



*RÖHM provides advanced clamping and gripping solutions tailored for the manufacturing of firearms, ammunition, armaments, and a broad spectrum of defense equipment.*



## SAFETY IN CLAMPING AND GRIPPING

Defense equipment manufacturers rely on RÖHM's engineering expertise, comprehensive in-house production capabilities, and proven product performance – all combining to deliver the highest level of technological reliability essential to the industry. This also applies to mechanical manufacturing. Clamping and gripping technology from RÖHM can be integrated into any process and any machining center, whether manual or automated. While maximum precision remains the top priority, large or intricately shaped workpieces often present unique challenges. This is where RÖHM's capability to deliver both advanced clamping and gripping technology, as well as fully customized system solutions, delivers significant value.

## FROM SMALL ARMS TO HOWITZERS

RÖHM provides clamping and gripping technology specifically designed for the mechanical machining of rifle and gun barrels. Achieving high-precision, low-vibration results with these long, slender, and often heavy workpieces demands tailored system solutions customized to each customer's requirements.

### TASK:

SMG barrels to be turned in a single clamping operation to maximize precision and efficiency

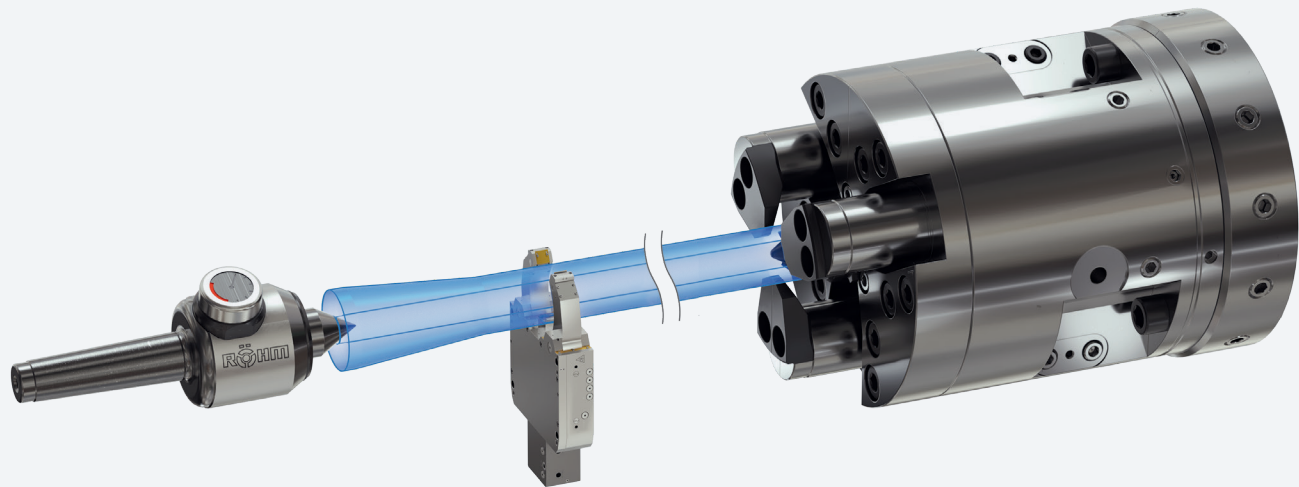
### SOLUTION:

Power-operated 160 mm diameter compensating chuck paired with a steady rest and live center for enhanced support and precision

PRECISION CLAMPING SOLUTIONS FOR  
RIFLE AND GUN BARREL MACHINING

### FEATURES:

- Engineered for high-speed, high-precision barrel machining
- Compact chuck design – retractable clamping jaws allow full turning access to the workpiece
- Kinematic clamping lever system – maintains high clamping forces – even at spindle speeds up to 4,000 rpm
- Adaptive clamping jaws – compensating force ensures secure hold across varying workpiece geometries
- Face driver technology
- Optimized for smallest diameters
- Quick-change via taper interface
- Precise centering through integrated center point
- Maintenance-friendly design – automatic central lubrication reduces wear and downtime



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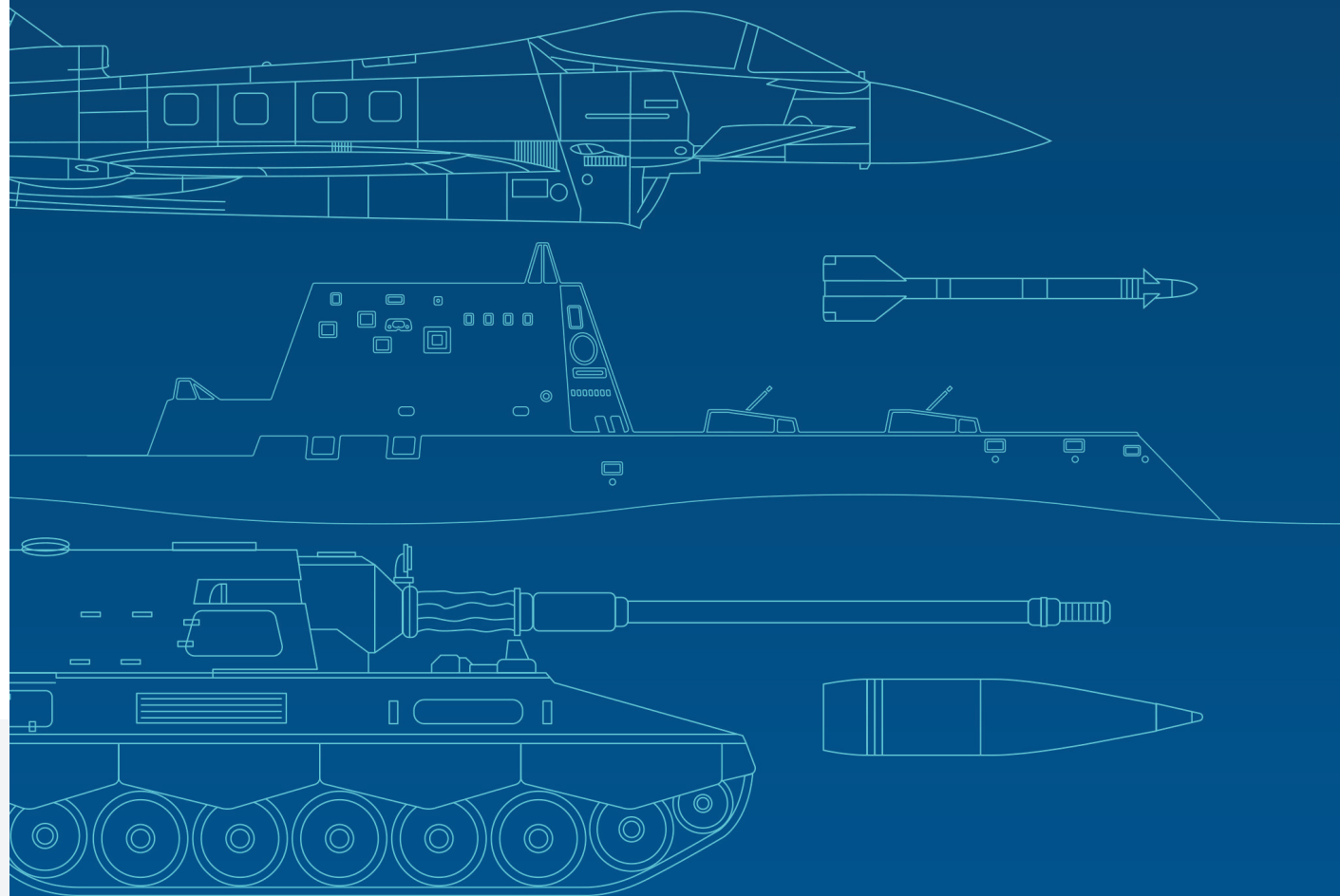
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## PRECISION CLAMPING AND GRIPPING SOLUTIONS FOR DEFENSE MANUFACTURING



RÖHM is an ITAR approved manufacturer and delivers solutions for the defense industry.





# A STRONG GRIP STARTS IN MANUFACTURING.

# RÖHM

## Over a Century of Engineering Excellence.

For more than 110 years, RÖHM has been at the forefront of clamping, gripping, and handling technology. Today, many of the world's leading machine and plant manufacturers rely on us as their trusted standard supplier – providing advanced solutions for turning, power clamping systems, collet chucks, mandrels, centering points, steady rests, and robotic gripping technology. Renowned for their durability, precision, and intelligent force and motion control, our products consistently deliver performance where it matters most. That's why RÖHM has been a valued partner to the defense industry for generations.

## DESIGNED FOR LARGE CARTRIDGES, ARTILLERY SHELLS AND PRECISION GUIDED AMMUNITION

RÖHM provides advanced clamping and gripping technology for manufacturing a wide range of medium and large-caliber ammunition – including 120 mm and 155 mm shells – formed through precision mechanical processing. We also offer tailored solutions for detonator production. But it's not just about precision. In high-volume manufacturing environments, robustness is just as critical. That's why our systems are adapted to meet the unique demands of each customer's production line – ensuring reliability, consistency, and optimum integration with existing processes.

### SELECTED EXAMPLES OF CLAMPING TECHNIQUES FOR AMMUNITION PART TURNING

#### TASK:

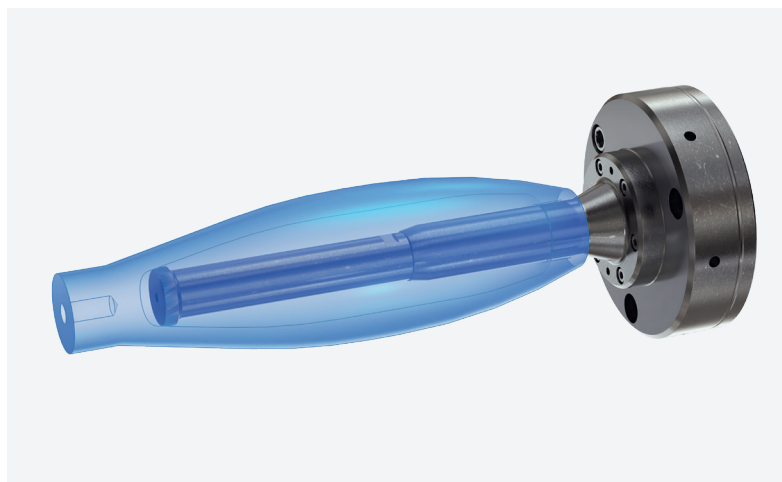
Two-stage clamping for precision internal and external machining of ammunition bodies

#### SOLUTION:

Power-operated KZF-S collet chuck clamping on the outside diameter of the workpiece

#### FEATURES:

- Integrated spindle stop with damping reduces vibration for smoother machining operations
- Rotatable workpiece mounting enables seamless transition between machining operations without repositioning
- Adjustable damping system via pull rod fine-tunes stop and damping settings for optimal performance
- Axial-free clamping eliminates axial pull against the stop for enhanced precision



#### TASK:

External machining of an ammunition component using a single clamping operation

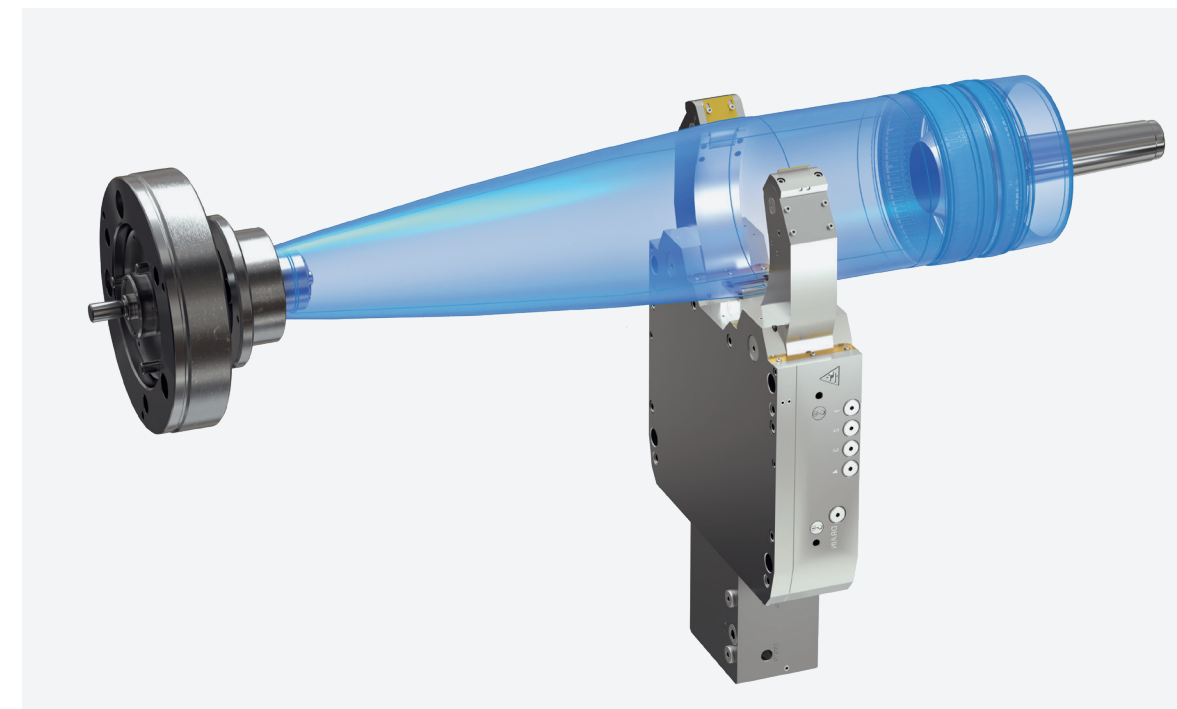
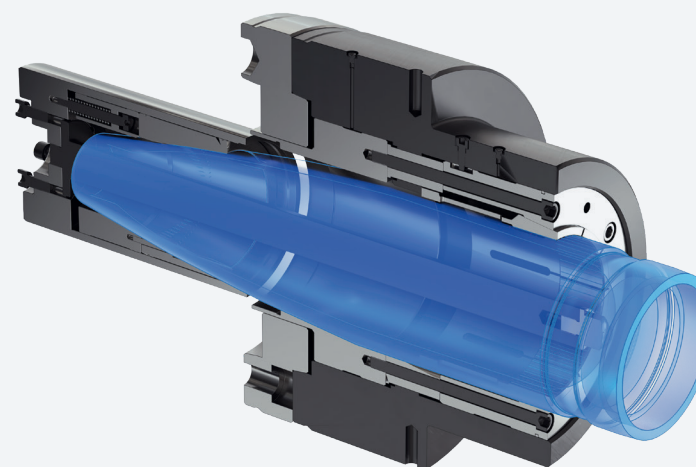
#### SOLUTION:

KFG power-operated sliding mandrel designed for internal diameter clamping of the workpiece

#### FEATURES:

- Angular stop positioned near the base of the workpiece ensures stable seating during machining, minimizing movement and improving repeatability for precision operations
- Knurled sliding jaw for maximum torque transmission provides superior grip and torque transfer, ideal for handling demanding materials without slippage
- Axial pull against the workpiece stop draws the part firmly into position for optimal alignment – enhancing clamping security and reducing vibration during machining

#### FIRST CLAMPING



#### TASK:

Internal and external machining of an ammunition component

#### SOLUTION:

KFS power-operated cartridge mandrel with integrated steady rest and centering cone for secure and precise workpiece support

#### FEATURES:

- Internal diameter clamping with grooved contact surfaces maximizes torque transmission for secure and slip-free workholding – essential for demanding machining tasks
- Steady rest support for first operation provides stable back-end support during initial machining – ensuring precision and reduced vibration
- Revolving centering taper (second operation) facilitates accurate centering without the need for a steady rest – enabling fast, uninterrupted processing
- Robot-compatible insertion aid streamlines automated loading for improved cycle times and seamless integration with robotic handling systems

#### SECOND CLAMPING

