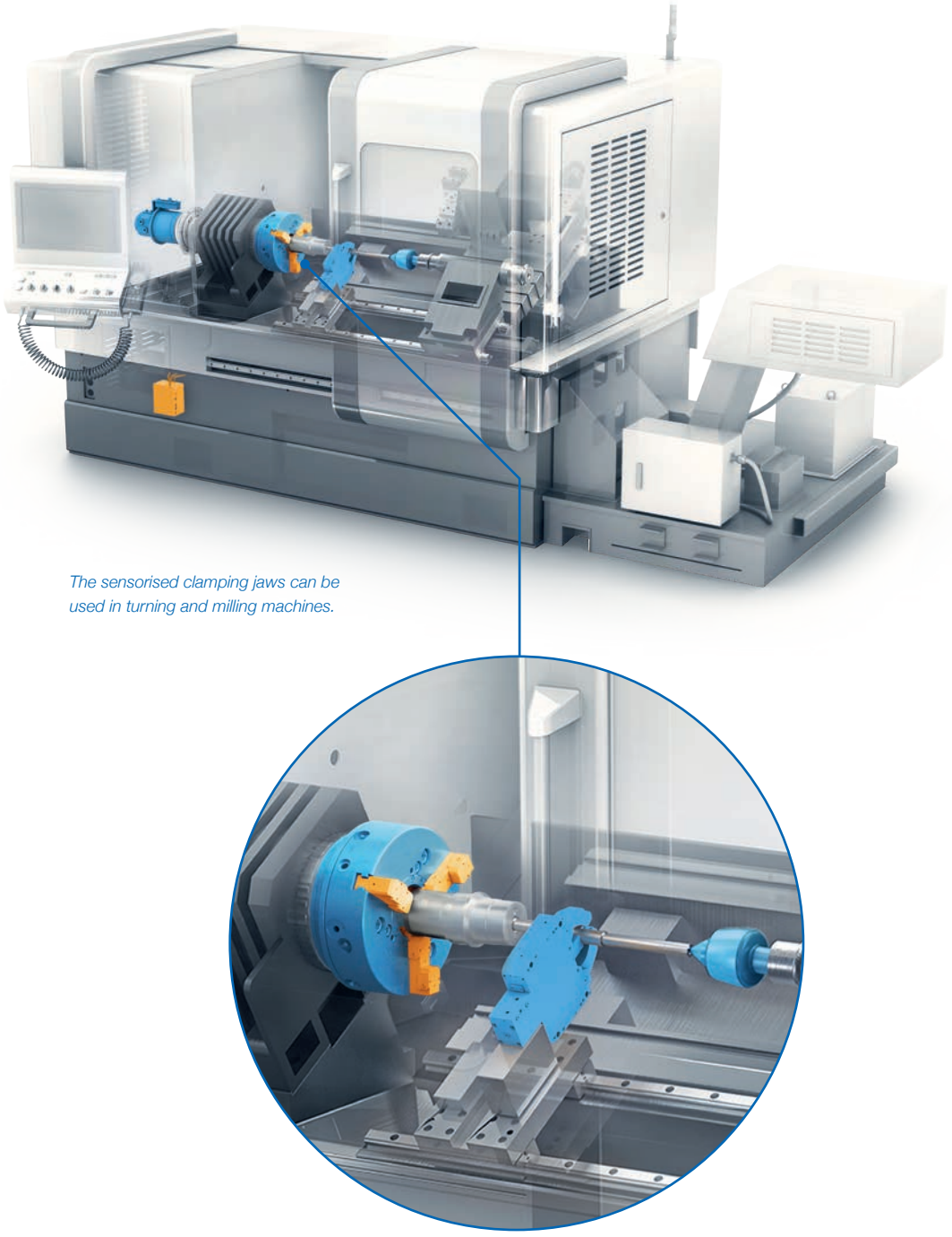

SMARTER. RÖHM.
iJaw
Clamping force
measurement
during machining.
RÖHM

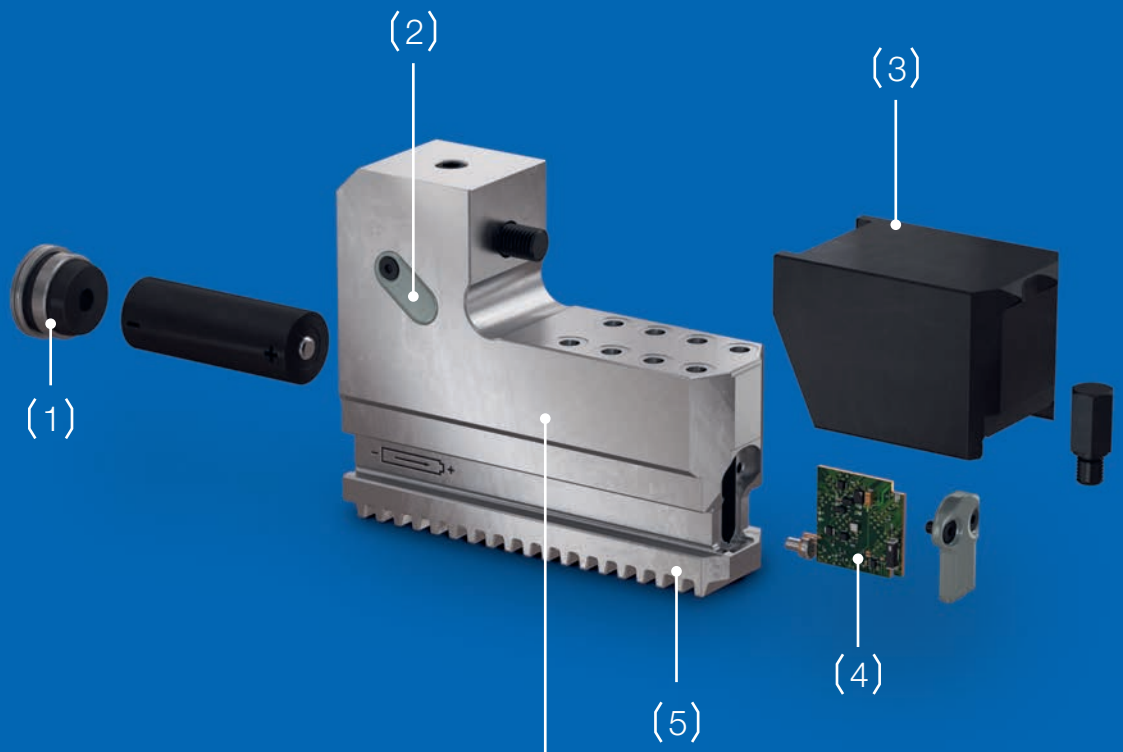
iJaw – CLAMPING FORCE MEASUREMENT DURING MACHINING.

Clamping forces in turning and milling machines can now be measured in real time during machining!

Different physical influences on the applied clamping force are recorded and output. With the analysis of the data, either by the machine operator or automated analysis, machining processes can be made more precise, safer and more efficient.



The sensorised clamping jaws can be used in turning and milling machines.



The jaws of the iJaw can be inserted into many chucks.

(1) Waterproof cover (IP68) Lithium-ion battery

(2) Sensor

(3) Clamping insert with mounting screw

(4) IO-Link Wireless Interface with antenna, or balancing weights for fine balancing

(5) Console jaw with straight toothing

A WORKPIECE NARRATES AND YOUR iJaw RECORDS IN REAL TIME.

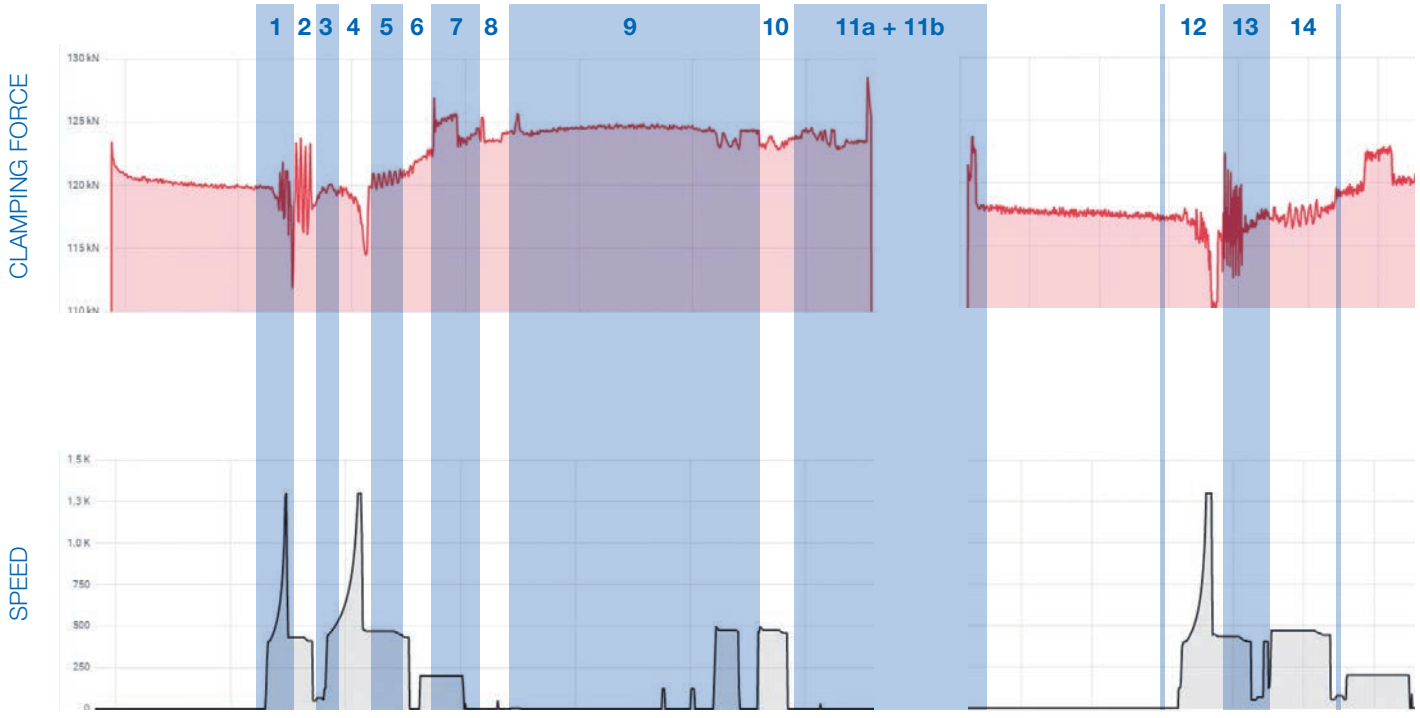
With the iJaw, you measure the clamping forces in real time.

The data is transmitted wirelessly to the gateway via IO-Link Wireless and can be passed on from there via Profinet to the machine or via WLAN to the iJaw Mobile App.

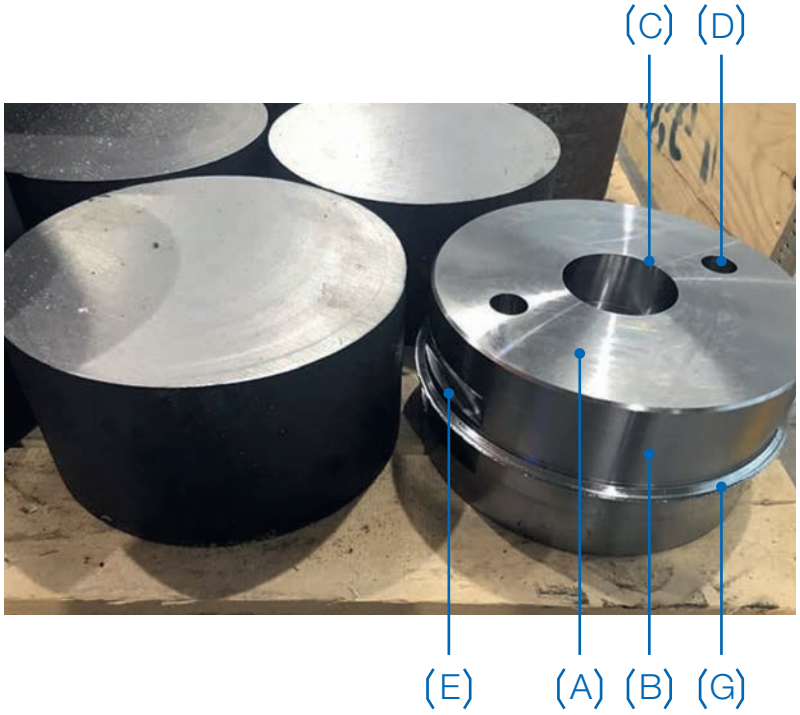
The example below shows the production of a turned part in series production on a multi-spindle lathe. An automatic power chuck with a jaws quick-change system of the type Duro-A RC 315 and a set of iJaw clamping jaws are used on each of the two spindles.

MACHINING ON THE MAIN SPINDLE

SUBSEQUENT MACHINING ON THE COUNTER SPINDLE



MACHINING STEPS



Turning, milling and drilling of turning blanks (left) on a multi-spindle machine. Right: finished workpiece

1	Facing (roughing) of the surface **A**. Turning up the spindle causes a reduction of the clamping force due to the centrifugal forces.
2	Facing (roughing) of surface **B**
3	Tool change
4	Facing (finishing) of surface **A**. Again decrease of the clamping force due to the centrifugal forces increasing with the speed.
5	Turning (finishing) of surface **B**.
6	Drilling of hole **C**
7	Drilling of hole **D**
8	Turning milling **E**
9	Turning of clamping seat **G**
10	Surface milling
11 a + 11b	Transfer from main spindle to counter spindle; Increase of clamping force due to axial offset of both spindles
12	Faceing
13	Turning (roughing)
14	Turning (finishing)

THIS IS WHAT THE iJaw STANDS FOR:

MORE PRODUCTIVITY

LOWER COSTS

GREATER SAFETY

With the iJaw, clamping forces can be measured and visualized in real-time during machining.

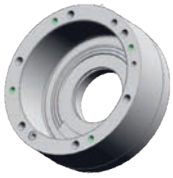
The influences on the workpiece due to machining are recorded and allow conclusions to be drawn about the machining that has taken place as well as a wide range of analyses and evaluations.

THE USE OF THE DETERMINED DATA ENABLES:

- Reduction of cycle times per workpiece
- Analysis and optimization of productivity in production
- Quality assurance in series production
- Increase of safety during production
- Optimal clamping of thin-walled components
- Documentation and analysis of past manufacturing processes

REDUCTION OF THE CYCLE TIME

The visualization of effective forces on the tool and workpiece during the machining process opens up completely new possibilities for optimizing the machining process. Now machine operators and process optimizers can rely on measured data when they want to speed up machining processes.



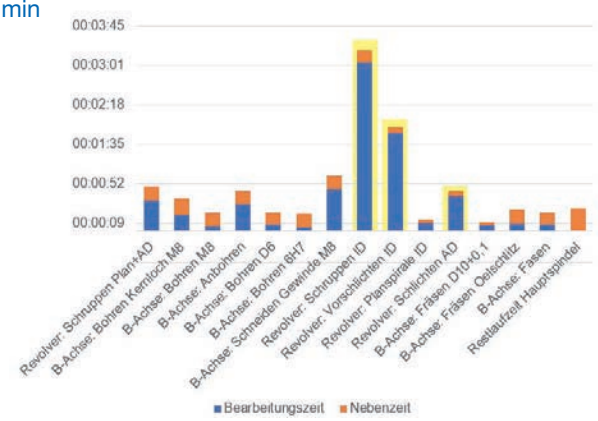
Reduction of parts costs
using the example of a
Röhm
piston housing
hydraulic cylinder

HIGH TIME SAVINGS IN SERIES PRODUCTION

Knowing the right effective forces means approaching the workpiece with the maximum possible machining forces. Feed and speed are optimally adjusted so that the machining time for a workpiece can be dramatically reduced. Not only in series production does this mean more throughput and lower part costs.

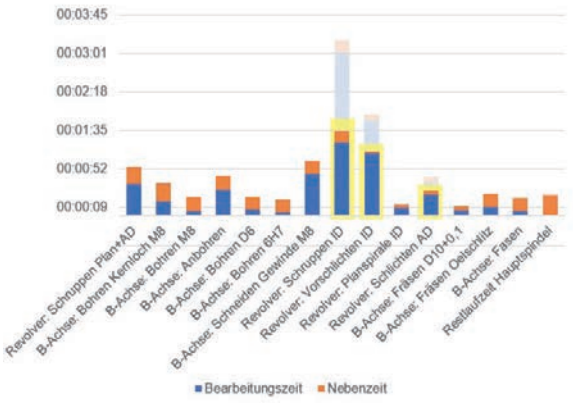
BEFORE OPTIMIZATION

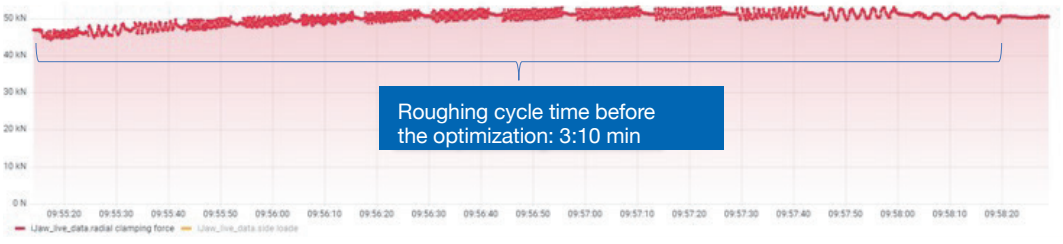
Total running time including handover: 12:25 min

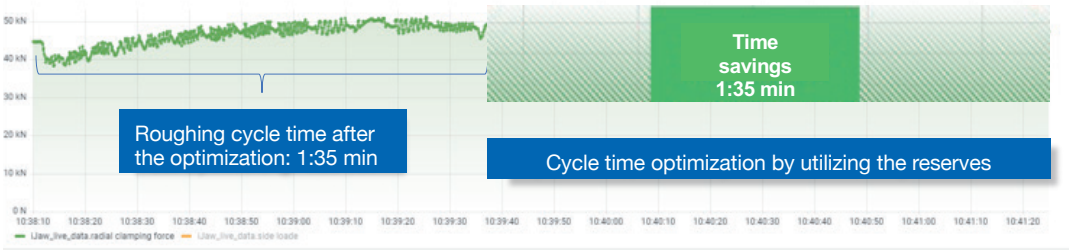


AFTER OPTIMIZATION

Total running time including handover: 09:45 min (-2:40 min)

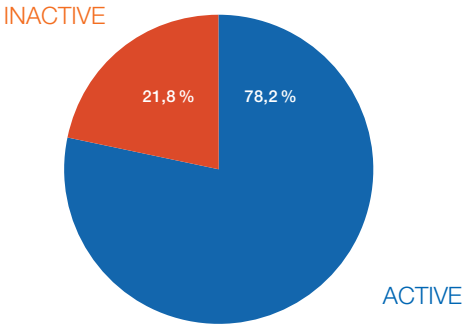


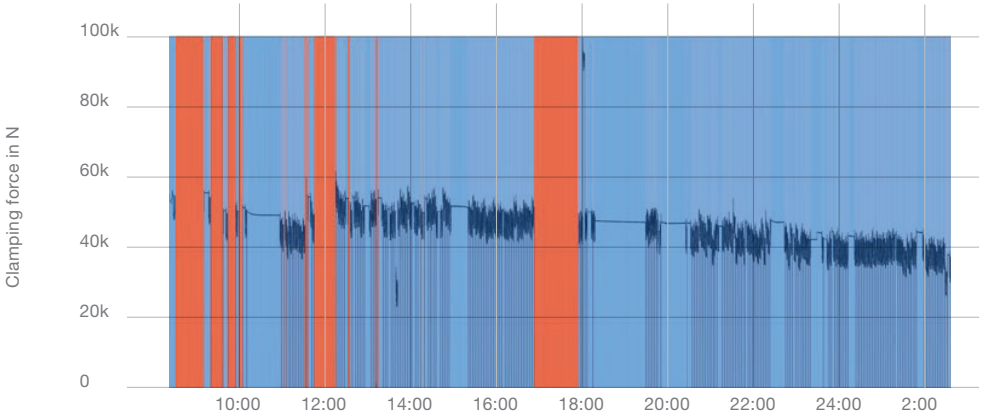




ANALYSIS AND OPTIMIZATION OF PRODUCTIVITY IN PRODUCTION

Why is the machine down? When does it do chip removal? How productive is it? These are all questions that you can also answer with the iJaw. A simple analysis shows you uptime and downtime. This allows you to start further analyses at shop floor level and optimization. Especially in times of rising energy costs, optimization of production processes is a must. The iJaw makes potentials transparent!



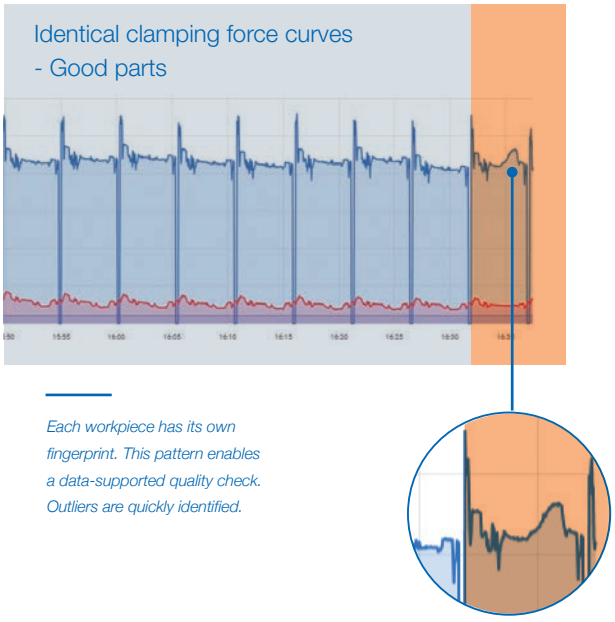


Especially in times of rising manufacturing costs, optimization of production processes is a must. The iJaw makes potentials transparent.

QUALITY ASSURANCE IN SERIES PRODUCTION

The iJaw measures the clamping force between the clamping jaw and workpiece in real-time. The clamping force curve is like the fingerprint of the production step. Each component has its own signature. Significant deviations from part to part in series production indicate malfunctions and faulty production. Parts with a deviating fingerprint can be identified quickly. This speeds up quality assurance and reduces costs.

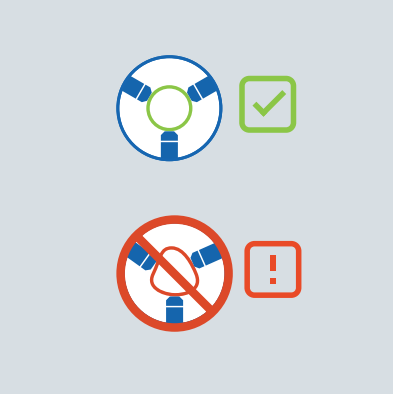
- Detection of rejects
- Sorting out before the next processing step saves follow-up costs



Each workpiece has its own fingerprint. This pattern enables a data-supported quality check. Outliers are quickly identified.

OPTIMAL CLAMPING OF THIN-WALLED WORKPIECES

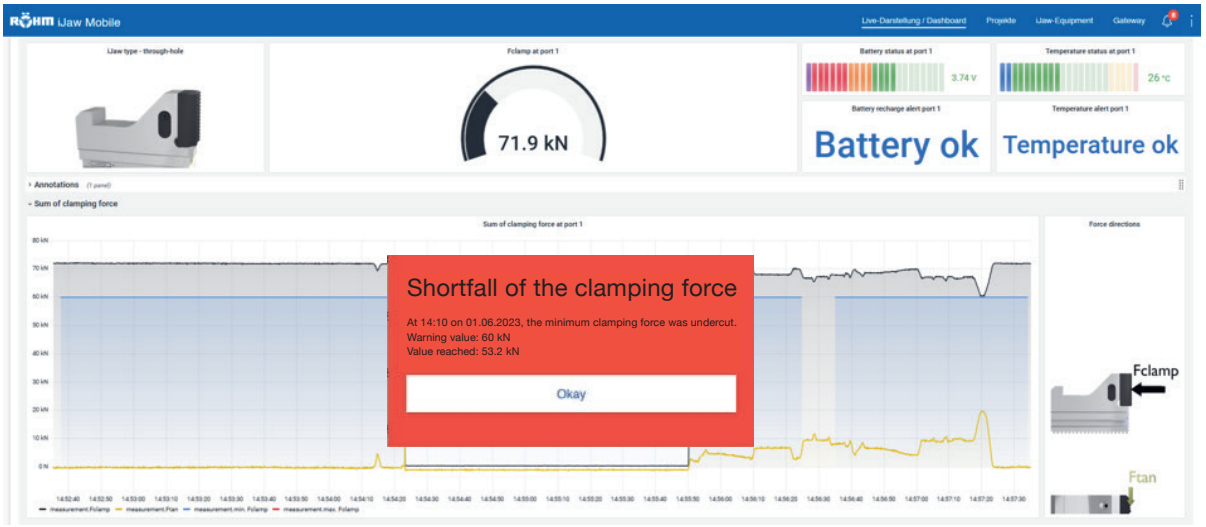
If you machine thin-walled components, then you may be familiar with the problem of deformation when the clamping force is too high. The iJaw helps you to clamp workpieces with exactly the required force and thus prevent deformation of the parts – and thus rejects.



- Clamping with exactly the right force
- No deformation of thin-walled components

INCREASE OF SAFETY DURING PRODUCTION

With the iJaw, you can see the clamping forces applied during the machining process in real-time. By knowing the minimum and maximum clamping forces, you can set up alarms when the applied clamping force is exceeded or not reached. This makes machining safer for people and materials, because you protect your employees and avoid costly accidents.



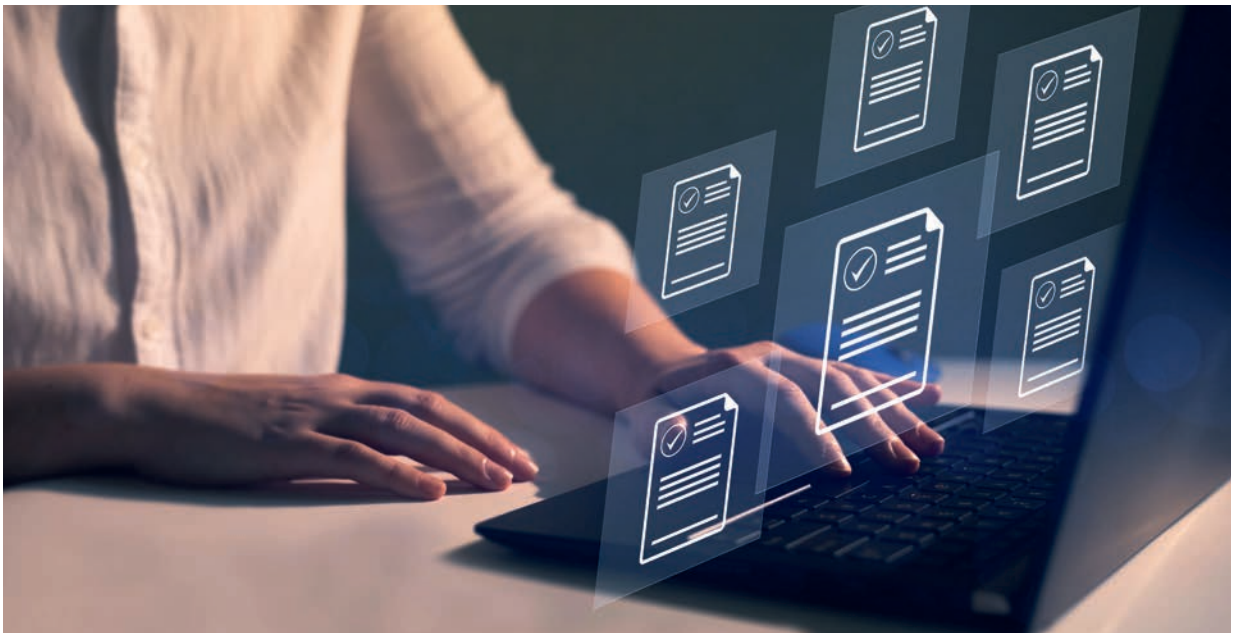
DOCUMENTATION AND ANALYSIS OF MANUFACTURING PROCESSES

Fulfilment of the verification obligation

With the iJaw, clamping forces can be measured and archived and thus documented. At any time after machining, the manufacturing process can be traced.

Carrying out analyses

The clamping force data is stored and thus documents the machining process.
The production of critical components can thus also be analysed retrospectively. This is, for example, for damage analysis or to investigate weak points in complex and lengthy manufacturing processes.



HMI CONNECTION

By HMI connection we mean the integration of the iJaw functions into the controller of the machine tool by the manufacturer. The iJaw data can be transmitted to the machine via the universal gateway. The machine controller then has real-time read access to the data. It can be used for control, regulation and visualization purposes.

THE OEM SOLUTION MAKES THE FOLLOWING FUNCTIONS AVAILABLE TO YOU:

BASIC FUNCTIONS

- Measurement of the clamping forces of internal and external clamping at a standstill and under rotation
- Setting the minimum and maximum clamping force
- Temperature of the iJaw
- Charging status of the battery

POSSIBLE APPLICATIONS:

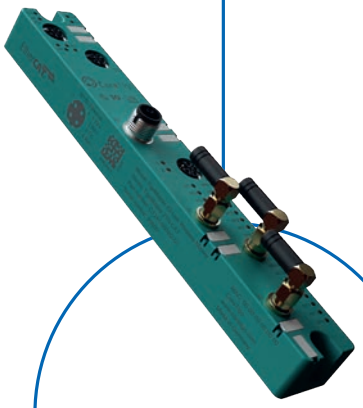
- Setting the minimum and maximum clamping force
- Alarm for undercutting and exceeding the minimum and maximum clamping force
- Limitation of the maximum speed to avoid undercutting of the clamping force
- Active control of the clamping pressure at a standstill
- Trend analysis for chuck condition
- Calculation tool for the minimum clamping force
- Triggering of machine stop if clamping force falls below the minimum clamping force
- And much more

GOOD TO KNOW

OEM solution can be obtained via machine manufacturers. Please contact your machine manufacturers.

(1) Real-time display of clamping forces
(2) Calculation of the minimum clamping force
(3) Battery charge status display
(4) Clamping force calculation for different applications
(5) Temperature display of the iJaw
(6) Chuck efficiency / condition of the chuck
(7) Numerical clamping force display

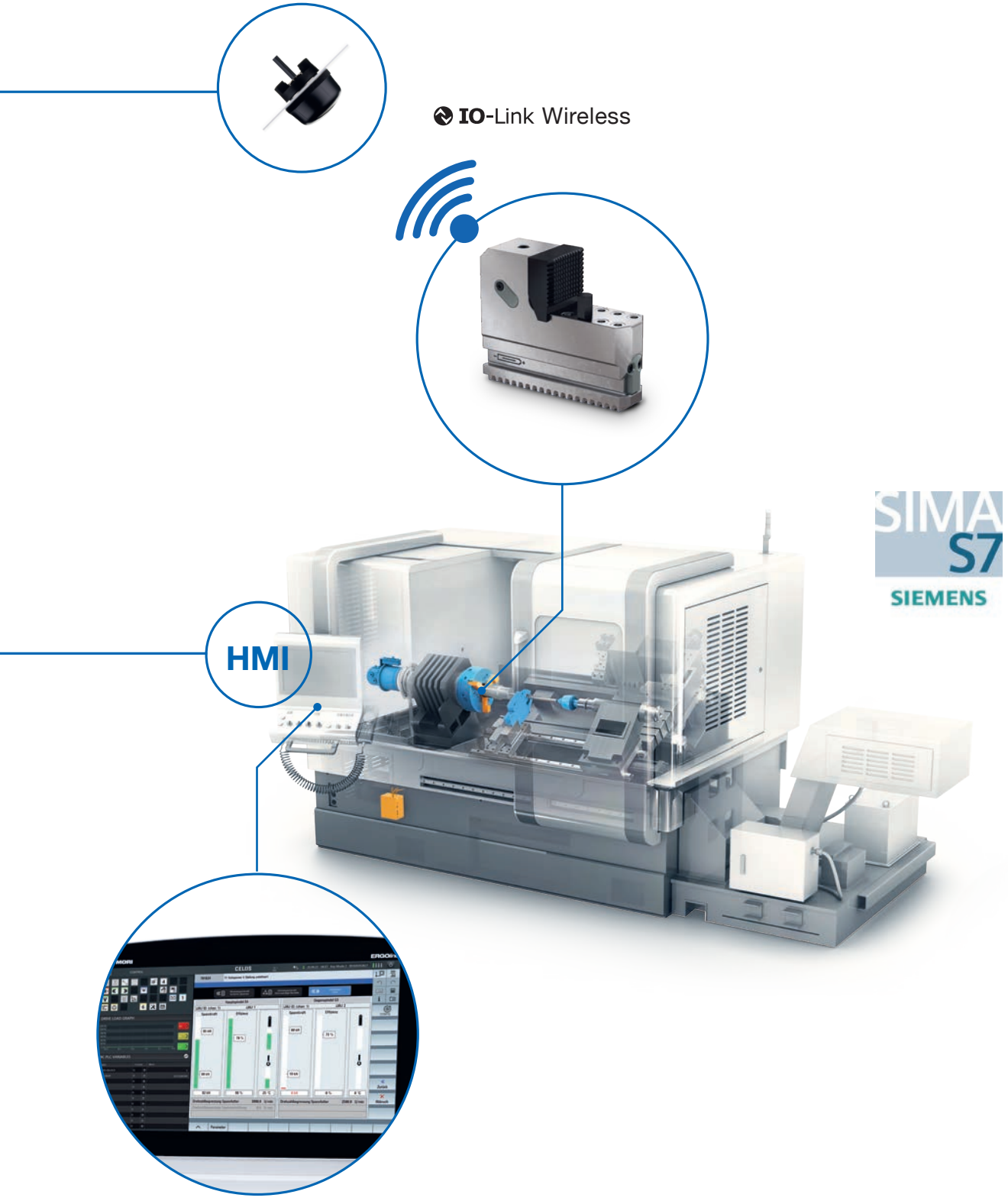
iJaw HARDWARE ARCHITECTURE
OEM SOLUTION



PLC integration

PROFINET®

1. OEM solution/PLC integration



AFTER MARKET SOLUTION – THE RETROFIT SOLUTION

Machine tools can be equipped with the iJaw very easily. For this you only need the sensorized clamping jaws, the iJaw Connect control cabinet and a medium for visualizing the measured data. This can be a local PC or a mobile tablet. The system is controlled by the iJaw Mobile web app. With this application, you establish the connection between the iJaw and the iJaw Connect so that you can retrieve the data. You can create jobs, manage your jaws and receive warnings via it, e.g. if the minimum clamping force has not been reached.

THE RETROFIT SOLUTION MAKES THE FOLLOWING FUNCTIONS AVAILABLE TO YOU:

FUNCTIONAL OVERVIEW:

- Measurement of the clamping forces of internal and external clamping at a standstill and under rotation
- Display of minimum and maximum clamping force
- Alarm when clamping force limit is exceeded or not reached
- Display of the clamping force curve on one or two spindles
- Productivity analysis from stored clamping force data
- Quality analysis with stored clamping force data
- Documentation of clamping force data
- Overview of all created projects
- Temperature of the iJaw
- Charging status of the battery

Temperature display
of the iJaw

Real-time display
of the clamping force

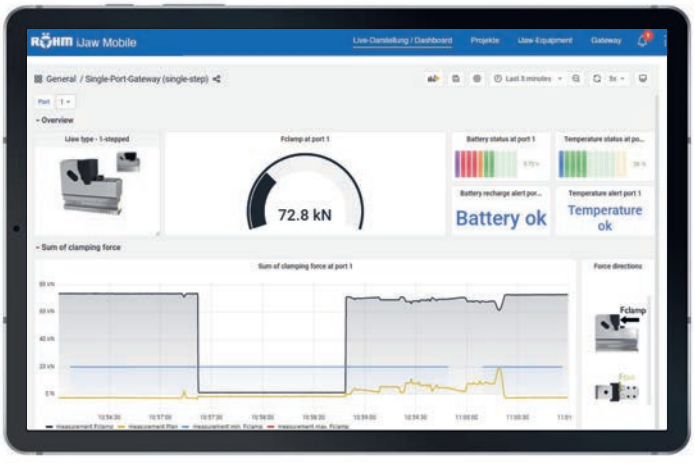
Display of the
jaw geometry

Charging status
of the battery

Clamping force curve

iJaw HARDWARE ARCHITECTURE
AFTER MARKET SOLUTION

Wi-Fi




IO-Link Wireless
IO-Link
Wireless

SMARTER. **RÖHM.**

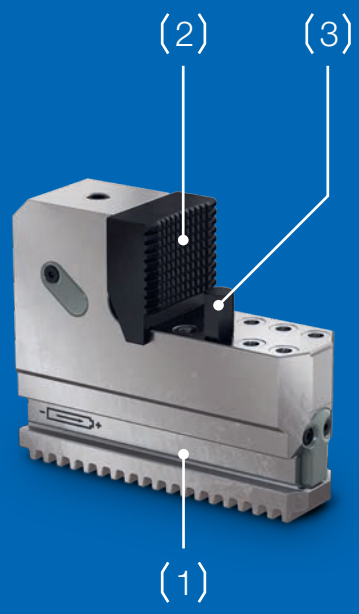
THE iJaw.
FROM RÖHM.

The iJaw is a sensor-integrated clamping jaw for clamping workpieces by means of manual or power-operated chucks.

With the iJaw, the clamping forces can be measured in real-time during machining.

The measured data is transmitted wirelessly via the IO-Link Wireless protocol. The iJaw Mobile Software is used for display and analysis. For example, by monitoring the clamping forces, a higher level of safety can be ensured during machining and lower part costs can be realized.

iJaw
single-stage



(1) Console jaw, single-stage iJaw

(2) Clamping insert, single-stage iJaw

(3) Face contact bolts

iJaw
two-stage

(4) Console jaw, two-stage iJaw

(5) Clamping insert, two-stage iJaw

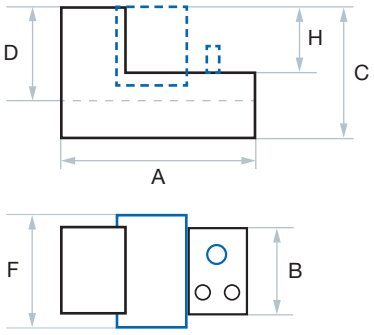
iJaw
through-hole

(6) Console jaw, through-hole iJaw

(7) Clamping insert, through-hole, hard iJaw

iJaw – SINGLE-STAGE – TECHNICAL SPECIFICATIONS

Size	215	260	315	400
Clamping height per clamping stage [mm]	30	35	40	45
Max. speed external clamping [rpm]	6,000	4,700	4,000	3,500
Max. speed internal clamping [rpm]	2,000	2,000	2,000	2,000
Clamping force up to [kN]	100	135	180	240
Max. distance iJaw – antenna [m] (feet)	15 (49.2)			
Battery time	1,400 mAh up to 304 h [5 days (depending on transmission rate)	2,300 mAh up to 504 h [7 days (depending on transmission rate)		
Radio frequency [GHz]	2.4 – 2.48			
Transmission rate [Hz]	100			
Toothing	straight toothing			

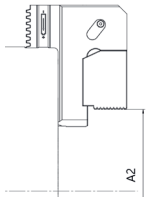


Size	215	260	315	400
ID no. iJaw Set	1392813	1391677	1392225	1393697
Jaw length A	94.5	109.5	118.9	127.5
Jaw length B	30	32	32	38
Jaw length C	82	90	100	106
Overhang length* D	57.4	61.5	66.3	72.3
Clamping height H	30	35	40	45
Thread face contact bolts	M6	M6	M6	M8

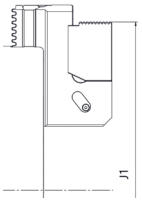
** Measured with a DURO-A RC power chuck*

iJaw – SINGLE-STAGE – CLAMPING RANGES

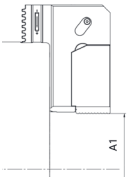
External clamping



Internal clamping



Through-hole clamping



215

Type	Clamping insert short, hard	Clamping insert long, hard	Clamping insert short, hard, claws	Clamping insert long, hard, claws	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	1392817	1392819	1392825	1392827	1392823	1392821
Clamping diameter A1					8 - 90	
Clamping diameter A2	94 - 177	43 - 125	94 - 174	42 - 122		6 - 90
Clamping diameter J1	128 - 201	180 - 215	130 - 200	181 - 215		130 - 215

260

Type	Clamping insert short, hard	Clamping insert long, hard	Clamping insert short, hard, claws	Clamping insert long, hard, claws	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	1391685	1391687	1389829	1389831	1391681	1391683
Clamping diameter A1					13 - 112	
Clamping diameter A2	120 - 219	48 - 147	116 - 215	44 - 143		20 - 219
Clamping diameter J1	131 - 230	203 - 260	136 - 230	207 - 260		134 - 260

315

Type	Clamping insert short, hard	Clamping insert long, hard	Clamping insert short, hard, claws	Clamping insert long, hard, claws	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	1392229	1392231	1392237	1392239	1392235	1392233
Clamping diameter A1					35 - 145	
Clamping diameter A2	139 - 249	67 - 177	139 - 249	72 - 177		18 - 251
Clamping diameter J1	177 - 287	249 - 315	176 - 286	247 - 315		175 - 315

400

Type	Clamping insert short, hard	Clamping insert long, hard	Clamping insert short, hard, claws	Clamping insert long, hard, claws	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	1393701	1393703	1393709	1393711	1393707	1393705
Clamping diameter A1					56 - 176	
Clamping diameter A2	180 - 300	108 - 228	177 - 294	111 - 229		48 - 300
Clamping diameter J1	228 - 348	300 - 400	233 - 351	310 - 400		235 - 400

CLAMPING INSERTS FOR SINGLE-STAGE iJaw JAWS

Clamping insert, hard, short, claws

Clamping insert, hard, long, claws

Clamping insert soft

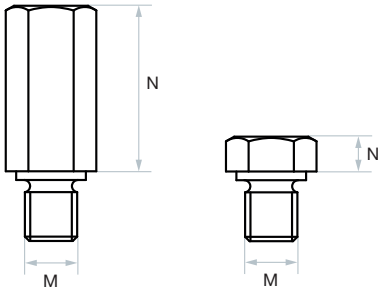
Clamping insert hard, through-hole

Clamping insert hard, short

Clamping insert hard, long

Face contact bolts

Clamping inserts – Single-stage iJaw – Set consisting of 3 pcs. + screws



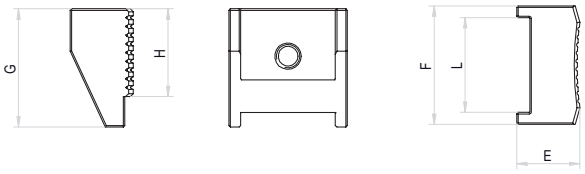
200 - 315

Type	Face contact bolts 5 mm	Face contact bolts 10 mm	Face contact bolts 15 mm	Face contact bolts 20 mm	Face contact bolts 25 mm	Face contact bolts 30 mm	Face contact bolts 35 mm
ID no. face contact bolts set	**1391689**	**1391691**	**1391693**	**1391695**	**1391697**	**1391699**	**1392243**
Face contact bolts height N	5	10	15	20	25	30	35
Thread M	M6	M6	M6	M6	M6	M6	M6

400

Type	Face contact bolts 5 mm	Face contact bolts 10 mm	Face contact bolts 15 mm	Face contact bolts 20 mm	Face contact bolts 25 mm	Face contact bolts 30 mm	Face contact bolts 35 mm	Face contact bolts 40 mm
ID no. face contact bolts set	**1393713**	**1393715**	**1393717**	**1393719**	**1393721**	**1393723**	**1393725**	**1393727**
Face contact bolts height N	5	10	15	20	25	30	35	40
Thread M	M8	M8	M8	M8	M8	M8	M8	M8

CLAMPING INSERTS SINGLE-STAGE



215

Type	Clamping insert short, hard	Clamping insert long, hard	Clamping insert short, hard, claws	Clamping insert long, hard, claws	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	**1392817**	**1392819**	**1392825**	**1392827**	**1392823**	**1392821**
Clamping insert length E	21	42	21	47	63	64
Clamping insert width F	40	40	40	40	40	40
Clamping insert height G	35	35	35	35	35	35
L	30	30	30	30	30	30
Clamping height H	30	30	30	30	30	30

260

Type	Clamping insert short, hard	Clamping insert long, hard	Clamping insert short, hard, claws	Clamping insert long, hard, claws	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	**1391685**	**1391687**	**1389829**	**1389831**	**1391681**	**1391683**
Clamping insert length E	21	58	23	59	75	73
Clamping insert width F	40	40	40	40	40	40
Clamping insert height G	40	40	40	40	40	40
L	32	32	32	32	32	32
Clamping height H	35	35	35	35	35	35

315

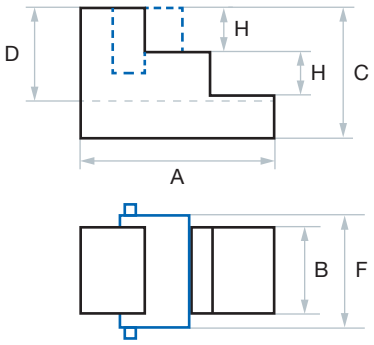
Type	Clamping insert short, hard	Clamping insert long, hard	Clamping insert short, hard, claws	Clamping insert long, hard, claws	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	**1392229**	**1392231**	**1392237**	**1392239**	**1392235**	**1392233**
Clamping insert length E	22	59	22	58	74	84
Clamping insert width F	40	40	40	40	40	40
Clamping insert height G	45	45	45	45	45	45
L	32	32	32	32	32	32
Clamping height H	40	40	40	40	40	40

400

Type	Clamping insert short, hard	Clamping insert long, hard	Clamping insert short, hard, claws	Clamping insert long, hard, claws	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	**1393701**	**1393703**	**1393709**	**1393711**	**1393707**	**1393705**
Clamping insert length E	22	58	24	59	84	86
Clamping insert width F	45	45	45	45	45	45
Clamping insert height G	50	50	50	50	50	50
L	38	38	38	38	38	38
Clamping height H	45	45	45	45	45	45

iJaw – TWO-STAGE – TECHNICAL SPECIFICATIONS

Size	215	260	315	400
Clamping height per clamping stage [mm]	15	17	20	23
Max. speed external clamping [rpm]	6,000	4,700	4,000	3,500
Max. speed internal clamping [rpm]	2,000	2,000	2,000	2,000
Clamping force up to [kN]	100	135	180	240
Max. distance iJaw – antenna [m] (feet)	15 (49.2)			
Battery time	1,400 mAh up to 304 h [5 days (depending on transmission rate)	2,300 mAh up to 504 h [7 days (depending on transmission rate)		
Radio frequency [GHz]	2.4 – 2.48			
Transmission rate [Hz]	100			
Toothing	straight toothing			

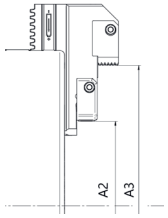


Size	215	260	315	400
ID no. iJaw Set	**1394233**	**1388989**	**1388990**	**1390109**
Jaw length A	94.5	109	118.4	127
Jaw length B	28	32	32	32
Jaw length C	67	73	80	88
Overhang length* D	42.4	44.5	46.3	54.3
Clamping height H	15	17	20	23

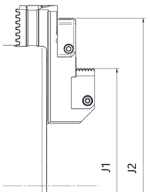
** Measured with a DURO-A RC power chuck*

iJaw – TWO-STAGE – CLAMPING RANGES

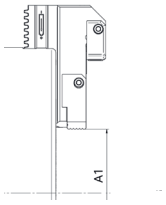
External clamping



Internal clamping



Through-hole clamping



215

Type	Clamping insert hard	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	**1394657**	**1394661**	**1394659**
Clamping diameter A1		9 - 91	
Clamping diameter A2	34 - 117		18 - 116
Clamping diameter A3	106 - 189		90 - 188
Clamping diameter J1	185 - 215		186 - 215
Clamping diameter J2	113 - 186		115 - 204

260

Type	Clamping insert hard	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	**1388625**	**1388627**	**1388626**
Clamping diameter A1		14 - 113	
Clamping diameter A2	37 - 136		15 - 133
Clamping diameter A3	133 - 232		111 - 229
Clamping diameter J1	212 - 260		236 - 260
Clamping diameter J2	117 - 216		136 - 235

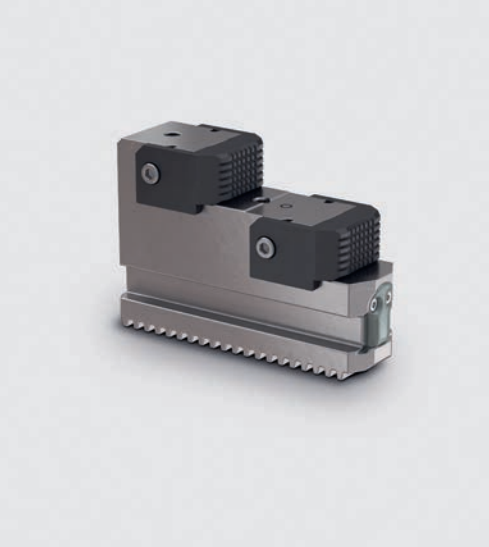
315

Type	Clamping insert short, hard	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	**1388974**	**1388976**	**1388975**
Clamping diameter A1		24 – 145	
Clamping diameter A2	47 – 169		28 – 196
Clamping diameter A3	155 – 277		136 – 277
Clamping diameter J1	244 – 315		244 – 315
Clamping diameter J2	135 – 258		137 – 278

400

Type	Clamping insert hard	Clamping insert through-hole, hard	Clamping insert soft
ID no. Clamping insert set	**1390113**	**1390117**	**1390115**
Clamping diameter A1		71 – 191	
Clamping diameter A2	97 – 218		74 – 219
Clamping diameter A3	199 – 320		176 – 321
Clamping diameter J1	309 – 400		309 – 400
Clamping diameter J2	208 – 327		206 – 350

CLAMPING INSERTS FOR TWO-STAGE iJaw JAWS



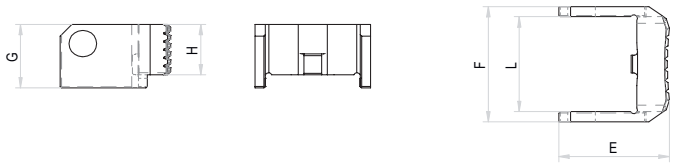
Clamping insert
hard

Clamping insert
soft

Clamping insert
hard, through-hole

Clamping
surfaces-cover

CLAMPING INSERT, TWO-STAGE



215

Type	Clamping insert hard	Clamping insert through-hole, hard	Clamping insert soft	Clamping surfaces-cover
ID no. Clamping insert set	**1394657**	**1394661**	**1394659**	**1394663**
L	28	28	28	28
Clamping insert length E	33	46	42	31
Clamping insert width F	35	35	35	35
Clamping insert height G	20	20	20	15
Clamping height H	15	15	15	-

260

Type	Clamping insert hard	Clamping insert through-hole, hard	Clamping insert soft	Clamping surfaces-cover
ID no. Clamping insert set	**1388625**	**1388627**	**1388626**	**1348566**
L	32	32	32	32
Clamping insert length E	37	49	48	36
Clamping insert width F	39	39	39	39
Clamping insert height G	22	22	22	17
Clamping height H	17	17	17	-

315

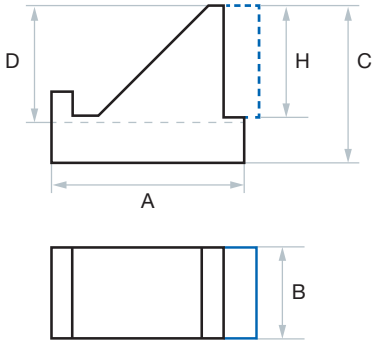
Type	Clamping insert hard	Clamping insert through-hole, hard	Clamping insert soft	Clamping surfaces-cover
ID no. Clamping insert set	**1388974**	**1388976**	**1388975**	**1391225**
L	32	32	32	32
Clamping insert length E	39	51	49	36
Clamping insert width F	39	39	39	39
Clamping insert height G	25	25	25	20
Clamping height H	20	20	20	-

400

Type	Clamping insert hard	Clamping insert through-hole, hard	Clamping insert soft	Clamping surfaces-cover
ID no. Clamping insert set	**1390113**	**1390117**	**1390115**	**1390119**
L	40	40	40	32
Clamping insert length E	44	58	55	39
Clamping insert width F	39	39	39	39
Clamping insert height G	28	28	28	23
Clamping height H	23	23	23	-

iJaw – THROUGH-HOLE – TECHNICAL SPECIFICATIONS

Size	215	260	315	400
Clamping height per clamping stage [mm]	40	50	50	60
Max. speed external clamping [rpm]	6,000	4,700	4,000	3,500
Max. speed internal clamping [rpm]	2,000	2,000	2,000	2,000
Clamping force up to [kN]	100	135	180	240
Max. distance iJaw – antenna [m] (feet)	15 (49.2)			
Battery time	1,400 mAh up to 304 h [5 days (depending on transmission rate)	2,300 mAh up to 504 h [7 days (depending on transmission rate)		
Radio frequency [GHz]	2.4 – 2.48			
Transmission rate [Hz]	100			
Toothing	straight toothing			

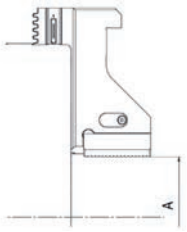


Size	215	260	315	400
ID no. iJaw Set	**1388993**	**1391289**	**1391725**	**1392525**
Jaw length A	96	109	118.4	127
Jaw length B	26	32	32	40
Jaw length C	74	88	93	106
Overhang length* D	49.4	59.5	59.3	72.3
Clamping height H	40	50	50	60

** Measured with a DURO-A RC power chuck*

iJaw – THROUGH-HOLE – CLAMPING RANGES

External clamping



215

Type	Clamping insert hard	Clamping insert soft
ID no. Clamping insert set	**1388581**	**1388582**
Clamping diameter A1	15 – 70	4 – 70

260

Type	Clamping insert hard	Clamping insert soft
ID no. Clamping insert set	**1391293**	**1391295**
Clamping diameter A1	12 – 87	4 – 87

315

Type	Clamping insert hard	Clamping insert soft
ID no. Clamping insert set	**1391729**	**1391731**
Clamping diameter A1	18 – 110	35 – 110

400

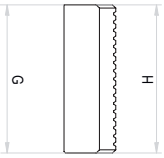
Type	Clamping insert hard	Clamping insert soft
ID no. Clamping insert set	**1392529**	**1392531**
Clamping diameter A1	21 – 127	37 – 127

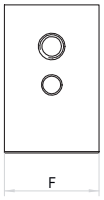
CLAMPING INSERTS FOR iJaw THROUGH-HOLE JAWS

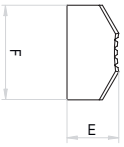
Clamping insert hard

Clamping insert soft

CLAMPING INSERTS, THROUGH-HOLE JAWS







215

Type	Clamping insert hard	Clamping insert soft
ID no. Clamping insert set	**1388581**	**1388582**
Clamping insert length E	14	19
Clamping insert width F	26	26
Clamping insert height G	40	40
Clamping height H	40	40

260

Type	Clamping insert hard	Clamping insert soft
ID no. Clamping insert set	**1391293**	**1391295**
Clamping insert length E	17	22
Clamping insert width F	32	32
Clamping insert height G	50	50
Clamping height H	50	50

315

Type	Clamping insert hard	Clamping insert soft
ID no. Clamping insert set	**1391729**	**1391731**
Clamping insert length E	18	26
Clamping insert width F	32	32
Clamping insert height G	50	50
Clamping height H	50	50

400

Type	Clamping insert hard	Clamping insert soft
ID no. Clamping insert set	**1392529**	**1392531**
Clamping insert length E	39	45
Clamping insert width F	40	40
Clamping insert height G	60	60
Clamping height H	60	60

iJaw FOR INDEPENDENT CHUCKS

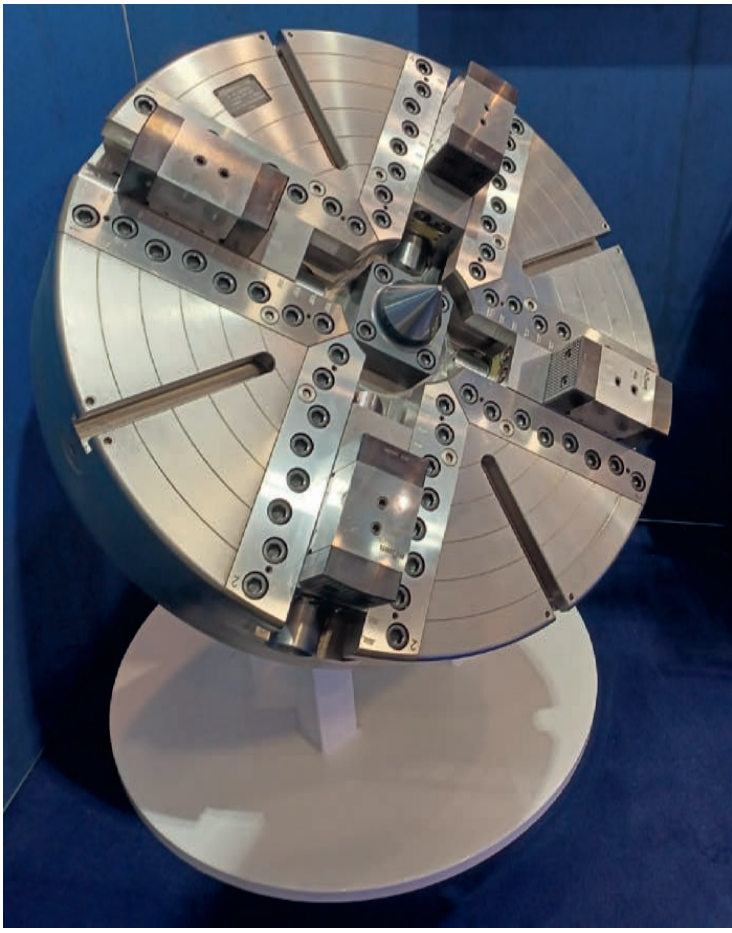
With the iJaw's real-time data, you can accurately align very large workpieces on independent chucks. By visualizing the clamping forces on each individual jaw, you can see any clamping pressure deviation exactly and thus correct it.

In addition, this speeds up the setup process because you can quickly see whether the correct clamping forces are applied and your workpiece is optimally clamped.

ALL THE ADVANTAGES OF THE iJaw FOR INDEPENDENT CHUCKS ALSO APPLY TO THE SYSTEM:

- More productivity through optimized processes such as shorter setup times
- Reduction of part costs through an optimized process and better quality monitoring
- Increased safety during machining due to constant monitoring of the clamping forces

The iJaw for the independent chuck is available on request.



DELIVERY CONTENTS

iJaw SET

	COMPONENT	NO.
	**iJaw sensor-integrated jaw** o Factory calibrated	1
	**Sensor-less jaw**	2

	COMPONENT	NO.
	**Case made of blue hard plastic including:** milled rigid foam insert	1

AFTER MARKET SOLUTION

	COMPONENT	NO.
	**iJaw Connect** Receiver electrical cabinet o iJaw Mobile App o IO-Link Wireless Antenna o Antenna extension cable, 10 m	1

Name	ID no.
iJaw Connect	1410836

OEM SOLUTION

For the machine-integrated solution,
please consult your machine manufacturer.

ACCESSORIES

Name	ID no.
10" Windows tablet for iJaw Mobile application	1381862
Tablet holder with magnetic base	1394952
Battery charger with USB cable	1388193
Rechargeable battery, 2300 mAh, 18500 Li-ion for iJaw size 260 / 315 / 400	1388178
Rechargeable battery, 1400 mAh, 18350 Li-ion for iJaw size 215	1388408
Antenna extension cable, 10 m (32'9")	1379934
IO-Link wireless antenna for iJaw	1411156


RÖHM
Battery ok

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Subject to changes.
ID no. 1355131 / 0723