

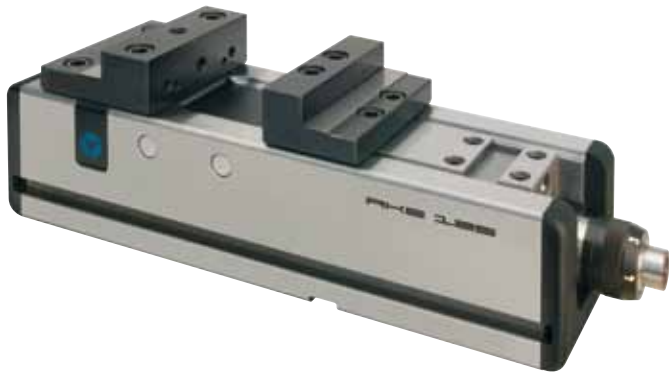
# Vice novelties

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:**

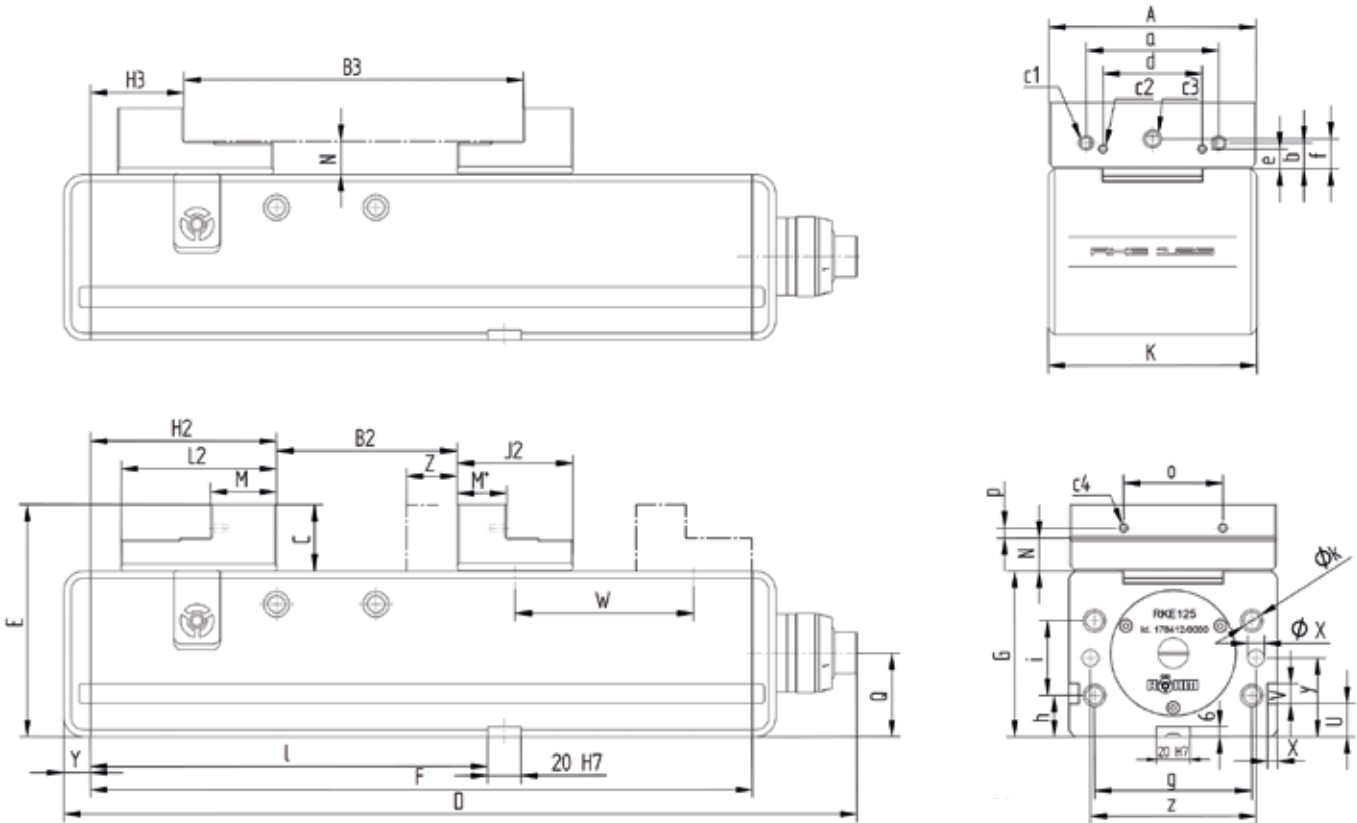
- Solid steel-body and all guidings hardened and ground
- Long clamping slide with clutch, hardened on all sides, function surfaces ground
- Locking pin with clamping force presetting
- Clamping surface for clamping claws

**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:**

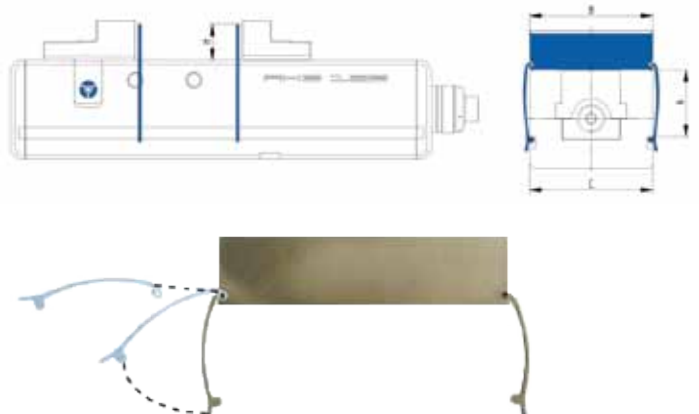
- Different height steppings - width only 3 mm
- No more difficult arrangement of the support rails.
- Rim near through holes can be machined without step jaws or problems due the slim precision support rails.
- Precision and quality parallelism better than 0.005 mm
- Quick cleaning

**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.

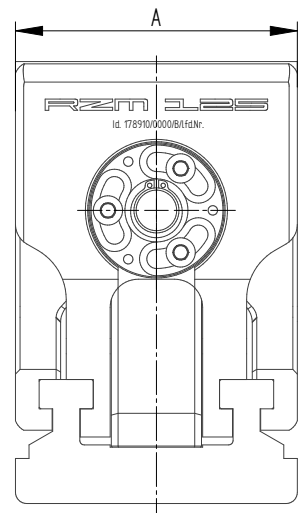
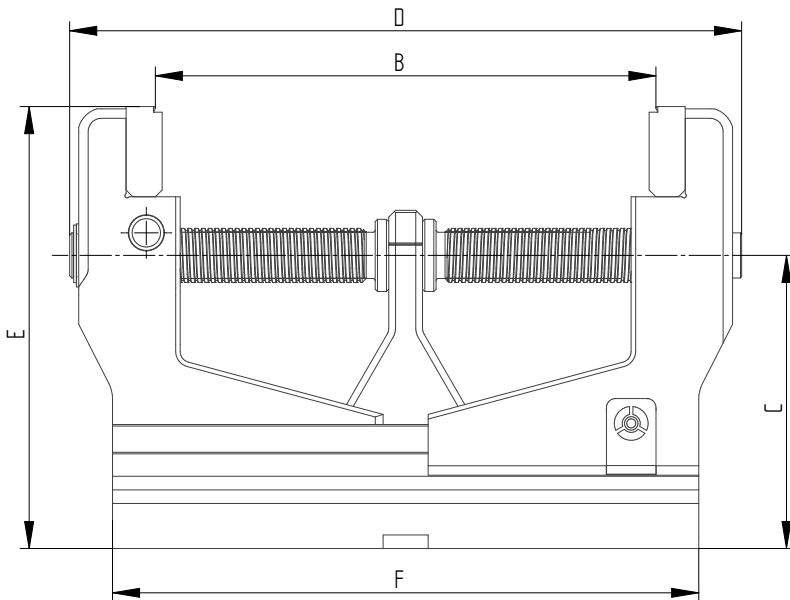
Without any additional substructures or special jaws, the centric clamping unit holds the workpiece securely – with a minimum interference contour which is standard with 5-axis clamping.

**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/mm<sup>2</sup> are securely clamped with a clamping depth of 2,5 mm.
- Flat jaws compatible to NC-Compact vice RKE

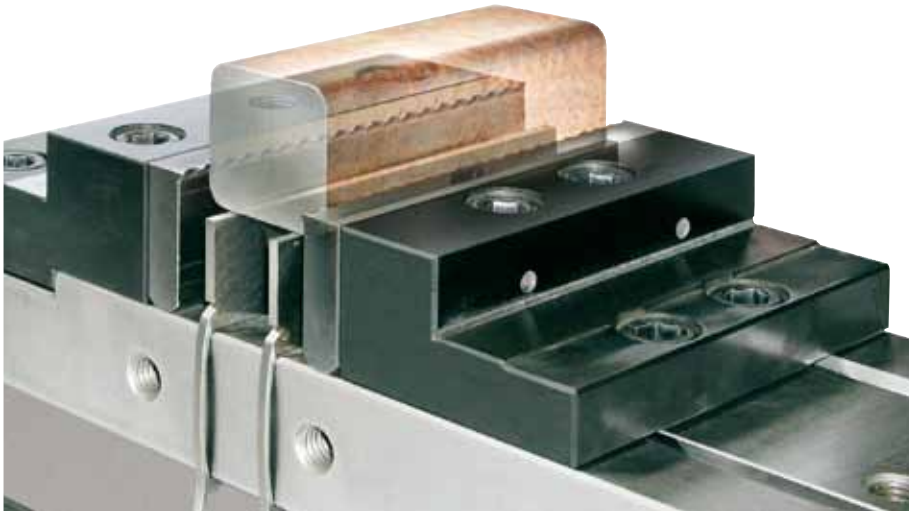


**Centric vice RZM**

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



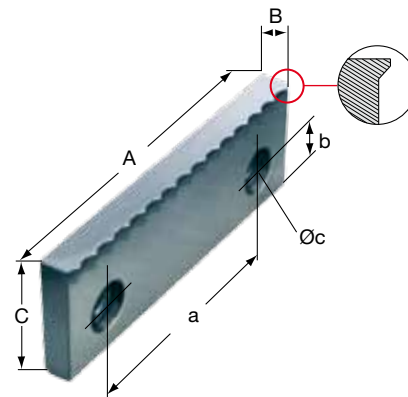
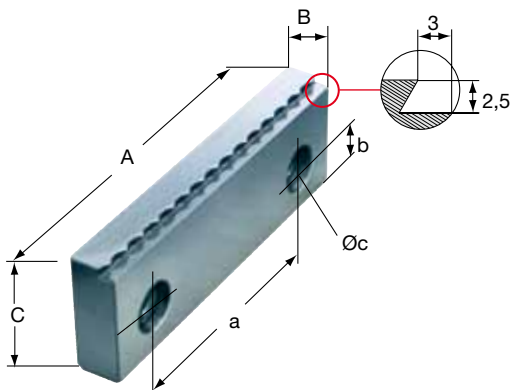
# SKB Claw jaws



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!*

**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.

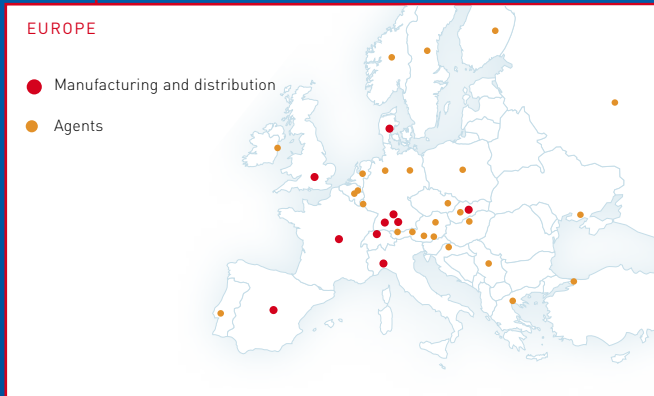
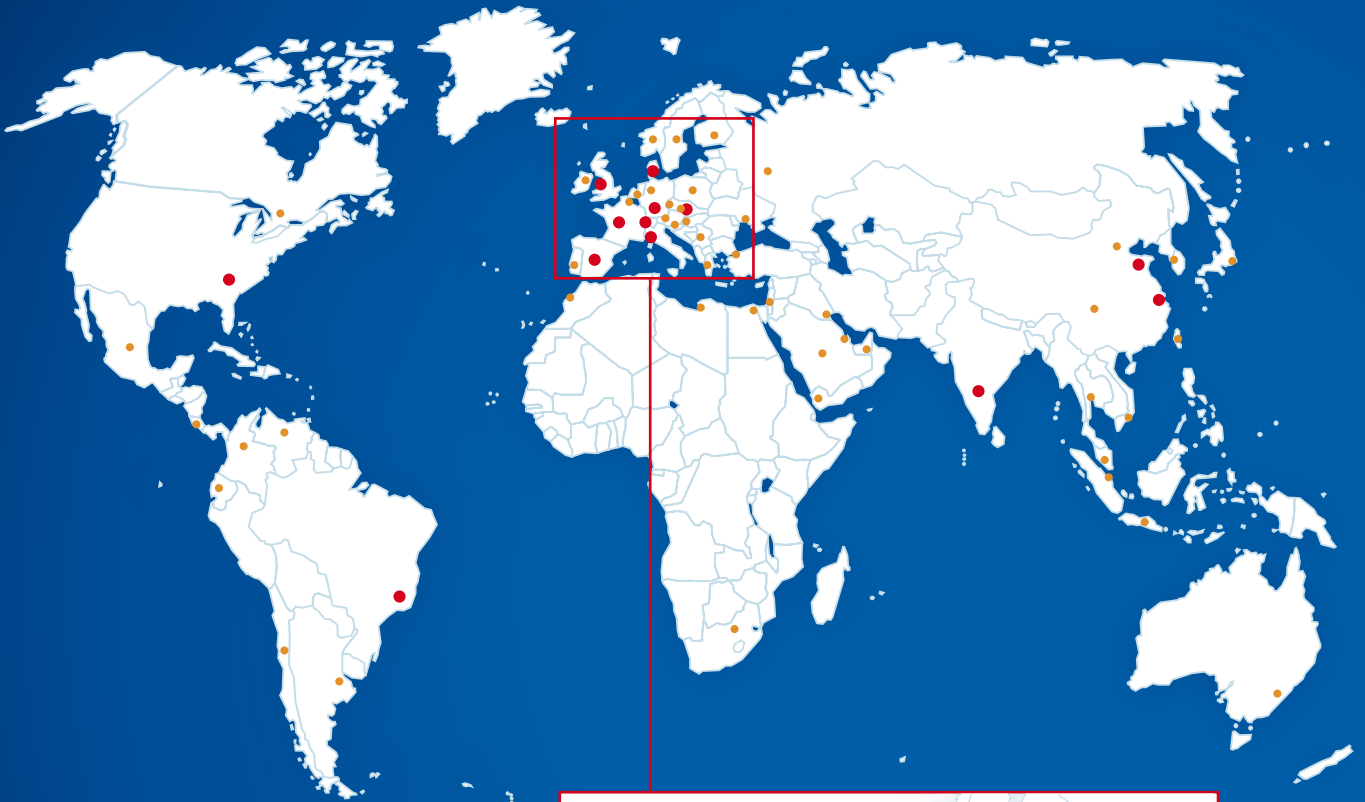
**Insert with round clamping shoulder RNR,**  
point-to-point clamping shoulder for machined workpieces with or without angular error.

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



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

Further sizes and designs available on request.



**RÖHM GmbH**

Heinrich-Röhm-Straße 50 | 89567 Sontheim/Brenz | Germany  
Tel 0049 73 25 – 16-0 | Fax 0049 73 25 – 16-510  
info@roehm.biz | www.roehm.biz