

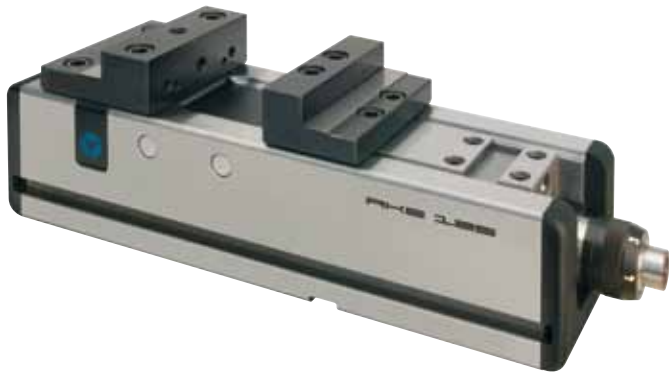
Vice novelties

Clamping technology for NC machining



<http://www.roehm.biz/schraubstockneuheiten>

RÖHM
driven by technology



The new NC-compact vice RKE: optimized design with proven quality. Especially used on CNC-machines.

Horizontal, side or in connection with a basic plate vertical mounting, for example as DUO clamping tower (back to back)

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.

Technical features:

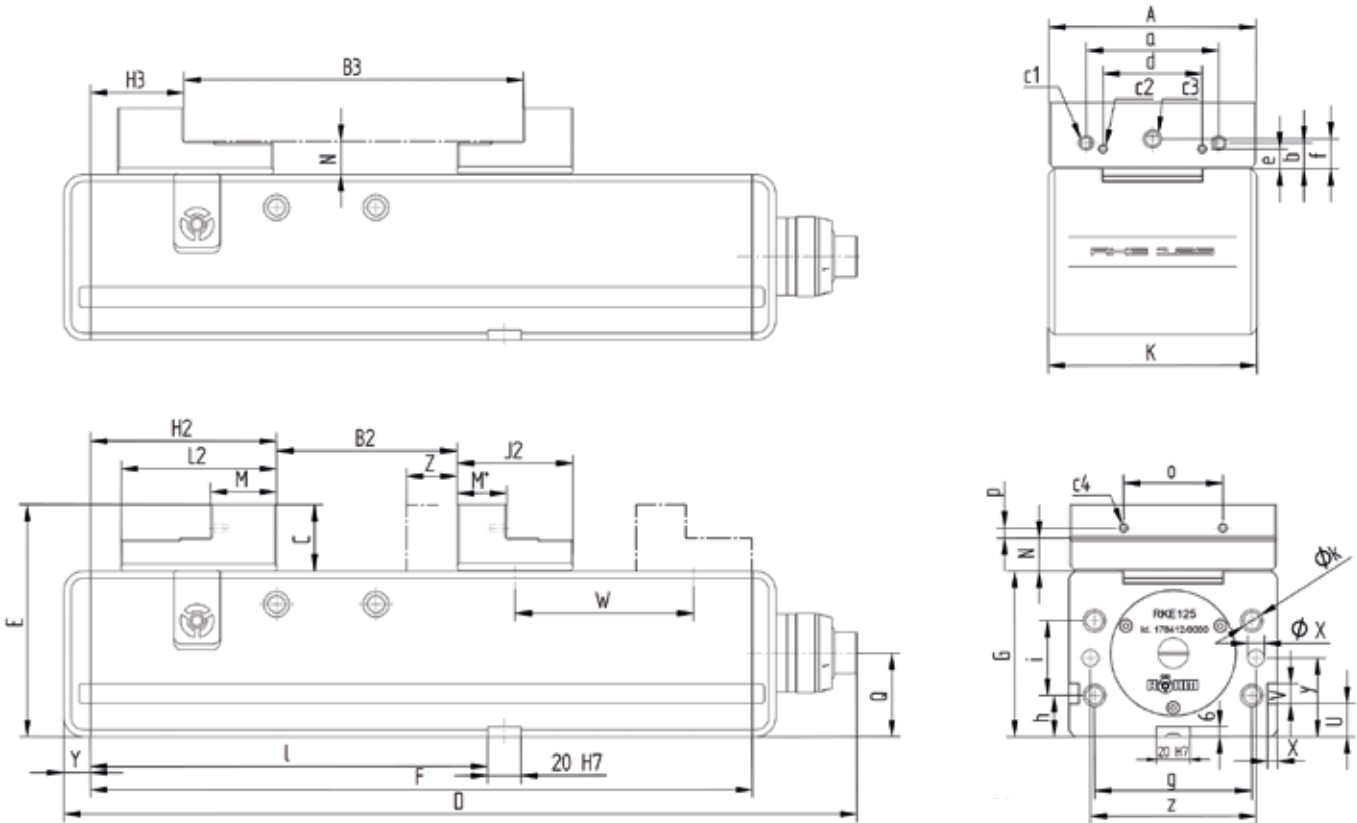
- Solid steel-body and all guidings hardened and ground
- Long clamping slide with clutch, hardened on all sides, function surfaces ground
- Locking pin with clamping force presetting
- Clamping surface for clamping claws

Customer advantage:

- Central grease nipples for simple lubrication of the spindle thread and all guides
- Solid chip guard prevents chips from penetrating the inside of the body
- Thread-bore for receiving all RÖHM flat-clamping jaws with jaw width 125/160 mm
- Thread for fastening angle drive

RKE basic with stepped jaws

Item-No.	178411	178412	178413	178414
Jaw width A	92	125	160	200
Jaw design	stepped jaws	stepped jaws	stepped jaws	stepped jaws
B2	0 - 138	0 - 216	0 - 320	0 - 315
B3	71 - 208	97 - 312	131 - 451	131 - 451
C	32	40	50	60
D	346	479	634	634
E	112	140	165	175
F	276	400	530	530
G-0,02	80	100	115	115
H2	80	112,5	130	135
H3	41	56,5	64	64
J1	-	-	-	-
J2	56	70	97	97
K	94	126	162	162
L2	64	94	98	103
M	25	40	34	39
M*	25	30	32,5	32,5
N-0,01	16	20	25	25
W	68	1x108	2x102,5	2x102,5
X	10	10	10	10
Z	70	109	117	117
a	63	80	100	125
b	13,6	15,6	19,6	24,6
c1	M 6x14	M 8x14	M 8x14	M 10x15
c2	M 5x9	M 5x10	M 5x9	M 5x10
c3	M 10x16	M 10x18	M 10x18	M 14x20
d	48	60	80	110
e	8	12	12	12
f	14	18	20	25
g	72	100	135	135
h	20	25	17,5	17,5
i	40	45	80	80
k	M10x12	M12x22	M16x25	M16x25
l	140	240	200	200
Clamping force kN	25	40	60	60
Weight kg	15	41	79	85



Support rails 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:

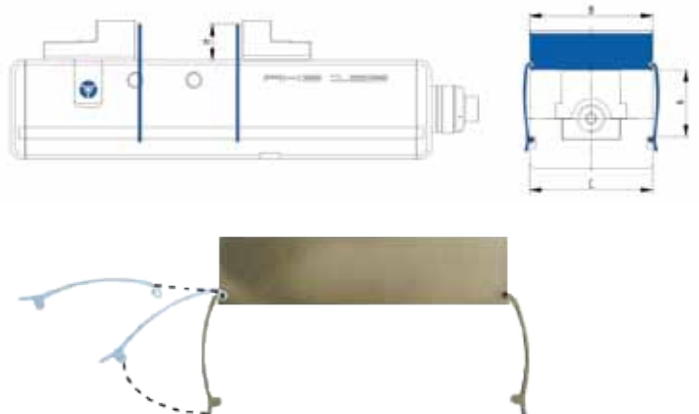
- Different height steppings - width only 3 mm
- No more difficult arrangement of the support rails.
- Rim near through holes can be machined without step jaws or problems due the slim precision support rails.
- Precision and quality parallelism better than 0.005 mm
- Quick cleaning

Delivery range:

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

Support rails Cliparc

Item-No.	1269621	1269622	1269623
For	RKE 92	RKE 125	RKE 160
Web height	A 48	68	83
Jaw and rail width	B 92	125	160
Rail height	H 10/16/18/20/23/25/26/27/28/29	10/15/20/25/28/30/33/35/36/37	10/15/20/25/30/35/40/43/45/47
Guiding width	C 94	126	162
Spare clamp (Set = 4 pieces)	1269624	1269625	1269626





The new RZM centric clamping vice from RÖHM is ideal for 5-axis processing centres.

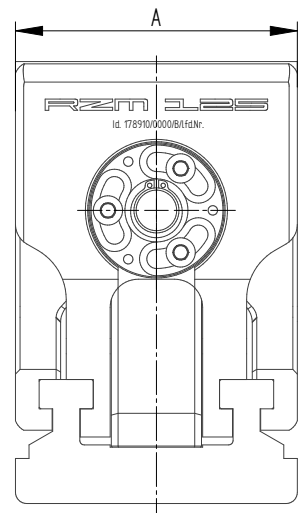
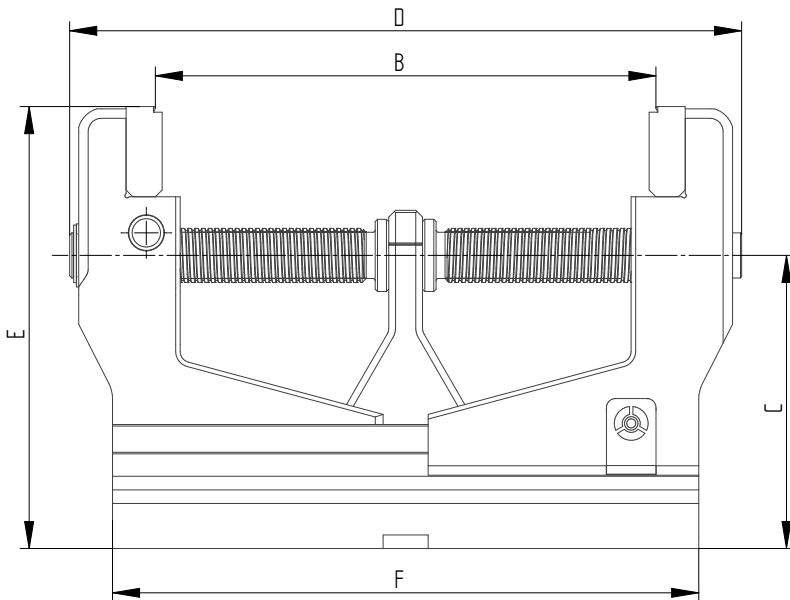
Without any additional substructures or special jaws, the centric clamping unit holds the workpiece securely – with a minimum interference contour which is standard with 5-axis clamping.

Technical features:

- High position of the clamping jaws
- The spindle situated at the top, close to the jaws
- Long jaw guidings and compact design
- Outstanding guidance characteristics are based on a patent-protected jaw guidance system

Customer advantages:

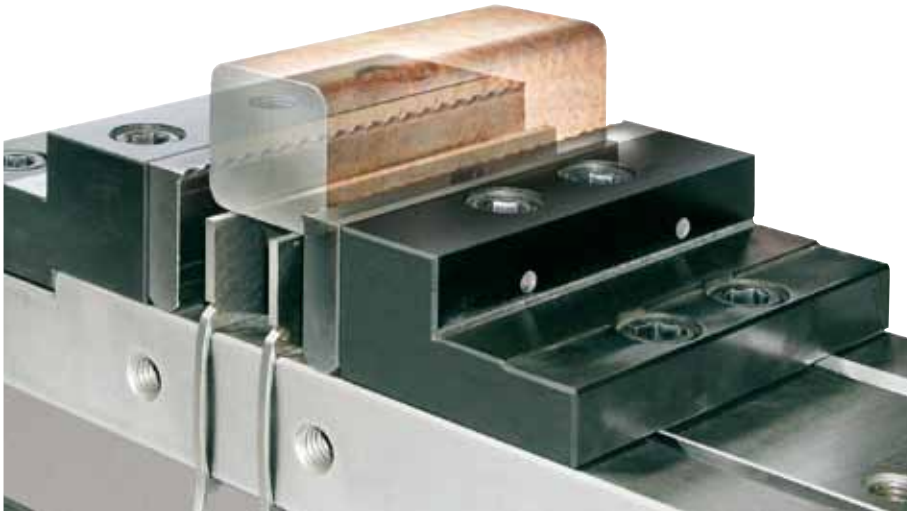
- Very open design for optimised chip removal, so even in heavy machining operations it is easy to keep the vice clean
- Highly suitable for the use with SKB claw jaws. Unfinished parts and parts for processing with a strength up to max. 900N/mm² are securely clamped with a clamping depth of 2,5 mm.
- Flat jaws compatible to NC-Compact vice RKE



Centric vice RZM

Design	short design	long design
Item no.	178911	178910
Jaw width A	125	125
B min.	23	23
B max.	142	222
C	130	130
D	217	297
E	196	196
F	180	260
Clamping force kN	25	25
Weight aprox. kg	17,4	20,3

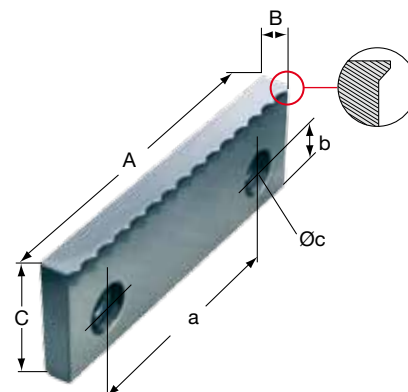
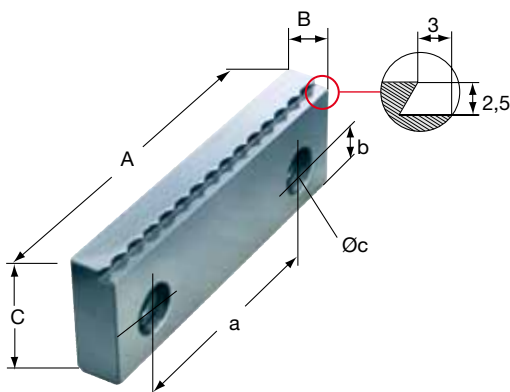
SKB Claw jaws



Claw jaws SKB without step, clamping depth > 2,5 mm, workpiece clamping e.g. with „Cliparc“ support rails

Claw jaws SKB: stronger, more flexible, more efficient - obviously the better choice

- Positive-fit clamping by the penetration of the hardened claw tips
- High holding forces: enhancement by a factor of 3 to 5 compared to standard jaws
- 5-side machining in one set-up
- Low material loss
- Shorter cycle times
- Reduced production costs and costs per piece
- For use on vices
- Easy to screw onto RÖHM NC-Compact Vices
- Easy, reliable clamping of parallel raw and sawed parts
- Hydraulic or manual clamping
- With fine step for clamping depth up to 2,5 mm
- Without fine step for clamping depth > 2,5 mm



Claw jaws SKB with fine step

2,5 mm clamping depth

Item no.	Satz	166514	166520	166522
A		92	125	160
B		14	16	18
C		32	40	50
a		63	80	100
b		13,6	15,6	19,6
Øc		7(M6)	9(M8)	9(M8)

Claw jaws SKB without step

universal for clamping depth > 2,5 mm

Item no.	Satz	166661	166667	166669
A		92	125	160
B		14	16	18
C		32	40	50
a		63	80	100
b		13,6	15,6	19,6
Øc		7(M6)	9(M8)	9(M8)

Clamping jaws of the rapid series for RKE / RZM

Clamping jaws of the Rapid series, to screw down the step jaw and the standard top jaw.

Application

Depending on the application and the workpiece to be machined, the clamping jaws shown on the right-hand side can be screwed down to the stepped jaw and the standard top jaw.

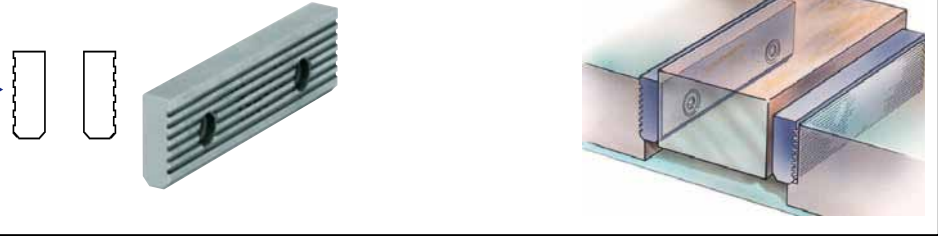


Stepped jaws



Standard top jaws

SGN standard jaws, for precise clamping of parallel parts with sensitive clamping surfaces reversible, one side smooth, one side longitudinal grooved.



SGN standard jaws, checkered, used to increase the specific surface pressure (higher retention force), reversible, one side fine-grooved, one side longitudinally grooved



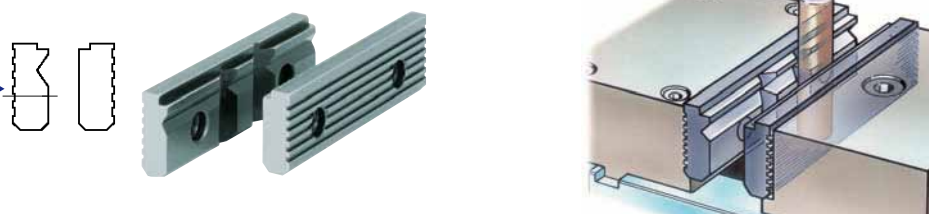
SPR V-jaw for precise clamping of round material in a vertical and horizontal position. For use in combination with SGN, as a geometrically defined position is achieved only in case of a three-point clamping action.



SNF draw-down jaws with spring plate especially suited to clamp unmachined parts. The spring plates are pressed down by the clamping force and thus effect a draw-down force.



SBO V-jaws and standard jaws, soft, with prism and work support.

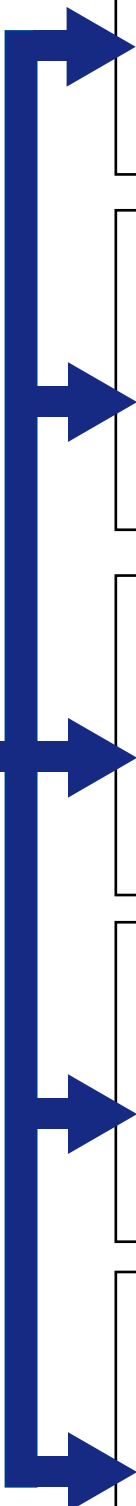


Quick-chang jaw inserts for RKE

Draw-down base jaws with permanent magnet and quick-change inserts.
 Clamping jaws compatible to NC-Compact vices and machine vices with identical jaw width.
These clamping jaws are available on request!



Claw insert RNK
 Inserts with claws for raw, unmachined workpieces.



Standard insert RNS
 for machined workpieces without angular error.

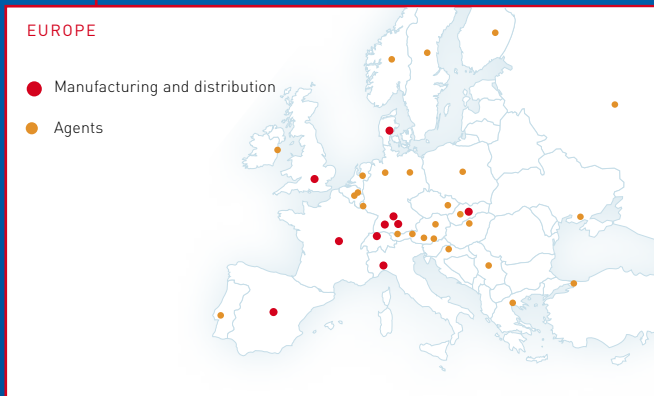
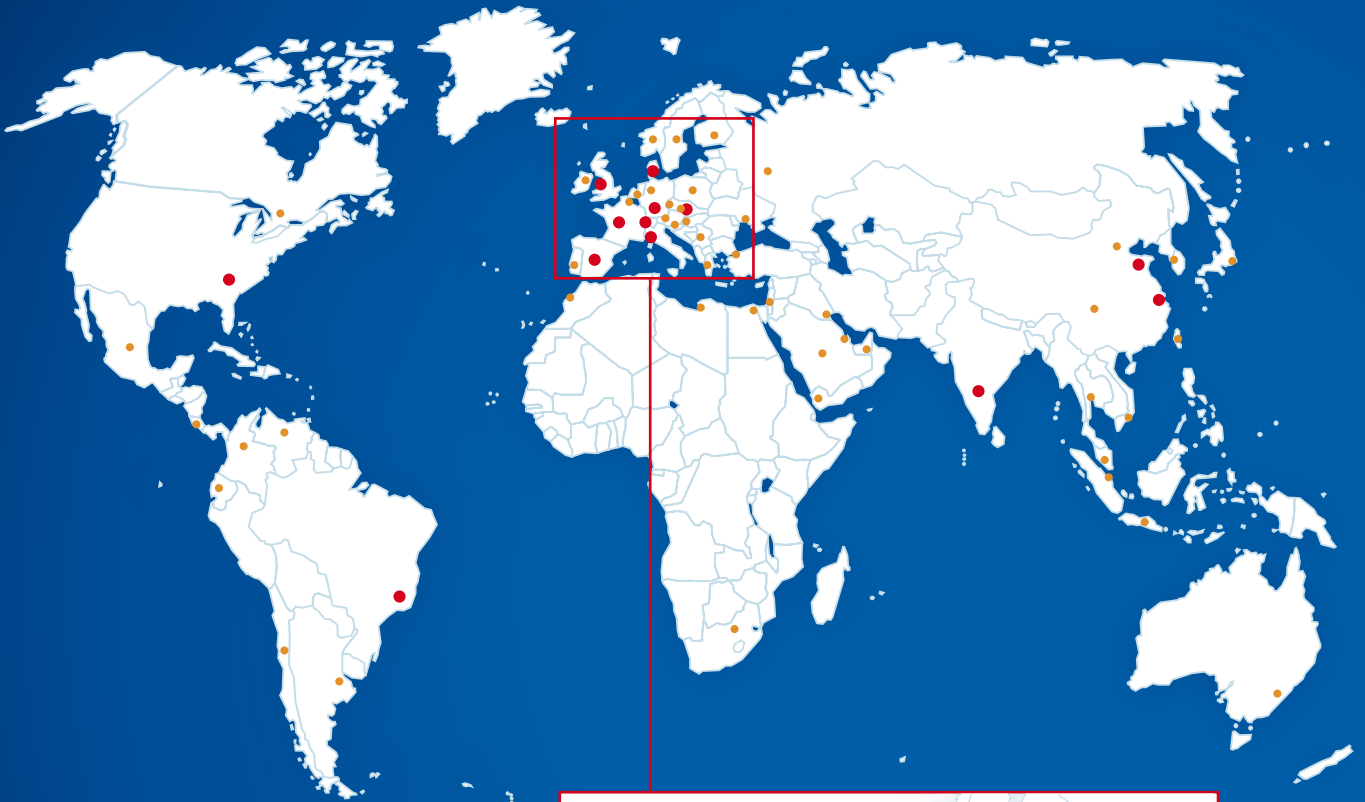
Standard insert RNS fine-checked
 used to increase the specific surface pressure (higher retention forces)

Claw insert RNK
 Inserts with claws for raw, unmachined workpieces.

Insert with round clamping shoulder RNR,
 point-to-point clamping shoulder for machined workpieces with or without angular error.

Work support RWA
 to be fixed to the standard inserts.
 Workpieces can be „raised“ for clamping with it.

Further sizes and designs available on request.



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