

Machine vices RB and RH

For high clamping accuracy

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

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

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

RB



RÖHM Machine vices RB:

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

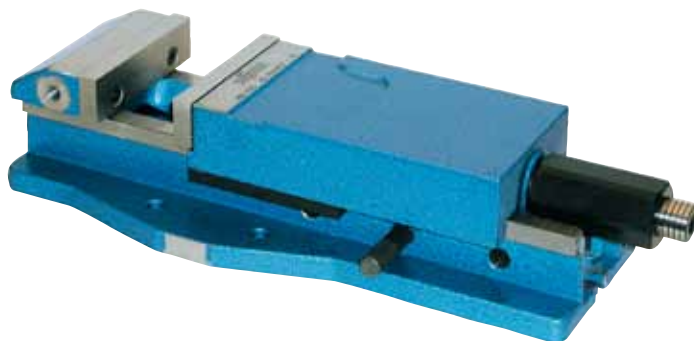
RH



RÖHM Machine vices RH:

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

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



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

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

Technical features:

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

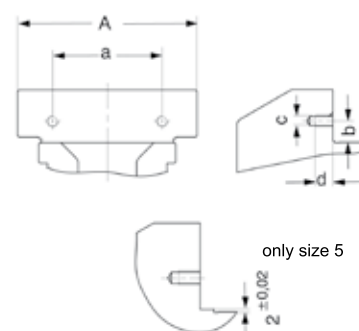
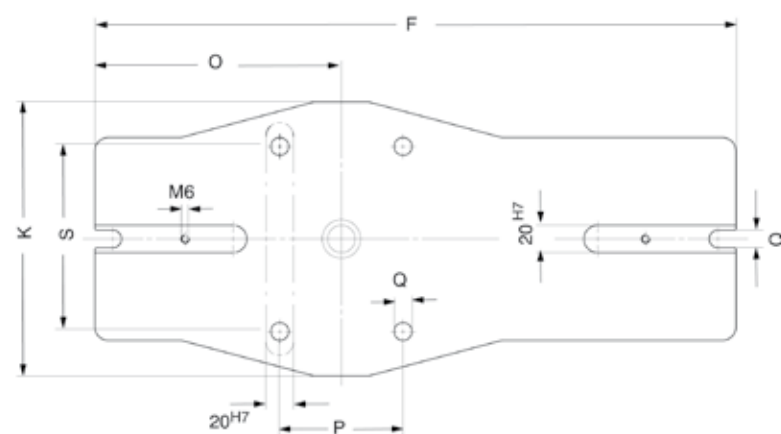
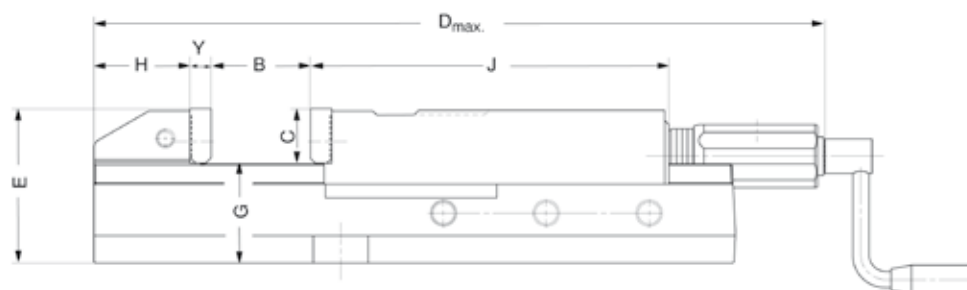
Customer advantage:

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

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

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

transversal slot for use in series in special version on request



Accessories RB / RH

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



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

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



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

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



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

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



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

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



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

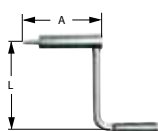
Accessories RB / RH

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



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

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



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

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



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

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



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

Tool group A37
Type 744 **Spindle complete**



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

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



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

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



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