td>1100</td>
</tr>
<tr>
<td>H</td>
<td>1400</td>
</tr>
<tr>
<td>I</td>
<td>1700</td>
</tr>
<tr>
<td>a</td>
<td>30</td>
</tr>
<tr>
<td>b</td>
<td>60</td>
</tr>
<tr>
<td>c</td>
<td>90</td>
</tr>
</tbody>
</table>

Standard top jaws SA, reversible

<table>
<thead>
<tr>
<th>Size</th>
<th>2/3a</th>
<th>3</th>
<th>4</th>
<th>5</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>110</td>
<td>125</td>
<td>160</td>
<td>200</td>
</tr>
<tr>
<td>B</td>
<td>90</td>
<td>109</td>
<td>128</td>
<td>128</td>
</tr>
<tr>
<td>C</td>
<td>39</td>
<td>49</td>
<td>60</td>
<td>70</td>
</tr>
<tr>
<td>D</td>
<td>41.5</td>
<td>44</td>
<td>50</td>
<td>50</td>
</tr>
<tr>
<td>E</td>
<td>16</td>
<td>20</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>F</td>
<td>102</td>
<td>102</td>
<td>110</td>
<td>110</td>
</tr>
<tr>
<td>G</td>
<td>38</td>
<td>39</td>
<td>42</td>
<td>42</td>
</tr>
<tr>
<td>H</td>
<td>11.6</td>
<td>15.6</td>
<td>15.6</td>
<td>19.6</td>
</tr>
<tr>
<td>J</td>
<td>7.6</td>
<td>9.6</td>
<td>9.6</td>
<td>13.6</td>
</tr>
<tr>
<td>K</td>
<td>31.6</td>
<td>39.6</td>
<td>49.6</td>
<td>62.6</td>
</tr>
<tr>
<td>a</td>
<td>63</td>
<td>80</td>
<td>100</td>
<td>125</td>
</tr>
<tr>
<td>b</td>
<td>13.6</td>
<td>15.6</td>
<td>19.6</td>
<td>24.6</td>
</tr>
<tr>
<td>c</td>
<td>M6</td>
<td>M8</td>
<td>M8</td>
<td>M10</td>
</tr>
</tbody>
</table>

Carrier jaws, reversible

<table>
<thead>
<tr>
<th>Size</th>
<th>2/3a</th>
<th>3</th>
<th>4</th>
<th>5</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>110</td>
<td>125</td>
<td>160</td>
<td>200</td>
</tr>
<tr>
<td>B</td>
<td>90</td>
<td>105</td>
<td>105</td>
<td>105</td>
</tr>
<tr>
<td>C</td>
<td>25</td>
<td>30</td>
<td>30</td>
<td>30</td>
</tr>
<tr>
<td>D</td>
<td>41</td>
<td>50</td>
<td>50</td>
<td>50</td>
</tr>
<tr>
<td>E</td>
<td>16</td>
<td>20</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>F</td>
<td>83</td>
<td>83</td>
<td>83</td>
<td>83</td>
</tr>
<tr>
<td>G</td>
<td>11</td>
<td>21</td>
<td>24</td>
<td>24</td>
</tr>
<tr>
<td>H</td>
<td>41</td>
<td>20</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>I</td>
<td>16</td>
<td>16</td>
<td>16</td>
<td>16</td>
</tr>
<tr>
<td>a</td>
<td>49</td>
<td>32</td>
<td>32</td>
<td>32</td>
</tr>
<tr>
<td>b</td>
<td>28</td>
<td>28</td>
<td>28</td>
<td>28</td>
</tr>
<tr>
<td>c</td>
<td>25</td>
<td>30</td>
<td>30</td>
<td>30</td>
</tr>
<tr>
<td>d</td>
<td>50</td>
<td>70</td>
<td>70</td>
<td>70</td>
</tr>
<tr>
<td>e</td>
<td>80</td>
<td>110</td>
<td>110</td>
<td>110</td>
</tr>
<tr>
<td>t</td>
<td>M12</td>
<td>M12</td>
<td>M12</td>
<td>M12</td>
</tr>
<tr>
<td>g</td>
<td>M12</td>
<td>M12</td>
<td>M12</td>
<td>M12</td>
</tr>
</tbody>
</table>

Clamping ranges: External clamping RKK

<table>
<thead>
<tr>
<th>Size</th>
<th>B5</th>
<th>B7</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>2+2a</td>
<td>59-233</td>
<td>89-263</td>
</tr>
<tr>
<td>3</td>
<td>30-257</td>
<td>110-337</td>
</tr>
<tr>
<td>4+5</td>
<td>59-335</td>
<td>144-461</td>
</tr>
</tbody>
</table>

NC-Compact vices

Jaw dimensions and clamping range RKK
SET-UP AND WORKING TIME REDUCTION BY TWIN CLAMPING

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

Then the crank is turned further, the other movable clamping jaw is placed against the workpiece, fixed and force is built up via the mechanical spindle. Balance springs compensate dimensional discrepancies from up to ±3 mm between workpiece I and workpiece II.
NC-COMPACT TWIN VICES

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

ADVANTAGES AT A GLANCE

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

Steel body and all guides have been hardened and ground on all sides

Double clamping with two movable clamping jaws and one fixed middle jaw

Only about 1.5 turns of the crank at maximum clamping force

Clamping force presetting with blocking device

www.eshop.roehm.biz
NC-Compact twin vices

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-hydraulic 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

Item no. 180466 180467

<table>
<thead>
<tr>
<th>Jaw width A mm</th>
<th>92</th>
<th>125</th>
</tr>
</thead>
<tbody>
<tr>
<td>B1 slot 1 mm</td>
<td>0 - 48</td>
<td>0 - 48</td>
</tr>
<tr>
<td>B1 slot 2 mm</td>
<td>48 - 96</td>
<td>46 - 94</td>
</tr>
<tr>
<td>B1 slot 3 mm</td>
<td>-</td>
<td>92 - 140</td>
</tr>
<tr>
<td>B2 slot 1 mm</td>
<td>42 - 79</td>
<td>51 - 88</td>
</tr>
<tr>
<td>B2 slot 2 mm</td>
<td>79 - 127</td>
<td>86 - 134</td>
</tr>
<tr>
<td>B2 slot 3 mm</td>
<td>-</td>
<td>132 - 180</td>
</tr>
<tr>
<td>C mm</td>
<td>92</td>
<td>40</td>
</tr>
<tr>
<td>D mm</td>
<td>512</td>
<td>680</td>
</tr>
<tr>
<td>E mm</td>
<td>117</td>
<td>146</td>
</tr>
<tr>
<td>F mm</td>
<td>356</td>
<td>496</td>
</tr>
<tr>
<td>G, 0.02 mm</td>
<td>85</td>
<td>105</td>
</tr>
<tr>
<td>H, 0.02 mm</td>
<td>30</td>
<td>40</td>
</tr>
<tr>
<td>J mm</td>
<td>56</td>
<td>70</td>
</tr>
<tr>
<td>K mm</td>
<td>94</td>
<td>126</td>
</tr>
<tr>
<td>L mm</td>
<td>10</td>
<td>10</td>
</tr>
<tr>
<td>M mm</td>
<td>25</td>
<td>30</td>
</tr>
<tr>
<td>N, 0.01 mm</td>
<td>16</td>
<td>20</td>
</tr>
<tr>
<td>O mm</td>
<td>55</td>
<td>55</td>
</tr>
<tr>
<td>P mm</td>
<td>144</td>
<td>172</td>
</tr>
<tr>
<td>T, 0.02 mm</td>
<td>30</td>
<td>37.5</td>
</tr>
<tr>
<td>U mm</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>V mm</td>
<td>12</td>
<td>12</td>
</tr>
<tr>
<td>W mm</td>
<td>1 x 48</td>
<td>2 x 46</td>
</tr>
<tr>
<td>X x depth</td>
<td>10 x 47 x 12</td>
<td>15H7 x 12</td>
</tr>
<tr>
<td>Y mm</td>
<td>12</td>
<td>13</td>
</tr>
<tr>
<td>Z mm</td>
<td>50</td>
<td>50</td>
</tr>
<tr>
<td>a mm</td>
<td>63</td>
<td>80</td>
</tr>
<tr>
<td>b mm</td>
<td>13.6</td>
<td>15.6</td>
</tr>
<tr>
<td>c1</td>
<td>M8 x 14</td>
<td>M6 x 14</td>
</tr>
<tr>
<td>c2</td>
<td>M5 x 9</td>
<td>M5 x 10</td>
</tr>
<tr>
<td>c3</td>
<td>M10 x 16</td>
<td>M10 x 18</td>
</tr>
<tr>
<td>d mm</td>
<td>48</td>
<td>60</td>
</tr>
<tr>
<td>e mm</td>
<td>8</td>
<td>12</td>
</tr>
<tr>
<td>f mm</td>
<td>14</td>
<td>18</td>
</tr>
<tr>
<td>g mm</td>
<td>70</td>
<td>95</td>
</tr>
<tr>
<td>h mm</td>
<td>20</td>
<td>25</td>
</tr>
<tr>
<td>i mm</td>
<td>50</td>
<td>45</td>
</tr>
<tr>
<td>k x depth</td>
<td>M10 x 18</td>
<td>M12 x 22</td>
</tr>
<tr>
<td>l, 0.02 mm</td>
<td>170</td>
<td>240</td>
</tr>
<tr>
<td>y, 0.01 mm</td>
<td>40</td>
<td>47.5</td>
</tr>
<tr>
<td>z mm</td>
<td>72</td>
<td>100</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>25</td>
<td>40</td>
</tr>
<tr>
<td>Weight kg</td>
<td>24</td>
<td>53</td>
</tr>
</tbody>
</table>
## Accessories RKD

### A37
**Stepped jaws SB,** reversible, with fixing screws

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>161831</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>162631</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
</tr>
</tbody>
</table>

### A37
**Standard jaws SGN,** one side smooth, one side grooved, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>162363</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>158897</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
</tbody>
</table>

### A37
**Standard jaws finely checkered SGNf,** one side finely checkered, one side grooved, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163223</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>163225</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
</tbody>
</table>

### A37
**Claw jaws with fine step,** 2.5 mm clamping depth

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166514</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>14</td>
</tr>
<tr>
<td>166520</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>

### A37
**Claw jaws without step,** universal for clamping depth >2.5 mm

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>16661</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>14</td>
</tr>
<tr>
<td>16667</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>

### A37
**Support rails Cliparc,** set with 10 different pairs of rails and 4 clamps in wooden box

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Web height A mm</th>
<th>Jaw width B mm</th>
<th>Rail height H mm</th>
<th>Spare clamp (Set = 4 pieces)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1295913</td>
<td>53</td>
<td>92</td>
<td>10/16/20/23/25/26/27/28/29</td>
<td>1295916</td>
</tr>
<tr>
<td>1295914</td>
<td>73</td>
<td>125</td>
<td>10/15/20/25/28/30/33/35/36/37</td>
<td>1295917</td>
</tr>
</tbody>
</table>
**Accessories RKD**

**A37 Center jaws MBA**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>161833</td>
<td>piece</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>30</td>
</tr>
<tr>
<td>162632</td>
<td>piece</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>40</td>
</tr>
</tbody>
</table>

**A37 Work support WAM, for center jaws**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>A mm</th>
<th>B mm</th>
<th>C mm</th>
<th>d mm</th>
<th>e mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>159613</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>10</td>
<td>16</td>
<td>48</td>
<td>8</td>
</tr>
<tr>
<td>158599</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>10</td>
<td>20</td>
<td>60</td>
<td>12</td>
</tr>
</tbody>
</table>

**A37 Draw-down jaws RNG, with two permanent magnets**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155237</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>150027</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39.5</td>
</tr>
</tbody>
</table>

**A37 Standard insert RNS, held by two permanent magnets**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155242</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>159032</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
</tbody>
</table>

**A37 Standard insert finely checkered RNSf, held by two permanent magnets**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163270</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>163267</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
</tbody>
</table>
NC-compact twin vices

Accessories RKD

A37
Claw insert RNK, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155247</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>159235</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
</tbody>
</table>

A37
Hand crank, turnable handle, hexagon socket

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Hexagon</th>
<th>A mm</th>
<th>L mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>134600</td>
<td>piece</td>
<td>125/160/200</td>
<td>14</td>
<td>104</td>
<td>160</td>
</tr>
</tbody>
</table>

A37
Angle drive

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>A mm</th>
<th>B mm</th>
<th>C mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>159647</td>
<td>piece</td>
<td>92</td>
<td>162</td>
<td>92</td>
<td>98</td>
</tr>
<tr>
<td>159015</td>
<td>piece</td>
<td>125</td>
<td>190</td>
<td>110</td>
<td>98</td>
</tr>
</tbody>
</table>

A37
Single clamp SPE, for mounting vices on end and on the base

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x55</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x60</td>
</tr>
<tr>
<td>149124</td>
<td>piece</td>
<td>18</td>
<td>M16x60</td>
</tr>
<tr>
<td>159722</td>
<td>piece</td>
<td>20</td>
<td>M16x65</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x65</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014825</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014829</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>
NC-Compact twin vices

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 moveable 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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>150468</th>
<th>180469</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jaw width A mm</td>
<td>92</td>
<td>125</td>
</tr>
<tr>
<td>B1 slot 1 mm</td>
<td>0-48</td>
<td>0-48</td>
</tr>
<tr>
<td>B1 slot 2 mm</td>
<td>48-96</td>
<td>46-94</td>
</tr>
<tr>
<td>B1 slot 3 mm</td>
<td>92-140</td>
<td></td>
</tr>
<tr>
<td>B2 slot 1 mm</td>
<td>42-79</td>
<td>51-88</td>
</tr>
<tr>
<td>B2 slot 2 mm</td>
<td>73-127</td>
<td>86-134</td>
</tr>
<tr>
<td>B2 slot 3 mm</td>
<td>132-180</td>
<td></td>
</tr>
<tr>
<td>C mm</td>
<td>32</td>
<td>40</td>
</tr>
<tr>
<td>D mm</td>
<td>492</td>
<td>630</td>
</tr>
<tr>
<td>E mm</td>
<td>117</td>
<td>145</td>
</tr>
<tr>
<td>F mm</td>
<td>366</td>
<td>495</td>
</tr>
<tr>
<td>G-0.02 mm</td>
<td>85</td>
<td>105</td>
</tr>
<tr>
<td>R-0.02 mm</td>
<td>30</td>
<td>40</td>
</tr>
<tr>
<td>J mm</td>
<td>56</td>
<td>70</td>
</tr>
<tr>
<td>K mm</td>
<td>94</td>
<td>126</td>
</tr>
<tr>
<td>L mm</td>
<td>10</td>
<td>10</td>
</tr>
<tr>
<td>M mm</td>
<td>25</td>
<td>30</td>
</tr>
<tr>
<td>N-0.01 mm</td>
<td>16</td>
<td>20</td>
</tr>
<tr>
<td>O mm</td>
<td>36</td>
<td>36</td>
</tr>
<tr>
<td>P mm</td>
<td>114</td>
<td>122</td>
</tr>
<tr>
<td>R mm</td>
<td>140</td>
<td>201</td>
</tr>
<tr>
<td>S mm</td>
<td>31</td>
<td>32</td>
</tr>
<tr>
<td>T-0.02 mm</td>
<td>30</td>
<td>37.5</td>
</tr>
<tr>
<td>U mm</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>V mm</td>
<td>12</td>
<td>12</td>
</tr>
<tr>
<td>W mm</td>
<td>1 x 48</td>
<td>2 x 46</td>
</tr>
<tr>
<td>Y mm</td>
<td>12</td>
<td>13</td>
</tr>
<tr>
<td>Z mm</td>
<td>50/53</td>
<td>50/53</td>
</tr>
<tr>
<td>Key-width SW</td>
<td>17</td>
<td>19</td>
</tr>
<tr>
<td>a mm</td>
<td>63</td>
<td>80</td>
</tr>
<tr>
<td>b mm</td>
<td>13.6</td>
<td>15.6</td>
</tr>
<tr>
<td>c1</td>
<td>M6 x 14</td>
<td>M8 x 14</td>
</tr>
<tr>
<td>c2</td>
<td>M5 x 9</td>
<td>M5 x 10</td>
</tr>
<tr>
<td>c3</td>
<td>M10 x 16</td>
<td>M10 x 18</td>
</tr>
<tr>
<td>d mm</td>
<td>48</td>
<td>65</td>
</tr>
<tr>
<td>e mm</td>
<td>8</td>
<td>12</td>
</tr>
<tr>
<td>f mm</td>
<td>14</td>
<td>18</td>
</tr>
<tr>
<td>g mm</td>
<td>70</td>
<td>95</td>
</tr>
<tr>
<td>h mm</td>
<td>20</td>
<td>25</td>
</tr>
<tr>
<td>i mm</td>
<td>50</td>
<td>45</td>
</tr>
<tr>
<td>k x depth</td>
<td>M10 x 18</td>
<td>M12 x 22</td>
</tr>
<tr>
<td>l-0.02 mm</td>
<td>177</td>
<td>237</td>
</tr>
<tr>
<td>ya0.01 mm</td>
<td>40</td>
<td>47.5</td>
</tr>
<tr>
<td>z mm</td>
<td>72</td>
<td>100</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>25</td>
<td>40</td>
</tr>
<tr>
<td>Weight kg</td>
<td>24</td>
<td>52</td>
</tr>
</tbody>
</table>

www.eshop.roehm.biz
NC-compact twin vices

RKD-M

on request

www.eshop.roehm.biz
## Accessories RKD-M

### A37
**Stepped jaws SB**, reversible, with fixing screws

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>161831</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>162631</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
</tr>
</tbody>
</table>

### A37
**Standard jaws SGN**, one side smooth, one side grooved, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>162363</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>158897</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
</tbody>
</table>

### A37
**Standard jaws finely checkered SGNf**, one side finely checkered, one side grooved, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163223</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>163225</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
</tbody>
</table>

### A37
**V-jaw PB**, horizontal and vertical

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
<th>Height prism mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>162365</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>16</td>
<td>19,5</td>
<td>12-36 12-36</td>
</tr>
<tr>
<td>158641</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>20</td>
<td>24</td>
<td>15-40 18-60</td>
</tr>
</tbody>
</table>

### A37
**Claw jaws with fine step**, 2.5 mm clamping depth

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166614</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>14</td>
</tr>
<tr>
<td>166620</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>
NC-compact twin vices

Accessories RKD-M

A37
Claw jaws without step, universal for clamping depth >2.5 mm

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166661</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>14</td>
</tr>
<tr>
<td>166667</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>

A37
Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Web height A</th>
<th>Jaw width B mm</th>
<th>Rail height H</th>
<th>Spare clamp (Set = 4 pieces)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1295913</td>
<td>53</td>
<td>92</td>
<td>15/16/18/20/23/25/26/27/28/29</td>
<td>1295916</td>
</tr>
<tr>
<td>1295914</td>
<td>73</td>
<td>125</td>
<td>15/15/20/25/28/33/35/36/37</td>
<td>1295917</td>
</tr>
</tbody>
</table>

A37
Draw-down jaws RNG, with two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155237</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>159227</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39.5</td>
</tr>
</tbody>
</table>

A37
Standard insert RNS, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155242</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>159232</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
</tbody>
</table>
Accessories RKD-M

A37
Standard insert finely checkered RNSf, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163270</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>163267</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
</tbody>
</table>

A37
Claw insert RNK, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155247</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>159235</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
</tbody>
</table>

A37
Drive adapter ATA

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Square</th>
</tr>
</thead>
<tbody>
<tr>
<td>162192</td>
<td>piece</td>
<td>92</td>
<td>17-1/2&quot;</td>
</tr>
<tr>
<td>161730</td>
<td>piece</td>
<td>125</td>
<td>19-1/2&quot;</td>
</tr>
</tbody>
</table>

A37
Fixed stepped jaw FSB, for single clamping, reversible

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>162633</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>160344</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
</tr>
</tbody>
</table>

A37
Center jaws MBA

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>161833</td>
<td>piece</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>30</td>
</tr>
<tr>
<td>162632</td>
<td>piece</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>40</td>
</tr>
</tbody>
</table>
## Accessories RKD-M

### A37
**Single clamp SPE**, for mounting vices on end and on the base.

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x50</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x60</td>
</tr>
<tr>
<td>149124</td>
<td>piece</td>
<td>18</td>
<td>M16x60</td>
</tr>
<tr>
<td>155722</td>
<td>piece</td>
<td>20</td>
<td>M16x65</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x65</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014825</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014829</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>
Clamping range RKD-M

### Clamping ranges: Twin clamping

<table>
<thead>
<tr>
<th>Size</th>
<th>B1</th>
<th>B2</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Groove 1</td>
<td>0 - 48</td>
</tr>
<tr>
<td></td>
<td>Groove 2</td>
<td>48 - 96</td>
</tr>
<tr>
<td></td>
<td>Groove 3</td>
<td>-</td>
</tr>
<tr>
<td></td>
<td>Groove 1</td>
<td>42 - 79</td>
</tr>
<tr>
<td></td>
<td>Groove 2</td>
<td>79 - 127</td>
</tr>
<tr>
<td></td>
<td>Groove 3</td>
<td>-</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Size</th>
<th>B3</th>
<th>B4</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Groove 1</td>
<td>30 - 132</td>
</tr>
<tr>
<td></td>
<td>Groove 2</td>
<td>136 - 228</td>
</tr>
<tr>
<td></td>
<td>Groove 3</td>
<td>-</td>
</tr>
<tr>
<td></td>
<td>Groove 1</td>
<td>92 - 195</td>
</tr>
<tr>
<td></td>
<td>Groove 2</td>
<td>188 - 290</td>
</tr>
<tr>
<td></td>
<td>Groove 3</td>
<td>-</td>
</tr>
</tbody>
</table>

### Clamping ranges: Centric clamping

<table>
<thead>
<tr>
<th>Size</th>
<th>B5</th>
<th>B6</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Groove 1</td>
<td>126 - 177</td>
</tr>
<tr>
<td></td>
<td>Groove 2</td>
<td>174 - 225</td>
</tr>
<tr>
<td></td>
<td>Groove 3</td>
<td>-</td>
</tr>
<tr>
<td></td>
<td>Groove 1</td>
<td>196 - 247</td>
</tr>
<tr>
<td></td>
<td>Groove 2</td>
<td>244 - 295</td>
</tr>
<tr>
<td></td>
<td>Groove 3</td>
<td>-</td>
</tr>
<tr>
<td></td>
<td>R*</td>
<td>101</td>
</tr>
<tr>
<td></td>
<td>R**</td>
<td>140</td>
</tr>
</tbody>
</table>

### 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 I 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

### Clamping ranges: Single clamping

<table>
<thead>
<tr>
<th>Size</th>
<th>B5</th>
<th>B6</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Groove 1</td>
<td>126 - 177</td>
</tr>
<tr>
<td></td>
<td>Groove 2</td>
<td>174 - 225</td>
</tr>
<tr>
<td></td>
<td>Groove 3</td>
<td>-</td>
</tr>
<tr>
<td></td>
<td>Groove 1</td>
<td>196 - 247</td>
</tr>
<tr>
<td></td>
<td>Groove 2</td>
<td>244 - 295</td>
</tr>
<tr>
<td></td>
<td>Groove 3</td>
<td>-</td>
</tr>
<tr>
<td></td>
<td>R*</td>
<td>101</td>
</tr>
<tr>
<td></td>
<td>R**</td>
<td>140</td>
</tr>
</tbody>
</table>

Remove central jaw and movable mounting jaw I.
Install fixed mounting jaw (accessory - not in scope of delivery).
Jaw stroke: “Z” 53mm
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.
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

- Very large clamping range due to the jaws’ patented guide system
- Extremely rigid clamping and effective force flow because the clamping spindle is very close to the workpiece
- Compact removal design for optimal workpiece accessibility from five sides
- Open design for optimized chip flow
NC-Compact self centering vices

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>178910</th>
<th>178911</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jaw width A mm</td>
<td>125</td>
<td>125</td>
</tr>
<tr>
<td>Design</td>
<td>long design</td>
<td>short design</td>
</tr>
<tr>
<td>B min.</td>
<td>22</td>
<td>23</td>
</tr>
<tr>
<td>B max.</td>
<td>222</td>
<td>142</td>
</tr>
<tr>
<td>BI mm</td>
<td>17-216</td>
<td>17-136</td>
</tr>
<tr>
<td>C mm</td>
<td>128</td>
<td>128</td>
</tr>
<tr>
<td>D mm</td>
<td>206</td>
<td>218</td>
</tr>
<tr>
<td>E mm</td>
<td>196,5</td>
<td>196,5</td>
</tr>
<tr>
<td>F mm</td>
<td>260</td>
<td>180</td>
</tr>
<tr>
<td>N mm</td>
<td>156,5</td>
<td>156,5</td>
</tr>
<tr>
<td>U mm</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>X mm</td>
<td>6</td>
<td>6</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>25</td>
<td>25</td>
</tr>
<tr>
<td>Tightening torque Nm</td>
<td>150</td>
<td>150</td>
</tr>
<tr>
<td>Weight kg</td>
<td>20,3</td>
<td>17,4</td>
</tr>
</tbody>
</table>

www.eshop.roehm.biz
RZM

NC-Compact self centering vices

4057

www.eshop.roehm.biz

on request
## Accessories RZM

### A37 Claw jaws without step, universal for clamping depth >2.5 mm

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166667</td>
<td>set</td>
<td>160</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166520</td>
<td>set</td>
<td>160</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>158897</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163225</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
</tbody>
</table>

### A37 V-jaw PB, horizontal and vertical

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
<th>Height prism mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>158641</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>20</td>
<td>24</td>
<td>15-40 18-60</td>
</tr>
</tbody>
</table>
## Accessories RZM

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150740</td>
<td>piece</td>
<td>125</td>
<td>135</td>
<td>39,6</td>
</tr>
</tbody>
</table>

### A37
**V-jaw and standard jaw SBO**, unhardened and burnished, with workpiece support

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>317260</td>
<td>set</td>
<td>125</td>
<td>135</td>
<td>39,8</td>
<td>3-13</td>
</tr>
</tbody>
</table>

### A37
**Spindle**, for shortening the clamping range of the long RZM version

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Length mm</th>
<th>Diameter mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>178958</td>
<td>piece</td>
<td>218</td>
<td>24</td>
</tr>
</tbody>
</table>

### A37
**Single clamp SPE**, for mounting vices on end and on the base

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x55</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x60</td>
</tr>
<tr>
<td>149124</td>
<td>piece</td>
<td>18</td>
<td>M16x50</td>
</tr>
<tr>
<td>155722</td>
<td>piece</td>
<td>20</td>
<td>M16x65</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x65</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014825</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014829</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>
NC-Compact self centering vices

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>180470</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jaw width A mm</td>
<td>125</td>
</tr>
<tr>
<td>B1 slot 1 mm</td>
<td>112-206</td>
</tr>
<tr>
<td>B1 slot 2 mm</td>
<td>204-298</td>
</tr>
<tr>
<td>B2 slot 1 mm</td>
<td>12-126</td>
</tr>
<tr>
<td>B2 slot 2 mm</td>
<td>124-218</td>
</tr>
<tr>
<td>C mm</td>
<td>40</td>
</tr>
<tr>
<td>D mm</td>
<td>578</td>
</tr>
<tr>
<td>E mm</td>
<td>170</td>
</tr>
<tr>
<td>F mm</td>
<td>395</td>
</tr>
<tr>
<td>G-0,02 mm</td>
<td>130</td>
</tr>
<tr>
<td>J mm</td>
<td>70</td>
</tr>
<tr>
<td>K mm</td>
<td>126</td>
</tr>
<tr>
<td>M mm</td>
<td>30</td>
</tr>
<tr>
<td>N-0,01 mm</td>
<td>20</td>
</tr>
<tr>
<td>O mm</td>
<td>55</td>
</tr>
<tr>
<td>P mm</td>
<td>170</td>
</tr>
<tr>
<td>Q mm</td>
<td>84,5</td>
</tr>
<tr>
<td>T-0,02 mm</td>
<td>37,5</td>
</tr>
<tr>
<td>U mm</td>
<td>20</td>
</tr>
<tr>
<td>V mm</td>
<td>12</td>
</tr>
<tr>
<td>W mm</td>
<td>46</td>
</tr>
<tr>
<td>X x depth H7 x 12</td>
<td></td>
</tr>
<tr>
<td>Y mm</td>
<td>12</td>
</tr>
<tr>
<td>Stroke Z mm</td>
<td>50</td>
</tr>
<tr>
<td>a mm</td>
<td>80</td>
</tr>
<tr>
<td>b mm</td>
<td>15,6</td>
</tr>
<tr>
<td>c1</td>
<td>M8x14</td>
</tr>
<tr>
<td>c2</td>
<td>M8x10</td>
</tr>
<tr>
<td>c3</td>
<td>M10x18</td>
</tr>
<tr>
<td>d mm</td>
<td>60</td>
</tr>
<tr>
<td>e mm</td>
<td>12</td>
</tr>
<tr>
<td>f mm</td>
<td>18</td>
</tr>
<tr>
<td>g mm</td>
<td>95</td>
</tr>
<tr>
<td>h mm</td>
<td>25</td>
</tr>
<tr>
<td>i mm</td>
<td>45</td>
</tr>
<tr>
<td>l-0,02 mm</td>
<td>190</td>
</tr>
<tr>
<td>yx0,01 mm</td>
<td>47,5</td>
</tr>
<tr>
<td>z mm</td>
<td>100</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>40</td>
</tr>
<tr>
<td>Weight kg</td>
<td>50,5</td>
</tr>
</tbody>
</table>
**Accessories RKZ**

**A37**

*Stepped jaws SB*, reversible, with fixing screws

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>162631</td>
<td>set</td>
<td>125</td>
<td>40</td>
</tr>
</tbody>
</table>

**A37**

*Raised stepped jaws ESB*

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>164399</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>60</td>
</tr>
</tbody>
</table>

**A37**

*Double V-jaw*, reversible, with fine step, for jaw dimensions of the double V-jaws please see page 4065!

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Length mm</th>
<th>Size prism mm</th>
<th>Clamping dia. D1 mm slot 1</th>
<th>Clamping dia. D1 mm slot 2</th>
<th>Clamping dia. D2 mm slot 1</th>
<th>Clamping dia. D2 mm slot 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>169756</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>84,5</td>
<td>86</td>
<td>56</td>
<td>15-40</td>
<td>-</td>
<td>30-92**</td>
<td>89-105</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>158897</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163225</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39,7</td>
</tr>
</tbody>
</table>
## Accessories RKZ

### A37 V-jaw PB, horizontal and vertical

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
<th>Height prism mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>158641</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>20</td>
<td>24</td>
<td>15-40</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>18-60</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166520</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>

### A37 Claw jaws without step, universal for clamping depth >2.5 mm

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166667</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>

### A37 Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Width A</th>
<th>Jaw width B mm</th>
<th>Rail height H</th>
<th>Spare clamp [Set = 4 pieces]</th>
</tr>
</thead>
<tbody>
<tr>
<td>1295915</td>
<td></td>
<td>98</td>
<td>125</td>
<td>15/15/20/25/28/30/33/35/39/37</td>
<td>1295918</td>
</tr>
</tbody>
</table>

### A37 Draw-down jaws RNG, with two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>159227</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>39.5</td>
</tr>
</tbody>
</table>

[www.eshop.roehm.biz](http://www.eshop.roehm.biz)
**Accessories RKZ**

**A37**  
**Standard insert RNS**, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>159232</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
</tbody>
</table>

**A37**  
**Standard insert finely checkered RNSf**, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163267</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
</tbody>
</table>

**A37**  
**Claw insert RNK**, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>159235</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>26</td>
</tr>
</tbody>
</table>

**A37**  
**Hand crank**, turnable handle, hexagon socket

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Hexagon</th>
<th>A mm</th>
<th>L mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>134600</td>
<td>piece</td>
<td>125/160/200</td>
<td>14</td>
<td>104</td>
<td>160</td>
</tr>
</tbody>
</table>

[www.eshop.roehm.biz](http://www.eshop.roehm.biz)
### Accessories RKZ

#### A37
**Angle drive**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>A mm</th>
<th>B mm</th>
<th>C mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>159015</td>
<td>piece</td>
<td>125</td>
<td>190</td>
<td>110</td>
<td>98</td>
</tr>
</tbody>
</table>

#### A37
**Single clamp SPE**, for mounting vices on end and on the base

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x50</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x50</td>
</tr>
<tr>
<td>149124</td>
<td>piece</td>
<td>18</td>
<td>M16x50</td>
</tr>
<tr>
<td>155722</td>
<td>piece</td>
<td>20</td>
<td>M16x50</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x50</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014825</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014829</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>

**Jaw dimensions**

**Double V-jaw**, reversible, with fine step

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivers</th>
<th>Size</th>
<th>Length</th>
</tr>
</thead>
<tbody>
<tr>
<td>169756</td>
<td>set</td>
<td>125</td>
<td></td>
</tr>
<tr>
<td></td>
<td>B</td>
<td>80</td>
<td></td>
</tr>
<tr>
<td></td>
<td>C</td>
<td>85,5</td>
<td></td>
</tr>
<tr>
<td></td>
<td>D1</td>
<td>15-40</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Groove 1</td>
<td>30-92**</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Groove 2</td>
<td>89-105</td>
<td></td>
</tr>
<tr>
<td></td>
<td>E</td>
<td>54</td>
<td></td>
</tr>
<tr>
<td></td>
<td>F</td>
<td>69,5</td>
<td></td>
</tr>
<tr>
<td></td>
<td>G</td>
<td>51,5</td>
<td></td>
</tr>
<tr>
<td></td>
<td>H</td>
<td>24</td>
<td></td>
</tr>
<tr>
<td></td>
<td>J</td>
<td>3</td>
<td></td>
</tr>
<tr>
<td></td>
<td>K</td>
<td>50</td>
<td></td>
</tr>
<tr>
<td></td>
<td>L</td>
<td>22,6</td>
<td></td>
</tr>
<tr>
<td></td>
<td>M</td>
<td>12</td>
<td></td>
</tr>
</tbody>
</table>

**Clamping capacity**

\[ \text{Clamping capacity } \begin{cases} 1 \text{ on request} \\ \text{Double V-jaw, reversible, with fine step} \\ \end{cases} \]

**Double V-jaw, reversible, with fine step**

\[ \text{Jaw dimensions} \]

\[ \text{www.eshop.roehm.biz} \]
NC-Compact self centering vices

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

Three jaw version

<table>
<thead>
<tr>
<th>Item no.</th>
<th>180190</th>
<th>180191</th>
<th>180192</th>
<th>180193</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jaw width A mm</td>
<td>50</td>
<td>70</td>
<td>92</td>
<td>125</td>
</tr>
<tr>
<td>B1 slot 1 mm</td>
<td>0-39</td>
<td>0 - 58</td>
<td>0 - 76</td>
<td>0 - 97</td>
</tr>
<tr>
<td>B1 slot 2 mm</td>
<td>36-75</td>
<td>48-106</td>
<td>70-146</td>
<td>92-189</td>
</tr>
<tr>
<td>B2 slot 1 mm</td>
<td>37-75</td>
<td>48-105</td>
<td>78-138</td>
<td>91-177</td>
</tr>
<tr>
<td>B2 slot 2 mm</td>
<td>72-111</td>
<td>95-153</td>
<td>132-208</td>
<td>172-269</td>
</tr>
<tr>
<td>C mm</td>
<td>20</td>
<td>25</td>
<td>32</td>
<td>40</td>
</tr>
<tr>
<td>Dmax mm</td>
<td>167</td>
<td>219</td>
<td>235</td>
<td>366</td>
</tr>
<tr>
<td>E mm</td>
<td>75</td>
<td>95</td>
<td>117</td>
<td>145</td>
</tr>
<tr>
<td>F mm</td>
<td>140</td>
<td>190</td>
<td>290</td>
<td>330</td>
</tr>
<tr>
<td>G-0,02 mm</td>
<td>55</td>
<td>70</td>
<td>85</td>
<td>105</td>
</tr>
<tr>
<td>J mm</td>
<td>32</td>
<td>41</td>
<td>56</td>
<td>70</td>
</tr>
<tr>
<td>K mm</td>
<td>52</td>
<td>72</td>
<td>94</td>
<td>126</td>
</tr>
<tr>
<td>M mm</td>
<td>14</td>
<td>17,5</td>
<td>25</td>
<td>30</td>
</tr>
<tr>
<td>N-0,01 mm</td>
<td>10</td>
<td>12</td>
<td>16</td>
<td>20</td>
</tr>
<tr>
<td>O mm</td>
<td>10</td>
<td>10</td>
<td>13</td>
<td>13</td>
</tr>
<tr>
<td>P mm</td>
<td>1</td>
<td>1</td>
<td>2</td>
<td>2</td>
</tr>
<tr>
<td>Q mm</td>
<td>31</td>
<td>40</td>
<td>51,5</td>
<td>53</td>
</tr>
<tr>
<td>U mm</td>
<td>15</td>
<td>20</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>V mm</td>
<td>12</td>
<td>12</td>
<td>12</td>
<td>12</td>
</tr>
<tr>
<td>W mm</td>
<td>18</td>
<td>24</td>
<td>35</td>
<td>46</td>
</tr>
<tr>
<td>Y mm</td>
<td>10</td>
<td>10</td>
<td>12</td>
<td>13</td>
</tr>
<tr>
<td>Z mm</td>
<td>20,5</td>
<td>30</td>
<td>39</td>
<td>49,5</td>
</tr>
<tr>
<td>a mm</td>
<td>-</td>
<td>-</td>
<td>63</td>
<td>80</td>
</tr>
<tr>
<td>b mm</td>
<td>-</td>
<td>-</td>
<td>13,6</td>
<td>15,6</td>
</tr>
<tr>
<td>c1</td>
<td>-</td>
<td>-</td>
<td>M6x10</td>
<td>M6x14</td>
</tr>
<tr>
<td>c2</td>
<td>M 4 x 8</td>
<td>M 5 x 8</td>
<td>M6x8</td>
<td>M6x8</td>
</tr>
<tr>
<td>c3</td>
<td>-</td>
<td>-</td>
<td>M10x16</td>
<td>M10x18</td>
</tr>
<tr>
<td>c4</td>
<td>M3x6</td>
<td>M4x8</td>
<td>M5x8</td>
<td>M5x8</td>
</tr>
<tr>
<td>d mm</td>
<td>26</td>
<td>37</td>
<td>48</td>
<td>60</td>
</tr>
<tr>
<td>e mm</td>
<td>5</td>
<td>6</td>
<td>8</td>
<td>12</td>
</tr>
<tr>
<td>f mm</td>
<td>-</td>
<td>-</td>
<td>14</td>
<td>18</td>
</tr>
<tr>
<td>g mm</td>
<td>60</td>
<td>65</td>
<td>120</td>
<td>155</td>
</tr>
<tr>
<td>p mm</td>
<td>32</td>
<td>52</td>
<td>55</td>
<td>55</td>
</tr>
<tr>
<td>q mm</td>
<td>38</td>
<td>52</td>
<td>55</td>
<td>55</td>
</tr>
<tr>
<td>r mm</td>
<td>20</td>
<td>30</td>
<td>32</td>
<td>32</td>
</tr>
<tr>
<td>s mm</td>
<td>15</td>
<td>19</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>t mm</td>
<td>6 kt-SW 8</td>
<td>6 kt-SW 10</td>
<td>6 kt-SW 14</td>
<td>6 kt-SW 14</td>
</tr>
<tr>
<td>u mm</td>
<td>4 kt-SW 12</td>
<td>4 kt-SW 14</td>
<td>4 kt-SW 19</td>
<td>4 kt-SW 19</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>12</td>
<td>15</td>
<td>20</td>
<td>25</td>
</tr>
<tr>
<td>Weight kg</td>
<td>3,5</td>
<td>7</td>
<td>10</td>
<td>18</td>
</tr>
</tbody>
</table>

A32
RKZ-M, with stepped jaws

www.eshop.roehm.biz

on request
NC-Compact self centering vices

RKZ-M

on request

www.eshop.roehm.biz
Amount of delivery

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width (mm)</th>
<th>Height (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>164864</td>
<td>set 50</td>
<td>50</td>
<td>20</td>
<td></td>
</tr>
<tr>
<td>164844</td>
<td>set 70</td>
<td>70</td>
<td>25</td>
<td></td>
</tr>
<tr>
<td>161831</td>
<td>set 92</td>
<td>92</td>
<td>32</td>
<td></td>
</tr>
<tr>
<td>162631</td>
<td>set 125</td>
<td>125</td>
<td>40</td>
<td></td>
</tr>
</tbody>
</table>

Raised stepped jaws ESB

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width (mm)</th>
<th>Height (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>164399</td>
<td>set 125</td>
<td>125</td>
<td>60</td>
<td></td>
</tr>
</tbody>
</table>

Double V-jaw, reversible, with fine step. For jaw dimensions of the double V-jaws please see page 4070!

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width (mm)</th>
<th>Height (mm)</th>
<th>Length (mm)</th>
<th>Height prism (mm)</th>
<th>Clamping dia. D1 (mm)</th>
<th>Clamping dia. D2 (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>169754</td>
<td>set 92</td>
<td>92</td>
<td>64.5</td>
<td>67</td>
<td>39</td>
<td>41.3</td>
<td>12-36</td>
<td>-</td>
</tr>
<tr>
<td>169756</td>
<td>set 125</td>
<td>125</td>
<td>84.5</td>
<td>86</td>
<td>54</td>
<td>58</td>
<td>15-40</td>
<td>-</td>
</tr>
<tr>
<td>169758</td>
<td>set 125</td>
<td>125</td>
<td>84.5</td>
<td>86</td>
<td>54</td>
<td>58</td>
<td>15-40</td>
<td>-</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width (mm)</th>
<th>Height (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>165161</td>
<td>set 50</td>
<td>50</td>
<td>19.6</td>
<td></td>
</tr>
<tr>
<td>165163</td>
<td>set 70</td>
<td>70</td>
<td>24.6</td>
<td></td>
</tr>
<tr>
<td>162363</td>
<td>set 92</td>
<td>92</td>
<td>32</td>
<td></td>
</tr>
<tr>
<td>158897</td>
<td>set 125</td>
<td>125</td>
<td>39.7</td>
<td></td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width (mm)</th>
<th>Height (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>165165</td>
<td>set 50</td>
<td>50</td>
<td>19.6</td>
<td></td>
</tr>
<tr>
<td>165167</td>
<td>set 70</td>
<td>70</td>
<td>24.6</td>
<td></td>
</tr>
<tr>
<td>163223</td>
<td>set 92</td>
<td>92</td>
<td>32</td>
<td></td>
</tr>
<tr>
<td>163225</td>
<td>set 125</td>
<td>125</td>
<td>39.7</td>
<td></td>
</tr>
</tbody>
</table>

V-jaw PB, horizontal and vertical

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width (mm)</th>
<th>Height (mm)</th>
<th>Thickness (mm)</th>
<th>Height prism (mm)</th>
<th>Chucking capacity (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>165169</td>
<td>set 50</td>
<td>50</td>
<td>20</td>
<td>10</td>
<td>12</td>
<td>6-16</td>
<td></td>
</tr>
<tr>
<td>165171</td>
<td>set 70</td>
<td>70</td>
<td>25</td>
<td>12</td>
<td>14</td>
<td>8-24</td>
<td></td>
</tr>
<tr>
<td>162365</td>
<td>set 92</td>
<td>92</td>
<td>32</td>
<td>16</td>
<td>19.5</td>
<td>12-36</td>
<td></td>
</tr>
<tr>
<td>158641</td>
<td>set 125</td>
<td>125</td>
<td>40</td>
<td>20</td>
<td>24</td>
<td>15-40</td>
<td></td>
</tr>
</tbody>
</table>

www.eshop.roehm.biz

Accessories RKZ-M
## Accessories RKZ-M

### A37
**Claw jaws with fine step** 2.5 mm clamping depth

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166514</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>14</td>
</tr>
<tr>
<td>166520</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>

### A37
**Claw jaws without step**, universal for clamping depth > 2.5 mm

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>166661</td>
<td>set</td>
<td>92</td>
<td>92</td>
<td>32</td>
<td>14</td>
</tr>
<tr>
<td>166667</td>
<td>set</td>
<td>125</td>
<td>125</td>
<td>40</td>
<td>16</td>
</tr>
</tbody>
</table>

### C15
**Hand crank HKU**, with octagon socket

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Octagon</th>
<th>L</th>
</tr>
</thead>
<tbody>
<tr>
<td>009150</td>
<td>piece</td>
<td>50</td>
<td>12</td>
<td>80</td>
</tr>
<tr>
<td>009152</td>
<td>piece</td>
<td>70</td>
<td>14</td>
<td>125</td>
</tr>
<tr>
<td>382112</td>
<td>piece</td>
<td>92</td>
<td>19</td>
<td>160</td>
</tr>
<tr>
<td>009154</td>
<td>piece</td>
<td>125</td>
<td>19</td>
<td>200</td>
</tr>
</tbody>
</table>

### A37
**Drive adapter ATA**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Square</th>
<th>Hexagon</th>
</tr>
</thead>
<tbody>
<tr>
<td>164971</td>
<td>piece</td>
<td>50</td>
<td>12</td>
<td>6</td>
</tr>
<tr>
<td>164842</td>
<td>piece</td>
<td>70</td>
<td>14</td>
<td>10</td>
</tr>
<tr>
<td>164625</td>
<td>piece</td>
<td>92/125</td>
<td>19</td>
<td>14</td>
</tr>
</tbody>
</table>

### A37
**Single clamp SPE**, for mounting vices on end and on the base

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x50</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x50</td>
</tr>
<tr>
<td>149124</td>
<td>piece</td>
<td>18</td>
<td>M16x50</td>
</tr>
<tr>
<td>155722</td>
<td>piece</td>
<td>20</td>
<td>M16x50</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x50</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014825</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014829</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>
General accessories - Cliparc

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

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

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

Support rails Cliparc

<table>
<thead>
<tr>
<th>Item no.</th>
<th>1269621</th>
<th>1269622</th>
<th>1269623</th>
<th>1269513</th>
<th>1269514</th>
<th>1269515</th>
</tr>
</thead>
<tbody>
<tr>
<td>Web height A</td>
<td>48</td>
<td>68</td>
<td>83</td>
<td>53</td>
<td>73</td>
<td>98</td>
</tr>
<tr>
<td>Jaw width B</td>
<td>92</td>
<td>125</td>
<td>160</td>
<td>92</td>
<td>125</td>
<td>125</td>
</tr>
<tr>
<td>Rail height H</td>
<td>10/16/18/20/23/25/26/27/28/29</td>
<td>10/15/20/25/30/35/40/43/45/47</td>
<td>10/15/20/25/28/30/33/35/36/37</td>
<td>10/15/20/25/28/30/33/35/36/37</td>
<td>10/15/20/25/28/30/33/35/36/37</td>
<td>10/15/20/25/28/30/33/35/36/37</td>
</tr>
<tr>
<td>Guidance width C</td>
<td>94</td>
<td>126</td>
<td>162</td>
<td>94</td>
<td>126</td>
<td>126</td>
</tr>
<tr>
<td>Spare clamp (Set = 4 pieces)</td>
<td>1269624</td>
<td>1269625</td>
<td>1269626</td>
<td>1269516</td>
<td>1269517</td>
<td>1269518</td>
</tr>
</tbody>
</table>

Jaw dimensions

Double V-jaw, reversible, with fine step

<table>
<thead>
<tr>
<th>Item no.</th>
<th>169754</th>
<th>169755</th>
</tr>
</thead>
<tbody>
<tr>
<td>Content of delivery</td>
<td>set</td>
<td>set</td>
</tr>
<tr>
<td>Size A</td>
<td>92</td>
<td>125</td>
</tr>
<tr>
<td>B</td>
<td>67</td>
<td>86</td>
</tr>
<tr>
<td>C</td>
<td>64,5</td>
<td>64,5</td>
</tr>
<tr>
<td>D1 Nut 1</td>
<td>12-36</td>
<td>15-40</td>
</tr>
<tr>
<td>D1 Nut 2</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>D2 Nut 1</td>
<td>30-75*</td>
<td>30-92**</td>
</tr>
<tr>
<td>D2 Nut 2</td>
<td>-</td>
<td>89-105</td>
</tr>
<tr>
<td>E</td>
<td>39</td>
<td>54</td>
</tr>
<tr>
<td>F</td>
<td>52,5</td>
<td>69,5</td>
</tr>
<tr>
<td>G</td>
<td>42,5</td>
<td>51,5</td>
</tr>
<tr>
<td>H</td>
<td>20</td>
<td>24</td>
</tr>
<tr>
<td>J</td>
<td>3</td>
<td>3</td>
</tr>
<tr>
<td>K</td>
<td>41,3</td>
<td>56</td>
</tr>
<tr>
<td>L</td>
<td>20</td>
<td>22,6</td>
</tr>
<tr>
<td>M</td>
<td>9</td>
<td>12</td>
</tr>
<tr>
<td>Clamping range</td>
<td>7-143</td>
<td>7-186</td>
</tr>
</tbody>
</table>

* Ø 63-75 side loading only; ** Ø 72-92 side loading only; Clamping range example RKZ-M
## General accessories

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
</tr>
</thead>
<tbody>
<tr>
<td>149125</td>
<td>piece</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x55</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x50</td>
</tr>
<tr>
<td>149124</td>
<td>piece</td>
<td>18</td>
<td>M16x50</td>
</tr>
<tr>
<td>155722</td>
<td>piece</td>
<td>20</td>
<td>M16x55</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x55</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
</tr>
</thead>
<tbody>
<tr>
<td>320400</td>
<td>piece</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
</tr>
</thead>
<tbody>
<tr>
<td>320401</td>
<td>piece</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
</tr>
</thead>
<tbody>
<tr>
<td>681192</td>
<td>piece</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014825</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014829</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>

---

www.eshop.roehm.biz
Clamping jaws

Clamping jaws to screw onto stepped jaws and standard top jaw
Clamping jaws compatible with NC-compact vices, NC-power vices and machine vices with the same jaw width.

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

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

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

SPR prism jaw
For precise clamping of round material in vertical and horizontal position.
The jaws are to be used in combination with a normal jaw, since a geometrically clear position is only achieved with a three-point clamping.

Pull-down jaws with SNF
Spring leaf are especially suitable for clamping raw parts.
The leaf springs are pressed by the clamping force downwards, thereby causing pull-down force.

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

1) not suitable for RZM
Quick change clamping inserts

Draw-down base jaws with permanent magnet and quick changeable clamping inserts
Clamping jaw comparable to the NC-compact vice and machine vices with the same jaw width.

- **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.

**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.

Other sizes and versions available upon request.

www.eshop.roehm.biz
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.
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
- Impressively reliable, service life and precision
- Fast and simple adjustment of the clamping range by pin system

Optimal coolant and chip drain due to new design

Extensive jaw programme

Simple and fast adjustment of the clamping range by pin system

Stepped clamping force presetting
RB-K

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>179075</th>
<th>179076</th>
<th>179077</th>
<th>179078</th>
<th>179079</th>
</tr>
</thead>
<tbody>
<tr>
<td>Size</td>
<td>1</td>
<td>2</td>
<td>3</td>
<td>4</td>
<td>5</td>
</tr>
<tr>
<td>Jaw width A mm</td>
<td>92</td>
<td>113</td>
<td>135</td>
<td>160</td>
<td>200</td>
</tr>
<tr>
<td>Clamping capacity B mm</td>
<td>100</td>
<td>170</td>
<td>220</td>
<td>310</td>
<td>350</td>
</tr>
<tr>
<td>C mm</td>
<td>31,6</td>
<td>31,6</td>
<td>39,6</td>
<td>49,6</td>
<td>66,6</td>
</tr>
<tr>
<td>D mm</td>
<td>490</td>
<td>583</td>
<td>679</td>
<td>817</td>
<td>1022</td>
</tr>
<tr>
<td>E mm</td>
<td>91</td>
<td>97</td>
<td>112</td>
<td>133</td>
<td>171</td>
</tr>
<tr>
<td>F mm</td>
<td>310</td>
<td>390</td>
<td>468</td>
<td>574</td>
<td>685</td>
</tr>
<tr>
<td>Gx0,02 mm</td>
<td>59</td>
<td>65,5</td>
<td>72,5</td>
<td>83,5</td>
<td>104,5</td>
</tr>
<tr>
<td>H mm</td>
<td>50</td>
<td>55</td>
<td>70</td>
<td>80</td>
<td>90</td>
</tr>
<tr>
<td>J mm</td>
<td>218</td>
<td>236,5</td>
<td>252</td>
<td>298</td>
<td>375</td>
</tr>
<tr>
<td>K/mm</td>
<td>160</td>
<td>160</td>
<td>200</td>
<td>240</td>
<td>280</td>
</tr>
<tr>
<td>O mm</td>
<td>115</td>
<td>160</td>
<td>180</td>
<td>220</td>
<td>230</td>
</tr>
<tr>
<td>P mm</td>
<td>90</td>
<td>90</td>
<td>90</td>
<td>90</td>
<td>160</td>
</tr>
<tr>
<td>Q mm</td>
<td>13</td>
<td>13</td>
<td>13</td>
<td>17</td>
<td>21</td>
</tr>
<tr>
<td>S mm</td>
<td>100</td>
<td>100</td>
<td>135</td>
<td>180</td>
<td>180</td>
</tr>
<tr>
<td>Y mm</td>
<td>12</td>
<td>12</td>
<td>16</td>
<td>16</td>
<td>20</td>
</tr>
<tr>
<td>a mm</td>
<td>63</td>
<td>63</td>
<td>80</td>
<td>100</td>
<td>140</td>
</tr>
<tr>
<td>b mm</td>
<td>13,6</td>
<td>13,6</td>
<td>15,6</td>
<td>19,6</td>
<td>23</td>
</tr>
<tr>
<td>c M</td>
<td>6M</td>
<td>6M</td>
<td>8M</td>
<td>8M</td>
<td>10</td>
</tr>
<tr>
<td>d mm</td>
<td>12</td>
<td>12</td>
<td>13</td>
<td>13</td>
<td>16</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>25</td>
<td>30</td>
<td>39</td>
<td>60</td>
<td>112</td>
</tr>
<tr>
<td>Weight kg</td>
<td>15,5</td>
<td>24</td>
<td>39</td>
<td>60</td>
<td>112</td>
</tr>
</tbody>
</table>
RB-K
## Accessories RB-K

### A37
**Draw-down jaws RNG, with two permanent magnets**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155237</td>
<td>set</td>
<td>1</td>
<td>92</td>
<td>32</td>
</tr>
<tr>
<td>155238</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>32</td>
</tr>
<tr>
<td>155239</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>40</td>
</tr>
<tr>
<td>155240</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>50</td>
</tr>
<tr>
<td>155241</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>67</td>
</tr>
</tbody>
</table>

### A37
**Standard insert RNS, held by two permanent magnets**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155242</td>
<td>set</td>
<td>1</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155243</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155244</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>40</td>
<td>26</td>
</tr>
<tr>
<td>155245</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>50</td>
<td>30</td>
</tr>
<tr>
<td>155246</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>67</td>
<td>36</td>
</tr>
</tbody>
</table>

### A37
**Standard insert, finely checkered RNSf, held by two permanent magnets**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163270</td>
<td>set</td>
<td>1</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>163271</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>163272</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>40</td>
<td>26</td>
</tr>
<tr>
<td>163273</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>50</td>
<td>30</td>
</tr>
<tr>
<td>163274</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>67</td>
<td>36</td>
</tr>
</tbody>
</table>

### A37
**Claw insert RNK, held by two permanent magnets**

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155247</td>
<td>set</td>
<td>1</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155248</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155249</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>40</td>
<td>26</td>
</tr>
<tr>
<td>155250</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>50</td>
<td>30</td>
</tr>
<tr>
<td>155251</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>67</td>
<td>36</td>
</tr>
</tbody>
</table>

© on request

www.eshop.roehm.biz
## Accessories RB-K

### A37
#### Insert with round clamping shoulder RNR, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155252</td>
<td>set</td>
<td>1</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155253</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155254</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>40</td>
<td>26</td>
</tr>
<tr>
<td>155255</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>50</td>
<td>30</td>
</tr>
<tr>
<td>155256</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>67</td>
<td>36</td>
</tr>
</tbody>
</table>

### A37
#### Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>134826</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>32</td>
</tr>
<tr>
<td>134830</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>40</td>
</tr>
<tr>
<td>134834</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>50</td>
</tr>
<tr>
<td>134854</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>67</td>
</tr>
</tbody>
</table>

### A37
#### Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077097</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>38</td>
</tr>
<tr>
<td>077098</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>46</td>
</tr>
<tr>
<td>077099</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>56</td>
</tr>
<tr>
<td>141791</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>68</td>
</tr>
</tbody>
</table>

### A37
#### Draw-down jaws SNF, with spring plate, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077104</td>
<td>set</td>
<td>2</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>077105</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>077106</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>141794</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>64,6</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>152752</td>
<td>piece</td>
<td>1</td>
<td>92</td>
<td>31,6</td>
</tr>
<tr>
<td>152753</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>152754</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>152755</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>152756</td>
<td>piece</td>
<td>5</td>
<td>200</td>
<td>64,6</td>
</tr>
</tbody>
</table>

▲ on request  
www.eshop.roehm.biz
## 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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163218</td>
<td>piece</td>
<td>1</td>
<td>92</td>
<td>31,6</td>
</tr>
<tr>
<td>156195</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>156196</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>156197</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>156199</td>
<td>piece</td>
<td>5</td>
<td>200</td>
<td>64,6</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>128770</td>
<td>piece</td>
<td>1</td>
<td>92</td>
<td>31,6</td>
<td>3-13</td>
</tr>
<tr>
<td>082362</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>31,6</td>
<td>3-13</td>
</tr>
<tr>
<td>082363</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
<td>4-20</td>
</tr>
<tr>
<td>082364</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
<td>5-29</td>
</tr>
<tr>
<td>129734</td>
<td>piece</td>
<td>5</td>
<td>200</td>
<td>64,6</td>
<td>6-37</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150739</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>150740</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>150741</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>156190</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>32</td>
<td>36</td>
</tr>
<tr>
<td>156191</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>40</td>
<td>40</td>
</tr>
<tr>
<td>156192</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>50</td>
<td>45</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Hexagon</th>
<th>A</th>
<th>L</th>
</tr>
</thead>
<tbody>
<tr>
<td>134693</td>
<td>piece</td>
<td>1/2</td>
<td>12</td>
<td>48</td>
<td>80</td>
</tr>
<tr>
<td>134198</td>
<td>piece</td>
<td>3</td>
<td>12</td>
<td>60</td>
<td>90</td>
</tr>
<tr>
<td>134489</td>
<td>piece</td>
<td>4</td>
<td>12</td>
<td>117</td>
<td>90</td>
</tr>
<tr>
<td>134600</td>
<td>piece</td>
<td>5</td>
<td>14</td>
<td>104</td>
<td>160</td>
</tr>
</tbody>
</table>
## Accessories RB-K

### A37

#### Hydraulic unit HDE

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>A</th>
<th>B</th>
</tr>
</thead>
<tbody>
<tr>
<td>094170</td>
<td>piece</td>
<td>1</td>
<td>102</td>
<td>56</td>
</tr>
<tr>
<td>226502</td>
<td>piece</td>
<td>2</td>
<td>109</td>
<td>62</td>
</tr>
<tr>
<td>226503</td>
<td>piece</td>
<td>3</td>
<td>114</td>
<td>70</td>
</tr>
<tr>
<td>226504</td>
<td>piece</td>
<td>4</td>
<td>115</td>
<td>70</td>
</tr>
<tr>
<td>226505</td>
<td>piece</td>
<td>5</td>
<td>147</td>
<td>98</td>
</tr>
</tbody>
</table>

### A37

#### Spindle, complete

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>L</th>
</tr>
</thead>
<tbody>
<tr>
<td>134185</td>
<td>piece</td>
<td>1</td>
<td>91</td>
</tr>
<tr>
<td>134186</td>
<td>piece</td>
<td>2</td>
<td>99</td>
</tr>
<tr>
<td>134187</td>
<td>piece</td>
<td>3</td>
<td>116</td>
</tr>
<tr>
<td>134188</td>
<td>piece</td>
<td>4</td>
<td>151</td>
</tr>
<tr>
<td>134189</td>
<td>piece</td>
<td>5</td>
<td>182</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>External Ø mm</th>
<th>Height</th>
<th>Center Ø</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>082441</td>
<td>2</td>
<td>242</td>
<td>30</td>
<td>28</td>
<td>7,5</td>
</tr>
<tr>
<td>082442</td>
<td>3</td>
<td>280</td>
<td>30</td>
<td>28</td>
<td>11</td>
</tr>
<tr>
<td>082443</td>
<td>4</td>
<td>340</td>
<td>34</td>
<td>28</td>
<td>18</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>External Ø mm</th>
<th>Height</th>
<th>Center Ø</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>090854</td>
<td>5</td>
<td>420</td>
<td>40</td>
<td>28</td>
<td>23</td>
</tr>
</tbody>
</table>
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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>179080</th>
<th>179081</th>
<th>179082</th>
<th>179083</th>
<th>179084</th>
</tr>
</thead>
<tbody>
<tr>
<td>Size</td>
<td>1</td>
<td>2</td>
<td>3</td>
<td>4</td>
<td>5</td>
</tr>
<tr>
<td>Jaw width A mm</td>
<td>92</td>
<td>113</td>
<td>135</td>
<td>160</td>
<td>200</td>
</tr>
<tr>
<td>Clamping capacity B mm</td>
<td>100</td>
<td>185</td>
<td>240</td>
<td>330</td>
<td>370</td>
</tr>
<tr>
<td>C mm</td>
<td>31,6</td>
<td>31,6</td>
<td>39,6</td>
<td>49,6</td>
<td>66,6</td>
</tr>
<tr>
<td>D mm</td>
<td>420</td>
<td>596</td>
<td>686</td>
<td>860</td>
<td>1015</td>
</tr>
<tr>
<td>E mm</td>
<td>91</td>
<td>97</td>
<td>112</td>
<td>133</td>
<td>171</td>
</tr>
<tr>
<td>F mm</td>
<td>310</td>
<td>390</td>
<td>468</td>
<td>574</td>
<td>685</td>
</tr>
<tr>
<td>G x 0,02 mm</td>
<td>0,5</td>
<td>65,5</td>
<td>72,5</td>
<td>83,5</td>
<td>104,5</td>
</tr>
<tr>
<td>H mm</td>
<td>50</td>
<td>55</td>
<td>70</td>
<td>80</td>
<td>90</td>
</tr>
<tr>
<td>J mm</td>
<td>218</td>
<td>236,5</td>
<td>262</td>
<td>298</td>
<td>375</td>
</tr>
<tr>
<td>K mm</td>
<td>160</td>
<td>160</td>
<td>200</td>
<td>240</td>
<td>280</td>
</tr>
<tr>
<td>O mm</td>
<td>115</td>
<td>160</td>
<td>180</td>
<td>220</td>
<td>230</td>
</tr>
<tr>
<td>P mm</td>
<td>90</td>
<td>90</td>
<td>90</td>
<td>90</td>
<td>160</td>
</tr>
<tr>
<td>Q mm</td>
<td>13</td>
<td>13</td>
<td>13</td>
<td>17</td>
<td>21</td>
</tr>
<tr>
<td>S mm</td>
<td>100</td>
<td>100</td>
<td>135</td>
<td>180</td>
<td>180</td>
</tr>
<tr>
<td>Y mm</td>
<td>12</td>
<td>12</td>
<td>16</td>
<td>16</td>
<td>20</td>
</tr>
<tr>
<td>a mm</td>
<td>63</td>
<td>63</td>
<td>80</td>
<td>100</td>
<td>140</td>
</tr>
<tr>
<td>b mm</td>
<td>13,6</td>
<td>13,5</td>
<td>15,6</td>
<td>19,6</td>
<td>23</td>
</tr>
<tr>
<td>c</td>
<td>M6</td>
<td>M6</td>
<td>M6</td>
<td>M8</td>
<td>M10</td>
</tr>
<tr>
<td>d mm</td>
<td>23</td>
<td>12</td>
<td>13</td>
<td>13</td>
<td>16</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>20</td>
<td>25</td>
<td>35</td>
<td>45</td>
<td>55</td>
</tr>
<tr>
<td>Weight kg</td>
<td>15,5</td>
<td>24</td>
<td>39</td>
<td>60</td>
<td>112</td>
</tr>
</tbody>
</table>

A10
RB-M, with SGN normal jaws and hand crank

www.eshop.roehm.biz
## Accessories RB-M

### A37
**Draw-down jaws RNG**, with two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155237</td>
<td>set 1</td>
<td>92</td>
<td></td>
<td>32</td>
</tr>
<tr>
<td>155238</td>
<td>set 2</td>
<td>110</td>
<td></td>
<td>32</td>
</tr>
<tr>
<td>155239</td>
<td>set 3</td>
<td>135</td>
<td></td>
<td>40</td>
</tr>
<tr>
<td>155240</td>
<td>set 4</td>
<td>160</td>
<td></td>
<td>50</td>
</tr>
<tr>
<td>155241</td>
<td>set 5</td>
<td>200</td>
<td></td>
<td>67</td>
</tr>
</tbody>
</table>

### A37
**Standard insert RNS**, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155242</td>
<td>set 1</td>
<td>92</td>
<td></td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155243</td>
<td>set 2</td>
<td>110</td>
<td></td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155244</td>
<td>set 3</td>
<td>135</td>
<td></td>
<td>40</td>
<td>26</td>
</tr>
<tr>
<td>155245</td>
<td>set 4</td>
<td>160</td>
<td></td>
<td>50</td>
<td>30</td>
</tr>
<tr>
<td>155246</td>
<td>set 5</td>
<td>200</td>
<td></td>
<td>67</td>
<td>36</td>
</tr>
</tbody>
</table>

### A37
**Standard insert finely checkered RNSf**, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163270</td>
<td>set 1</td>
<td>92</td>
<td></td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>163271</td>
<td>set 2</td>
<td>110</td>
<td></td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>163272</td>
<td>set 3</td>
<td>135</td>
<td></td>
<td>40</td>
<td>26</td>
</tr>
<tr>
<td>163273</td>
<td>set 4</td>
<td>160</td>
<td></td>
<td>50</td>
<td>30</td>
</tr>
<tr>
<td>163274</td>
<td>set 5</td>
<td>200</td>
<td></td>
<td>67</td>
<td>36</td>
</tr>
</tbody>
</table>

### A37
**Claw insert RNK**, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155247</td>
<td>set 1</td>
<td>92</td>
<td></td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155248</td>
<td>set 2</td>
<td>110</td>
<td></td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155249</td>
<td>set 3</td>
<td>135</td>
<td></td>
<td>40</td>
<td>26</td>
</tr>
<tr>
<td>155250</td>
<td>set 4</td>
<td>160</td>
<td></td>
<td>50</td>
<td>30</td>
</tr>
<tr>
<td>155251</td>
<td>set 5</td>
<td>200</td>
<td></td>
<td>67</td>
<td>36</td>
</tr>
</tbody>
</table>
Accessories RB-M

A37  Insert with round clamping shoulder RNR, held by two permanent magnets

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>C mm</th>
<th>Y mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>155252</td>
<td>set</td>
<td>1</td>
<td>92</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155253</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>155254</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>40</td>
<td>26</td>
</tr>
<tr>
<td>155255</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>50</td>
<td>30</td>
</tr>
<tr>
<td>155256</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>67</td>
<td>36</td>
</tr>
</tbody>
</table>

A37  Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>134826</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>32</td>
</tr>
<tr>
<td>134830</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>40</td>
</tr>
<tr>
<td>134834</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>50</td>
</tr>
<tr>
<td>134854</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>67</td>
</tr>
</tbody>
</table>

A37  Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077097</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>38</td>
</tr>
<tr>
<td>077098</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>46</td>
</tr>
<tr>
<td>077099</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>56</td>
</tr>
<tr>
<td>141791</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>68</td>
</tr>
</tbody>
</table>

A37  Draw-down jaws SNF, with spring plate, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077104</td>
<td>set</td>
<td>2</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>077105</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>077106</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>141794</td>
<td>set</td>
<td>5</td>
<td>200</td>
<td>64,6</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>152752</td>
<td>piece</td>
<td>1</td>
<td>92</td>
<td>31,6</td>
</tr>
<tr>
<td>152753</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>152764</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>152755</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>152756</td>
<td>piece</td>
<td>5</td>
<td>200</td>
<td>64,6</td>
</tr>
</tbody>
</table>
### Accessories RB-M

#### A37<br>Normal jaw finely checkered SGN, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163218</td>
<td>piece</td>
<td>1</td>
<td>92</td>
<td>31,6</td>
</tr>
<tr>
<td>156195</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>156196</td>
<td>piece</td>
<td>3</td>
<td>136</td>
<td>39,6</td>
</tr>
<tr>
<td>156197</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>156199</td>
<td>piece</td>
<td>5</td>
<td>200</td>
<td>64,6</td>
</tr>
</tbody>
</table>

#### A37<br>V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN, only suitable for double clamping

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>128770</td>
<td>piece</td>
<td>1</td>
<td>92</td>
<td>31,6</td>
<td>3-13</td>
</tr>
<tr>
<td>082362</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>31,6</td>
<td>3-13</td>
</tr>
<tr>
<td>082363</td>
<td>piece</td>
<td>3</td>
<td>136</td>
<td>39,6</td>
<td>4-20</td>
</tr>
<tr>
<td>082364</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
<td>6-40</td>
</tr>
<tr>
<td>129734</td>
<td>piece</td>
<td>5</td>
<td>200</td>
<td>64,6</td>
<td>6-37</td>
</tr>
</tbody>
</table>

#### A37<br>Normal jaw SGNA, with movable workpiece stop, hardened and ground, only suitable for double clamping

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150739</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>150740</td>
<td>piece</td>
<td>3</td>
<td>136</td>
<td>39,6</td>
</tr>
<tr>
<td>150741</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
</tr>
</tbody>
</table>

#### C15<br>Hand crank HKU, with octagon socket

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Octagon</th>
<th>L</th>
</tr>
</thead>
<tbody>
<tr>
<td>129658</td>
<td>piece</td>
<td>2/3</td>
<td>12</td>
<td>90</td>
</tr>
<tr>
<td>009150</td>
<td>piece</td>
<td>4/5</td>
<td>12</td>
<td>80</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>External Ø mm</th>
<th>Height</th>
<th>Center Ø</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>082441</td>
<td>2</td>
<td>242</td>
<td>30</td>
<td>28</td>
<td>7,5</td>
</tr>
<tr>
<td>082442</td>
<td>3</td>
<td>290</td>
<td>30</td>
<td>28</td>
<td>11</td>
</tr>
<tr>
<td>082443</td>
<td>4</td>
<td>340</td>
<td>34</td>
<td>28</td>
<td>18</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>External Ø mm</th>
<th>Height</th>
<th>Center Ø</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>090864</td>
<td>5</td>
<td>420</td>
<td>40</td>
<td>28</td>
<td>23</td>
</tr>
</tbody>
</table>
NC power vices

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 clamping 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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>153394</th>
<th>153395</th>
<th>153396</th>
<th>153397</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sizes</td>
<td>1</td>
<td>2</td>
<td>3</td>
<td>4</td>
</tr>
<tr>
<td>B mm</td>
<td>0-100</td>
<td>0-110</td>
<td>0-220</td>
<td>0-310</td>
</tr>
<tr>
<td>B1 mm</td>
<td>0-175</td>
<td>0-225</td>
<td>0-310</td>
<td>0-450</td>
</tr>
<tr>
<td>B2 mm</td>
<td>125-300</td>
<td>138-363</td>
<td>146-454</td>
<td>146-454</td>
</tr>
<tr>
<td>B3 mm</td>
<td>199-374</td>
<td>220-445</td>
<td>248-556</td>
<td>248-556</td>
</tr>
<tr>
<td>C mm</td>
<td>31,6</td>
<td>31,6</td>
<td>39,6</td>
<td>49,6</td>
</tr>
<tr>
<td>D max mm</td>
<td>490</td>
<td>583</td>
<td>681</td>
<td>817</td>
</tr>
<tr>
<td>E ax0,02 mm</td>
<td>91,2</td>
<td>97,7</td>
<td>112,7</td>
<td>133,7</td>
</tr>
<tr>
<td>F mm</td>
<td>310</td>
<td>310</td>
<td>468</td>
<td>574</td>
</tr>
<tr>
<td>G ax0,02 mm</td>
<td>59</td>
<td>65,5</td>
<td>72,5</td>
<td>83,5</td>
</tr>
<tr>
<td>H ax0,02 mm</td>
<td>50</td>
<td>55</td>
<td>70</td>
<td>80</td>
</tr>
<tr>
<td>J mm</td>
<td>218</td>
<td>236,5</td>
<td>262</td>
<td>298</td>
</tr>
<tr>
<td>K ax0,02 mm</td>
<td>94</td>
<td>115</td>
<td>137</td>
<td>162</td>
</tr>
<tr>
<td>L ax0,02 mm</td>
<td>130</td>
<td>190</td>
<td>190</td>
<td>240</td>
</tr>
<tr>
<td>M mm</td>
<td>61,5</td>
<td>68</td>
<td>78</td>
<td>93</td>
</tr>
<tr>
<td>T ax0,02 mm</td>
<td>12,5</td>
<td>17,5</td>
<td>22,5</td>
<td>22,5</td>
</tr>
<tr>
<td>Y ax0,01 mm</td>
<td>11,6</td>
<td>11,6</td>
<td>15,6</td>
<td>15,6</td>
</tr>
<tr>
<td>a mm</td>
<td>63</td>
<td>63</td>
<td>80</td>
<td>100</td>
</tr>
<tr>
<td>b mm</td>
<td>13,6</td>
<td>13,6</td>
<td>15,6</td>
<td>19,6</td>
</tr>
<tr>
<td>c mm</td>
<td>M6</td>
<td>M6</td>
<td>M8</td>
<td>M8</td>
</tr>
<tr>
<td>d mm</td>
<td>12</td>
<td>12</td>
<td>13</td>
<td>13</td>
</tr>
<tr>
<td>e ax0,02 mm</td>
<td>89,5</td>
<td>96</td>
<td>111</td>
<td>132</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>25</td>
<td>30</td>
<td>40</td>
<td>50</td>
</tr>
<tr>
<td>Weight kg</td>
<td>15,5</td>
<td>24</td>
<td>29</td>
<td>65</td>
</tr>
</tbody>
</table>

www.eshop.roehm.biz

Ÿ on request
Accessories RBA

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077104</td>
<td>set 2a</td>
<td>113</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>077105</td>
<td>set 125</td>
<td>135</td>
<td>39,6</td>
<td></td>
</tr>
<tr>
<td>077106</td>
<td>set 160</td>
<td>160</td>
<td>49,6</td>
<td></td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>152752</td>
<td>piece 92</td>
<td>92</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>152753</td>
<td>piece 2a</td>
<td>113</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>152754</td>
<td>piece 3</td>
<td>135</td>
<td>39,6</td>
<td></td>
</tr>
<tr>
<td>152755</td>
<td>piece 160</td>
<td>160</td>
<td>49,6</td>
<td></td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163218</td>
<td>piece 92</td>
<td>92</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>156195</td>
<td>piece 2a</td>
<td>113</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>156196</td>
<td>piece 3</td>
<td>135</td>
<td>39,6</td>
<td></td>
</tr>
<tr>
<td>156197</td>
<td>piece 160</td>
<td>160</td>
<td>49,6</td>
<td></td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm Horizontal</th>
<th>Vertical</th>
</tr>
</thead>
<tbody>
<tr>
<td>128770</td>
<td>piece 92</td>
<td>92</td>
<td>31,6</td>
<td>3-13</td>
<td>5-32</td>
<td></td>
</tr>
<tr>
<td>082362</td>
<td>piece 2a</td>
<td>113</td>
<td>31,6</td>
<td>3-13</td>
<td>5-32</td>
<td></td>
</tr>
<tr>
<td>082363</td>
<td>piece 125</td>
<td>135</td>
<td>39,6</td>
<td>4-20</td>
<td>6-40</td>
<td></td>
</tr>
<tr>
<td>082364</td>
<td>piece 160</td>
<td>160</td>
<td>49,6</td>
<td>5-29</td>
<td>7-48</td>
<td></td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm Horizontal</th>
<th>Vertical</th>
</tr>
</thead>
<tbody>
<tr>
<td>317259</td>
<td>set 2a</td>
<td>110</td>
<td>31,8</td>
<td>3-12</td>
<td>5-32</td>
<td></td>
</tr>
<tr>
<td>317260</td>
<td>set 125</td>
<td>135</td>
<td>39,8</td>
<td>3-13</td>
<td>6-40</td>
<td></td>
</tr>
<tr>
<td>317261</td>
<td>set 4</td>
<td>160</td>
<td>49,8</td>
<td>5-22</td>
<td>7-48</td>
<td></td>
</tr>
</tbody>
</table>
Accessories RBA

A37
Normal jaw SGNA, with movable workpiece stop, hardened and ground, only suitable for double clamping

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150739</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31.6</td>
</tr>
<tr>
<td>150740</td>
<td>piece</td>
<td>125</td>
<td>135</td>
<td>39.6</td>
</tr>
<tr>
<td>150741</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>49.6</td>
</tr>
</tbody>
</table>

A37
Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>134826</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>32</td>
</tr>
<tr>
<td>134830</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>40</td>
</tr>
<tr>
<td>134834</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>50</td>
</tr>
</tbody>
</table>

A37
Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077097</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>38</td>
</tr>
<tr>
<td>077098</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>46</td>
</tr>
<tr>
<td>077099</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>56</td>
</tr>
</tbody>
</table>

A37
Stepped top jaw ASB, for stationary jaw

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>153403</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>19</td>
</tr>
<tr>
<td>153405</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>22</td>
</tr>
<tr>
<td>153407</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>25</td>
</tr>
</tbody>
</table>

A37
Stepped top jaw ASB, for movable jaw

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>153404</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>19</td>
</tr>
<tr>
<td>153406</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>22</td>
</tr>
<tr>
<td>153408</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>25</td>
</tr>
</tbody>
</table>

A37
Hand crank, turnable handle, hexagon socket

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Hexagon</th>
<th>A mm</th>
<th>L mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>134593</td>
<td>piece</td>
<td>1/2</td>
<td>12</td>
<td>48</td>
<td>80</td>
</tr>
<tr>
<td>134198</td>
<td>piece</td>
<td>92</td>
<td>12</td>
<td>60</td>
<td>90</td>
</tr>
<tr>
<td>134499</td>
<td>piece</td>
<td>4</td>
<td>12</td>
<td>117</td>
<td>90</td>
</tr>
</tbody>
</table>

A on request

www.eshop.roehm.biz
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°)

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>142351</td>
<td>piece</td>
<td>1-4</td>
</tr>
</tbody>
</table>

**A37**

*Hydraulic unit HDE*

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>A mm</th>
<th>B mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>094170</td>
<td>piece</td>
<td>1</td>
<td>102</td>
<td>56</td>
</tr>
<tr>
<td>226502</td>
<td>piece</td>
<td>2</td>
<td>109</td>
<td>62</td>
</tr>
<tr>
<td>226503</td>
<td>piece</td>
<td>3</td>
<td>114</td>
<td>70</td>
</tr>
<tr>
<td>226504</td>
<td>piece</td>
<td>4</td>
<td>115</td>
<td>70</td>
</tr>
</tbody>
</table>

**A37**

*Spindle, complete*

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>L mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>134185</td>
<td>piece</td>
<td>1</td>
<td>91</td>
</tr>
<tr>
<td>134186</td>
<td>piece</td>
<td>2</td>
<td>99</td>
</tr>
<tr>
<td>134187</td>
<td>piece</td>
<td>3</td>
<td>116</td>
</tr>
<tr>
<td>134188</td>
<td>piece</td>
<td>4</td>
<td>151</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x55</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x60</td>
</tr>
<tr>
<td>149124</td>
<td>piece</td>
<td>18</td>
<td>M16x60</td>
</tr>
<tr>
<td>155722</td>
<td>piece</td>
<td>20</td>
<td>M16x65</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x65</td>
</tr>
</tbody>
</table>
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
- Strong, 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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>154763</th>
<th>154764</th>
<th>154765</th>
</tr>
</thead>
<tbody>
<tr>
<td>Size</td>
<td>2</td>
<td>3</td>
<td>4</td>
</tr>
<tr>
<td>Jaw width A mm</td>
<td>113</td>
<td>135</td>
<td>160</td>
</tr>
<tr>
<td>B1 mm</td>
<td>0-175</td>
<td>0-225</td>
<td>0-310</td>
</tr>
<tr>
<td>B2 mm</td>
<td>125-300</td>
<td>138-363</td>
<td>146-454</td>
</tr>
<tr>
<td>B3 mm</td>
<td>199-374</td>
<td>220-445</td>
<td>248-556</td>
</tr>
<tr>
<td>C mm</td>
<td>31,6</td>
<td>39,6</td>
<td>49,6</td>
</tr>
<tr>
<td>Dmax mm</td>
<td>500</td>
<td>578</td>
<td>702</td>
</tr>
<tr>
<td>E=0,02 mm</td>
<td>97,7</td>
<td>112,7</td>
<td>133,7</td>
</tr>
<tr>
<td>F mm</td>
<td>390</td>
<td>468</td>
<td>574</td>
</tr>
<tr>
<td>G=0,02 mm</td>
<td>65,5</td>
<td>72,5</td>
<td>83,5</td>
</tr>
<tr>
<td>H=0,02 mm</td>
<td>55</td>
<td>70</td>
<td>80</td>
</tr>
<tr>
<td>J mm</td>
<td>211</td>
<td>213</td>
<td>240</td>
</tr>
<tr>
<td>K=0,02 mm</td>
<td>115</td>
<td>137</td>
<td>162</td>
</tr>
<tr>
<td>L=0,02 mm</td>
<td>190</td>
<td>190</td>
<td>240</td>
</tr>
<tr>
<td>M mm</td>
<td>73,5</td>
<td>80,5</td>
<td>96</td>
</tr>
<tr>
<td>T=0,02 mm</td>
<td>17,5</td>
<td>17,5</td>
<td>22,5</td>
</tr>
<tr>
<td>Y=0,01 mm</td>
<td>11,6</td>
<td>15,6</td>
<td>15,6</td>
</tr>
<tr>
<td>a mm</td>
<td>63</td>
<td>80</td>
<td>100</td>
</tr>
<tr>
<td>b mm</td>
<td>13,6</td>
<td>15,6</td>
<td>19,6</td>
</tr>
<tr>
<td>c mm</td>
<td>M6</td>
<td>M8</td>
<td>M8</td>
</tr>
<tr>
<td>d mm</td>
<td>12</td>
<td>13</td>
<td>13</td>
</tr>
<tr>
<td>ex=0,02 mm</td>
<td>96</td>
<td>111</td>
<td>132</td>
</tr>
<tr>
<td>f mm</td>
<td>82</td>
<td>80</td>
<td>100</td>
</tr>
<tr>
<td>g mm</td>
<td>16</td>
<td>30</td>
<td>30</td>
</tr>
<tr>
<td>h mm</td>
<td>M 8 x 14</td>
<td>M10x16</td>
<td>M12x20</td>
</tr>
<tr>
<td>i mm</td>
<td>63</td>
<td>80</td>
<td>100</td>
</tr>
<tr>
<td>k mm</td>
<td>30</td>
<td>30</td>
<td>30</td>
</tr>
<tr>
<td>l mm</td>
<td>85</td>
<td>105</td>
<td>120</td>
</tr>
<tr>
<td>m mm</td>
<td>30</td>
<td>35</td>
<td>35</td>
</tr>
<tr>
<td>n mm</td>
<td>52</td>
<td>70</td>
<td>96</td>
</tr>
<tr>
<td>o mm</td>
<td>135</td>
<td>135</td>
<td>142</td>
</tr>
<tr>
<td>pH7 mm</td>
<td>12</td>
<td>14</td>
<td>14</td>
</tr>
<tr>
<td>q mm</td>
<td>5</td>
<td>5</td>
<td>5</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>30</td>
<td>40</td>
<td>50</td>
</tr>
<tr>
<td>Weight kg</td>
<td>22</td>
<td>36</td>
<td>62</td>
</tr>
</tbody>
</table>
Accessories RBAW

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077104</td>
<td>set</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>077105</td>
<td>set</td>
<td>125</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>077106</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>152753</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>152754</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>152755</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>156195</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>156196</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>156197</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>082362</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
<td>3-13 5-32</td>
</tr>
<tr>
<td>082363</td>
<td>piece</td>
<td>125</td>
<td>135</td>
<td>39,6</td>
<td>4-20 6-40</td>
</tr>
<tr>
<td>082364</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
<td>5-29 7-48</td>
</tr>
</tbody>
</table>

A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>317259</td>
<td>set</td>
<td>2a</td>
<td>110</td>
<td>31,8</td>
<td>3-12 5-32</td>
</tr>
<tr>
<td>317260</td>
<td>set</td>
<td>125</td>
<td>135</td>
<td>39,8</td>
<td>3-13 6-40</td>
</tr>
<tr>
<td>317261</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>49,8</td>
<td>5-22 7-48</td>
</tr>
</tbody>
</table>

www.eshop.roehm.biz
Accessories RBAW

A37
Normal jaw SGNA, with movable workpiece stop, hardened and ground, only suitable for double clamping

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150739</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>150740</td>
<td>piece</td>
<td>125</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>150741</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
</tr>
</tbody>
</table>

A37
Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>134826</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>32</td>
</tr>
<tr>
<td>134830</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>40</td>
</tr>
<tr>
<td>134834</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>50</td>
</tr>
</tbody>
</table>

A37
Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077097</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>38</td>
</tr>
<tr>
<td>077098</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>46</td>
</tr>
<tr>
<td>077099</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>56</td>
</tr>
</tbody>
</table>

A37
Stepped top jaw ASB, for stationary jaw

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>153403</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>19</td>
</tr>
<tr>
<td>153405</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>22</td>
</tr>
<tr>
<td>153407</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>25</td>
</tr>
</tbody>
</table>

A37
Stepped top jaw ASB, for movable jaw

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>153404</td>
<td>piece</td>
<td>2</td>
<td>113</td>
<td>19</td>
</tr>
<tr>
<td>153406</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>22</td>
</tr>
<tr>
<td>153408</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>25</td>
</tr>
</tbody>
</table>

A37
Floating jaw horizontal PEB, for clamping non-parallel workpieces

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Thickness mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>156190</td>
<td>piece</td>
<td>92</td>
<td>113</td>
<td>32</td>
<td>36</td>
</tr>
<tr>
<td>156191</td>
<td>piece</td>
<td>125</td>
<td>135</td>
<td>40</td>
<td>40</td>
</tr>
<tr>
<td>156192</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>50</td>
<td>45</td>
</tr>
</tbody>
</table>

▲ on request  www.eshop.roehm.biz  4097
## Accessories RBAW

### A37
**Hand crank**, turnable handle, hexagon socket

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Hexagon</th>
<th>A mm</th>
<th>L mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>134499</td>
<td>piece</td>
<td>4</td>
<td>12</td>
<td>117</td>
<td>90</td>
</tr>
</tbody>
</table>

### A37
**Single clamp SPE**, for mounting vices on end and on the base

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x55</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x60</td>
</tr>
<tr>
<td>150722</td>
<td>piece</td>
<td>20</td>
<td>M16x60</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x65</td>
</tr>
<tr>
<td>155722</td>
<td>piece</td>
<td>20</td>
<td>M16x65</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014825</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014829</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>
General accessories

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149125</td>
<td>piece</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>149121</td>
<td>piece</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>149122</td>
<td>piece</td>
<td>14</td>
<td>M12x50</td>
</tr>
<tr>
<td>149123</td>
<td>piece</td>
<td>16</td>
<td>M12x60</td>
</tr>
<tr>
<td>149124</td>
<td>piece</td>
<td>18</td>
<td>M16x50</td>
</tr>
<tr>
<td>155722</td>
<td>piece</td>
<td>20</td>
<td>M16x55</td>
</tr>
<tr>
<td>151507</td>
<td>piece</td>
<td>22</td>
<td>M16x55</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
</tr>
</thead>
<tbody>
<tr>
<td>320400</td>
<td>piece</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
</tr>
</thead>
<tbody>
<tr>
<td>320401</td>
<td>piece</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
</tr>
</thead>
<tbody>
<tr>
<td>681192</td>
<td>piece</td>
</tr>
</tbody>
</table>

**A37**

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014825</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014829</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>
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

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

### A37
#### Step jaw SB, for stationary jaw

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>1043226</td>
<td>piece</td>
<td>125</td>
<td>120</td>
<td>38</td>
</tr>
<tr>
<td>1043228</td>
<td>piece</td>
<td>150</td>
<td>146</td>
<td>48</td>
</tr>
<tr>
<td>1043230</td>
<td>piece</td>
<td>175</td>
<td>171</td>
<td>58</td>
</tr>
</tbody>
</table>

### A37
#### Step jaw SB, for movable jaw

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>1043227</td>
<td>piece</td>
<td>125</td>
<td>120</td>
<td>38</td>
</tr>
<tr>
<td>1043228</td>
<td>piece</td>
<td>150</td>
<td>146</td>
<td>48</td>
</tr>
<tr>
<td>1043231</td>
<td>piece</td>
<td>175</td>
<td>171</td>
<td>58</td>
</tr>
</tbody>
</table>

### A37
#### V-jaw PB with jaw steps, for movable jaw

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>1043409</td>
<td>piece</td>
<td>125</td>
<td>120</td>
<td>38</td>
</tr>
<tr>
<td>1043410</td>
<td>piece</td>
<td>150</td>
<td>146</td>
<td>48</td>
</tr>
<tr>
<td>1043411</td>
<td>piece</td>
<td>175</td>
<td>171</td>
<td>58</td>
</tr>
</tbody>
</table>

### A37
#### Incline jaw WB (for circular parts), for movable jaw

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>1043412</td>
<td>piece</td>
<td>125</td>
<td>120</td>
<td>38</td>
</tr>
<tr>
<td>1043413</td>
<td>piece</td>
<td>150</td>
<td>146</td>
<td>48</td>
</tr>
<tr>
<td>1043414</td>
<td>piece</td>
<td>175</td>
<td>171</td>
<td>58</td>
</tr>
</tbody>
</table>

### A37
#### Single clamp SPE

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>T-slot</th>
<th>Thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>163329</td>
<td>piece</td>
<td>125</td>
<td>12</td>
<td>M10x45</td>
</tr>
<tr>
<td>163330</td>
<td>piece</td>
<td>125</td>
<td>14</td>
<td>M12x55</td>
</tr>
<tr>
<td>163331</td>
<td>piece</td>
<td>125</td>
<td>16</td>
<td>M12x55</td>
</tr>
<tr>
<td>163332</td>
<td>piece</td>
<td>125</td>
<td>18</td>
<td>M16x55</td>
</tr>
<tr>
<td>163333</td>
<td>piece</td>
<td>150/175</td>
<td>12</td>
<td>M10x50</td>
</tr>
<tr>
<td>163334</td>
<td>piece</td>
<td>150/175</td>
<td>14</td>
<td>M12x55</td>
</tr>
<tr>
<td>163335</td>
<td>piece</td>
<td>150/175</td>
<td>16</td>
<td>M12x55</td>
</tr>
<tr>
<td>163336</td>
<td>piece</td>
<td>150/175</td>
<td>18</td>
<td>M16x60</td>
</tr>
</tbody>
</table>

### A37
#### Rotation plate DP

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>External Ø mm</th>
<th>Height</th>
</tr>
</thead>
<tbody>
<tr>
<td>476867</td>
<td>125</td>
<td>226</td>
<td>47</td>
</tr>
<tr>
<td>476868</td>
<td>150</td>
<td>290</td>
<td>58</td>
</tr>
<tr>
<td>476870</td>
<td>175</td>
<td>320</td>
<td>58</td>
</tr>
</tbody>
</table>
RS Machine vices

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>128031</th>
<th>128032</th>
<th>128033</th>
<th>128034</th>
<th>111648</th>
</tr>
</thead>
<tbody>
<tr>
<td>Size</td>
<td>1</td>
<td>2</td>
<td>3</td>
<td>4</td>
<td>5</td>
</tr>
<tr>
<td>Jaw width A mm</td>
<td>92</td>
<td>113</td>
<td>135</td>
<td>160</td>
<td>200</td>
</tr>
<tr>
<td>B mm</td>
<td>85</td>
<td>105</td>
<td>125</td>
<td>145</td>
<td>185</td>
</tr>
<tr>
<td>C mm</td>
<td>31,6</td>
<td>31,6</td>
<td>39,6</td>
<td>49,6</td>
<td>62,6</td>
</tr>
<tr>
<td>D mm</td>
<td>362</td>
<td>423</td>
<td>510</td>
<td>575</td>
<td>675</td>
</tr>
<tr>
<td>F mm</td>
<td>260</td>
<td>300</td>
<td>365</td>
<td>410</td>
<td>490</td>
</tr>
<tr>
<td>G mm</td>
<td>48</td>
<td>66</td>
<td>64</td>
<td>70</td>
<td>82</td>
</tr>
<tr>
<td>H mm</td>
<td>50</td>
<td>50</td>
<td>70</td>
<td>80</td>
<td>90</td>
</tr>
<tr>
<td>J mm</td>
<td>174</td>
<td>200</td>
<td>242</td>
<td>273</td>
<td>322</td>
</tr>
<tr>
<td>K mm</td>
<td>160</td>
<td>160</td>
<td>200</td>
<td>240</td>
<td>280</td>
</tr>
<tr>
<td>L mm</td>
<td>115</td>
<td>125</td>
<td>155</td>
<td>175</td>
<td>200</td>
</tr>
<tr>
<td>P mm</td>
<td>60</td>
<td>60</td>
<td>70</td>
<td>80</td>
<td>118</td>
</tr>
<tr>
<td>Q mm</td>
<td>13</td>
<td>13</td>
<td>13</td>
<td>17</td>
<td>21</td>
</tr>
<tr>
<td>R mm</td>
<td>14</td>
<td>14</td>
<td>14</td>
<td>18</td>
<td>22</td>
</tr>
<tr>
<td>S mm</td>
<td>120</td>
<td>120</td>
<td>146</td>
<td>184,5</td>
<td>210</td>
</tr>
<tr>
<td>T mm</td>
<td>12</td>
<td>12</td>
<td>16</td>
<td>16</td>
<td>20</td>
</tr>
<tr>
<td>a mm</td>
<td>63</td>
<td>63</td>
<td>80</td>
<td>100</td>
<td>125</td>
</tr>
<tr>
<td>b mm</td>
<td>13,6</td>
<td>13,6</td>
<td>15,6</td>
<td>19,6</td>
<td>24,6</td>
</tr>
<tr>
<td>c  M</td>
<td>6</td>
<td>6</td>
<td>8</td>
<td>8</td>
<td>10</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>18</td>
<td>20</td>
<td>35</td>
<td>45</td>
<td>55</td>
</tr>
<tr>
<td>Weight kg</td>
<td>12</td>
<td>13,5</td>
<td>25</td>
<td>40</td>
<td>65</td>
</tr>
</tbody>
</table>

www.eshop.roehm.biz
RS machine vice

RS on request

www.eshop.roehm.biz
## Accessories RS

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077104</td>
<td>set 2a</td>
<td>113</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>077105</td>
<td>set 125</td>
<td>135</td>
<td>39,6</td>
<td></td>
</tr>
<tr>
<td>077106</td>
<td>set 160</td>
<td>160</td>
<td>49,6</td>
<td></td>
</tr>
<tr>
<td>077107</td>
<td>set 200</td>
<td>200</td>
<td>62,6</td>
<td></td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>152752</td>
<td>piece 1</td>
<td>92</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>152753</td>
<td>piece 2</td>
<td>113</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>152754</td>
<td>piece 3</td>
<td>135</td>
<td>39,6</td>
<td></td>
</tr>
<tr>
<td>152755</td>
<td>piece 4</td>
<td>160</td>
<td>49,6</td>
<td></td>
</tr>
<tr>
<td>152759</td>
<td>piece 5</td>
<td>200</td>
<td>62,6</td>
<td></td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>163218</td>
<td>piece 92</td>
<td>92</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>156195</td>
<td>piece 2a</td>
<td>113</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>156196</td>
<td>piece 3</td>
<td>135</td>
<td>39,6</td>
<td></td>
</tr>
<tr>
<td>156197</td>
<td>piece 160</td>
<td>160</td>
<td>49,6</td>
<td></td>
</tr>
<tr>
<td>156198</td>
<td>piece 200</td>
<td>200</td>
<td>62,6</td>
<td></td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm Horizontal</th>
<th>Vertical</th>
</tr>
</thead>
<tbody>
<tr>
<td>128770</td>
<td>piece 92</td>
<td>92</td>
<td>31,6</td>
<td>3-13</td>
<td>5-32</td>
<td></td>
</tr>
<tr>
<td>082362</td>
<td>piece 2a</td>
<td>113</td>
<td>31,6</td>
<td>3-13</td>
<td>5-32</td>
<td></td>
</tr>
<tr>
<td>082363</td>
<td>piece 125</td>
<td>135</td>
<td>39,6</td>
<td>4-20</td>
<td>6-40</td>
<td></td>
</tr>
<tr>
<td>082364</td>
<td>piece 160</td>
<td>160</td>
<td>49,6</td>
<td>5-29</td>
<td>7-48</td>
<td></td>
</tr>
<tr>
<td>082365</td>
<td>piece 200</td>
<td>200</td>
<td>62,6</td>
<td>6-37</td>
<td>8-56</td>
<td></td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150739</td>
<td>piece 2a</td>
<td>113</td>
<td>31,6</td>
<td></td>
</tr>
<tr>
<td>150740</td>
<td>piece 125</td>
<td>135</td>
<td>39,6</td>
<td></td>
</tr>
<tr>
<td>150741</td>
<td>piece 4</td>
<td>160</td>
<td>49,6</td>
<td></td>
</tr>
</tbody>
</table>
## Accessories RS

### C15
**Hand crank HKU**, with octagon socket

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Octagon</th>
<th>L mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>009150</td>
<td>piece</td>
<td>50</td>
<td>12</td>
<td>80</td>
</tr>
<tr>
<td>009152</td>
<td>piece</td>
<td>70</td>
<td>14</td>
<td>125</td>
</tr>
<tr>
<td>009153</td>
<td>piece</td>
<td>92</td>
<td>17</td>
<td>160</td>
</tr>
<tr>
<td>009154</td>
<td>piece</td>
<td>125</td>
<td>19</td>
<td>200</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>External Ø mm</th>
<th>Height mm</th>
<th>Center Ø mm</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>129814</td>
<td>1/2</td>
<td>242</td>
<td>30</td>
<td>28</td>
<td>7,5</td>
</tr>
<tr>
<td>082442</td>
<td>3</td>
<td>280</td>
<td>30</td>
<td>28</td>
<td>11</td>
</tr>
<tr>
<td>082443</td>
<td>4</td>
<td>340</td>
<td>34</td>
<td>28</td>
<td>18</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>External Ø mm</th>
<th>Height mm</th>
<th>Center Ø mm</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>090854</td>
<td>5</td>
<td>420</td>
<td>40</td>
<td>28</td>
<td>23</td>
</tr>
</tbody>
</table>
**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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>014523</th>
<th>014740</th>
<th>014752</th>
<th>014802</th>
<th>014807</th>
</tr>
</thead>
<tbody>
<tr>
<td>Size</td>
<td>2</td>
<td>3</td>
<td>4</td>
<td>5</td>
<td>6</td>
</tr>
<tr>
<td>Jaw width A mm</td>
<td>113</td>
<td>135</td>
<td>160</td>
<td>200</td>
<td>250</td>
</tr>
<tr>
<td>B mm</td>
<td>110</td>
<td>140</td>
<td>180</td>
<td>300</td>
<td>400</td>
</tr>
<tr>
<td>C mm</td>
<td>31,6</td>
<td>39,6</td>
<td>49,6</td>
<td>62,6</td>
<td>62,6</td>
</tr>
<tr>
<td>D mm</td>
<td>358</td>
<td>408</td>
<td>495</td>
<td>655</td>
<td>767</td>
</tr>
<tr>
<td>F mm</td>
<td>344</td>
<td>394</td>
<td>480</td>
<td>640</td>
<td>751</td>
</tr>
<tr>
<td>G mm</td>
<td>61</td>
<td>65,5</td>
<td>74</td>
<td>79</td>
<td>85</td>
</tr>
<tr>
<td>J mm</td>
<td>81</td>
<td>87</td>
<td>107</td>
<td>123</td>
<td>123</td>
</tr>
<tr>
<td>K mm</td>
<td>132</td>
<td>152</td>
<td>180</td>
<td>200</td>
<td>220</td>
</tr>
<tr>
<td>O mm</td>
<td>149</td>
<td>174</td>
<td>214</td>
<td>234</td>
<td>244</td>
</tr>
<tr>
<td>P mm</td>
<td>50</td>
<td>60</td>
<td>60</td>
<td>70</td>
<td>80</td>
</tr>
<tr>
<td>Q mm</td>
<td>11</td>
<td>11</td>
<td>17</td>
<td>17</td>
<td>17</td>
</tr>
<tr>
<td>R mm</td>
<td>13</td>
<td>13</td>
<td>17</td>
<td>17</td>
<td>21</td>
</tr>
<tr>
<td>S mm</td>
<td>101</td>
<td>118,5</td>
<td>142</td>
<td>158</td>
<td>175</td>
</tr>
<tr>
<td>Y mm</td>
<td>12</td>
<td>16</td>
<td>16</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>a mm</td>
<td>63</td>
<td>80</td>
<td>100</td>
<td>125</td>
<td>160</td>
</tr>
<tr>
<td>b mm</td>
<td>13,6</td>
<td>15,6</td>
<td>19,6</td>
<td>24,6</td>
<td>24,6</td>
</tr>
<tr>
<td>c</td>
<td>M6</td>
<td>M8</td>
<td>M8</td>
<td>M10</td>
<td>M10</td>
</tr>
<tr>
<td>Clamping force kN</td>
<td>15</td>
<td>22</td>
<td>24</td>
<td>25</td>
<td>28</td>
</tr>
<tr>
<td>Weight kg</td>
<td>12,4</td>
<td>19</td>
<td>31</td>
<td>52</td>
<td>71</td>
</tr>
</tbody>
</table>

[www.eshop.roehm.biz](http://www.eshop.roehm.biz)
## Accessories UZ

### A37
**Draw-down jaws SNF,** with spring plate, hardened and ground

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>077103</td>
<td>set</td>
<td>2</td>
<td>90</td>
<td>24,6</td>
</tr>
<tr>
<td>077104</td>
<td>set</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>077105</td>
<td>set</td>
<td>125</td>
<td>136</td>
<td>39,6</td>
</tr>
<tr>
<td>077106</td>
<td>set</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>077107</td>
<td>set</td>
<td>200</td>
<td>200</td>
<td>62,6</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>152767</td>
<td>piece</td>
<td>2</td>
<td>90</td>
<td>24,6</td>
</tr>
<tr>
<td>152753</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>152754</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>152755</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>152759</td>
<td>piece</td>
<td>200</td>
<td>200</td>
<td>62,6</td>
</tr>
<tr>
<td>152760</td>
<td>piece</td>
<td>6</td>
<td>250</td>
<td>62,6</td>
</tr>
<tr>
<td>152762</td>
<td>piece</td>
<td></td>
<td>300</td>
<td>79,6</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>156195</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>156196</td>
<td>piece</td>
<td>3</td>
<td>135</td>
<td>39,6</td>
</tr>
<tr>
<td>156197</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
</tr>
<tr>
<td>156198</td>
<td>piece</td>
<td>200</td>
<td>200</td>
<td>62,6</td>
</tr>
</tbody>
</table>

### A37
**V-jaw SPR,** with vertically and horizontally ground-in prisms, hardened, for combination with SGN, only suitable for double clamping

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm</th>
<th>Horizontal</th>
<th>Vertical</th>
</tr>
</thead>
<tbody>
<tr>
<td>082361</td>
<td>piece</td>
<td>2</td>
<td>90</td>
<td>24,6</td>
<td>3-13</td>
<td>5-32</td>
<td></td>
</tr>
<tr>
<td>082362</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
<td>3-13</td>
<td>5-32</td>
<td></td>
</tr>
<tr>
<td>082363</td>
<td>piece</td>
<td>125</td>
<td>135</td>
<td>39,6</td>
<td>4-20</td>
<td>6-40</td>
<td></td>
</tr>
<tr>
<td>082364</td>
<td>piece</td>
<td>160</td>
<td>160</td>
<td>49,6</td>
<td>5-29</td>
<td>7-48</td>
<td></td>
</tr>
<tr>
<td>082365</td>
<td>piece</td>
<td>200</td>
<td>200</td>
<td>62,6</td>
<td>6-37</td>
<td>8-56</td>
<td></td>
</tr>
<tr>
<td>082366</td>
<td>piece</td>
<td>6</td>
<td>250</td>
<td>62,6</td>
<td>7-45</td>
<td>9-65</td>
<td></td>
</tr>
</tbody>
</table>

### A37
**V-jaw and standard jaw SBO,** unhardened and burnished, with workpiece support

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

### A37
**Normal jaw SGNA,** with movable workpiece stop, hardened and ground, only suitable for double clamping

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150739</td>
<td>piece</td>
<td>2a</td>
<td>113</td>
<td>31,6</td>
</tr>
<tr>
<td>150740</td>
<td>piece</td>
<td>125</td>
<td>125</td>
<td>39,6</td>
</tr>
<tr>
<td>150741</td>
<td>piece</td>
<td>4</td>
<td>160</td>
<td>49,6</td>
</tr>
</tbody>
</table>

[www.eshop.roehm.biz](http://www.eshop.roehm.biz)
## Accessories UZ

### C15
**Hand crank HKU**, with octagon socket

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Octagon (mm)</th>
<th>L (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>009152</td>
<td>piece</td>
<td>70</td>
<td>14</td>
<td>125</td>
</tr>
<tr>
<td>009153</td>
<td>piece</td>
<td>92</td>
<td>17</td>
<td>160</td>
</tr>
<tr>
<td>009154</td>
<td>piece</td>
<td>125</td>
<td>19</td>
<td>200</td>
</tr>
</tbody>
</table>

### General accessories

#### A37
**Work locator WSA**, universally adjustable, for fastening to the machine table (size 14 T-slot) or for screwing onto the NC-compact vice / machine vice (M12)

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>320401</td>
<td>piece</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Length (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>014823</td>
<td>set</td>
<td>20x12</td>
<td>22</td>
</tr>
<tr>
<td>014826</td>
<td>set</td>
<td>20x14</td>
<td>25</td>
</tr>
<tr>
<td>014827</td>
<td>set</td>
<td>20x16</td>
<td>25</td>
</tr>
<tr>
<td>014829</td>
<td>set</td>
<td>20x18</td>
<td>25</td>
</tr>
<tr>
<td>014831</td>
<td>set</td>
<td>20x20</td>
<td>22</td>
</tr>
<tr>
<td>014833</td>
<td>set</td>
<td>20x22</td>
<td>32</td>
</tr>
</tbody>
</table>
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.
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

Body made of special steel casting for flexible application

Reversible clamping jaws: one side smooth or respectively with longitudinal and cross prism, one side grooved, ground on both sides

Long guidance of moving jaw, even in the external clamping range

Quick clamping system optimized for workpiece series machining

www.eshop.roehm.biz
**APPLICATION**
For securely clamping workpieces on drills and measuring machines.

**TYPE**
Clamping system mechanical, manually operated.
Standard version.

**CUSTOMER BENEFITS**
- Quick-clamping vice
- For quick clamping and unclamping, particularly in the case of series work-piece machining
- Optimal price/performance ratio
- One-hand operation
- Long guidance of moving jaw, even in the external clamping range
- Clamping jaws are hardened and reversible, one side smooth and ground on both sides
- Solid clamping jaw with one longitudinal prism and two transverse prisms
- Both jaws with support surface for clamping flat workpieces

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

---

**A12**
**BSS**, with V-jaw and normal jaw SBO

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>Jaw width mm</th>
<th>Jaw height mm</th>
<th>Clamping capacity mm</th>
<th>Length mm</th>
<th>Height mm</th>
<th>Length body mm</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>134158</td>
<td>2</td>
<td>110</td>
<td>32</td>
<td>130</td>
<td>510</td>
<td>72,5</td>
<td>315</td>
<td>9,5</td>
</tr>
<tr>
<td>134159</td>
<td>3</td>
<td>135</td>
<td>40</td>
<td>160</td>
<td>687</td>
<td>80,5</td>
<td>365</td>
<td>13,5</td>
</tr>
</tbody>
</table>

---

**APPLICATION**
For securely clamping workpieces on drills and measuring machines.

**TYPE**
Clamping system mechanical, manually operated.
Standard version.

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

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

---

**A12**
**BOF**, with V-jaw and normal jaw SBO

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>Jaw width mm</th>
<th>Jaw height mm</th>
<th>Clamping capacity mm</th>
<th>Length mm</th>
<th>Height mm</th>
<th>Length body mm</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>142835</td>
<td>1</td>
<td>90</td>
<td>25</td>
<td>90</td>
<td>356</td>
<td>60</td>
<td>195</td>
<td>5,5</td>
</tr>
<tr>
<td>111595</td>
<td>2</td>
<td>110</td>
<td>32</td>
<td>130</td>
<td>470</td>
<td>72,5</td>
<td>315</td>
<td>9,5</td>
</tr>
<tr>
<td>111596</td>
<td>3</td>
<td>135</td>
<td>40</td>
<td>160</td>
<td>550</td>
<td>80,5</td>
<td>365</td>
<td>13,5</td>
</tr>
<tr>
<td>111597</td>
<td>4</td>
<td>160</td>
<td>50</td>
<td>220</td>
<td>692</td>
<td>90,5</td>
<td>445</td>
<td>25</td>
</tr>
</tbody>
</table>
Drilling machine vices

BMS

APPLICATION
For securely clamping workpieces on drills and measuring machines.

TYPE
D. I. Y. design for small drill stands. 
Clamping system mechanical, manually operated.

CUSTOMER BENEFITS
- Lever movable (included in scope of delivery)
- Both jaws 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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>Jaw width mm</th>
<th>Clamping capacity mm</th>
<th>Length body mm</th>
<th>Width body mm</th>
<th>Height mm</th>
<th>Jaw height mm</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>007193</td>
<td>1</td>
<td>65</td>
<td>65</td>
<td>125</td>
<td>105</td>
<td>43</td>
<td>25</td>
<td>1.2</td>
</tr>
<tr>
<td>007194</td>
<td>2</td>
<td>80</td>
<td>85</td>
<td>150</td>
<td>130</td>
<td>46</td>
<td>25</td>
<td>1.7</td>
</tr>
<tr>
<td>007196</td>
<td>3</td>
<td>100</td>
<td>80</td>
<td>170</td>
<td>175</td>
<td>57</td>
<td>25</td>
<td>4.2</td>
</tr>
</tbody>
</table>

---

A12
BSH, sturdy craftsman design

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>Jaw width mm</th>
<th>Clamping capacity mm</th>
<th>Length body mm</th>
<th>Width body mm</th>
<th>Height mm</th>
<th>Jaw height mm</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>007197</td>
<td>4</td>
<td>80</td>
<td>80</td>
<td>200</td>
<td>140</td>
<td>70</td>
<td>40</td>
<td>5</td>
</tr>
<tr>
<td>007201</td>
<td>5</td>
<td>100</td>
<td>95</td>
<td>215</td>
<td>175</td>
<td>75</td>
<td>40</td>
<td>7</td>
</tr>
<tr>
<td>007202</td>
<td>6</td>
<td>120</td>
<td>110</td>
<td>260</td>
<td>215</td>
<td>85</td>
<td>40</td>
<td>11</td>
</tr>
<tr>
<td>007207</td>
<td>7</td>
<td>140</td>
<td>150</td>
<td>300</td>
<td>220</td>
<td>85</td>
<td>45</td>
<td>12.5</td>
</tr>
</tbody>
</table>

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
- Lever movable (included in scope of delivery)
- 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

on request
www.eshop.roehm.biz
**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
- Lever movable (included in scope of delivery)

**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
- Lever movable (included in scope of delivery)

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>Jaw width mm</th>
<th>Clamping capacity mm</th>
<th>Jaw height mm</th>
<th>Length mm</th>
<th>Height mm</th>
<th>Length body mm</th>
<th>Width mm</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>863421</td>
<td>1</td>
<td>80</td>
<td>70</td>
<td>30</td>
<td>234</td>
<td>58</td>
<td>154</td>
<td>142</td>
<td>3,6</td>
</tr>
<tr>
<td>863422</td>
<td>2</td>
<td>100</td>
<td>92</td>
<td>30</td>
<td>272</td>
<td>63,5</td>
<td>175</td>
<td>152</td>
<td>4,3</td>
</tr>
<tr>
<td>863423</td>
<td>3</td>
<td>120</td>
<td>110</td>
<td>30</td>
<td>345</td>
<td>63,5</td>
<td>225</td>
<td>180</td>
<td>6,3</td>
</tr>
<tr>
<td>1132597</td>
<td>4</td>
<td>150</td>
<td>125</td>
<td>30</td>
<td>378</td>
<td>65</td>
<td>238</td>
<td>198</td>
<td>8,1</td>
</tr>
</tbody>
</table>

**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
- Lever movable (included in scope of delivery)

**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
- Lever movable (included in scope of delivery)

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>Jaw width mm</th>
<th>Clamping capacity mm</th>
<th>Jaw height mm</th>
<th>Length mm</th>
<th>Height mm</th>
<th>Length body mm</th>
<th>Width mm</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>007182</td>
<td>2</td>
<td>100</td>
<td>93</td>
<td>30</td>
<td>279</td>
<td>65</td>
<td>189</td>
<td>159</td>
<td>5,1</td>
</tr>
</tbody>
</table>
## Accessories BMS

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
<th>Height mm</th>
<th>Chucking capacity mm</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Horizontal</td>
</tr>
<tr>
<td>332714</td>
<td>set</td>
<td>1</td>
<td>90</td>
<td>24,8</td>
<td>4-17</td>
</tr>
<tr>
<td>317259</td>
<td>set</td>
<td>2</td>
<td>110</td>
<td>31,8</td>
<td>3-12</td>
</tr>
<tr>
<td>317260</td>
<td>set</td>
<td>3</td>
<td>135</td>
<td>39,8</td>
<td>3-13</td>
</tr>
<tr>
<td>317261</td>
<td>set</td>
<td>4</td>
<td>160</td>
<td>49,8</td>
<td>5-22</td>
</tr>
</tbody>
</table>

### A37

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Contents of delivery</th>
<th>Size</th>
<th>Width mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>1128341</td>
<td>set</td>
<td>1</td>
<td>80</td>
</tr>
<tr>
<td>1128342</td>
<td>set</td>
<td>2</td>
<td>100</td>
</tr>
<tr>
<td>11283441)</td>
<td>set</td>
<td>2</td>
<td>100</td>
</tr>
<tr>
<td>1128343</td>
<td>set</td>
<td>3</td>
<td>120</td>
</tr>
<tr>
<td>11931081)</td>
<td>set</td>
<td>4</td>
<td>150</td>
</tr>
</tbody>
</table>

1) only for DPV 3-W

[www.eshop.roehm.biz](http://www.eshop.roehm.biz)
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

Made of alloyed tool steel, hardened and finely ground

Positive locking in any desired angular position by locking screws

2-dimensional angle adjustment and can be rotated by 360°

Fine setting screw on the lower part allows precise angle adjustment

Swivelling scale with nonius

Turning scale with nonius

GRINDING AND INSPECTION VICES
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

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

1) Base to stationary jaw clamping surface
2) Base to upper guide edge

A29
PL-S, with quick adjustment

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

1) Base to stationary jaw clamping surface
2) Base to upper guide edge

www.eshop.roehm.biz

▲ 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
- No spindle which could cause contamination during electric discharge machining, for example

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>Squareness 1) / 100 mm</th>
<th>Parallelism 2) / 100 mm</th>
<th>Jaw width mm</th>
<th>B mm</th>
<th>Total height mm</th>
<th>C mm</th>
<th>G mm</th>
<th>Length body mm</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>1111185</td>
<td>0</td>
<td>0.005</td>
<td>0.005</td>
<td>60</td>
<td>55</td>
<td>25</td>
<td>25</td>
<td>25</td>
<td>110</td>
<td>1.4</td>
</tr>
<tr>
<td>1111186</td>
<td>1</td>
<td>0.005</td>
<td>0.005</td>
<td>73</td>
<td>100</td>
<td>67</td>
<td>35</td>
<td>32</td>
<td>190</td>
<td>4.1</td>
</tr>
<tr>
<td>1111187</td>
<td>2</td>
<td>0.005</td>
<td>0.005</td>
<td>100</td>
<td>125</td>
<td>90</td>
<td>45</td>
<td>45</td>
<td>245</td>
<td>7.3</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>Squareness 1)/ 100 mm</th>
<th>Parallelism 2)/ 100 mm</th>
<th>Jaw width mm</th>
<th>B mm</th>
<th>Total height mm</th>
<th>C mm</th>
<th>G mm</th>
<th>Length body mm</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>1111182</td>
<td>0</td>
<td>0.005</td>
<td>0.002</td>
<td>60</td>
<td>55</td>
<td>25</td>
<td>25</td>
<td>25</td>
<td>110</td>
<td>1.6</td>
</tr>
<tr>
<td>1111183</td>
<td>1</td>
<td>0.005</td>
<td>0.002</td>
<td>73</td>
<td>100</td>
<td>74</td>
<td>35</td>
<td>32</td>
<td>210</td>
<td>4.0</td>
</tr>
<tr>
<td>1111184</td>
<td>2</td>
<td>0.005</td>
<td>0.002</td>
<td>88</td>
<td>125</td>
<td>88</td>
<td>40</td>
<td>40</td>
<td>250</td>
<td>7.6</td>
</tr>
</tbody>
</table>

1) Base for stationary jaw clamping surface
2) Base for upper guide edge

---

on request

www.eshop.roehm.biz
Grinding and inspection vice

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

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

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

A29
PS-SV, front swivelling axis

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>Squareness / 100 mm</th>
<th>Parallelism / 100 mm</th>
<th>Angular accuracy</th>
<th>Jaw width</th>
<th>B (mm)</th>
<th>Total height</th>
<th>C (mm)</th>
<th>Length body mm</th>
<th>G (mm)</th>
<th>H (mm)</th>
<th>J (mm)</th>
<th>K (mm)</th>
<th>a</th>
<th>W (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>370778</td>
<td>1</td>
<td>0.005</td>
<td>0.002</td>
<td>45° ± 15°</td>
<td>70</td>
<td>80</td>
<td>93</td>
<td>30</td>
<td>160</td>
<td>63</td>
<td>33</td>
<td>45</td>
<td>100</td>
<td></td>
<td>5.3</td>
</tr>
<tr>
<td>370779</td>
<td>2</td>
<td>0.005</td>
<td>0.002</td>
<td>45° ± 15°</td>
<td>90</td>
<td>120</td>
<td>113</td>
<td>40</td>
<td>210</td>
<td>73</td>
<td>40</td>
<td>50</td>
<td>150</td>
<td></td>
<td>11</td>
</tr>
</tbody>
</table>

A29
PS-ZD, 2-dimensional

<table>
<thead>
<tr>
<th>Item no.</th>
<th>Size</th>
<th>Squareness / 100 mm</th>
<th>Parallelism / 100 mm</th>
<th>Jaw width</th>
<th>B (mm)</th>
<th>Total height</th>
<th>C (mm)</th>
<th>Length body mm</th>
<th>G (mm)</th>
<th>H (mm)</th>
<th>J (mm)</th>
<th>L (mm)</th>
<th>M (mm)</th>
<th>N (mm)</th>
<th>P (mm)</th>
<th>R (mm)</th>
<th>T (mm)</th>
<th>β</th>
<th>α</th>
<th>W (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>370782</td>
<td>1</td>
<td>0.005</td>
<td>0.002</td>
<td>70</td>
<td>80</td>
<td>137</td>
<td>30</td>
<td>160</td>
<td>32</td>
<td>33</td>
<td>45</td>
<td>110</td>
<td>5</td>
<td>65</td>
<td>75</td>
<td>70</td>
<td>180</td>
<td>360°</td>
<td>0° - 120°</td>
<td>2xM6x15</td>
</tr>
<tr>
<td>370783</td>
<td>2</td>
<td>0.005</td>
<td>0.002</td>
<td>120</td>
<td>150</td>
<td>210</td>
<td>40</td>
<td>270</td>
<td>50</td>
<td>55</td>
<td>70</td>
<td>160</td>
<td>10</td>
<td>105</td>
<td>120</td>
<td>105</td>
<td>270</td>
<td>360°</td>
<td>0° - 70°</td>
<td>2xM6x20</td>
</tr>
</tbody>
</table>
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

www.eshop.roehm.biz
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

<table>
<thead>
<tr>
<th>Machine run-time</th>
<th>Set-up of the workpiece</th>
</tr>
</thead>
</table>

With Power-Grip zero point clamping system

<table>
<thead>
<tr>
<th>Simultaneous setting up on the pallet</th>
<th>Machine run-time</th>
<th>Additional machine capacity</th>
<th>Pallet exchange</th>
</tr>
</thead>
</table>