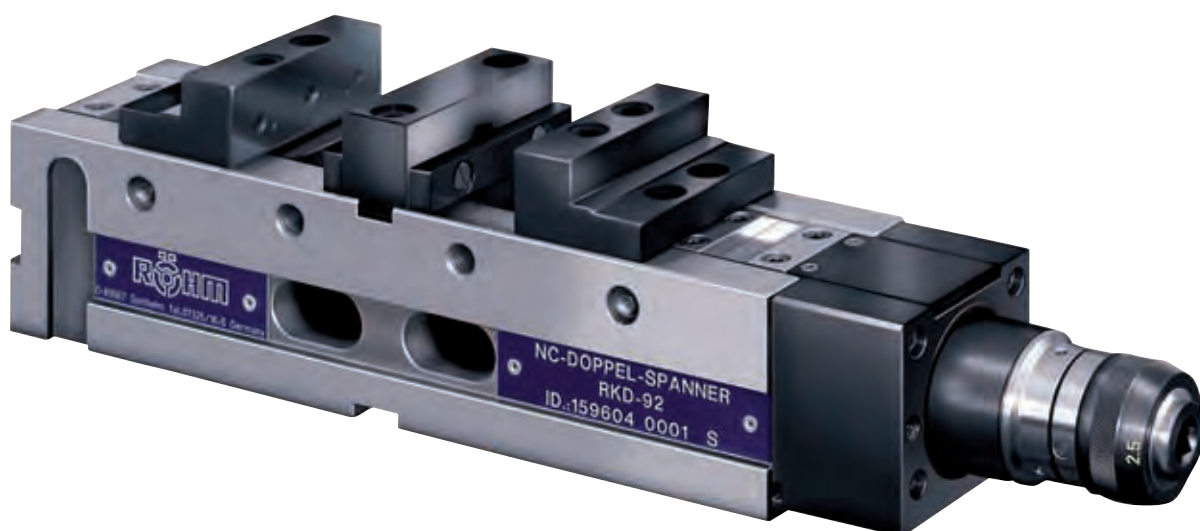


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**There's no escaping here. Even heavy parts  
are packed precisely and secured safely.  
With clamping forces of up to 15 tonnes!**





## VICES

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**Please note:**  
The delivery time specified in the catalogue is valid from 01.01.2012

# Operation guide

|                                 | NC-Compact vices  |                                      |   |                       |                              |  |  |
|---------------------------------|---|--------------------------------------|---|-----------------------|------------------------------|--|--|
|                                 | RKK   | RKE                                  | RKE-L   | RKG-L                 | RKE-LV                       | RKE-M LV   | RKE-H L  |
| <b>Clamping system</b>          | mechanical-hydraulic <sup>1)</sup><br>mechanical-machanical | mechanical-mechanical                | mechanical-hydraulic <sup>1)</sup><br>mechanical-machanical | mechanical-mechanical | mechanical-mechanical        | mechanical without power transmitter <sup>3)</sup> | hydraulic with stroke                            |
| <b>Jaw width</b>                | 92<br>113<br>135<br>160<br>200                              | 125<br>160                           | 92<br>125<br>160<br>200                                     | 125<br>160<br>200     | 125                          | 92<br>125  | 125  |
| <b>Types of jaws</b>            | Stepped jaws <sup>1)</sup> ; Standard with normal jaws      | Standard- or stepped jaws            | Standard- or stepped jaws                                   | Stepped jaws          | Stepped- or carrier jaws     | Stepped jaws                                       | Standard- or stepped jaws                        |
| <b>Clamping capacity</b>        | 0 - 340   | 0 - 451                              | 0 - 451   | 0 - 451               | 0 - 192                      | 0 - 206  | 0 - 312  |
| <b>Max. clamping force [kN]</b> | 25 - 60   | 40 - 60                              | 25 - 60   | 40 - 60               | 40                           | 25 - 40  | 40   |
| <b>Possible operation</b>       | 3-Side<br>Duo-Tower<br>Quattro-Tower                        | 3-Side<br>Duo-Tower<br>Quattro-Tower | Base  | Base                  | Base                         | Base   | Base   |
| <b>Clamping</b>                 | single clamping   | single clamping                      | single clamping   | single clamping       | single clamping              | single clamping                                    | single clamping                                  |
| <b>Extra</b>                    |   | Basic body extension                 |   |                       | Fixed jaws on operators side | Actuation double-sided                             | hydraulic connection for single-acting cylinders |
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<sup>1)</sup> only size 92

<sup>1)</sup> only size 92

<sup>3)</sup> Constant clamping force at each clamping Sequence and large repeating accuracy only when using a torque wrench

# Operation guide

| Type                            | NC-Compact-twin vices               |  | NC-Compact-self centering vices     |  | NC-self centering vices                           | NC power vices               |  |
|---------------------------------|-------------------------------------|--|-------------------------------------|--|---|------------------------------|--|
|                                 | RKD                                 | RKD-M  | RKZ                                 | RKZ-M  | NCZ   | RBA                          | RBAW   |
| <b>Clamping system</b>          | mechanical-mechanical               | mechanical without power transmitter <sup>*)</sup> | mechanical-mechanical               | mechanical without power transmitter <sup>*)</sup> | mechanical without power transmitter              | mechanical-hydraulic         | mechanical-hydraulic                                 |
| <b>Jaw width</b>                | 92<br>125                           | 92<br>125  | 125                                 | 50<br>70<br>92<br>125                              | 110<br>160  | 92<br>113<br>135<br>160      | 113<br>135<br>160                                    |
| <b>Types of jaws</b>            | Centre jaws with stepped jaws       | Centre jaws with stepped jaws                      | Stepped jaws                        | Stepped jaws                                       | Standard jaws                                     | Normal jaws                  | Normal jaws  |
| <b>Clamping capacity</b>        | 0 - 180                             | 0 - 180  | 32- 298                             | 0 - 269  | 38 - 222  | 0 - 310                      | 0 - 310  |
| <b>Max. clamping force [kN]</b> | 25 - 40                             | 25 - 40  | 40                                  | 10 - 25  | 25 - 50   | 25 - 50                      | 30 - 50  |
| <b>Possible operation</b>       | 3-Side<br>Duo-Tower<br>Quattro-Towe | 3-Side<br>Duo-Tower<br>Quattro-Towe                | 3-Side<br>Duo-Tower<br>Quattro-Towe | Base   | Base  | 3-Side                       | 3-Side   |
| <b>Clamping</b>                 | twin clamping                       | twin / centric/single clamping                     | centric clamping                    | centric clamping                                   | twin / centric/single clamping                    | single clamping              | single clamping                                      |
| <b>Extra</b>                    |                                     |  | V-jaws                              | V-jaws   | actuation with hydraulic motor or pneumatic motor | Clamping capacity presetting | Integrated angle drive, Clamping capacity presetting |
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<sup>\*)</sup> Constant clamping force at each clamping Sequence and large repeating accuracy only when using a torque wrench

|                                 | Machine vices                                |  |  |  |  |  |  |
|---------------------------------|--|--|--|--|--|--|--|
|                                 | RB   | RH   | MSR  | RS   | SG   | Draw-down-vice<br>UH                               | Self-centering<br>vice<br>UZ                       |
| <b>Clamping system</b>          | mechanical-hydraulic                         | hydraulic with stroke  | mechanical without power transmitter <sup>*)</sup> | mechanical without power transmitter <sup>*)</sup> | mechanical without power transmitter <sup>*)</sup> | mechanical without power transmitter <sup>*)</sup> | mechanical without power transmitter <sup>*)</sup> |
| <b>Jaw width</b>                | 113<br>135<br>160<br>200<br>250<br>315       | 113<br>135<br>160<br>200   | 125<br>150<br>175                                  | 92<br>113<br>135<br>160<br>200                     | 92<br>113<br>135<br>160<br>200<br>250              | 90<br>113<br>135<br>160<br>200<br>250<br>300       | 113<br>135<br>160<br>200<br>250                    |
| <b>Types of jaws</b>            | Normal jaws                                  | Normal jaws  | Draw-down jaws                                     | Normal jaws  | Normal jaws  | Normal jaws  | Normal jaws  |
| <b>Clamping capacity</b>        | 0 - 420                                      | 0 - 350  | 0 - 400  | 0 - 185  | 0 - 345  | 0 - 400  | 0 - 400  |
| <b>Max. clamping force [kN]</b> | 30 - 150                                     | 25 - 100   | 30 - 60  | 18 - 55  | 20 - 60  | 20 - 70  | 15 - 28  |
| <b>Possible operation</b>       | Base   | Base   | Base   | Base   | Base   | Base   | Base   |
| <b>Clamping</b>                 | single clamping                              | single clamping  | single clamping                                    | single clamping                                    | single clamping                                    | single clamping                                    | centric clamping                                   |
| <b>Extra</b>                    | Rotation plate, Clamping capacity presetting | Rotation plate, for single-acting cylinder, Clamping capacity presetting | Rotation plate, Clamping capacity presetting       | Rotation plate                                     | Rotation plate, Clamping capacity presetting       | Rotation plate, immobile jaws on operators side    | Rotation plate                                     |
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<sup>\*)</sup> Constant clamping force at each clamping Sequence and large repeating accuracy only when using a torque wrench

# Operation guide

| Drilling machine vices          |                              |                              |                              |                              |                              |                         |
|---------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|-------------------------|
| Typ                             | BOF                          | BSS                          | DPV                          | DPV 3-W                      | BSH                          |                         |
| <b>Clamping system</b>          | mechanical manually operated | mechanical manually operated | mechanical manually operated | mechanical manually operated | mechanical manually operated |                         |
| <b>Jaw width</b>                | 90<br>110<br>135<br>160      | 110<br>135                   | 80<br>100<br>120<br>150      | 100                          | 65<br>80<br>100              | 80<br>100<br>120<br>140 |
| <b>Types of jaws</b>            | SBO-jaws, soft               | SBO-jaws, soft               | SBO-jaws, soft               | SBO-jaws, soft               | SBO-jaws, soft               |                         |
| <b>Clamping capacity</b>        | 0 - 220                      | 0 - 160                      | 0 - 125                      | 0 - 93                       | 0 - 150                      |                         |
| <b>Max. clamping force [kN]</b> | -                            | -                            | -                            | -                            | -                            |                         |
| <b>Possible operation</b>       | Base                         | Base                         | Base                         | 3-Side                       | Base                         |                         |
| <b>Clamping</b>                 | single clamping              | single clamping              | single clamping              | single clamping              | single clamping              |                         |
| <b>Extra</b>                    |                              | quick-acting clamping        |                              |                              | D.I.Y. user- design          | sturdy craftsman design |
| <b>Page</b>                     | 4092                         | 4092                         | 4092                         | 4093                         | 4093                         |                         |

# Operation guide

|                                 | Precision vices              |                              |                              |                              |                              |                              |                              |                              |                              |            |
|---------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------|
|                                 | PL-S                         | PLF                          | PL-G                         | PSK-S                        | PSK-O                        | Precision sine vices         |                              |                              | PS-ZD                        |            |
| <b>Clamping system</b>          | mechanical manually operated | mechanical manually operated | mechanical manually operated | mechanical manually operated | mechanical manually operated | mechanical manually operated | mechanical manually operated | mechanical manually operated | mechanical manually operated | mechanical |
| <b>Jaw width</b>                | 34<br>45<br>70<br>90<br>120  | 50<br>73<br>100              | 60<br>73<br>88               | 45<br>65<br>100<br>125       | 45<br>65<br>100<br>125       | 70<br>90                     | 70                           | 75                           | 70<br>120                    |            |
| <b>Types of jaws</b>            | fixed and movable jaws       | fixed and movable jaws       | fixed and movable jaws       | fixed and movable jaws       | fixed and movable jaws       | fixed and movable jaws       | fixed and movable jaws       | fixed and movable jaws       | fixed and movable jaws       |            |
| <b>Clamping capacity</b>        | 0 - 150                      | 0 - 125                      | 0 - 125                      | 0 - 150                      | 0 - 140                      | 0 - 120                      | 0 - 50                       | 0 - 80                       | 0 - 150                      |            |
| <b>Max. clamping force [kN]</b> | -                            | -                            | -                            | -                            | -                            | -                            | -                            | -                            | -                            |            |
| <b>Possible operation</b>       | 3-Side                       | 3-Side                       | 3-Side                       | 3-Side                       | 3-Side                       | Base                         | Base                         | Base                         | Base                         |            |
| <b>Clamping</b>                 | single clamping              | single clamping              | single clamping              | single clamping              | single clamping              | single clamping              | single clamping              | single clamping              | single clamping              |            |
| <b>Extra</b>                    | without spindle              | without spindle              | with spindle                 | with spindle                 | without spindle              | Sinus-swivelling axis        |                              |                              | two-dimensional              |            |
|                                 |                              |                              |                              |                              |                              | front                        | rear                         | longitudinal                 |                              |            |
| <b>Page</b>                     | 4095                         | 4095                         | 4096                         | 4096                         | 4096                         | 4097                         | 4097                         | 4097                         | 4098                         |            |



# Range of application

| Range of application                                  | RKK<br>RKE<br>RKE-L<br>RKD<br>RKZ | RKE-HL | DUO<br>QUATRO | NCZ    | RB | RH | RBA<br>RBAW | RS<br>SG<br>UH | UZ     | PL<br>PSK<br>PS<br>SW | BOF<br>BSS<br>BSH | DPV<br>DPV 3-W | MS     |
|---|-----------------------------------|--------|---------------|--------|----|----|-------------|----------------|--------|-----------------------|-------------------|----------------|--------|
| Machining centers with high working accuracy          | ●                                 | ●      | ●             | ●      | ■  | ■  | ●           | ■              | ■      | ▲<br>2                |                   |                | ■      |
| Universal-milling-machines with high working accuracy | ●                                 | ●      | ●             | ●      | ■  | ■  | ●           | ■              | ■      | ▲<br>2                |                   |                | ■      |
| Universal-milling-machines standard version           | ■                                 | ■      | ■             | ●      | ■  | ■  | ■           | ■              | ■      | ▲                     |                   |                | ■      |
| Erosion machines                                      |                                   |        |               |        |    |    |             | ▲<br>1         | ▲<br>1 | ●                     |                   |                | ▲<br>1 |
| Jig boring machine                                    | ●                                 | ●      | ●             | ●      | ■  | ■  | ●           | ▲              | ▲      | ●                     |                   |                | ▲      |
| Measuring machines with measuring devices             |                                   |        |               |        |    |    |             |                |        | ●                     |                   |                |        |
| Planing machines                                      | ■                                 | ■      | ■             | ■      | ■  | ■  | ■           | ■              | ●      |                       |                   |                |        |
| Drilling machines                                     |                                   |        |               |        |    |    |             |                |        |                       | ●                 | ●              |        |
| Grinding machines                                     | ■                                 | ■      | ■             | ■      | ■  | ■  | ■           | ■              | ■      | ●                     |                   |                | ▲      |
| Series production                                     | ■                                 | ●      | ■             | ■      | ■  | ●  | ■           | ■              | ■      | ■                     | ■                 | ■              | ■      |
| Application for automatic operation                   |                                   | ●      |               | ●<br>3 |    | ●  |             |                |        |                       |                   |                |        |
| For machines with pallet-changing-equipment           | ●                                 | ▲      | ●             | ●      | ●  | ▲  | ●           | ●              | ●      |                       | ■                 | ■              | ■      |
| For end and side fastening (only specific types)      | ●                                 | ●      |               |        |    |    | ●           |                |        |                       |                   | ●              |        |
| For small drilling jobs (DIY work)                    |                                   |        |               |        |    |    |             |                |        |                       |                   | ■              |        |

- = Particularly suitable
- = Normal application
- ▲ = Possible, with reservations

- 1 = Dirt and wear on the moving parts
- 2 = Low clamping force
- 3 = With hydraulic motor or pneumatic motor

# Sectional view toggle lever principle

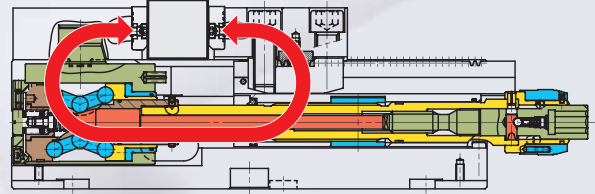
## NC-Compact vices

### RKK Size 2-5

NC-Compact vice for very high clamping precision. Clamping slide with toothing for continuously variable presetting. The power transmitter is mounted in the fixed jaw. This form of support enables high-precision clamping.

## Toggle lever principle

### Sectional view RKK Size 2 - 5

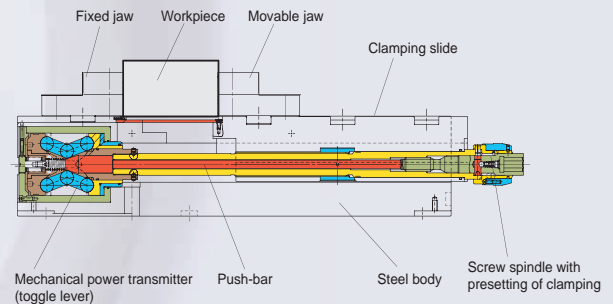


### RKE

High-end NC-Compact vice. Mounting of the power transmitter in the steel body. The RKE version is also available with cast body (**RKG**). Both clamping systems are also available in a simplified version (**RKE-L / RKG-L**).

Also offered in this series are an NC-Compact vice for 5-side machining (**RKE-LV**) and a clamping system with hydraulic actuation (**RKE-HL**).

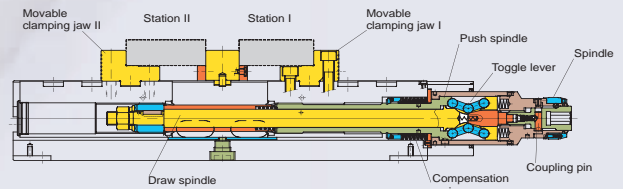
### Sectional view RKE



### RKD

NC-Compact twin vice with two movable clamping jaws (left-hand/right-hand thread) and a fixed center jaw.

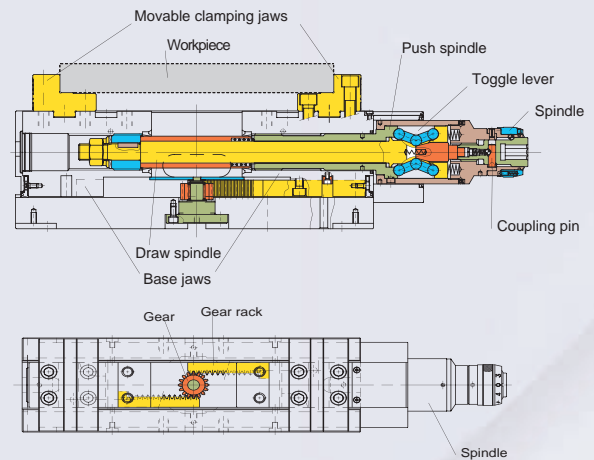
### Sectional view RKD



### RKZ

NC-Compact vice with two movable clamping jaws and large clamping stroke. The force acts equally on both jaws via push spindle and draw spindle. Form-fitted racks in the lower area of the main jaw mesh towards the center into a centrally mounted pinion.

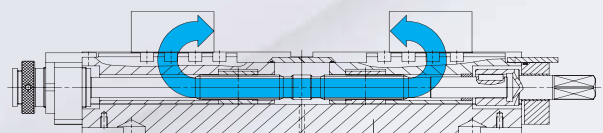
### Sectional view RKZ



### NCZ

The NC self-centering vice NCZ is universally suited for use in machining centers and conventional machine tools. The NCZ offers various actuation options.

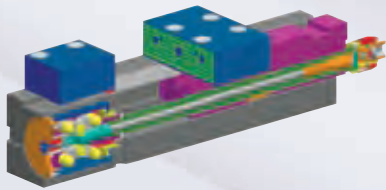
### Sectional view NCZ



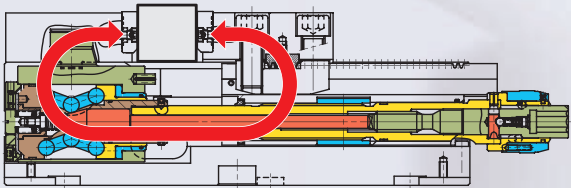
# Functional description / Schematic representation

## Clamping system mechanical-mechanical with toggle lever

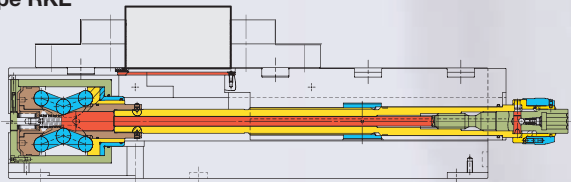
### Single clamping



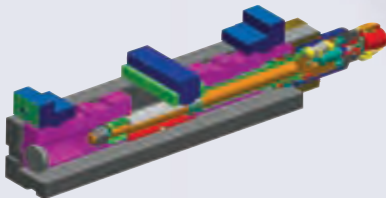
Type RKK



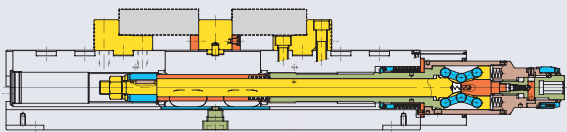
Type RKE



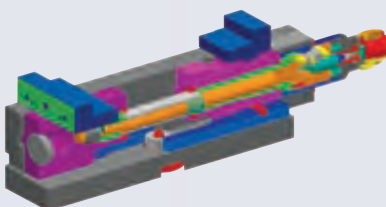
### Twin clamping



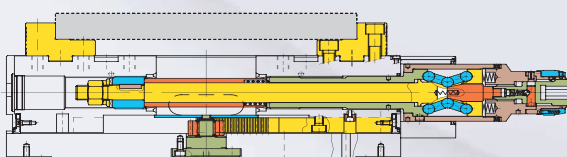
Type RKD



### Centric clamping



Type RKZ



#### a) Clamping with power transmission

Mechanical pretensioning is achieved by turning the hand-crank. The threaded spindle with the large incline brings the movable clamping jaw into contact with the workpiece, whereby resistance can be noted on the hand-crank. Continuing to turn the crank in clockwise direction triggers automatic disengagement and switch to mechanical transmission.

Further turning of the crank moves a pressure pin axially, which generates the high clamping force through spreading of the toggle lever.

#### b) Presetting of different clamping forces

To avoid damage to sensitive workpieces caused by excessive clamping force, different clamping forces can be preset.

The presetting can be performed simply by turning the adjustment collar on the end of the spindle.

#### c) Mechanical clamping without power transmission

For consecutive clamping of multiple workpieces having uneven contact surfaces, greater pretensioning is required. Turning the adjustment collar to "0" deactivates the mechanical power transmission. The workpieces can then be mechanically pretensioned until the yield in the workpieces is eliminated.

The adjustment collar can then be set to the desired clamping force, and the high clamping force introduced.

**RKK:** The power transmission guarantees that the body remains mostly free from deformation; a very high clamping accuracy is achieved.

Movable clamping jaw I is brought to the workpiece in Station 1 by clockwise turning of the spindle using the hand-crank, and held there at a clamping force of approx. 100 daN ("third hand function"). Continuing to turn the crank brings movable clamping jaw II to the workpiece in Station II and fixes it there. Turning the hand-crank further in clockwise direction all the way exceeds the release torque of the coupling pin and initiates mechanical power transmission of the toggle lever. The accumulating pressure is distributed evenly over the push-and-draw spindle on the clamping jaws. Compensating springs compensate for dimensional variations up to  $\pm 3\text{mm}$  between workpiece I and workpiece II. During tensioning, both clamping stations must be occupied by identical workpieces!

The two movable clamping jaws are brought to the workpiece by clockwise turning of the spindle with the hand-crank (left-hand/right-hand thread). Turning the hand-crank further in clockwise direction all the way exceeds the release torque of the coupling pin and initiates mechanical power transmission of the toggle lever. The accumulating pressure is distributed evenly over the push-and-draw spindle on the clamping jaws. Form-fitted racks in the lower area of the main jaw mesh towards the center into a centrally mounted gear.

This connection effects the synchronous, respectively simultaneous central motion of the movable clamping jaw over the entire clamping stroke, regardless of clamping force and clamping span.

# RKK with SA / SGN jaws



They are primarily used with modern CNC milling machines and machining centers requiring a high degree of accuracy. Clamping possible on 3 sides.

**RKK size 1: Clamping system mechanical-hydraulic with power transmitter, manually operated; with stepped jaws**  
**RKK sizes 2 to 5: Clamping system mechanical-mechanical with power transmitter, manually operated; with standard jaws SA and normal jaw SGN**

Compact and solid construction makes RÖHM NC-compact vices stand out.

**Technical features:**

- the solid steel body and all guide surfaces are hardened and ground on all sides
- locking pin with clamping force presetting
- mounting thread for workpiece stop
- clamping surface for clamping claws
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured

**Customer advantage:**

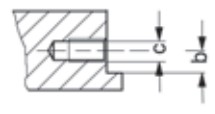
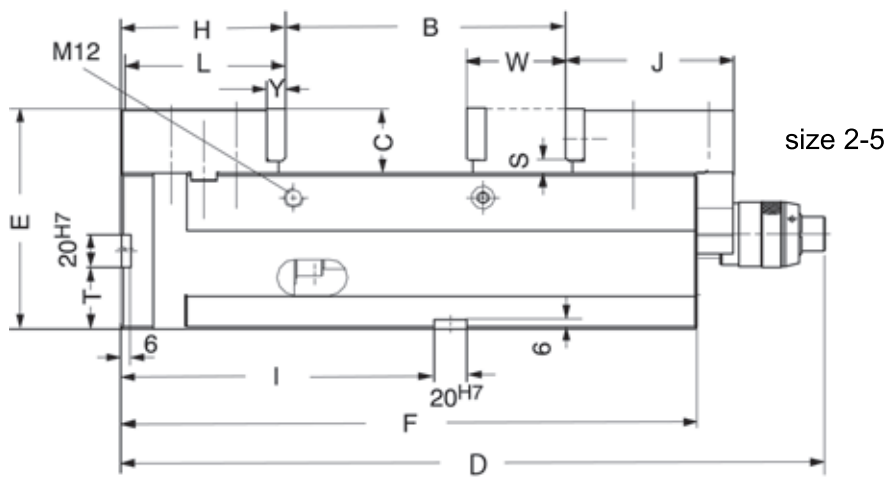
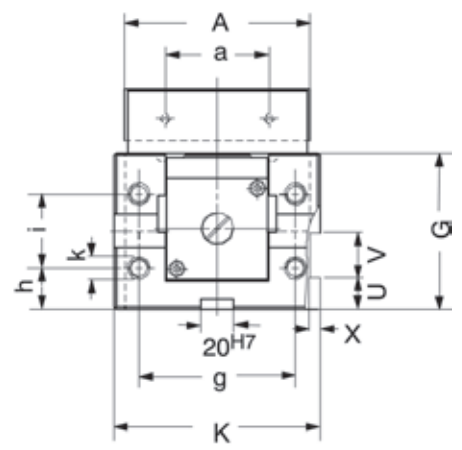
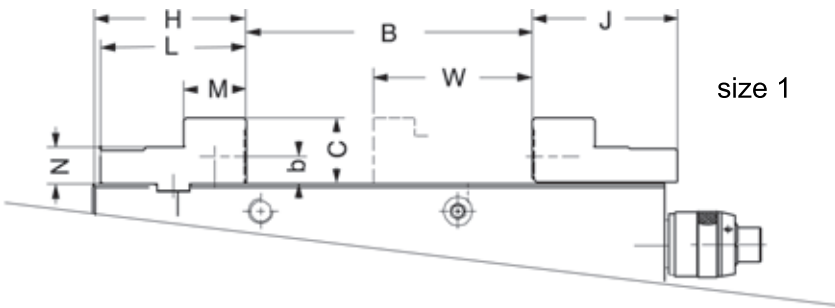
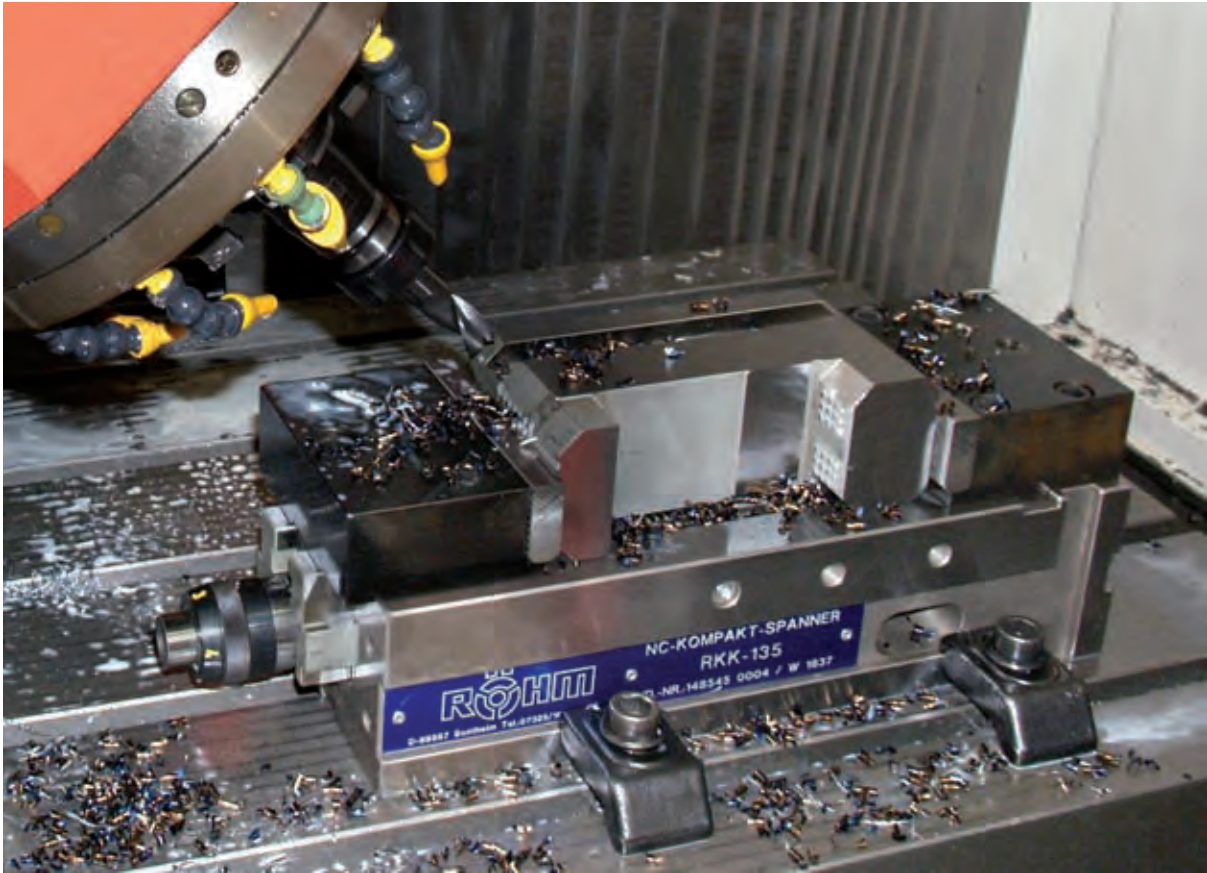
- non-deformable design for very high clamping accuracy
- size 1: long clamping slide with diagonal offset, hardened on all sides, function surfaces ground
- size 2-5: long clamping slide with tothing

Tool group A32  
 Type 743-10 RKK  
 with standard jaws SA and  
 SGN normal jaw

| Item no.            | 162640 <sup>1)</sup> ■ | 148681 ■ | 151342 ■ | 148545 ■ | 148682 ■ | 149371 ■ |
|---------------------|------------------------|----------|----------|----------|----------|----------|
| Size                | 1                      | 2        | 2a       | 3        | 4        | 5        |
| Jaw width A         | 92                     | 113      | 113      | 135      | 160      | 200      |
| Clamping capacity B | 0-138                  | 0-170    | 0-170    | 0-215    | 0-340    | 0-340    |
| C                   | 32                     | 39       | 39       | 49       | 60       | 70       |
| D                   | 330                    | 424      | 424      | 483      | 618      | 618      |
| E                   | 112                    | 133      | 133      | 148      | 179      | 189      |
| F                   | 276                    | 350      | 350      | 400      | 525      | 525      |
| G <sub>-0,02</sub>  | 80                     | 95       | 95       | 100      | 120      | 120      |
| H <sub>-0,05</sub>  | 73                     | 100      | 100      | 110,5    | 130      | 130      |
| J                   | 70                     | 102      | 102      | 102      | 110      | 110      |
| K                   | 94                     | 125      | 125      | 150      | 205      | 205      |
| L                   | 70                     | 99       | 99       | 109      | 128      | 128      |
| M                   | 30                     | -        | -        | -        | -        | -        |
| N                   | 18                     | -        | -        | -        | -        | -        |
| S                   | -                      | 74       | 74       | 9,4      | 10,4     | 74       |
| T <sub>-0,02</sub>  | 30                     | 37,5     | 37,5     | 40       | 50       | 50       |
| U                   | 20                     | 20       | 20       | 20       | 20       | 20       |
| V                   | 20                     | 40       | 40       | 40       | 40       | 40       |
| W                   | 68                     | 125      | 125      | 168      | 235      | 235      |
| X                   | 4,5                    | 6,5      | 6,5      | 6,5      | 6,5      | 6,5      |
| Y                   | -                      | 11,6     | 11,6     | 15,6     | 15,6     | 19,6     |
| Clamping travel     | 70                     | 50       | 50       | 60       | 108      | 108      |
| a                   | 63                     | 63       | 63       | 80       | 100      | 125      |
| b                   | 13,6                   | 13,6     | 13,6     | 15,6     | 19,6     | 24,6     |
| c                   | M6x11                  | M6x12    | M6x12    | M8x13    | M8x13    | M10x15   |
| g                   | 70                     | 95       | 95       | 110      | 145      | 145      |
| h                   | 20                     | 25       | 25       | 22,5     | 20       | 20       |
| i                   | 40                     | 45       | 45       | 55       | 80       | 80       |
| k                   | M10x12                 | M12x20   | M12x20   | M12x22   | M16x20   | M16x20   |
| l <sub>-0,02</sub>  | 140                    | 190      | 190      | 240      | 365      | 365      |
| Clamping force kN   | 25                     | 30       | 40       | 40       | 60       | 60       |
| Weight kg           | 15                     | 35       | 35       | 50       | 107      | 108      |

1) With stepped jaws

**RKK with SA / SGN jaws**



## Accessories RKK

Tool group A37  
Type 743-51 **Stepped jaws SB**  
reversible

| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 162627 <span style="color: yellow;">■</span> | set                  | 1    | 92    | 32     |



Tool group A37  
Type 743-50  
**Standard top jaws SA**  
reversible, for use in conjunction  
with bolt-on jaws, with mounting  
screws

| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 149233 <span style="color: yellow;">■</span> | set                  | 2/2a | 109   | 39     |
| 149236 <span style="color: yellow;">■</span> | set                  | 3    | 132   | 49     |
| 149373 <span style="color: yellow;">■</span> | set                  | 4    | 157   | 60     |
| 149374 <span style="color: yellow;">■</span> | set                  | 5    | 197   | 70     |



Tool group A37  
Type 743-70 **Carrier jaws TB**  
reversible, for use in conjunction  
with pronged inserts or special  
jaws, with mounting screws

| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 148687 <span style="color: yellow;">■</span> | set                  | 2/2a | 110   | 25     |
| 147748 <span style="color: yellow;">■</span> | set                  | 3    | 135   | 30     |
| 148688 <span style="color: yellow;">■</span> | set                  | 4    | 160   | 30     |
| 149384 <span style="color: yellow;">■</span> | set                  | 5    | 200   | 30     |



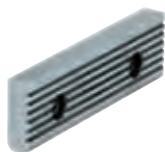
Tool group A37  
Type 726-74 **Pronged insert KRE**  
for carrier jaws 743-70  
with fixing screw

| Item no.                                    | Contents of delivery | Size         | Width | Height |
|---|----------------------|--------------|-------|--------|
| 146070 <span style="color: green;">●</span> | piece                | 1/2/3/4/5/2a | 30    | 20     |



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 |
|---|----------------------|------|-------|--------|
| 152752 <span style="color: green;">●</span> | piece                | 1    | 92    | 31,6   |
| 152753 <span style="color: green;">●</span> | piece                | 2/2a | 113   | 31,6   |
| 152754 <span style="color: green;">●</span> | piece                | 3    | 135   | 39,6   |
| 152755 <span style="color: green;">●</span> | piece                | 4    | 160   | 49,6   |
| 152759 <span style="color: green;">●</span> | piece                | 5    | 200   | 62,6   |



## Accessories RKK

| Tool group A37<br>Type 721<br><b>Normal jaw fine checkered SGNf</b><br>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 |
|--|----------|----------------------|------|-------|--------|
|  | 163218 ● | piece                | 1    | 92    | 31,6   |
|  | 156195 ■ | piece                | 2/2a | 113   | 31,6   |
|  | 156196 ● | piece                | 3    | 135   | 39,6   |
|  | 156197 ● | piece                | 4    | 160   | 49,6   |
|  | 156198 ■ | piece                | 5    | 200   | 62,6   |



| Tool group A37<br>Type 721 <b>V-jaw SPR</b><br>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 |
|  | 128770 ● | piece                | 1    | 92    | 31,6   | 3-13           | 5-32     |
|  | 082362 ● | piece                | 2/2a | 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     |
|  | 082365 ● | piece                | 5    | 200   | 62,6   | 6-37           | 8-56     |



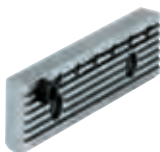
| Tool group A37<br>Type 721 <b>Draw-down jaws SNF</b><br>with spring plate, hardened and ground | Item no. | Contents of delivery | Size | Width | Height |
|--|----------|----------------------|------|-------|--------|
|  | 077104 ■ | set                  | 2/2a | 113   | 31,6   |
|  | 077105 ● | set                  | 3    | 135   | 39,6   |
|  | 077106 ● | set                  | 4    | 160   | 49,6   |
|  | 077107 ■ | set                  | 5    | 200   | 62,6   |



| Tool group A37<br>Type 728-00<br><b>V-jaw and standard jawSBO</b><br>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                  | 2/2a | 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     |

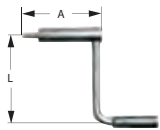


| Tool group A37<br>Type 721-52 <b>Normal jaw SGNA</b><br>with movable workpiece locator, hardened and ground; only suitable for twin-clamping | Item no. | Contents of delivery | Size | Width | Height |
|--|----------|----------------------|------|-------|--------|
|  | 150739 ■ | piece                | 2/2a | 113   | 31,6   |
|  | 150740 ■ | piece                | 3    | 135   | 39,6   |
|  | 150741 ■ | piece                | 4    | 160   | 49,6   |



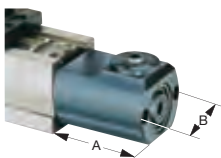
# Accessories RKK

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



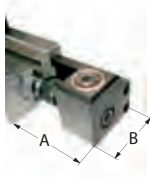
| Item no. | Contents of delivery | Size       | Hexagon | A   | L   |
|----------|----------------------|------------|---------|-----|-----|
| 134198 ● | piece                | 1          | 12      | 60  | 90  |
| 134600 ● | piece                | 2/3/4/5/2a | 14      | 104 | 160 |

Tool group A37  
Type 743-19 **90° Angle drive**  
for RKK 92 / RKE-L 92  
for fastening to NC-compact vices,  
ideal for side-mounted clamping  
jaws or for large machine tables



| Item no. | Contents of delivery | Size | A     | B  | C    |
|----------|----------------------|------|-------|----|------|
| 154185 ■ | piece                | 92   | 113,5 | 90 | 83,5 |

Tool group A37  
Type 743-19 **90° Angle drive**  
for RKK 2-5

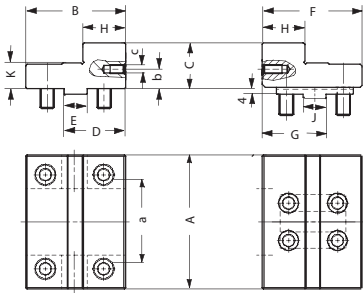


| Item no. | Contents of delivery | Size | A   | B    | C  |
|----------|----------------------|------|-----|------|----|
| 151650 ■ | piece                | 2/2a | 154 | 93,5 | 98 |
| 151651 ■ | piece                | 3    | 161 | 101  | 98 |
| 151652 ■ | piece                | 4/5  | 174 | 111  | 98 |



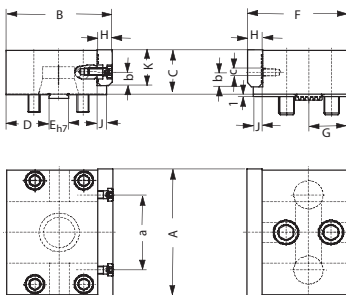
# Clamping jaw dimensions for RKK

Type 743 - 51 SB  
Stepped jaws, reversible



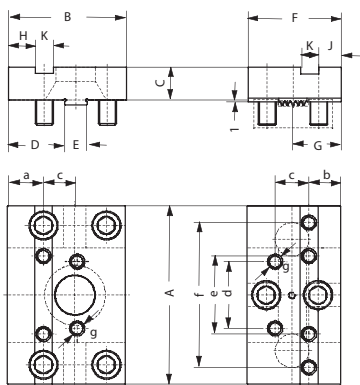
| Size            | 1    |
|-----------------|------|
| A               | 92   |
| B               | 70   |
| C               | 32   |
| D               | 43   |
| E <sub>h7</sub> | 16   |
| F               | 70   |
| G               | 45   |
| H               | 30   |
| J <sub>g6</sub> | 16   |
| K               | 18   |
| a               | 63   |
| b               | 13,6 |
| c               | M6   |

Type 743 - 50 SA  
SA standard top jaws, reversible



| Size            | 2    | 3    | 4    | 5    |
|-----------------|------|------|------|------|
| A               | 113  | 135  | 160  | 200  |
| B               | 99   | 109  | 128  | 128  |
| C               | 39   | 49   | 60   | 70   |
| D               | 41,5 | 44   | 50   | 50   |
| E <sub>h7</sub> | 16   | 20   | 20   | 20   |
| F               | 102  | 102  | 110  | 110  |
| G               | 38   | 39   | 42   | 42   |
| H               | 11,6 | 15,6 | 15,6 | 19,6 |
| J               | 76   | 9,6  | 9,6  | 13,6 |
| K               | 31,6 | 39,6 | 49,6 | 62,6 |
| a               | 63   | 80   | 100  | 125  |
| b               | 13,6 | 15,6 | 19,6 | 24,6 |
| c               | M6   | M8   | M8   | M10  |

Type 743 - 70 TB  
Carrier jaws, reversible



| Size            | 2   | 3   | 4   | 5   |
|-----------------|-----|-----|-----|-----|
| A               | 110 | 135 | 160 | 200 |
| B               | 90  | 95  | 105 | 105 |
| C               | 25  | 30  | 30  | 30  |
| D               | 41  | 44  | 50  | 50  |
| E <sub>h7</sub> | 16  | 20  | 20  | 20  |
| F               | 83  | 83  | 83  | 83  |
| G               | 43  | 43  | 43  | 43  |
| H               | 41  | 21  | 24  | 24  |
| J               | 20  | 20  | 20  | 20  |
| K <sub>H7</sub> | 16  | 16  | 16  | 16  |
| a               | 49  | 29  | 32  | 32  |
| b               | 28  | 28  | 28  | 28  |
| c               | 25  | 25  | 30  | 30  |
| d               | 50  | 60  | 70  | 70  |
| e               | 80  | 60  | 70  | 110 |
| f               | -   | 110 | 130 | 160 |
| g               | M12 | M12 | M12 | M12 |

## Clamping ranges: External clamping RKK

| Size | SN with SNS | SN reversed | Carrier jaws with pronged inserts | Carrier jaws with pronged inserts | Stepped jaw<br>Stepped jaw, reversed |
|------|-------------|-------------|-----------------------------------|-----------------------------------|--------------------------------------|
| 1    | -           | -           | -                                 | -                                 | B <sub>9</sub>                       |
| 2+2a | 0-170       | 35-206      | 59-233                            | 89-263                            | B <sub>10</sub>                      |
| 3    | 0-215       | 29-255      | 30-257                            | 110-337                           |                                      |
| 4+5  | 0-340       | 48-386      | 59-395                            | 144-481                           |                                      |



Especially used on CNC-machines. With the DUO clamping tower exists the possibility to clamp two NC compact vices, face mounting back to back.

**Clamping system mechanical-mechanical with power transmitter, manually operated**  
**Horizontal, vertical or side mounting.**

**Technical features:**

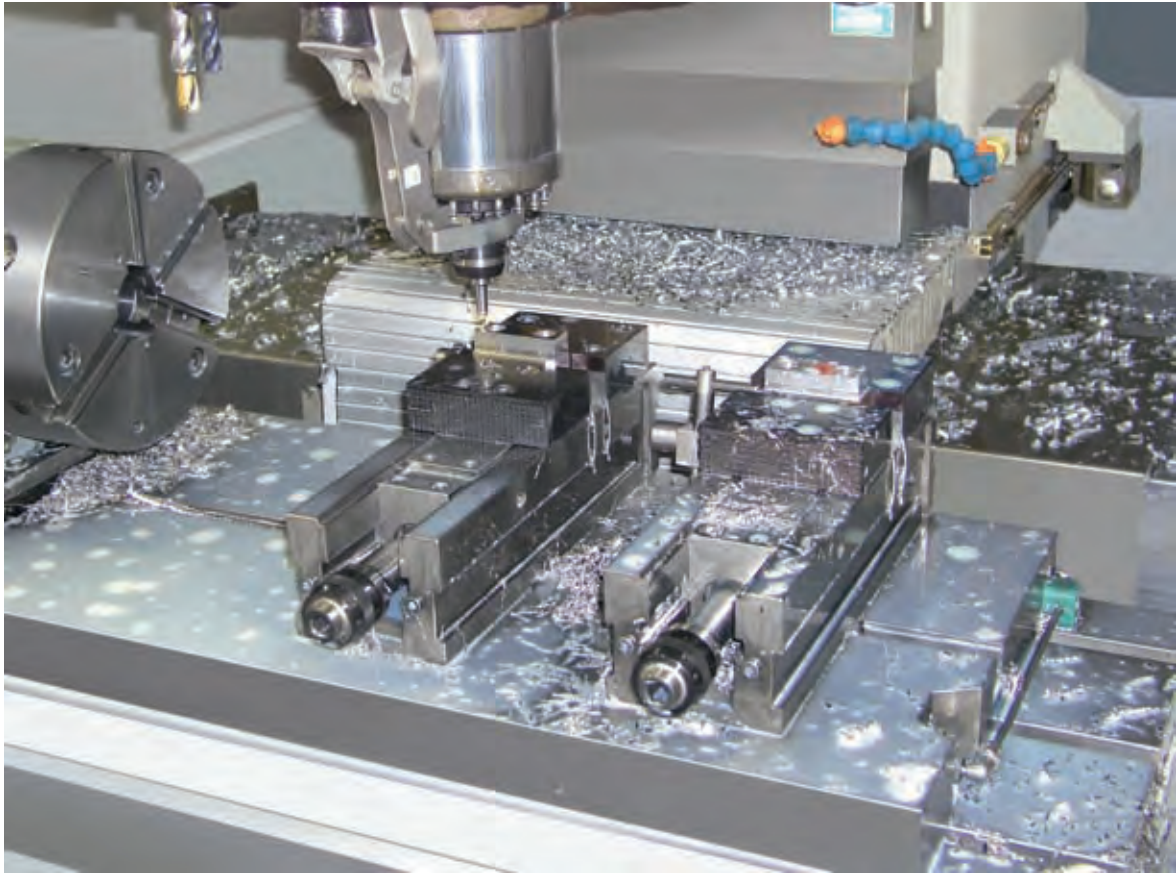
- the solid steel body and all guide surfaces are hardened and ground on all sides
- long clamping slide with clutch, hardened on all sides, function surfaces ground
- locking pin with clamping force presetting
- clamping surface for clamping claws
- solid chip guard prevents chips from penetrating the inside of the body

**Customer advantage:**

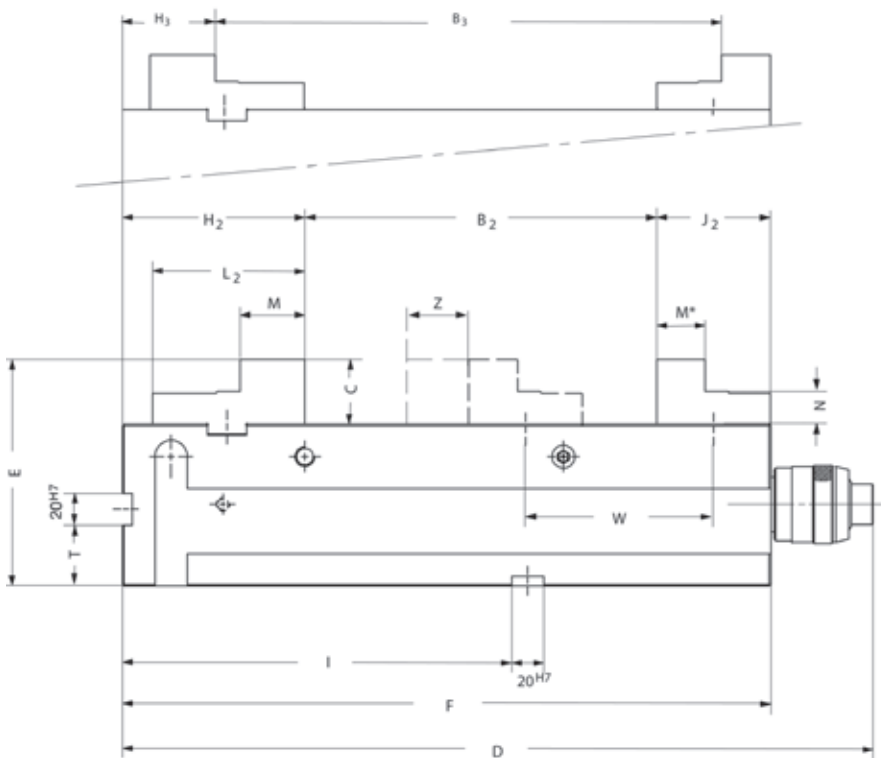
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured
- thread-bore for receiving all RÖHM flat-clamping jaws with jaw width 125/160mm
- thread for fastening angle drive

Tool group A32  
 Type 743-10 RKE  
 with stepped jaws or standard clamping jaws

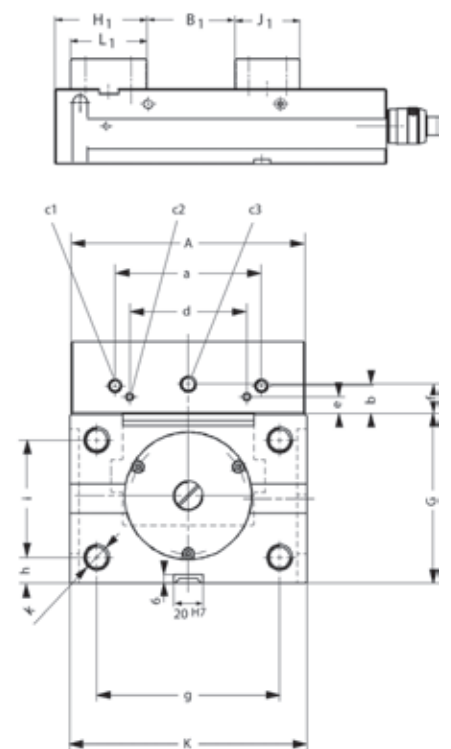
| Item no.            | 160342 ●     | 162648 ●     | 162646 ●               | 162647 ■               |
|---------------------|--------------|--------------|------------------------|------------------------|
| Jaw width A         | 125          | 160          | 125                    | 160                    |
| Jaw design          | stepped jaws | stepped jaws | standard clamping jaws | standard clamping jaws |
| B1                  | -            | -            | 0-215                  | 0-320                  |
| B2                  | 0 - 216      | 0 - 320      | -                      | -                      |
| B3                  | 97 - 312     | 131 - 451    | -                      | -                      |
| C                   | 40           | 50           | 40                     | 50                     |
| D                   | 463          | 618          | 463                    | 618                    |
| F                   | 400          | 530          | 400                    | 530                    |
| G <sub>-0,02</sub>  | 100          | 115          | 100                    | 115                    |
| H1 <sub>-0,05</sub> | -            | -            | 110,5                  | 130                    |
| H2 <sub>-0,05</sub> | 112,5        | 130          | -                      | -                      |
| H3 <sub>-0,05</sub> | 56,5         | 64           | -                      | -                      |
| J1                  | -            | -            | 78                     | 100                    |
| J2                  | 70           | 97           | -                      | -                      |
| K                   | 126          | 162          | 126                    | 162                    |
| L1                  | -            | -            | 92                     | 100                    |
| L2                  | 94           | 98           | -                      | -                      |
| M                   | 40           | 34           | -                      | -                      |
| M*                  | 30           | 32,5         | 30                     | 32,5                   |
| N <sub>-0,01</sub>  | 20           | 25           | -                      | -                      |
| T <sub>-0,02</sub>  | 37,5         | 47,5         | 37,5                   | 47,5                   |
| W                   | 1 x 108      | 2 x 102,5    | 1 x 108                | 2 x 102,5              |
| Z                   | 109          | 117          | 109                    | 117                    |
| a                   | 80           | 100          | 80                     | 100                    |
| b                   | 15,6         | 19,6         | 15,6                   | 19,6                   |
| c1                  | M8x14        | M8x14        | M8x14                  | M8x14                  |
| c2                  | M5x10        | M5x10        | M5x10                  | M5x10                  |
| c3                  | M10x18       | M10x18       | M10x18                 | M10x18                 |
| d                   | 60           | 80           | 60                     | 80                     |
| e                   | 12           | 12           | 12                     | 12                     |
| f                   | 18           | 20           | 18                     | 20                     |
| g                   | 95           | 125          | 95                     | 125                    |
| h                   | 25           | 175          | 25                     | 175                    |
| i                   | 45           | 80           | 45                     | 80                     |
| k                   | M 12 x 22    | M 16 x 25    | M 12 x 22              | M 16 x 25              |
| l <sub>-0,02</sub>  | 240          | 200          | 240                    | 200                    |
| Clamping force kN   | 40           | 60           | 40                     | 60                     |
| Weight kg           | 41           | 79           | 41                     | 79                     |



stepped jaws



standard jaws



## Accessories RKE

Tool group A37  
Type 743-50  
**Standard top jaws SA**  
reversible



| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 162628 ● | set                  | 125  | 125   | 40     |
| 162629 ● | set                  | 160  | 160   | 50     |

Tool group A37  
Type 743-51 **Stepped jaws SB**  
reversible



| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 160343 ● | set                  | 125  | 125   | 40     |
| 162630 ● | set                  | 160  | 160   | 50     |

Tool group A37  
Type 743-72 **Carrier jaws TB**  
without swivelling claw inserts



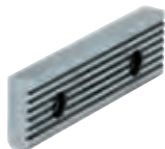
| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 165856 ● | set                  | 125  | 125   | 20     |
| 166218 ● | set                  | 160  | 160   | 25     |

Tool group A37  
Type 743-74  
**Swivelling pronged inserts**  
for carrier jaws 743-72



| Item no. | Contents of delivery | Size | Ø  | Height |
|----------|----------------------|------|----|--------|
| 165854 ● | piece                | 125  | 28 | 10     |
| 166216 ● | piece                | 160  | 30 | 10     |

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 |
|----------|----------------------|------|-------|--------|
| 158897 ● | set                  | 125  | 125   | 39,7   |
| 152755 ● | piece                | 160  | 160   | 49,6   |

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 |
|----------|----------------------|------|-------|--------|
| 163225 ● | set                  | 125  | 125   | 39,7   |
| 156197 ● | piece                | 160  | 160   | 49,6   |

## Accessories RKE

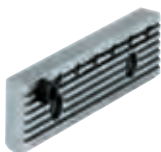
Tool group A37  
Type 721 **V-jaw SPR**  
with vertical and horizontal ground  
V's, hardened, for use in  
combination with SGN;  
only suitable for twin-clamping

| Item no. | Contents of delivery | Size | Width | Height | Clamping range |          |
|----------|----------------------|------|-------|--------|----------------|----------|
|          |                      |      |       |        | Horizontal     | Vertical |
| 082363 ● | piece                | 125  | 135   | 39,6   | 4-20           | 6-40     |
| 082364 ● | piece                | 160  | 160   | 49,6   | 5-29           | 7-48     |



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 |
|----------|----------------------|------|-------|--------|
| 150740 ■ | piece                | 125  | 135   | 39,6   |
| 150741 ■ | piece                | 160  | 160   | 49,6   |



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

| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 077105 ● | set                  | 125  | 135   | 39,6   |
| 077106 ● | set                  | 160  | 160   | 49,6   |



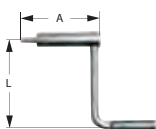
Tool group A37  
Type 728-00  
**V-jaw and standard jawSBO**  
soft and gunmetal-finished, with  
work support; for BOF and BSS

| Item no. | Contents of delivery | Size | Width | Height | Clamping range |          |
|----------|----------------------|------|-------|--------|----------------|----------|
|          |                      |      |       |        | Horizontal     | Vertical |
| 317260 ● | set                  | 125  | 135   | 39,8   | 3-13           | 6-40     |
| 317261 ● | set                  | 160  | 160   | 49,8   | 5-22           | 7-48     |



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

| Item no. | Contents of delivery | Size    | Hexagon | A   | L   |
|----------|----------------------|---------|---------|-----|-----|
| 134600 ● | piece                | 125/160 | 14      | 104 | 160 |

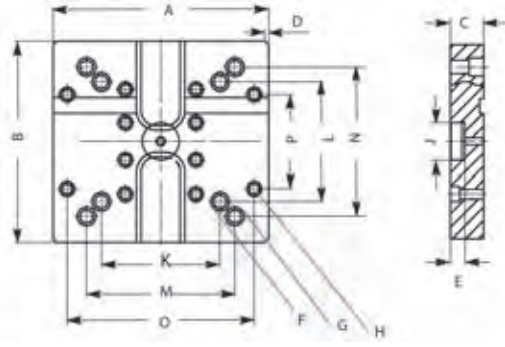


Tool group A37  
Type 743-19  
**90° Angle drive**

| Item no. | Contents of delivery | Size | A   | B   | C  |
|----------|----------------------|------|-----|-----|----|
| 158339 ● | piece                | 125  | 133 | 106 | 98 |
| 158888 ● | piece                | 160  | 166 | 111 | 98 |



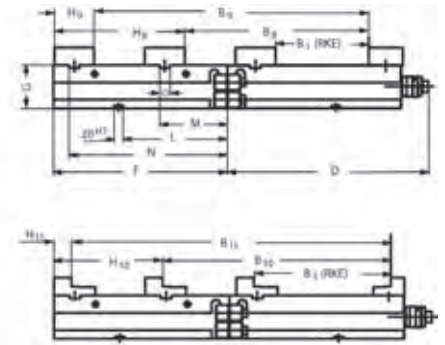
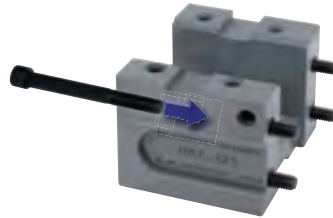
# Special Accessories RKK / RKE



Tool group A37  
Type 743-10  
**Standard basic plate GP**  
for DUO-Tower  
for NC compact vices

| Item no. | For  | A   | B   | C  | D     | E  | F     | G     | H     | J  | K   | L   | M   | N   | O   | P   | Weight kg |
|----------|--|-----|-----|----|-------|----|-------|-------|-------|----|-----|-----|-----|-----|-----|-----|-----------|
| 164016 ▲ | RKD 92 /<br>RKD-M 92                           | 250 | 250 | 45 | 5x45° | 20 | KM 12 | KM 16 | KM 16 | 50 | 126 | 126 | 160 | 160 | 200 | 200 | 24        |
| 164018 ▲ | RKK 92 /<br>RKE 92                             | 250 | 250 | 45 | 5x45° | 20 | KM 12 | KM 16 | KM 16 | 50 | 126 | 126 | 160 | 160 | 200 | 200 | 24        |
| 164020 ▲ | RKK 113 /<br>RKE 125 /<br>RKD 125 /<br>RKZ 125 | 290 | 270 | 45 | 5x45° | 20 | KM 16 | KM 16 | KM 12 | 50 | 160 | 160 | 200 | 200 | 252 | 126 | 29        |
| 164022 ▲ | RKK 135  | 290 | 270 | 45 | 5x45° | 20 | KM 16 | KM 16 | KM 12 | 50 | 200 | 200 | 240 | 240 | 252 | 126 | 29        |
| 164024 ▲ | RKK 160 /<br>RKK 200                           | 350 | 350 | 45 | 5x45° | 20 | KM 16 | KM 12 | KM 16 | 50 | 240 | 160 | 252 | 252 | 300 | 300 | 45        |
| 164026 ▲ | RKE 160 /<br>(RKE 200)                         | 350 | 350 | 45 | 5x45° | 20 | KM 16 | KM 12 | KM 16 | 50 | 240 | 160 | 252 | 252 | 300 | 300 | 45        |

Special accessories  
RKK / RKE

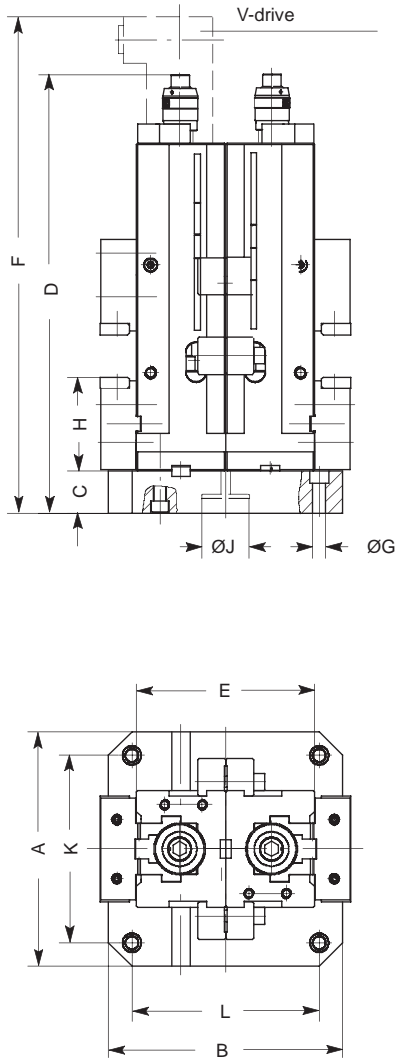


Tool group A37  
Type 743-10  
**Extension GKV** for extension of  
clamping capacity for extra-long  
workpieces (**only RKE**)  
fastening with dual clamps  
respectively with screws (included)

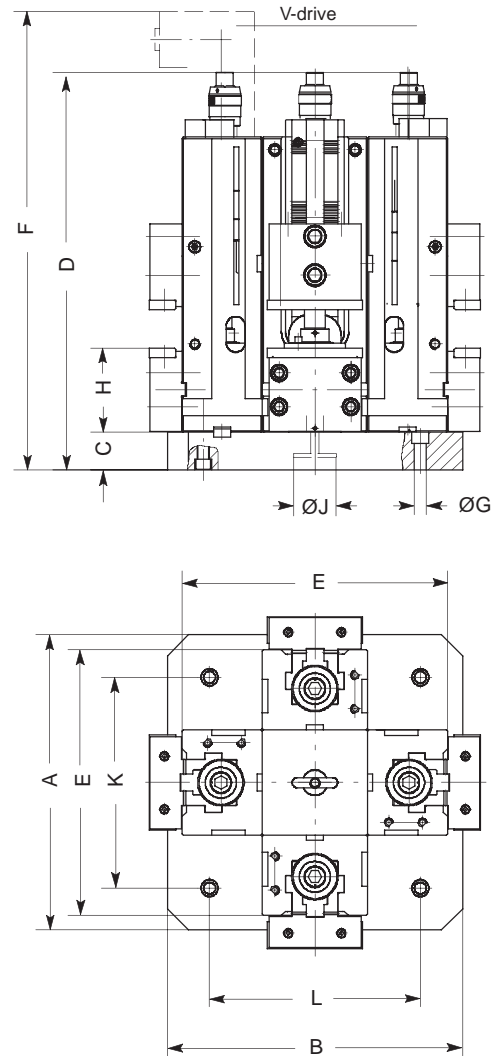
| Item no. | For     | D   | F   | G   | L   | M   | N   | O  | B1    | B3      | B8      | B9      | B10     | B11      | H8  | H9  | H10 | H11 | Fixing      |       | Weight kg |
|----------|---------|-----|-----|-----|-----|-----|-----|----|-------|---------|---------|---------|---------|----------|-----|-----|-----|-----|-------------|-------|-----------|
|          |         |     |     |     |     |     |     |    |       |         |         |         |         |          |     |     |     |     | Dual clamps | Screw |           |
| 164118 ■ | RKE 125 | 463 | 105 | 100 | -   | -   | 68  | 24 | 0-215 | 97-312  | -       | 121-335 | -       | 218-432  | -   | 95  | -   | 41  |             | •     | 6,5       |
| 164120 ■ | RKE 125 | 463 | 200 | 100 | -   | -   | 160 | 24 | 0-215 | 97-312  | -       | 213-427 | -       | 310-524  | -   | 98  | -   | 44  |             | •     | 13        |
| 158436 ■ | RKE 125 | 463 | 400 | 100 | 240 | 156 | 364 | 24 | 0-215 | 97-312  | 208-422 | 416-630 | 306-520 | 514-728  | 302 | 94  | 248 | 40  | •           |       | 26        |
| 164122 ■ | RKE 160 | 618 | 190 | 115 | -   | -   | 150 | 30 | 0-320 | 131-451 | -       | 215-535 | -       | 346-666  | -   | 105 | -   | 39  | •           |       | 18        |
| 164124 ■ | RKE 160 | 618 | 295 | 115 | -   | -   | 253 | 30 | 0-320 | 131-451 | -       | 318-638 | -       | 449-769  | -   | 107 | -   | 41  | •           |       | 27        |
| 158911 ■ | RKE 160 | 618 | 530 | 115 | 200 | 225 | 493 | 30 | 0-320 | 131-451 | 290-605 | 560-875 | 421-736 | 681-1006 | 370 | 102 | 304 | 36  | •           |       | 49        |

# Duo and Quatro clamping towers RKK and RKE

Duo clamping towers (on request)



Quatro clamping towers (on request)



Technical data

| Size      | RKK 92 | RKK 113 RKK 113a | RKK 135 | RKK 160 | RKK 200 | RKE 125 | RKE 160 RKE 200 |
|-----------|--------|------------------|---------|---------|---------|---------|-----------------|
| Jaw width | 92     | 113              | 135     | 160     | 200     | 125     | 160             |
| A         | 250    | 250              | 290     | 350     | 350     | 250     | 350             |
| B         | 250    | 250              | 270     | 350     | 350     | 250     | 350             |
| C         | 45     | 45               | 45      | 45      | 45      | 45      | 45              |
| D         | 375    | 469              | 528     | 663     | 663     | 508     | 663             |
| E         | 160    | 190              | 200     | 240     | 240     | 200     | 230             |
| F         | 435    | 549              | 606     | 744     | 744     | 578     | 741             |
| G*        |        |                  |         |         |         |         |                 |
| H         | 73     | 100              | 110,5   | 130     | 130     | 110,5   | 130             |
| J*        |        |                  |         |         |         |         |                 |
| K*        |        |                  |         |         |         |         |                 |
| L*        |        |                  |         |         |         |         |                 |
| kg        | 50     | 90               | 125     | 260     | 260     | 105     | 200             |

\* On inquiry insert dimensions please

Technical data

| Size      | RKK 92 | RKK 113 RKK 113a | RKK 135 | RKK 160 | RKK 200 | RKE 125 | RKE 160 RKE 200 |
|-----------|--------|------------------|---------|---------|---------|---------|-----------------|
| Jaw width | 92     | 113              | 135     | 160     | 200     | 125     | 160             |
| A         | 320    | 350              | 400     | 500     | 500     | 350     | 400             |
| B         | 320    | 350              | 400     | 500     | 500     | 350     | 400             |
| C         | 45     | 45               | 45      | 45      | 45      | 45      | 45              |
| D         | 375    | 469              | 528     | 663     | 663     | 508     | 663             |
| E         | 254    | 315              | 350     | 445     | 445     | 325     | 392             |
| F         | 435    | 549              | 606     | 744     | 744     | 578     | 741             |
| G*        |        |                  |         |         |         |         |                 |
| H         | 73     | 100              | 110,5   | 130     | 130     | 110,5   | 130             |
| J*        |        |                  |         |         |         |         |                 |
| K*        |        |                  |         |         |         |         |                 |
| L*        |        |                  |         |         |         |         |                 |
| kg        | 100    | 180              | 250     | 530     | 530     | 210     | 375             |

\* On inquiry insert dimensions please

**RKE-L**



Especially used on CNC-machines.  
Base mounting.

**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
- all guide surfaces are 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:**

- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured
- solid chip guard prevents chips from penetrating the inside of the body

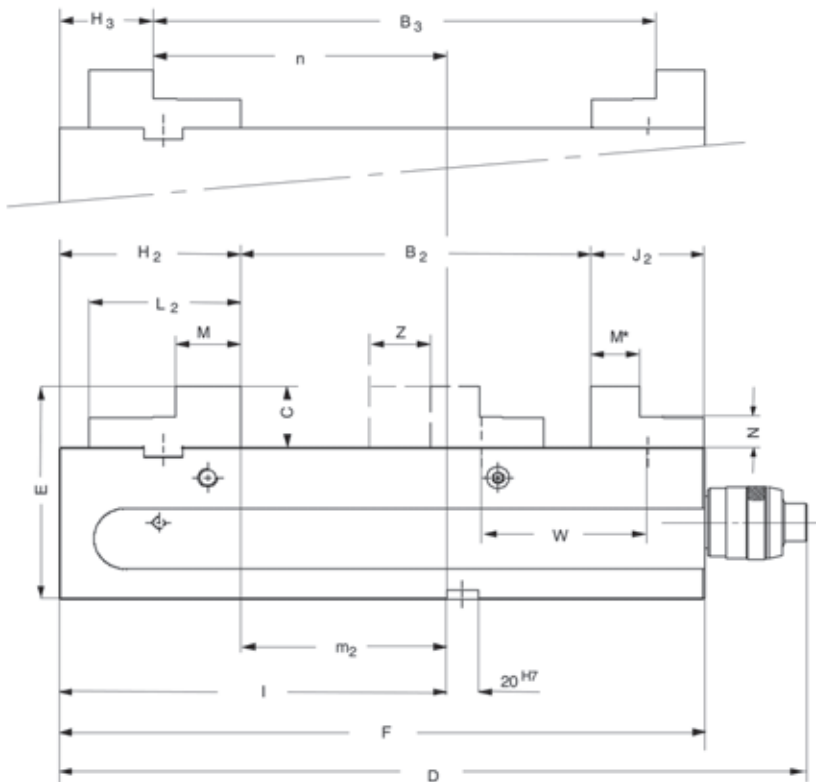
Tool group A32  
Type 743-10 RKE-L  
with stepped jaws or standard  
clamping jaws

| Item no.            | 162829 ●     | 160671 ●     | 162830 ●     | 163375 ●     | 162827 ■                       | 162828 ■                       | 163374 ■                       |
|---------------------|--------------|--------------|--------------|--------------|--------------------------------|--------------------------------|--------------------------------|
| Jaw width A         | 92           | 125          | 160          | 200          | 125                            | 160                            | 200                            |
| Jaw design          | stepped jaws | stepped jaws | stepped jaws | stepped jaws | standard clamping jaws 0 - 215 | standard clamping jaws 0 - 320 | standard clamping jaws 0 - 320 |
| B1                  | -            | -            | -            | -            | -                              | -                              | -                              |
| B2                  | 0 - 138      | 0 - 216      | 0 - 320      | 0 - 315      | -                              | -                              | -                              |
| B3                  | 71 - 208     | 97 - 312     | 131 - 451    | 131 - 451    | -                              | -                              | -                              |
| C                   | 32           | 40           | 50           | 60           | 40                             | 50                             | 60                             |
| D                   | 330          | 463          | 618          | 618          | 463                            | 618                            | 618                            |
| F                   | 276          | 400          | 530          | 530          | 400                            | 530                            | 530                            |
| G <sub>-0,02</sub>  | 80           | 100          | 115          | 115          | 100                            | 115                            | 115                            |
| H1                  | -            | -            | -            | -            | 110,5                          | 130                            | 130                            |
| H2                  | 80           | 112,5        | 130          | 135          | -                              | -                              | -                              |
| H3                  | 41           | 56,5         | 64           | 64           | -                              | -                              | -                              |
| J1                  | -            | -            | -            | -            | 78                             | 100                            | 100                            |
| J2                  | 56           | 70           | 97           | 97           | -                              | -                              | -                              |
| K                   | 94           | 126          | 162          | 162          | 126                            | 162                            | 162                            |
| L1                  | -            | -            | -            | -            | 92                             | 100                            | 105                            |
| L2                  | 64           | 94           | 98           | 103          | -                              | -                              | -                              |
| M                   | 25           | 40           | 34           | 39           | -                              | -                              | -                              |
| M*                  | 25           | 30           | 32,5         | 32,5         | -                              | -                              | -                              |
| N <sub>-0,01</sub>  | 16           | 20           | 25           | 25           | -                              | -                              | -                              |
| W                   | 68           | 1x108        | 2x102,5      | 2x102,5      | 1x108                          | 2x102,5                        | 2x102,5                        |
| Z                   | 70           | 109          | 117          | 117          | 109                            | 117                            | 117                            |
| a                   | 63           | 80           | 100          | 125          | 80                             | 100                            | 125                            |
| b                   | 13,6         | 15,6         | 19,6         | 24,6         | 15,6                           | 19,6                           | 24,6                           |
| c1                  | M 6x14       | M 8x14       | M 8x14       | M 10x15      | M 8x14                         | M 8x14                         | M 10x15                        |
| c2                  | M 5x9        | M 5x10       | M 5x9        | M 5x10       | M 5x10                         | M 5x9                          | M 5x10                         |
| c3                  | M 10x16      | M 10x18      | M 10x18      | M 14x20      | M 10x18                        | M 10x18                        | M 14x20                        |
| d                   | 48           | 60           | 80           | 110          | 60                             | 80                             | 110                            |
| e                   | 8            | 12           | 12           | 12           | 12                             | 12                             | 12                             |
| f                   | 14           | 18           | 20           | 25           | 18                             | 20                             | 25                             |
| l                   | 140          | 240          | 200          | 200          | 240                            | 200                            | 200                            |
| m1 <sub>-0,02</sub> | -            | -            | -            | -            | 129,5                          | 70                             | 65                             |
| m2 <sub>-0,02</sub> | 60           | 127,5        | 70           | 65           | -                              | -                              | -                              |
| n <sub>-0,02</sub>  | 99           | 183,5        | 136          | 136          | -                              | -                              | -                              |
| Clamping force kN   | 25           | 40           | 60           | 60           | 40                             | 60                             | 60                             |
| Weight kg           | 15           | 41           | 79           | 85           | 41                             | 79                             | 85                             |

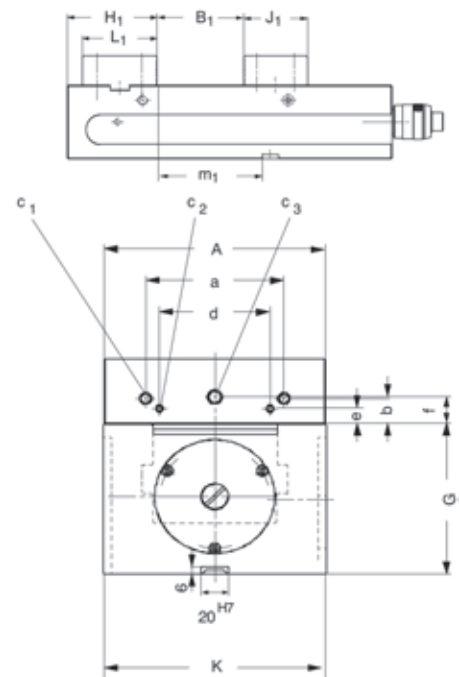




stepped jaws



standard jaws



## Accessories RKE-L

Tool group A37  
Type 743-50  
**Standard top jaws SA**  
reversible



| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 162628 ● | set                  | 125  | 125   | 40     |
| 162629 ● | set                  | 160  | 160   | 50     |
| 162984 ● | set                  | 200  | 200   | 60     |

Tool group A37  
Type 743-51 **Stepped jaws SB**  
reversible



| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 162851 ● | set                  | 92   | 92    | 32     |
| 160343 ● | set                  | 125  | 125   | 40     |
| 162630 ● | set                  | 160  | 160   | 50     |
| 162985 ● | set                  | 200  | 200   | 60     |

Tool group A37  
Type 743-72 **Carrierja wsTB**  
without swivelling claw inserts



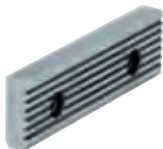
| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 165856 ● | set                  | 125  | 125   | 20     |
| 166218 ● | set                  | 160  | 160   | 25     |

Tool group A37  
Type 743-74  
**Swivelling pronged inserts**  
for carrier jaws 743-72



| Item no. | Contents of delivery | Size | Ø  | Height |
|----------|----------------------|------|----|--------|
| 165854 ● | piece                | 125  | 28 | 10     |
| 166216 ● | piece                | 160  | 30 | 10     |

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 |
|----------|----------------------|------|-------|--------|
| 152752 ● | piece                | 92   | 92    | 31,6   |
| 158897 ● | set                  | 125  | 125   | 39,7   |
| 152755 ● | piece                | 160  | 160   | 49,6   |
| 152759 ● | piece                | 200  | 200   | 62,6   |

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 |
|----------|----------------------|------|-------|--------|
| 163218 ● | piece                | 92   | 92    | 31,6   |
| 163225 ● | set                  | 125  | 125   | 39,7   |
| 156197 ● | piece                | 160  | 160   | 49,6   |
| 156198 ● | piece                | 200  | 200   | 62,6   |

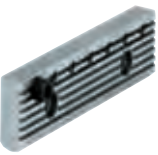
# Accessories RKE-L

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



| Item no. | Contents of delivery | Size | Width | Height | Clamping range |          |
|----------|----------------------|------|-------|--------|----------------|----------|
|          |                      |      |       |        | Horizontal     | Vertical |
| 128770 ● | piece                | 92   | 92    | 31,6   | 3-13           | 5-32     |
| 082363 ● | piece                | 125  | 135   | 39,6   | 4-20           | 6-40     |
| 082364 ● | piece                | 160  | 160   | 49,6   | 5-29           | 7-48     |
| 082365 ● | piece                | 200  | 200   | 62,6   | 6-37           | 8-56     |

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 |
|----------|----------------------|------|-------|--------|
| 150740 ■ | piece                | 125  | 135   | 39,6   |
| 150741 ■ | piece                | 160  | 160   | 49,6   |

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



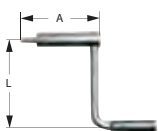
| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 077105 ● | set                  | 125  | 135   | 39,6   |
| 077106 ● | set                  | 160  | 160   | 49,6   |
| 077107 ■ | set                  | 200  | 200   | 62,6   |

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 |
| 317260 ● | set                  | 125  | 135   | 39,8   | 3-13           | 6-40     |
| 317261 ● | set                  | 160  | 160   | 49,8   | 5-22           | 7-48     |

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



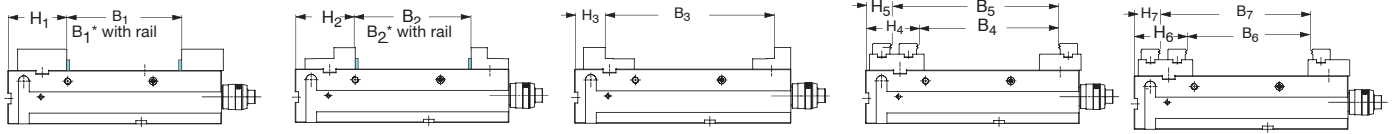
| Item no. | Contents of delivery | Size        | Hexagon | A   | L   |
|----------|----------------------|-------------|---------|-----|-----|
| 134198 ● | piece                | 92          | 12      | 60  | 90  |
| 134600 ● | piece                | 125/160/200 | 14      | 104 | 160 |

Tool group A37  
Type 743-19  
**90° Angle drive**



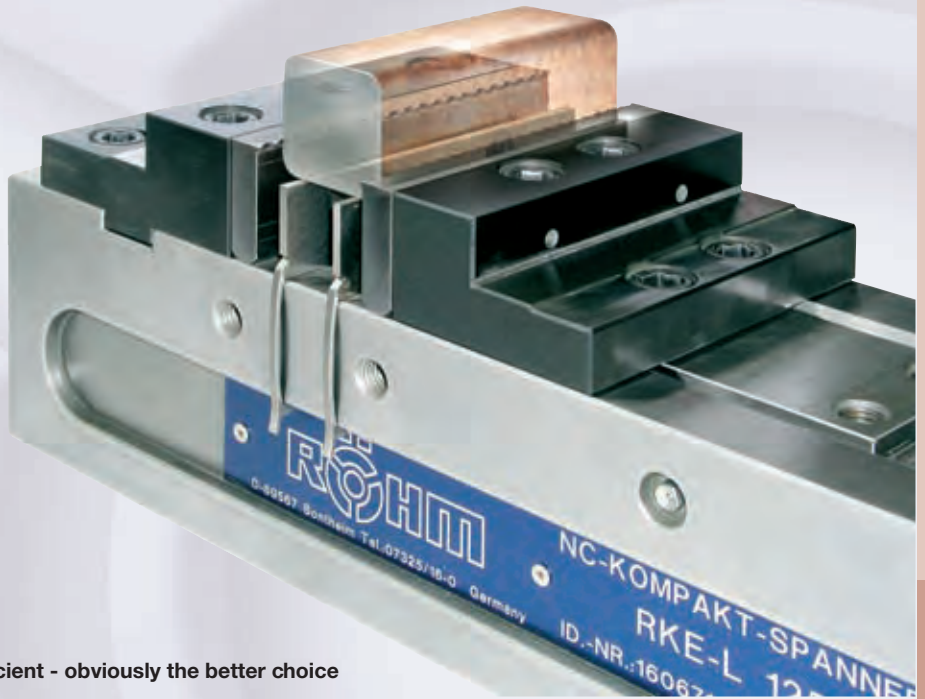
| Item no. | Contents of delivery | Size    | A     | B   | C    |
|----------|----------------------|---------|-------|-----|------|
| 154185 ■ | piece                | 92      | 113,5 | 90  | 83,5 |
| 158339 ● | piece                | 125     | 133   | 106 | 98   |
| 158888 ● | piece                | 160/200 | 166   | 111 | 98   |

# Clamping ranges RKE / RKE-L



|                      | Standard jaws |                     | Stepped jaws |                     |      |         | Carrier jaws with pronged inserts           |   |   |  |
|----------------------|---------------|---------------------|--------------|---------------------|------|---------|---|---|---|--|
|                      | H1            | B1<br>B1* with rail | H2           | B2<br>B2* with rail | H3   | B3      | H4/H5                                       | B4/B5   | H6/H7                                       | B6/B7  |
| RKE-L 92             | -             | -                   | 80           | 0-138<br>*12-138    | 41   | 71-208  | -   | -   | -   | -  |
| RKE 125<br>RKE-L 125 | 110,5         | 0-215<br>*12-215    | 112,5        | 0-216<br>*12-216    | 56,5 | 97-312  | H <sub>4</sub> : 98<br>H <sub>5</sub> : 48  | B <sub>4</sub> : 50-262<br>B <sub>5</sub> : 100-321 | H <sub>6</sub> : 98<br>H <sub>7</sub> : 48  | B <sub>6</sub> : 20-232<br>B <sub>7</sub> : 70-282 |
| RKE 160<br>RKE-L 160 | 130           | 0-320<br>*12-320    | 130          | 0-320<br>*12-320    | 64   | 131-451 | H <sub>4</sub> : 122<br>H <sub>5</sub> : 52 | B <sub>4</sub> : 67-383<br>B <sub>5</sub> : 137-453 | H <sub>6</sub> : 122<br>H <sub>7</sub> : 52 | B <sub>6</sub> : 18-334<br>B <sub>7</sub> : 88-404 |
| RKE-L 92             | 130           | 0-320<br>*12-320    | 135          | 0-315<br>*12-315    | 64   | 131-451 | -   | -   | -   | -  |

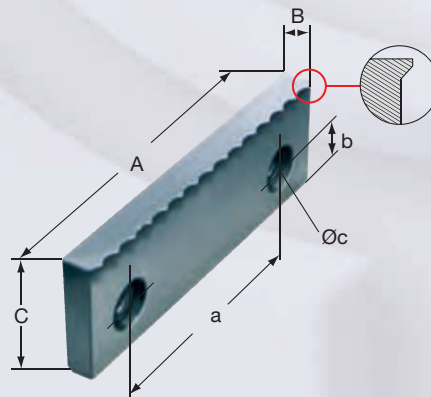
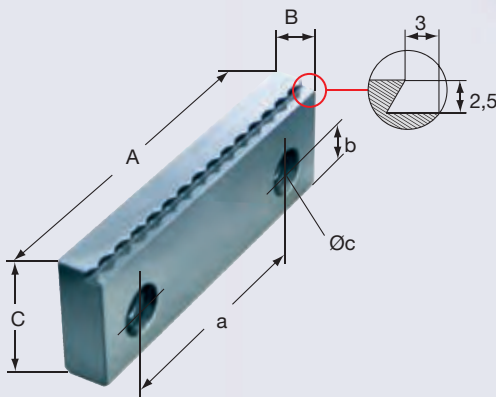
**SKB Claw jaws - the clever alternative to embossing technology**



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

Tool group A37

| Item no. Set | 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

Tool group A37

| Item no. Set | 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)  |

# RKG-L



Base mounting.  
Made in one casting.

**Clamping system mechanical-mechanical with power transmitter, manually operated**  
**With stepped jaws**

**Technical features:**

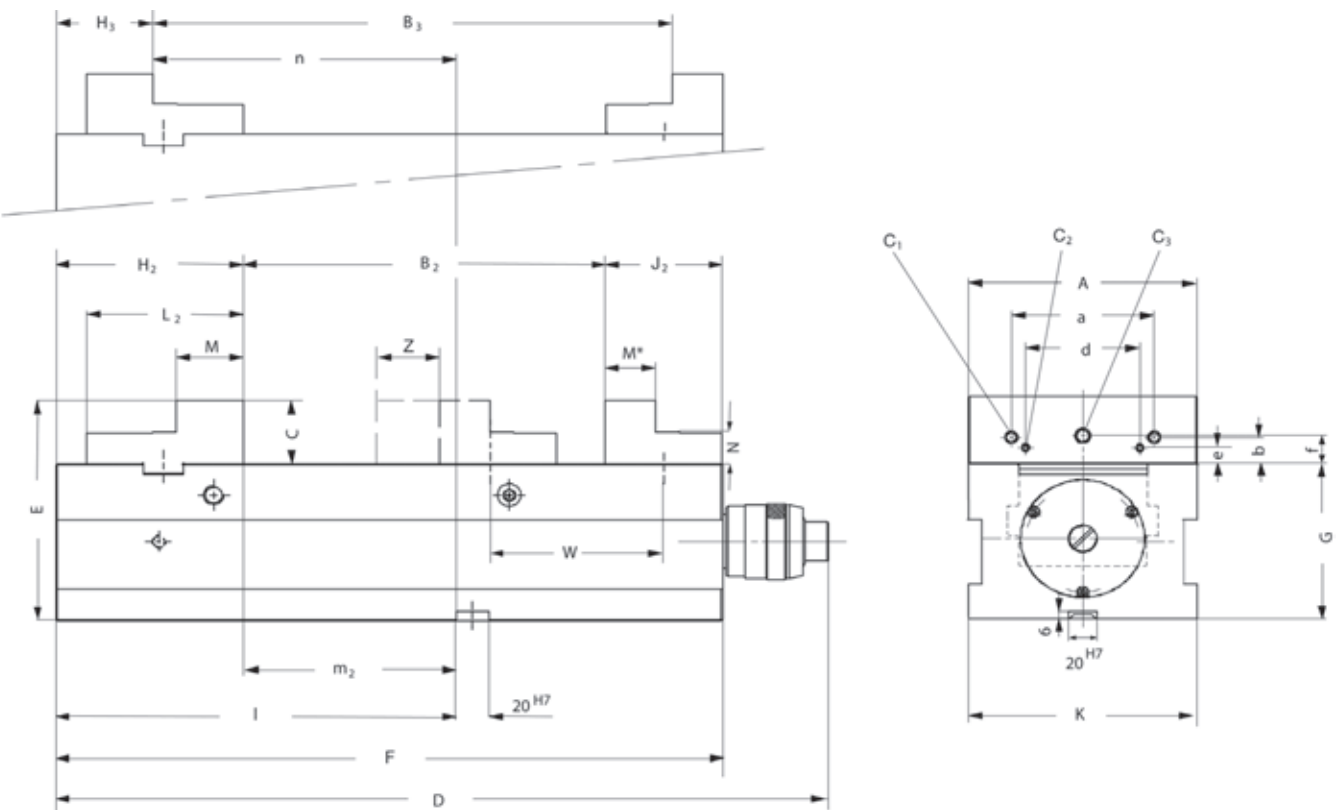
- function surfaces hardened and ground
- stable basic body made of GGG
- long clamping slide with clutch
- locking pin with clamping force presetting
- clamping surfaces for clamping claws

**Customer advantage:**

- solid chip guard prevents chips from penetrating the inside of the body
- stepped jaws, reversible, hardened and ground
- mounting thread M12 for workpiece stop

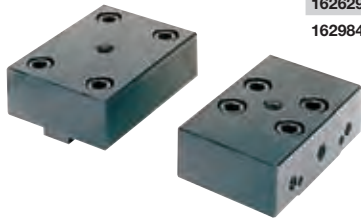
Tool group A32  
Type 743-10 **RKG-L**  
**With stepped jaws**

| Item no.            | 164691 ●     | 164692 ●     | 164693 ■     |
|---------------------|--------------|--------------|--------------|
| Jaw width A         | 125          | 160          | 200          |
| Jaw design          | stepped jaws | stepped jaws | stepped jaws |
| B2                  | 0-216        | 0 - 320      | 0 - 315      |
| B3                  | 97-312       | 131 - 451    | 131 - 451    |
| C                   | 40           | 50           | 60           |
| D                   | 463          | 618          | 618          |
| E                   | 140          | 165          | 175          |
| F                   | 400          | 530          | 530          |
| G <sub>-0,02</sub>  | 100          | 115          | 115          |
| H2                  | 112,5        | 130          | 135          |
| H3                  | 56,5         | 64           | 64           |
| J2                  | 70           | 97           | 97           |
| K                   | 126          | 162          | 162          |
| L2                  | 94           | 98           | 103          |
| M                   | 40           | 34           | 39           |
| M*                  | 30           | 32,5         | 32,5         |
| N <sub>-0,01</sub>  | 20           | 25           | 25           |
| W                   | 1x108        | 2x102,5      | 2x102,5      |
| Z                   | 109          | 117          | 117          |
| a                   | 80           | 100          | 125          |
| b                   | 15,6         | 19,6         | 24,6         |
| c1                  | M8x14        | M 8x14       | M 10x15      |
| c2                  | M5x10        | M 5x9        | M 5x10       |
| c3                  | M10x18       | M 10x18      | M 14x20      |
| d                   | 60           | 80           | 110          |
| e                   | 12           | 12           | 12           |
| f                   | 18           | 20           | 25           |
| l                   | 240          | 200          | 200          |
| m2 <sub>-0,02</sub> | 127,5        | 70           | 65           |
| n <sub>±0,02</sub>  | 183,5        | 136          | 136          |
| Clamping force kN   | 40           | 60           | 60           |
| Weight kg           | 41           | 79           | 85           |



## Accessories RKG-L

Tool group A37  
Type 743-50  
**Standard top jaws SA**  
reversible



| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 162628 ● | set                  | 125  | 125   | 40     |
| 162629 ● | set                  | 160  | 160   | 50     |
| 162984 ● | set                  | 200  | 200   | 60     |

Tool group A37  
Type 743-51 **Stepped jaws SB**  
reversible



| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 160343 ● | set                  | 125  | 125   | 40     |
| 162630 ● | set                  | 160  | 160   | 50     |
| 162985 ● | set                  | 200  | 200   | 60     |

Tool group A37  
Type 743-72 **Carrier jaws TB**  
without swivelling claw inserts



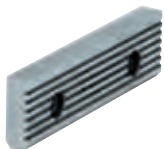
| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 165856 ● | set                  | 125  | 125   | 20     |
| 166218 ● | set                  | 160  | 160   | 25     |

Tool group A37  
Type 743-74  
**Swivelling pronged inserts**  
for carrier jaws 743-72



| Item no. | Contents of delivery | Size | Ø  | Height |
|----------|----------------------|------|----|--------|
| 165854 ● | piece                | 125  | 28 | 10     |
| 166216 ● | piece                | 160  | 30 | 10     |

Tool group A37  
Type 746-50 **Standard jaws SGN**  
one side smooth, one side  
grooved, hardened and ground



| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 158897 ● | set                  | 125  | 125   | 39,7   |
| 152755 ● | piece                | 160  | 160   | 49,6   |
| 152759 ● | piece                | 200  | 200   | 62,6   |

Tool group A37  
Type 746-50 **Standard jaws 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 |
|----------|----------------------|------|-------|--------|
| 163225 ● | set                  | 125  | 125   | 39,7   |
| 156197 ● | piece                | 160  | 160   | 49,6   |
| 156198 ● | piece                | 200  | 200   | 62,6   |



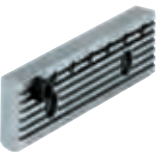
## Accessories RKG-L

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



| Item no. | Contents of delivery | Size | Width | Height | Clamping range |          |
|----------|----------------------|------|-------|--------|----------------|----------|
|          |                      |      |       |        | Horizontal     | Vertical |
| 082363 ● | piece                | 125  | 135   | 39,6   | 4-20           | 6-40     |
| 082364 ● | piece                | 160  | 160   | 49,6   | 5-29           | 7-48     |
| 082365 ● | piece                | 200  | 200   | 62,6   | 6-37           | 8-56     |

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 |
|----------|----------------------|------|-------|--------|
| 150740 ■ | piece                | 125  | 135   | 39,6   |
| 150741 ■ | piece                | 160  | 160   | 49,6   |

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



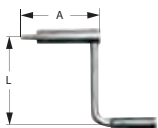
| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 077105 ● | set                  | 125  | 135   | 39,6   |
| 077106 ● | set                  | 160  | 160   | 49,6   |
| 077107 ■ | set                  | 200  | 200   | 62,6   |

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 |
| 317260 ● | set                  | 125  | 135   | 39,8   | 3-13           | 6-40     |
| 317261 ● | set                  | 160  | 160   | 49,8   | 5-22           | 7-48     |

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



| Item no. | Contents of delivery | Size        | Hexagon | A   | L   |
|----------|----------------------|-------------|---------|-----|-----|
| 134600 ● | piece                | 125/160/200 | 14      | 104 | 160 |

Tool group A37  
Type 743-19  
**90° Angle drive**



| Item no. | Contents of delivery | Size    | A   | B   | C  |
|----------|----------------------|---------|-----|-----|----|
| 158339 ● | piece                | 125     | 133 | 106 | 98 |
| 158888 ● | piece                | 160/200 | 166 | 111 | 98 |

**RKE-LV**



Collision free 5-side machining in one operation

**Clamping system mechanical-mechanical with power transmitter, manually operated**  
Short, compact design

**Technical features:**

- with tension clamping, 0-point of workpiece-end on operators side
- large clamping range
- no shifting of the movable top jaw
- steel body and all guidings hardened and ground
- massive chip protection

**Customer advantage:**

- minimal processing times
- high-precision positioning
- compact design
- carrier jaws incl. swivelling claw inserts; for clamping of circular and rectangular workpieces

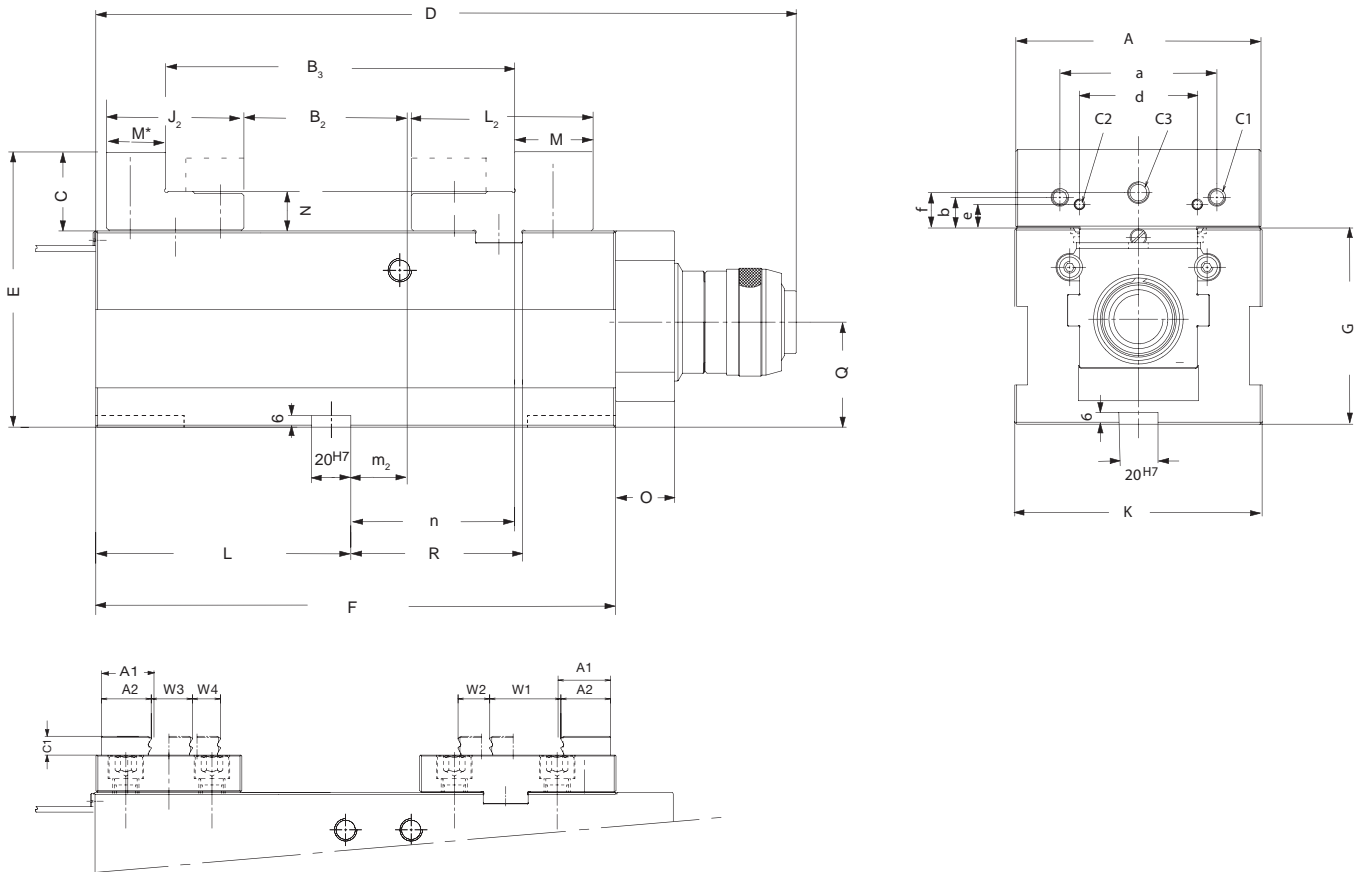
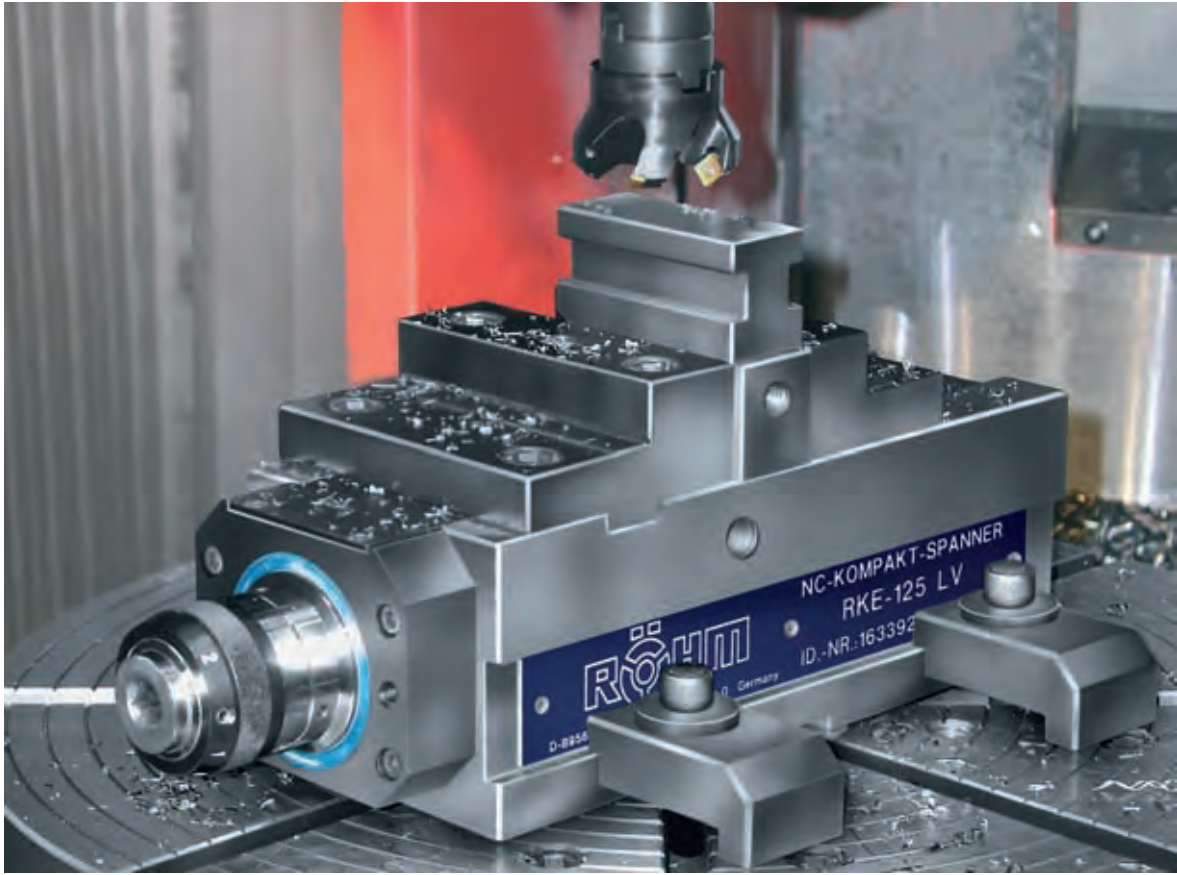
**Clamping ranges carrier jaws:**

rightangular workpieces: 35 - 215 mm,  
circular workpieces: dia. 65 - 225 mm

Tool group A32  
Type 743-10 **RKE-LV**  
**With reversible stepped jaws or carrier jaws**

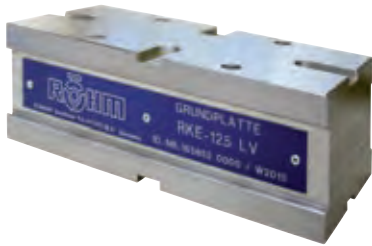
| Item no.            | 163392 ●     | 165851 ■     |
|---------------------|--------------|--------------|
| Jaw width A         | 125          | 125          |
| Jaw design          | stepped jaws | carrier jaws |
| B2                  | 0-96         | 35-215       |
| B3                  | 96-192       | 65-225       |
| C                   | 40           | 20           |
| D                   | 372          | 372          |
| E                   | 140          | 130          |
| F                   | 280          | 280          |
| J2                  | 70           | 78           |
| K                   | 126          | 126          |
| L                   | 145          | 125          |
| L2                  | 94           | 105          |
| M                   | 40           | -            |
| M*                  | 30           | -            |
| N <sub>0,01</sub>   | 20           | 20           |
| O                   | 30           | 30           |
| Q                   | 53,5         | 53,5         |
| R                   | 87,5         | 87,5         |
| a                   | 60           | -            |
| b                   | 15,6         | -            |
| c1                  | M10          | -            |
| c2                  | M8           | -            |
| c3                  | M5           | -            |
| d                   | 80           | -            |
| e                   | 12           | -            |
| f                   | 18           | -            |
| m2 <sub>±0,02</sub> | 27,5         | -            |
| n <sub>±0,02</sub>  | 83,5         | -            |
| Clamping force kN   | 40           | 40           |
| A1                  | -            | 28           |
| A2                  | -            | 26,5         |
| C1                  | -            | 10           |
| W1                  | -            | 38           |
| W2                  | -            | 17           |
| W3                  | -            | 22           |
| W4                  | -            | 15           |
| Weight kg           | 29           | 29           |

**RKE-LV**



## Accessories RKE-LV

| Tool group A37<br>Type 743-10<br><b>Standard basic plate GP</b> | Item no. | Contents of delivery | Size | Length | Width | Height | Weight kg |
|---|----------|----------------------|------|--------|-------|--------|-----------|
|   | 165852 ● | piece                | 125  | 280    | 126   | 90     | 24        |



| Tool group A37<br>Type 743-50<br><b>Standard top jaws SA</b><br>reversible | Item no. | Contents of delivery | Size | Width | Height |
|--|----------|----------------------|------|-------|--------|
|  | 162628 ● | set                  | 125  | 125   | 40     |



| Tool group A37<br>Type 743-51 <b>Stepped jaws SB</b><br>reversible | Item no. | Contents of delivery | Size | Width | Height |
|--|----------|----------------------|------|-------|--------|
|  | 160343 ● | set                  | 125  | 125   | 40     |



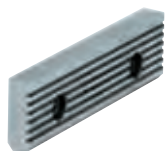
| Tool group A37<br>Type 743-72 <b>Carrier jaws TB</b><br>without swivelling claw inserts | Item no. | Contents of delivery | Size | Width | Height |
|---|----------|----------------------|------|-------|--------|
|   | 165856 ■ | set                  | 125  | 125   | 20     |



| Tool group A37<br>Type 743-74<br><b>Swivelling pronged inserts</b><br>for carrier jaws 743-72 | Item no. | Contents of delivery | Size | Ø  | Height |
|---|----------|----------------------|------|----|--------|
|   | 165854 ● | piece                | 125  | 28 | 10     |



| Tool group A37<br>Type 746-50 <b>Standard jaws SGN</b><br>one side smooth, one side<br>grooved, hardened and ground | Item no. | Contents of delivery | Size | Width | Height |
|---|----------|----------------------|------|-------|--------|
|   | 158897 ● | set                  | 125  | 125   | 39,7   |



## Accessories RKE-LV

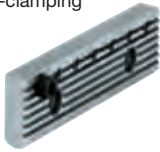
| Tool group A37<br>Type 746-50<br><b>Standard jaws fine checkered SGNr</b>   | Item no. | Contents of delivery | Size | Width | Height |
|---|----------|----------------------|------|-------|--------|
| reversible, used to increase the specific surface pressure (higher retention force), one side fine checkered, one side longitudinally checkered | 163225 ● | set                  | 125  | 125   | 39,7   |



| Tool group A37<br>Type 721 <b>V-jaw SPR</b><br>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 |
|  | 082363 ● | piece                | 125  | 135   | 39,6   | 4-20           | 6-40     |



| Tool group A37<br>Type 721-52 <b>Normal jaw SGNA</b><br>with movable workpiece locator, hardened and ground; only suitable for twin-clamping | Item no. | Contents of delivery | Size | Width | Height |
|--|----------|----------------------|------|-------|--------|
|  | 150740 ▲ | piece                | 125  | 135   | 39,6   |



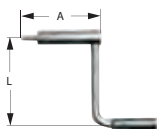
| Tool group A37<br>Type 721 <b>Draw-down jaws SNF</b><br>with spring plate, hardened and ground | Item no. | Contents of delivery | Size | Width | Height |
|--|----------|----------------------|------|-------|--------|
|  | 077105 ● | set                  | 125  | 135   | 39,6   |



| Tool group A37<br>Type 728-00<br><b>V-jaw and standard jawSBO</b><br>soft and gunmetal-finished, with work support; for BOF and BSS | Item no. | Contents of delivery | Size | Width | Height | Clamping range |          |
|---|----------|----------------------|------|-------|--------|----------------|----------|
|   |          |                      |      |       |        | Horizontal     | Vertical |
|   | 317260 ● | set                  | 125  | 135   | 39,8   | 3-13           | 6-40     |



| Tool group A37<br>Type 744 <b>Hand crank</b><br>turnable handle, hexagon socket | Item no. | Contents of delivery | Size | Hexagon | A   | L   |
|---|----------|----------------------|------|---------|-----|-----|
|   | 134600 ● | piece                | 125  | 14      | 104 | 160 |



| Tool group A37<br>Type 743-19<br><b>90° Angle drive</b> | Item no. | Contents of delivery | Size | A   | B   | C  |
|---|----------|----------------------|------|-----|-----|----|
|   | 158339 ● | piece                | 125  | 133 | 106 | 98 |



# RKE-M LV



Because of the short design the RKE-M LV is perfect suitable for operation on 5 sides in one setting.

**Clamping system mechanical without power transmitter, manually operated.**

The equipment with transferable and reversible stepped jaws enables a high flexibility and wide range.

Adjusted to the workpiece, a large number of different clamping jaws of the RÖHM-assessories-program is available.

**Technical features:**

- solid steel body
- all guide surfaces are hardened and ground
- long clamping slide with clutch, hardened on all sides, function surfaces ground
- clamping surfaces for clamping claws
- shortend design with few interference sides; low risk of collision
- interchangeable jaw program for all kinds of operation

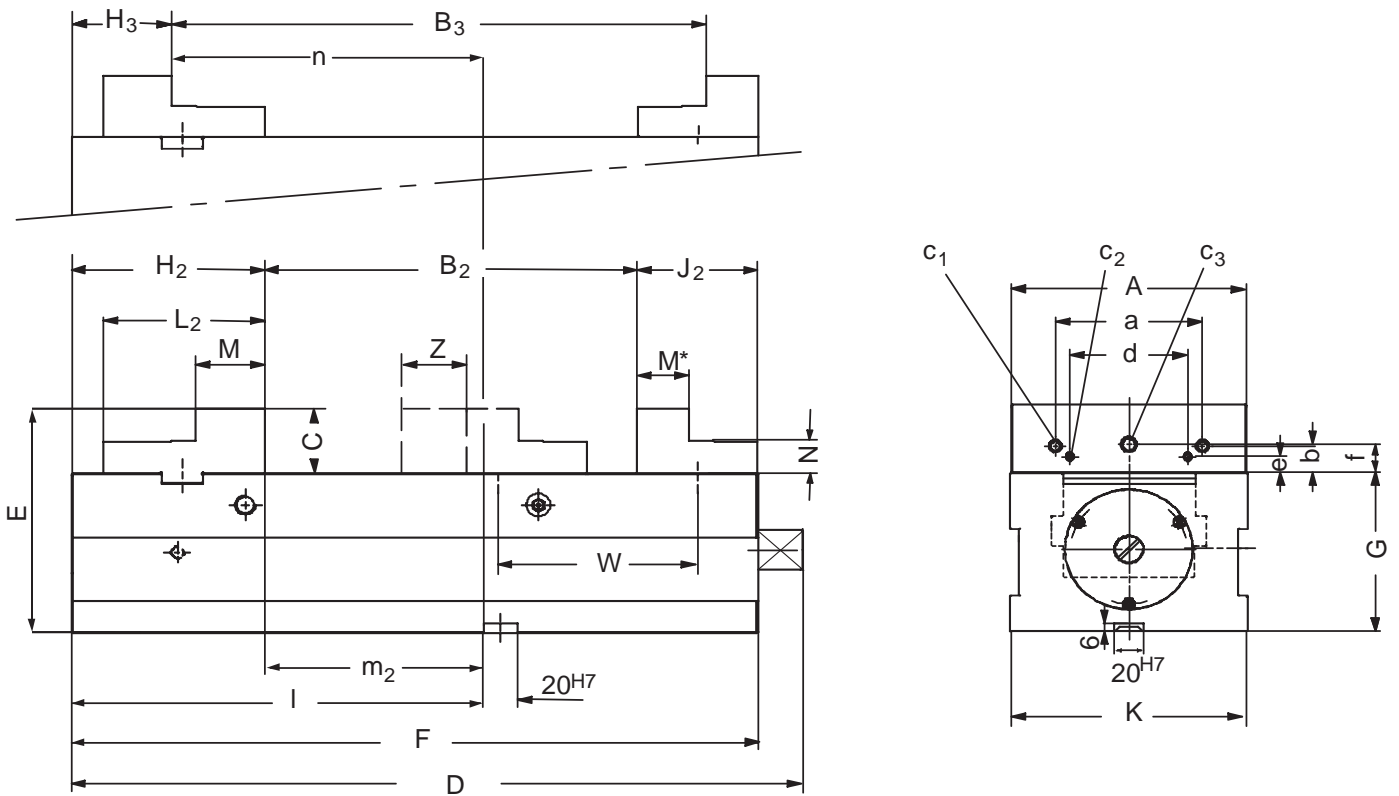
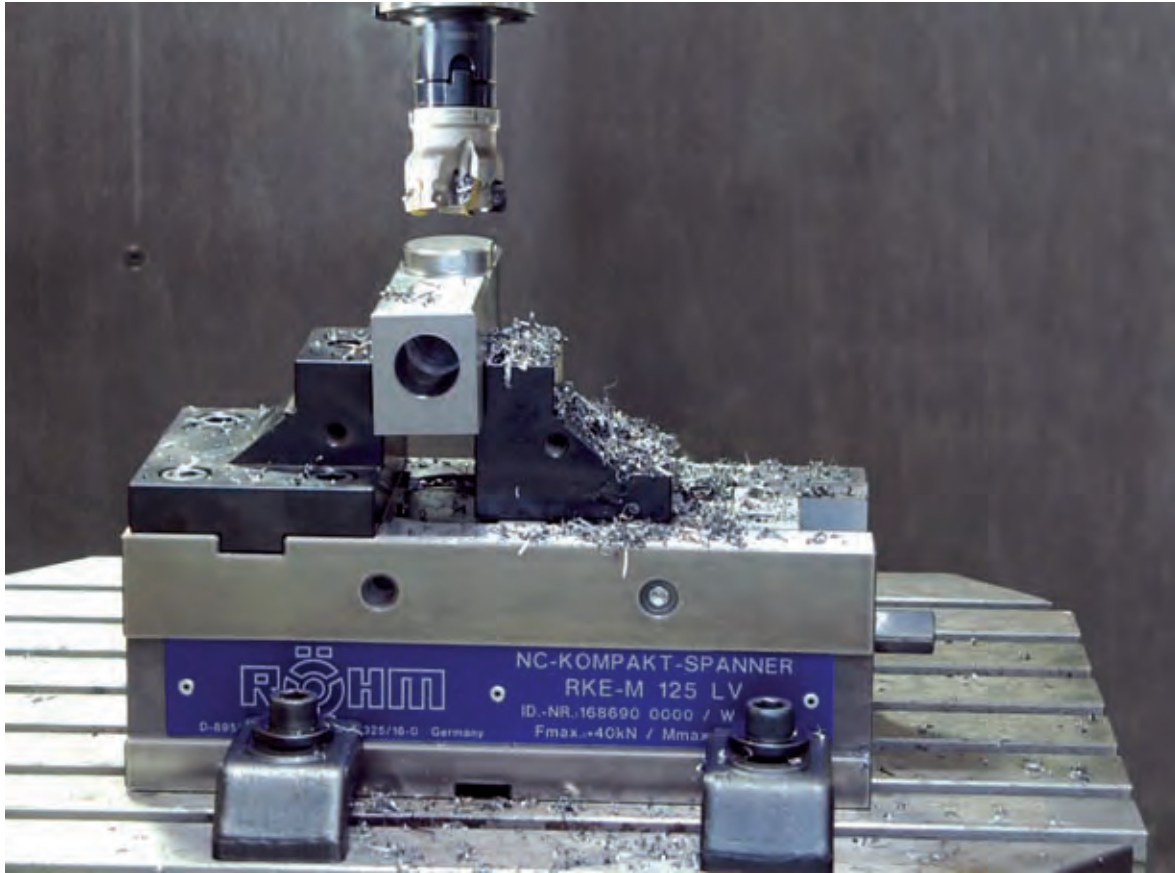
**Customer advantage:**

- the NC-compact vice can be actuated on both sides

Tool group A32  
Type 743-00 RKE-M LV  
With stepped jaws

| Item no.            | 168689 <span style="color: yellow;">■</span> | 168690 <span style="color: green;">●</span> |
|---------------------|--|---|
| Jaw width A         | 92   | 125   |
| Jaw design          | stepped jaws                                 | stepped jaws                                |
| B1                  | -  | -   |
| B2                  | 0-98   | 0-110                                       |
| B3                  | 71-168                                       | 97-206                                      |
| C                   | 32   | 40  |
| D                   | 240  | 305   |
| E                   | 112  | 140   |
| F                   | 220  | 280   |
| G <sub>±0,02</sub>  | 80   | 100   |
| H <sub>1</sub>      | -  | -   |
| H2                  | 65   | 96,5  |
| H3                  | 26   | 40,5  |
| J1                  | -  | -   |
| J2                  | 56   | 70  |
| K                   | 94   | 126   |
| L1                  | -  | -   |
| L2                  | 64   | 94  |
| M                   | 25   | 40  |
| M*                  | 25   | 30  |
| N <sub>±0,01</sub>  | 16   | 20  |
| T <sub>-0,02</sub>  | -  | -   |
| Shifting range W    | 1x48   | 1x46  |
| Clamping travel Z   | 52   | 65  |
| a                   | 63   | 80  |
| b                   | 13,6   | 15,6  |
| c1                  | M 6x10                                       | M8x14                                       |
| c2                  | M5x8   | M5x10                                       |
| c3                  | M10x16                                       | M10x18                                      |
| d                   | 48   | 60  |
| e                   | 8  | 12  |
| f                   | 14   | 18  |
| g                   | -  | -   |
| h                   | -  | -   |
| i                   | -  | -   |
| l                   | 100  | 125   |
| m2 <sub>±0,02</sub> | 35   | 28,5  |
| n <sub>±0,02</sub>  | 74   | 84,5  |
| Clamping force kN   | 25   | 40  |
| Weight kg           | 12   | 27  |

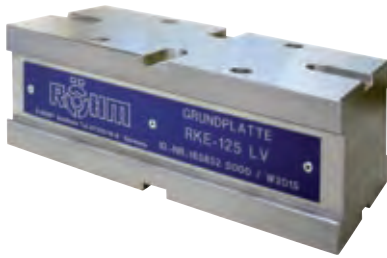
**RKE-M LV**



## Accessories RKE-M LV

Tool group A37  
Type 743-10  
**Standard basic plate GP**

| Item no. | Contents of delivery | Size | Length | Width | Height | Weight kg |
|----------|----------------------|------|--------|-------|--------|-----------|
| 165852 ● | piece                | 125  | 280    | 126   | 90     | 24        |



Tool group A37  
Type 743-50  
**Standard top jaws SA**  
reversible

| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 162628 ● | set                  | 125  | 125   | 40     |



Tool group A37  
Type 743-51 **Stepped jaws SB**  
reversible

| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 162851 ■ | set                  | 92   | 92    | 32     |
| 160343 ● | set                  | 125  | 125   | 40     |



Tool group A37  
Type 743-72 **Carrier jaws TB**  
without swivelling claw inserts

| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 165856 ■ | set                  | 125  | 125   | 20     |



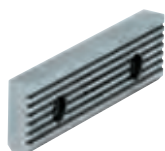
Tool group A37  
Type 743-74 **Swivelling pronged inserts**  
for carrier jaws 743-72

| Item no. | Contents of delivery | Size | Ø  | Height |
|----------|----------------------|------|----|--------|
| 165854 ● | piece                | 125  | 28 | 10     |



Tool group A37  
Type 746-50 **Standard jaws SGN**  
one side smooth, one side  
grooved, hardened and ground

| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 152752 ● | piece                | 92   | 92    | 31,6   |
| 158897 ● | set                  | 125  | 125   | 39,7   |



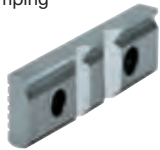


## Accessories RKE-M LV

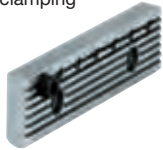
| Tool group A37<br>Type 746-50<br><b>Standard jaws fine checkered SGNf</b><br>reversible, used to increase the specific surface pressure (higher retention force), one side fine checkered, one side longitudinally checkered | Item no.        | Contents of delivery | Size | Width | Height |
|--|-----------------|----------------------|------|-------|--------|
|  | <b>163218</b> ● | piece                | 92   | 92    | 31,6   |
| <b>163225</b> ●  | set             | 125                  | 125  | 39,7  |        |



| Tool group A37<br>Type 721 <b>V-jaw SPR</b><br>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 |
| <b>128770</b> ●  | piece    | 92                   | 92   | 31,6  | 3-13   | 5-32           |          |
| <b>082363</b> ●  | piece    | 125                  | 135  | 39,6  | 4-20   | 6-40           |          |



| Tool group A37<br>Type 721-52 <b>Normal jaw SGNA</b><br>with movable workpiece locator, hardened and ground; only suitable for twin-clamping | Item no. | Contents of delivery | Size | Width | Height |
|--|----------|----------------------|------|-------|--------|
|  |          |                      |      |       |        |
| <b>150740</b> ■  | piece    | 125                  | 135  | 39,6  |        |



| Tool group A37<br>Type 721 <b>Draw-down jaws SNF</b><br>with spring plate, hardened and ground | Item no. | Contents of delivery | Size | Width | Height |
|--|----------|----------------------|------|-------|--------|
|  |          |                      |      |       |        |
| <b>077105</b> ●  | set      | 125                  | 135  | 39,6  |        |



| Tool group A37<br>Type 728-00<br><b>V-jaw and standard jawSBO</b><br>soft and gunmetal-finished, with work support; for BOF and BSS | Item no. | Contents of delivery | Size | Width | Height | Clamping range |          |
|---|----------|----------------------|------|-------|--------|----------------|----------|
|   |          |                      |      |       |        | Horizontal     | Vertical |
| <b>317259</b> ●   | set      | 92                   | 110  | 31,8  | 3-12   | 5-32           |          |
| <b>317260</b> ●   | set      | 125                  | 135  | 39,8  | 3-13   | 6-40           |          |



| Tool group C15<br>Type 7004-Y <b>Hand crank HKU</b><br>with octagon socket | Item no. | Contents of delivery | Size | Octagon | L |
|--|----------|----------------------|------|---------|---|
|  |          |                      |      |         |   |
| <b>009152</b> ●  | piece    | 125                  | 14   | 125     |   |



| Tool group A37<br>Type 743-00 <b>Drive adapter ATA</b> | Item no. | Contents of delivery | Size    | Square |
|--|----------|----------------------|---------|--------|
|  |          |                      |         |        |
| <b>161103</b> ■  | piece    | 125                  | 14-1/2" |        |



# RKE-H L



Especially used on CNC-machines.  
Base mounting with mechanical power intensification.

**Clamping system hydraulic with stroke, hydraulic connection for single-acting cylinders.**

**Technical features:**

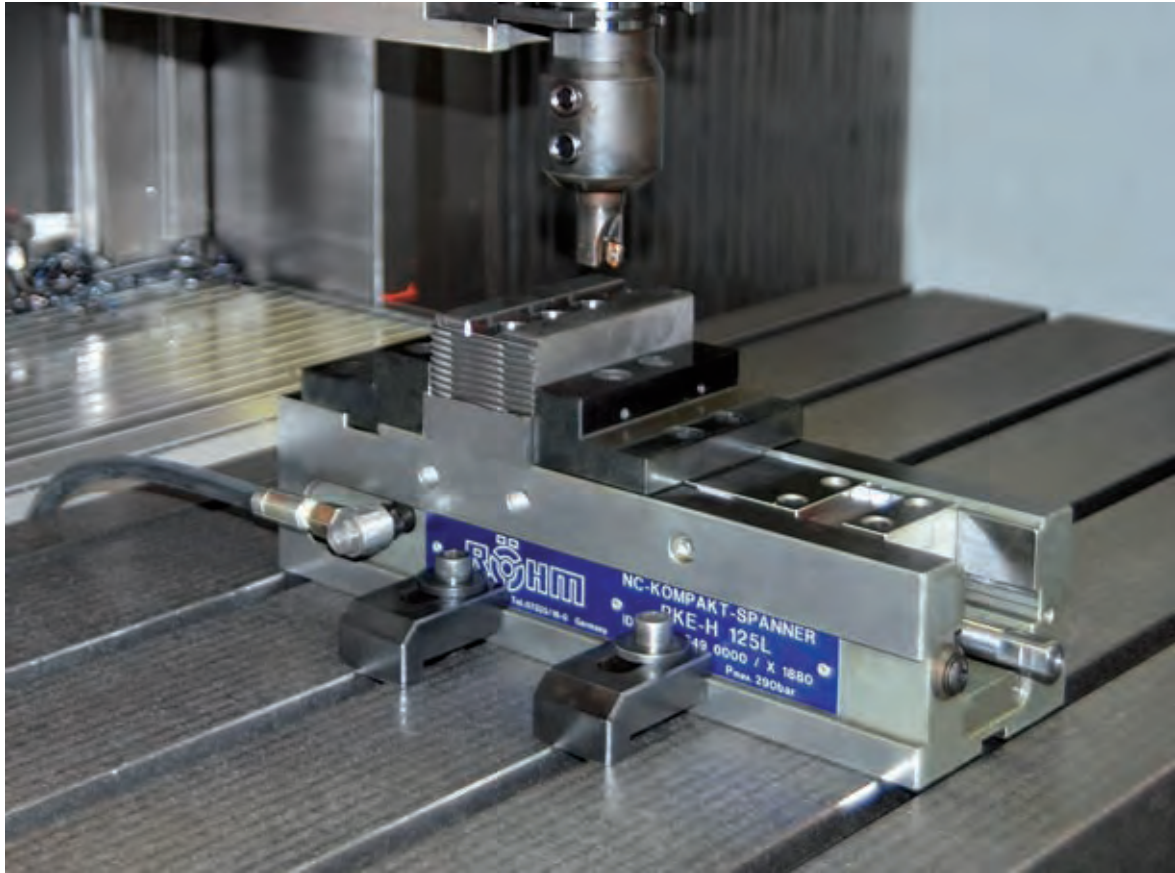
- solid steel-body
- all guide surfaces are hardened and ground
- long clamping slide with clutch, hardened on all sides, function surfaces ground
- clamping surface for clamping claws

**Customer advantage:**

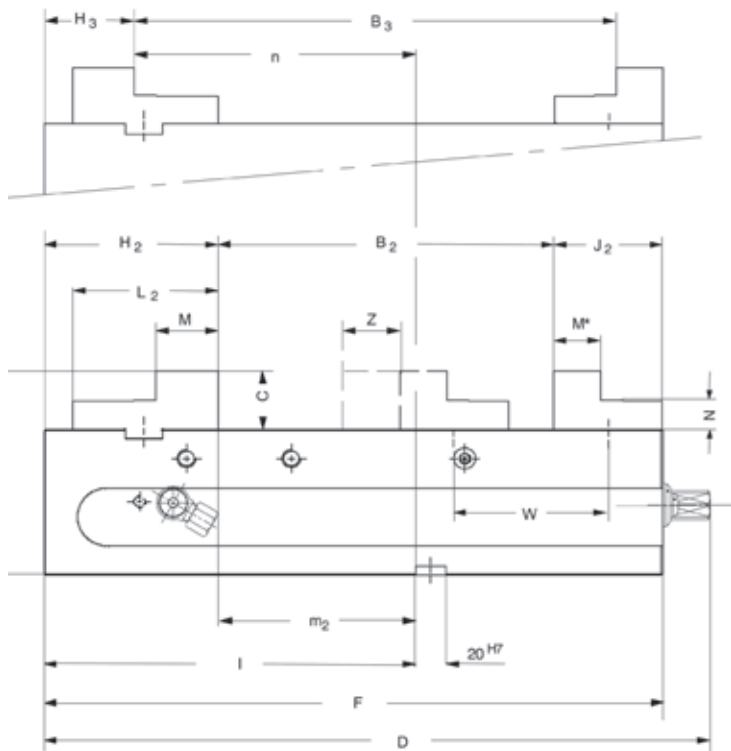
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured
- solid chip guard prevents chips from penetrating the inside of the body

Tool group A32  
Type 743-20 **RKE-H L**  
with stepped jaws or standard  
clamping jaws

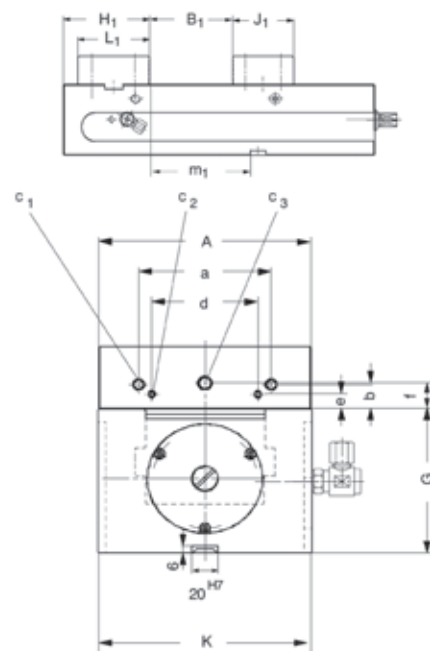
| Item no.            | 165649 ▲     | 165646 ▲               |
|---------------------|--------------|------------------------|
| Jaw width A         | 125          | 125                    |
| Jaw design          | stepped jaws | standard clamping jaws |
| B1                  | -            | 0-215                  |
| B2                  | 0 - 216      | -                      |
| B3                  | 97 - 312     | -                      |
| C                   | 40           | 40                     |
| D                   | 428          | 428                    |
| E                   | 140          | 140                    |
| F                   | 400          | 400                    |
| G <sub>±0,02</sub>  | 100          | 100                    |
| H <sub>1</sub>      | -            | 110,5                  |
| H <sub>2</sub>      | 112,5        | -                      |
| H <sub>3</sub>      | 56,5         | -                      |
| J <sub>1</sub>      | -            | 78                     |
| J <sub>2</sub>      | 70           | -                      |
| K                   | 126          | 126                    |
| L <sub>1</sub>      | -            | 92                     |
| L <sub>2</sub>      | 94           | -                      |
| M                   | 40           | -                      |
| M*                  | 30           | -                      |
| N <sub>±0,01</sub>  | 20           | -                      |
| Shifting range W    | 1x108        | 1x108                  |
| Clamping travel Z   | 109          | 109                    |
| a                   | 80           | 80                     |
| b                   | 15,6         | 15,6                   |
| c1                  | M 8x14       | M 8x14                 |
| c2                  | M 5x10       | M 5x10                 |
| c3                  | M10x18       | M 10x18                |
| d                   | 60           | 60                     |
| e                   | 12           | 12                     |
| f                   | 18           | 18                     |
| l                   | 240          | 240                    |
| m1 <sub>±0,02</sub> | -            | 129,5                  |
| m2 <sub>±0,02</sub> | 127,5        |                        |
| n <sub>±0,02</sub>  | 183,5        |                        |
| Clamping force kN   | 40           | 40                     |
| Weight kg           | 41           | 41                     |



stepped jaws



standard jaws



# Accessories RKE-H L

| Tool group A37<br>Type 743-50<br><b>Standard top jaws SA</b><br>reversible | Item no. | Contents of delivery | Size | Width | Height |
|--|----------|----------------------|------|-------|--------|
|  | 162628 ● | set                  | 125  | 125   | 40     |



| Tool group A37<br>Type 743-51 <b>Stepped jaws SB</b><br>reversible | Item no. | Contents of delivery | Size | Width | Height |
|--|----------|----------------------|------|-------|--------|
|  | 160343 ● | set                  | 125  | 125   | 40     |



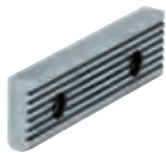
| Tool group A37<br>Type 743-72 <b>Carrierjaws TB</b><br>without swivelling claw inserts | Item no. | Contents of delivery | Size | Width | Height |
|--|----------|----------------------|------|-------|--------|
|  | 165856 ■ | set                  | 125  | 125   | 20     |



| Tool group A37<br>Type 743-74 <b>Swivelling pronged inserts</b> for carrier jaws 743-72 | Item no. | Contents of delivery | Size | Ø  | Height |
|---|----------|----------------------|------|----|--------|
|   | 165854 ● | piece                | 125  | 28 | 10     |

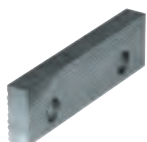


| Tool group A37<br>Type 721 <b>Normal jaw SGN</b><br>one side smooth, one side<br>grooved, both sides ground | Item no. | Contents of delivery | Size | Width | Height |
|---|----------|----------------------|------|-------|--------|
|   | 158897 ● | set                  | 125  | 125   | 39,7   |



| Tool group A37<br>Type 746-50<br><b>Standard jaws fine checkered SGNf</b> | Item no. | Contents of delivery | Size | Width | Height |
|---|----------|----------------------|------|-------|--------|
|   | 163225 ● | set                  | 125  | 125   | 39,7   |

reversible, used to increase the specific surface pressure (higher retention force), one side fine checkered, one side longitudinally checkered



## Accessories RKE-H L

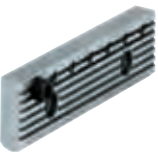
Tool group A37  
Type 721 **V-jaw SPR**  
with vertical and horizontal ground  
V's, hardened, for use in combina-  
tion with SGN; only suitable for  
twin-clamping

| Item no. | Contents of delivery | Size | Width | Height | Clamping range |          |
|----------|----------------------|------|-------|--------|----------------|----------|
|          |                      |      |       |        | Horizontal     | Vertical |
| 082363 ● | piece                | 125  | 135   | 39,6   | 4-20           | 6-40     |



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 |
|----------|----------------------|------|-------|--------|
| 150740 ■ | piece                | 125  | 135   | 39,6   |



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

| Item no. | Contents of delivery | Size | Width | Height |
|----------|----------------------|------|-------|--------|
| 077105 ● | set                  | 125  | 135   | 39,6   |



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

| Item no. | Contents of delivery | Size | Width | Height | Clamping range |          |
|----------|----------------------|------|-------|--------|----------------|----------|
|          |                      |      |       |        | Horizontal     | Vertical |
| 317260 ● | set                  | 125  | 135   | 39,8   | 3-13           | 6-40     |



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

| Item no. | Contents of delivery | Size | Octagon | L   |
|----------|----------------------|------|---------|-----|
| 009152 ● | piece                | 125  | 14      | 125 |





For flexible clamping on machining centres and other production systems.  
Three clamping positions: horizontal, vertical and lateral

**Clamping system mechanical-mechanical with power transmitter, manually operated**

Only approx. 1 1/2 crank rotations at max. clamping force.

**Technical features:**

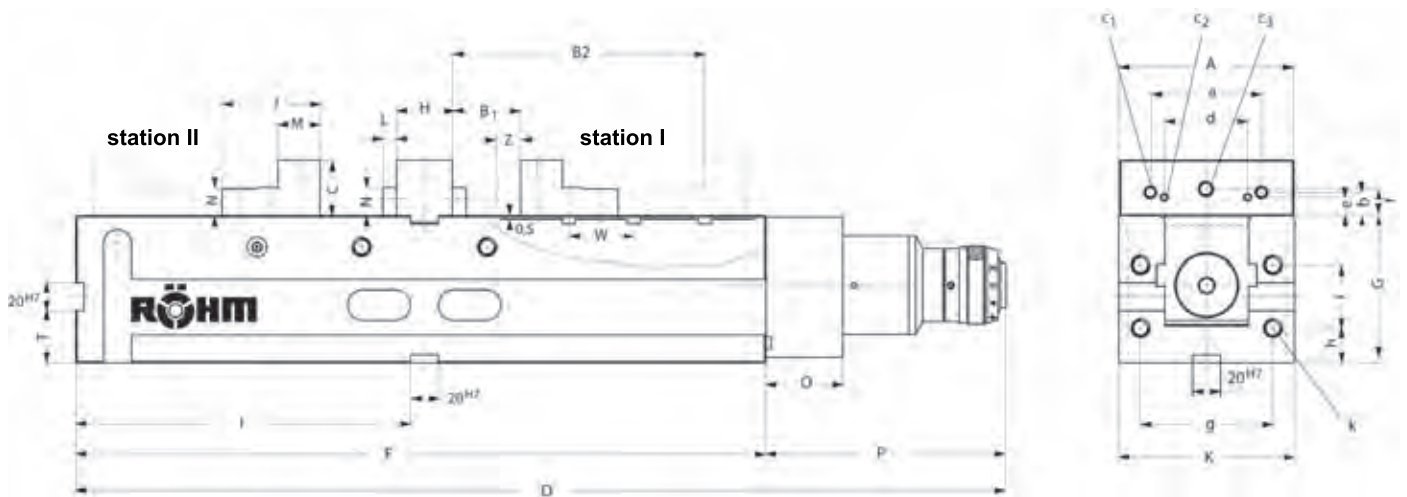
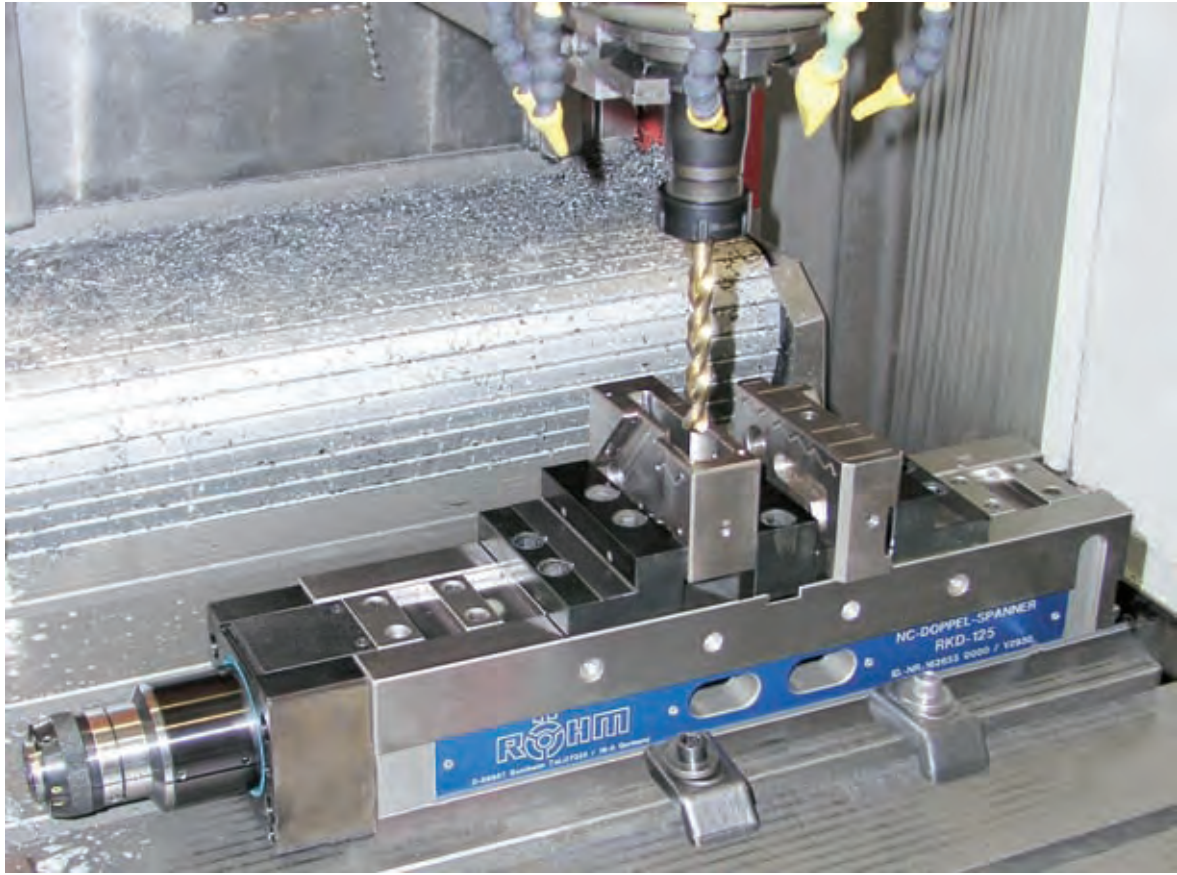
- pre-adjustment of clamping force by means of locking system
- double-clamping via two mobile claws (left-right hand thread) and one immobile centre jaw
- the solid steel body and all guide surfaces are hardened and ground on all sides
- fastening of the vice with clamping claws only
- thread for fastening angle drive

**Customer advantage:**

- constant clamping force for increased repeating accuracy 0,01
- no overloading of the vice at max. clamping force
- self-locking power transmission
- the clamping thread of the spindle is protected in all positions to prevent the penetration of dirt and chips
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured

Tool group A32  
Type 749-10 **RKD**  
With reversible stepped jaws  
and centre jaw

| Item no.           | 161830 ● | 162655 ●  |
|--------------------|----------|-----------|
| Jaw width A        | 92       | 125       |
| B1 slot 1          | 0 - 48   | 0 - 48    |
| B1 slot 2          | 48 - 96  | 46 - 94   |
| B1 slot 3          | -        | 92 - 140  |
| B2 slot 1          | 42 - 79  | 51 - 88   |
| B2 slot 2          | 79 - 127 | 86 - 134  |
| B2 slot 3          | -        | 132 - 180 |
| C                  | 32       | 40        |
| D                  | 500      | 667       |
| F                  | 356      | 495       |
| G <sub>-0,02</sub> | 85       | 105       |
| H <sub>0,02</sub>  | 30       | 40        |
| J                  | 56       | 70        |
| K                  | 94       | 126       |
| L                  | 10       | 10        |
| M                  | 25       | 30        |
| N <sub>-0,01</sub> | 16       | 20        |
| O                  | 55       | 55        |
| P                  | 144      | 172       |
| T <sub>-0,02</sub> | 30       | 37,5      |
| W                  | 1 x 48   | 2 x 46    |
| Z                  | 50       | 50        |
| a                  | 63       | 80        |
| b                  | 13,6     | 15,6      |
| c1                 | M6x14    | M8 x 14   |
| c2                 | M5 x 9   | M5 x 10   |
| c3                 | M10 x 16 | M10 x 18  |
| d                  | 48       | 60        |
| e                  | 8        | 12        |
| f                  | 14       | 18        |
| g                  | 70       | 95        |
| h                  | 20       | 25        |
| i                  | 50       | 45        |
| k                  | M10 x 18 | M12 x 22  |
| l <sub>-0,02</sub> | 170      | 240       |
| Clamping force kN  | 25       | 40        |
| Weight kg          | 24       | 53        |



**RKD-M**


For flexible clamping on machining centres and other production systems.  
Three clamping functions: Twin clamping - centric clamping - single clamping

**Clamping system mechanical without power transmitter, manually operated.**

With drive spindle on one side.

**Horizontal, vertical or side mounting.**

**Technical features:**

- machine vice with two mobile jaws and one immobile centre jaw
- the solid steel body and all guide surfaces are hardened and ground on all sides
- fastening of the vice with clamping claws only (direct mounting on request)
- constant clamping force during every clamping operation and high repeating accuracy if torque wrenches are used
- large clamp stroke, 50 mm per jaw

**Customer advantage:**

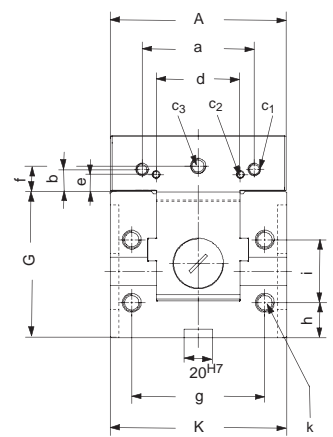
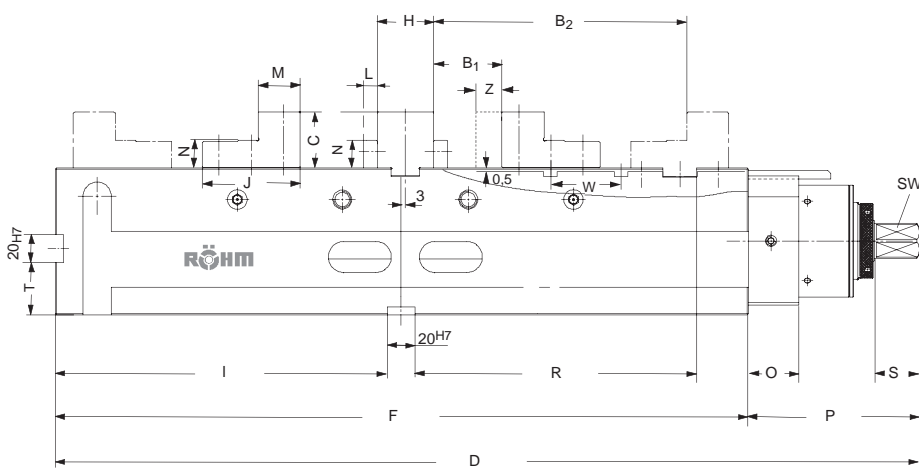
- the clamping thread of the spindle is protected in all positions to prevent the penetration of dirt and chips
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured
- the compact vice is on delivery equipped for twin and centric clamping operation by means of provided hand crank

Tool group A32  
Type 749-00 **RKD-M**  
**With reversible stepped jaws and centre jaw**

| Item no.           | 162653 ● | 162654 ● |
|--------------------|----------|----------|
| Jaw width A        | 92       | 125      |
| B1 slot 1          | 0-48     | 0-48     |
| B1 slot 2          | 48-96    | 46-94    |
| B1 slot 3          | -        | 92-140   |
| B2 slot 1          | 42-79    | 51-88    |
| B2 slot 2          | 79-127   | 86-134   |
| B2 slot 3          | -        | 132-180  |
| C                  | 32       | 40       |
| D                  | 480      | 617      |
| F                  | 366      | 495      |
| G <sub>-0,02</sub> | 85       | 105      |
| H <sub>-0,02</sub> | 30       | 40       |
| J                  | 56       | 70       |
| K                  | 94       | 126      |
| L                  | 10       | 10       |
| M                  | 25       | 30       |
| N <sub>-0,01</sub> | 16       | 20       |
| O                  | 36       | 36       |
| P                  | 114      | 122      |
| R                  | 143      | 201      |
| S                  | 31       | 32       |
| T <sub>-0,02</sub> | 30       | 37,5     |
| W                  | 1 x 48   | 2 x 46   |
| Z                  | 50/53    | 50/53    |
| Key-width SW       | 17       | 19       |
| a                  | 63       | 80       |
| b                  | 13,6     | 15,6     |
| c1                 | M6 x 14  | M8 x 14  |
| c2                 | M5 x 9   | M5 x 10  |
| c3                 | M10 x 16 | M10 x 18 |
| d                  | 48       | 60       |
| e                  | 8        | 12       |
| f                  | 14       | 18       |
| g                  | 70       | 95       |
| h                  | 20       | 25       |
| i                  | 50       | 45       |
| k                  | M10 x 18 | M12 x 22 |
| l <sub>-0,02</sub> | 177      | 237      |
| Clamping force kN  | 25       | 40       |
| Weight kg          | 24       | 52       |



**RKD-M**

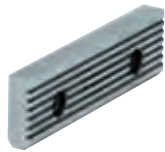


## Accessories RKD

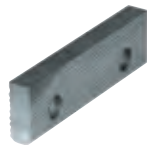
| Tool group A37<br>Type 726-60<br><b>Stepped jaws SB</b><br>reversible, with fixing screws | Item no.                                     | Contents of delivery | Size | Width | Height |
|---|--|----------------------|------|-------|--------|
|   | 161831 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     |
|   | 162631 <span style="color: yellow;">■</span> | set                  | 125  | 125   | 40     |



| Tool group A37<br>Type 726-50 <b>Standard jaws SGN</b><br>one side smooth, one side<br>grooved, hardened and ground | Item no.                                     | Contents of delivery | Size | Width | Height |
|---|--|----------------------|------|-------|--------|
|   | 162363 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     |
|   | 158897 <span style="color: green;">●</span>  | set                  | 125  | 125   | 39,7   |



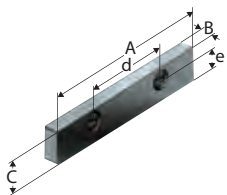
| Tool group A37<br>Type 726-50 <b>Standard jaws fine checked SGNf</b><br>one side fine checked, one side<br>grooved, hardened and ground | Item no.                                     | Contents of delivery | Size | Width | Height |
|---|--|----------------------|------|-------|--------|
|   | 163223 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     |
|   | 163225 <span style="color: green;">●</span>  | set                  | 125  | 125   | 39,7   |



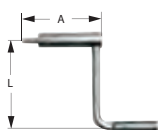
| Tool group A37<br>Type 749-51 <b>Center jaws MBA</b> | Item no.                                     | Contents of delivery | Size | Width | Height | Thickness |
|--|--|----------------------|------|-------|--------|-----------|
|  | 161833 <span style="color: yellow;">■</span> | piece                | 92   | 92    | 32     | 30        |
|  | 162632 <span style="color: yellow;">■</span> | piece                | 125  | 125   | 40     | 40        |



| Tool group A37<br>Type 749-51 <b>Work support WAM</b><br>for center jaws | Item no.                                     | Contents of delivery | Size | A   | B  | C  | d  | e  |
|--|--|----------------------|------|-----|----|----|----|----|
|  | 159613 <span style="color: yellow;">■</span> | set                  | 92   | 92  | 10 | 16 | 48 | 8  |
|  | 158599 <span style="color: yellow;">■</span> | set                  | 125  | 125 | 10 | 20 | 60 | 12 |



| Tool group A37<br>Type 744 <b>Hand crank</b><br>turnable handle, hexagon socket | Item no.                                    | Contents of delivery | Size   | Hexagon | A   | L   |
|---|---|----------------------|--------|---------|-----|-----|
|   | 134600 <span style="color: green;">●</span> | piece                | 92/125 | 14      | 104 | 160 |



| Tool group A37<br>Type 726-19 <b>Angle drive</b> | Item no.                                     | Contents of delivery | Size | A   | B   | C  |
|--|--|----------------------|------|-----|-----|----|
|  | 159647 <span style="color: yellow;">■</span> | piece                | 92   | 162 | 92  | 98 |
|  | 159015 <span style="color: yellow;">■</span> | piece                | 125  | 190 | 110 | 98 |

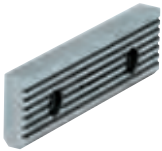


## Accessories RKD-M

| Tool group A37<br>Type 726-60<br><b>Stepped jaws SB</b><br>reversible, with fixing screws | Item no.                                     | Contents of delivery | Size | Width | Height |
|---|--|----------------------|------|-------|--------|
|   | 161831 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     |
|   | 162631 <span style="color: yellow;">■</span> | set                  | 125  | 125   | 40     |



| Tool group A37<br>Type 726-50 <b>Standard jaws SGN</b><br>one side smooth, one side<br>grooved, hardened and ground | Item no.                                     | Contents of delivery | Size | Width | Height |
|---|--|----------------------|------|-------|--------|
|   | 162363 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     |
|   | 158897 <span style="color: green;">●</span>  | set                  | 125  | 125   | 39,7   |



| Tool group A37<br>Type 726-50 <b>Standard jaws fine checkered SGNf</b><br>one side fine checkered, one side<br>grooved, hardened and ground | Item no.                                     | Contents of delivery | Size | Width | Height |
|---|--|----------------------|------|-------|--------|
|   | 163223 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     |
|   | 163225 <span style="color: green;">●</span>  | set                  | 125  | 125   | 39,7   |



| Tool group A37<br>Type 726-52 <b>V-jaw PB</b><br>horizontal and vertical | Item no.                                     | Contents of delivery | Size | Width | Height | Thickness | Height prism | Clamping range |          |
|--|--|----------------------|------|-------|--------|-----------|--------------|----------------|----------|
|  |  |                      |      |       |        |           |              | horizontal     | vertical |
|  | 162365 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     | 16        | 19,5         | 12-36          | 12-36    |
|  | 158641 <span style="color: yellow;">■</span> | set                  | 125  | 125   | 40     | 20        | 24           | 15-40          | 18-60    |



| Tool group A37<br>Type 749-00 <b>Drive adapter ATA</b> | Item no.                                     | Contents of delivery | Size | Square  |
|--|--|----------------------|------|---------|
|  | 162192 <span style="color: yellow;">■</span> | piece                | 92   | 17-1/2" |
|  | 161730 <span style="color: yellow;">■</span> | piece                | 125  | 19-1/2" |



| Tool group A37<br>Type 749-51<br><b>Fixed stepped jaw FSB</b><br>for single clamping, reversible | Item no.                                     | Contents of delivery | Size | Width | Height |
|--|--|----------------------|------|-------|--------|
|  | 162633 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     |
|  | 160344 <span style="color: green;">●</span>  | set                  | 125  | 125   | 40     |



# Accessories RKD-M

Tool group A37  
Type 749-51 **Center jaws MBA**



| Item no.                                     | Contents of delivery | Size | Width | Height | Thickness |
|--|----------------------|------|-------|--------|-----------|
| 161833 <span style="color: yellow;">■</span> | piece                | 92   | 92    | 32     | 30        |
| 162632 <span style="color: yellow;">■</span> | piece                | 125  | 125   | 40     | 40        |

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

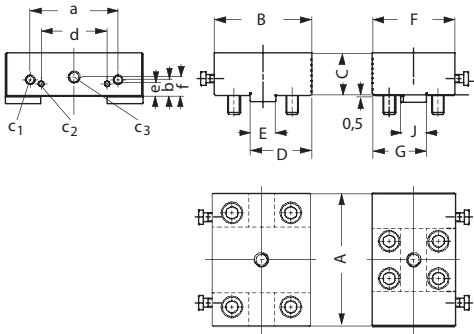


| Item no.                                    | Contents of delivery | Size | Octagon | L   |
|---|----------------------|------|---------|-----|
| 009153 <span style="color: green;">●</span> | piece                | 92   | 17      | 160 |
| 009154 <span style="color: green;">●</span> | piece                | 125  | 19      | 200 |

## Clamping jaw dimensions for NC-Compact vices

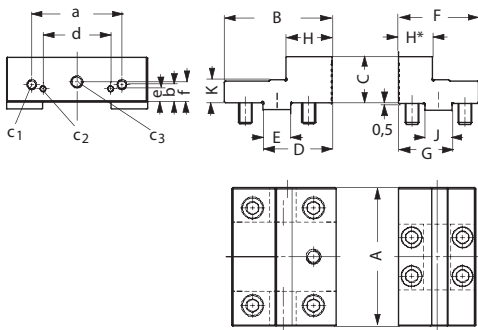
Clamping jaw dimensions for NC-Compact vices RKE, RKE-L, RKG-L, RKE-LV, RKE-M, RKE-H, RKG-M

Type 743 - 50 SA  
**Standard top jaws - Set**



| Jaw width       | 125    | 160    | 200    |
|-----------------|--------|--------|--------|
| Item no.        | 162628 | 162629 | 162984 |
| B               | 92     | 100    | 105    |
| C               | 40     | 50     | 60     |
| D               | 58     | 65     | 65     |
| E <sub>h7</sub> | 24     | 30     | 30     |
| F               | 78     | 100    | 100    |
| G               | 51     | 65     | 65     |
| J <sub>g6</sub> | 24     | 30     | 30     |
| a               | 80     | 100    | 125    |
| b               | 15,6   | 19,6   | 24,6   |
| c1              | M8     | M8     | M10    |
| c2              | M5     | M5     | M5     |
| c3              | M10    | M10    | M14    |
| d               | 60     | 80     | 110    |
| e               | 12     | 12     | 12     |
| f               | 18     | 20     | 25     |

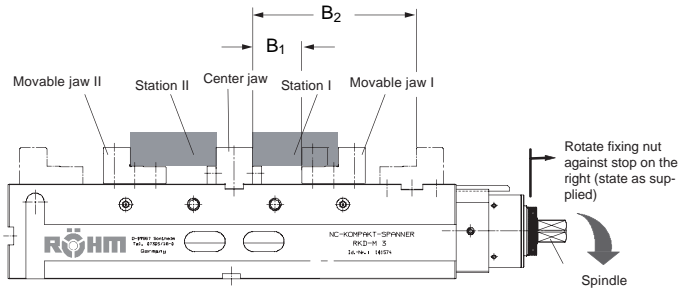
Type 743 - 51 SB  
**Stepped jaws - Set**



| Jaw width       | 92     | 125    | 160     | 200     |
|-----------------|--------|--------|---------|---------|
| Item no.        | 162851 | 160343 | 162630  | 162985  |
| B               | 64     | 94     | 98      | 103     |
| C               | 32     | 40     | 50      | 60      |
| D               | 42     | 60     | 65      | 70      |
| E <sub>h7</sub> | 20     | 24     | 30      | 30      |
| F               | 56     | 70     | 97      | 97      |
| G               | 38     | 47     | 63,5    | 63,5    |
| H/H*            | 25/25  | 40/30  | 34/32,5 | 39/32,5 |
| J <sub>g6</sub> | 20     | 24     | 30      | 30      |
| K               | 16     | 20     | 25      | 25      |
| a               | 63     | 80     | 100     | 125     |
| b               | 13,6   | 15,6   | 19,6    | 24,6    |
| c1              | M6     | M8     | M8      | M10     |
| c2              | M5     | M5     | M5      | M5      |
| c3              | M10    | M10    | M10     | M14     |
| d               | 48     | 60     | 80      | 110     |
| e               | 8      | 12     | 12      | 12      |
| f               | 14     | 18     | 20      | 25      |

# Clamping ranges RKD-M

## Clamping ranges: Twin clamping



**Function:**

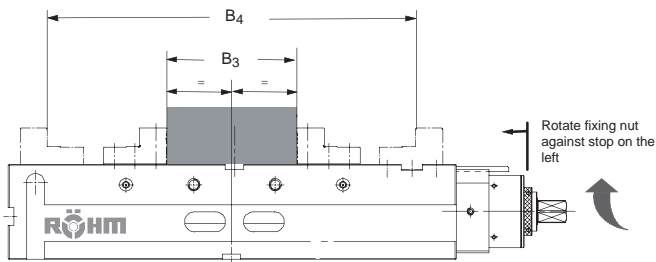
To adjust mobile jaw I with regard to the workpiece of station I turn the spindle to the right by means of the handle (left-right handed thread). About 1 kN are applied to keep the jaw in the adjusted position (third-hand function). By further turning the lever, mobile jaw II is adjusted with regard to workpiece in station II, locked and power via the mechanical spindle is transmitted. By means of compensating springs, variations between workpiece I and II of up to ± 3 mm are compensated.

**Both stations must always be equipped with identical workpieces for clamping!**

Fixing nut - stop on the right (spindle provides compensation)  
 Jaw stroke: "Z" Station I: 50mm  
 Station II: 56mm

| Size           |          | 92       | 125       |
|----------------|----------|----------|-----------|
| B <sub>1</sub> | Groove 1 | 0 - 48   | 0 - 48    |
|                | Groove 2 | 48 - 96  | 46 - 94   |
|                | Groove 3 | -        | 92 - 140  |
| B <sub>2</sub> | Groove 1 | 42 - 79  | 51 - 88   |
|                | Groove 2 | 79 - 127 | 86 - 134  |
|                | Groove 3 | -        | 132 - 180 |

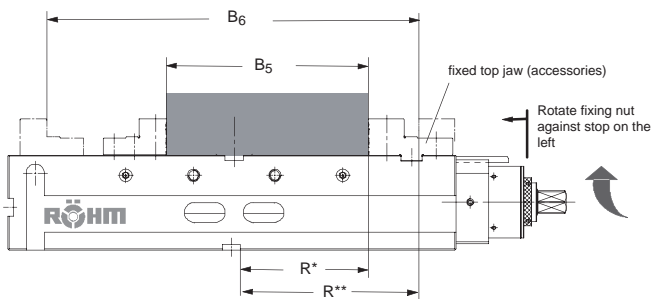
## Clamping ranges: Centric clamping



Remove central jaw  
 Fixing nut - stop on the left (spindle rigid)  
 Stroke per jaw: "Z" 53mm

| Size           |          | 92        | 125       |
|----------------|----------|-----------|-----------|
| B <sub>3</sub> | Groove 1 | 30 - 132  | 40 - 142  |
|                | Groove 2 | 126 - 228 | 132 - 235 |
|                | Groove 3 | -         | 224 - 327 |
| B <sub>4</sub> | Groove 1 | 92 - 195  | 120 - 222 |
|                | Groove 2 | 188 - 290 | 212 - 315 |
|                | Groove 3 | -         | 304 - 407 |

## Clamping ranges: Single clamping



Remove central jaw and movable mounting jaw I.  
 Install fixed mounting jaw (accessory - not in scope of delivery).  
 Fixing nut - stop on the left (spindle rigid)  
 Stroke of moving jaw: "Z" 53mm

| Size           |          | 92        | 125       |
|----------------|----------|-----------|-----------|
| B <sub>5</sub> | Groove 1 | 126 - 177 | 171 - 222 |
|                | Groove 2 | 174 - 225 | 217 - 268 |
|                | Groove 3 | -         | 263 - 314 |
| B <sub>6</sub> | Groove 1 | 196 - 247 | 267 - 318 |
|                | Groove 2 | 244 - 295 | 313 - 364 |
|                | Groove 3 | -         | 360 - 410 |
|                | R*       | 101       | 141       |
|                | R**      | 140       | 197       |



**Horizontal, vertical or side mounting.**

**Clamping system mechanical-mechanical with power transmitter, manually operated**  
Self-centering with two mobile jaws

**Technical features:**

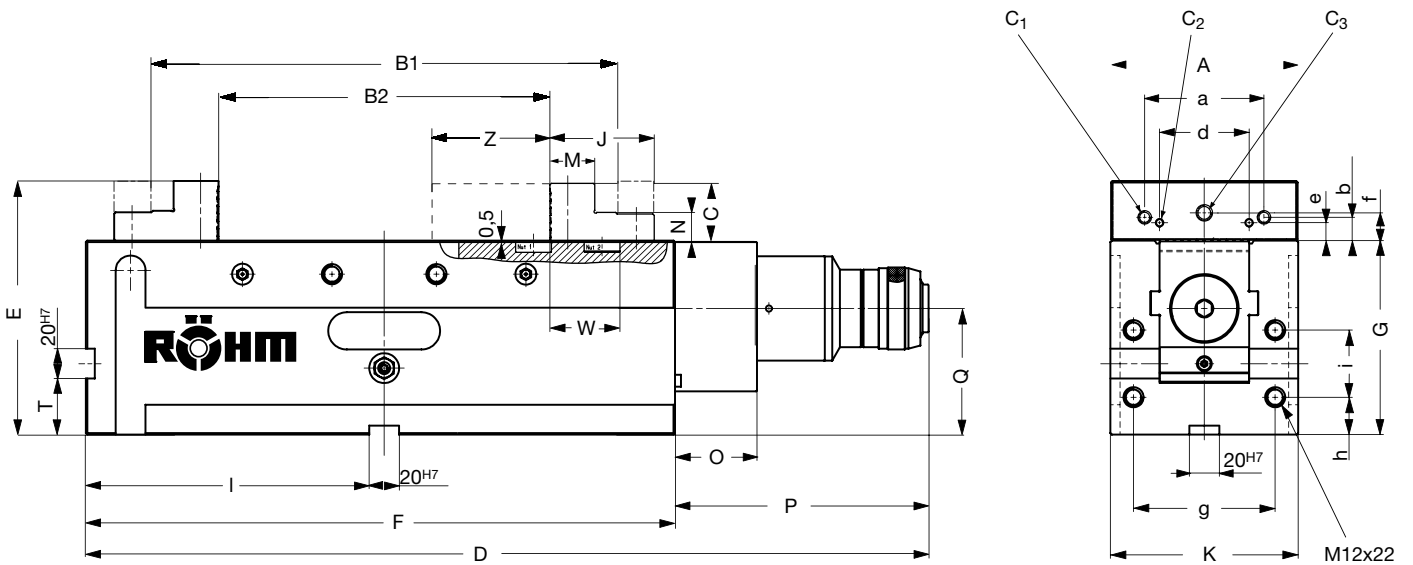
- constant force for each clamping process
- increased repeating accuracy
- the steel body and all guide surfaces are hardened and ground
- fastening of the vice with clamping claws only
- clamping accuracy at the centre:  $\pm 0,01$  - Repeating accuracy: 0,01

**Customer advantage:**

- the clamping thread of the spindle is protected in all positions to prevent the penetration of dirt and chips
- due to on both sides fixed grease nipples the lubrication of the spindle thread and all guides is ensured
- equipped as standard with stepped interchangeable jaws

Tool group A32  
Type 726-10 **RKZ**  
With stepped jaws

| Item no.           | 16256 ● |
|--------------------|---------|
| Jaw width A        | 125     |
| B1 slot 1          | 112-206 |
| B1 slot 2          | 204-298 |
| B2 slot 1          | 32-126  |
| B2 slot 2          | 124-218 |
| C                  | 40      |
| D                  | 565     |
| E                  | 170     |
| F                  | 395     |
| G <sub>-0,02</sub> | 130     |
| J                  | 70      |
| K                  | 126     |
| M                  | 30      |
| N <sub>-0,01</sub> | 20      |
| O                  | 55      |
| P                  | 170     |
| Q                  | 84,5    |
| T <sub>-0,02</sub> | 37,5    |
| W                  | 46      |
| Z stroke           | 50      |
| a                  | 80      |
| b                  | 15,6    |
| c1                 | M8x14   |
| c2                 | M5x10   |
| c3                 | M10x18  |
| d                  | 60      |
| e                  | 12      |
| f                  | 18      |
| g                  | 95      |
| h                  | 25      |
| i                  | 45      |
| l <sub>-0,02</sub> | 190     |
| Clamping force kN  | 40      |
| Weight kg          | 50,5    |



## Accessories RKZ

Tool group A37  
Type 726-60 **Stepped jaws SB**  
reversible, with fixing screws

| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 162631 <span style="color: yellow;">■</span> | set                  | 125  | 125   | 40     |



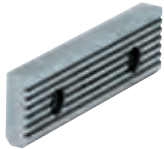
Tool group A37  
Type 726-60 **Raised stepped jaws ESB**

| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 164399 <span style="color: yellow;">■</span> | set                  | 125  | 125   | 60     |



Tool group A37  
Type 746-50 **Standard jaws SGN**  
one side smooth, one side  
grooved, hardened and ground

| Item no.                                    | Contents of delivery | Size | Width | Height |
|---|----------------------|------|-------|--------|
| 158897 <span style="color: green;">●</span> | set                  | 125  | 125   | 39,7   |



Tool group A37  
Type 746-50 **Standard jaws 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 |
|---|----------------------|------|-------|--------|
| 163225 <span style="color: green;">●</span> | set                  | 125  | 125   | 39,7   |





## Accessories RKZ

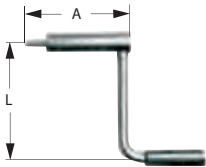
Tool group A37  
Type 726-52 **V-jaw PB**  
horizontal and vertical

| Item no.                                     | Contents of delivery | Size | Width | Height | Thickness | Height prism | Clamping range |          |
|--|----------------------|------|-------|--------|-----------|--------------|----------------|----------|
|  |                      |      |       |        |           |              | horizontal     | vertical |
| 158641 <span style="color: yellow;">■</span> | set                  | 125  | 125   | 40     | 20        | 24           | 15-40          | 18-60    |



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

| Item no.                                    | Contents of delivery | Size | Hexagon | A   | L   |
|---|----------------------|------|---------|-----|-----|
| 134600 <span style="color: green;">●</span> | piece                | 125  | 14      | 104 | 160 |



Tool group A37  
Type 726-19 **Angle drive**

| Item no.                                     | Contents of delivery | Size | A   | B   | C  |
|--|----------------------|------|-----|-----|----|
| 159015 <span style="color: yellow;">■</span> | piece                | 125  | 190 | 110 | 98 |



**RKZ-M**


Highly suitable for 5-side machining

**Clamping system mechanical without power transmitter, manually operated.**  
Self-centering with two mobile jaws

**Technical features:**

- Short, compact design
- large stroke
- the steel body and all guide surfaces are hardened and ground
- constant clamping force during every clamping operation and high repeating accuracy if torque wrenches are used
- clamping accuracy at the centre:  $\pm 0,02$  - repeating accuracy: 0,01

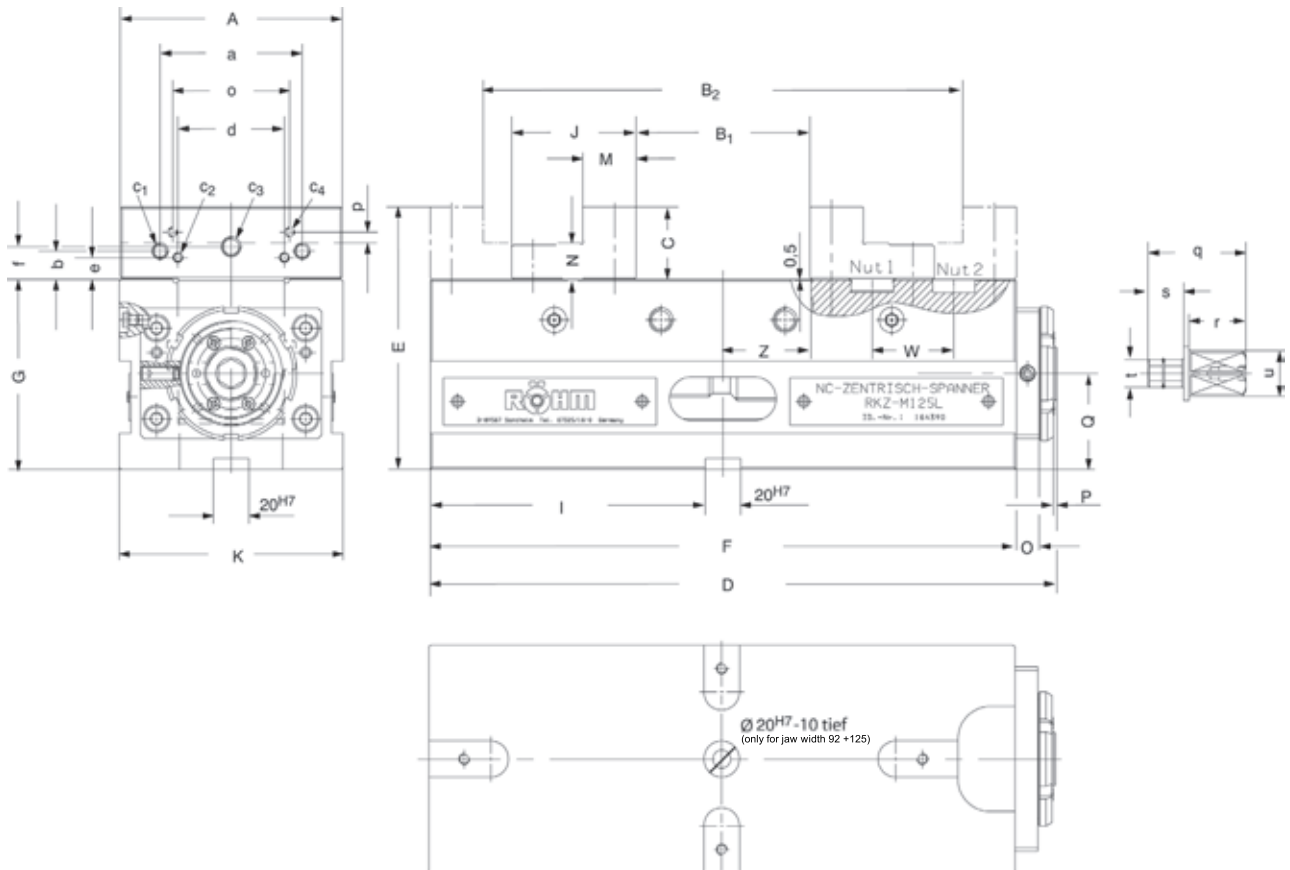
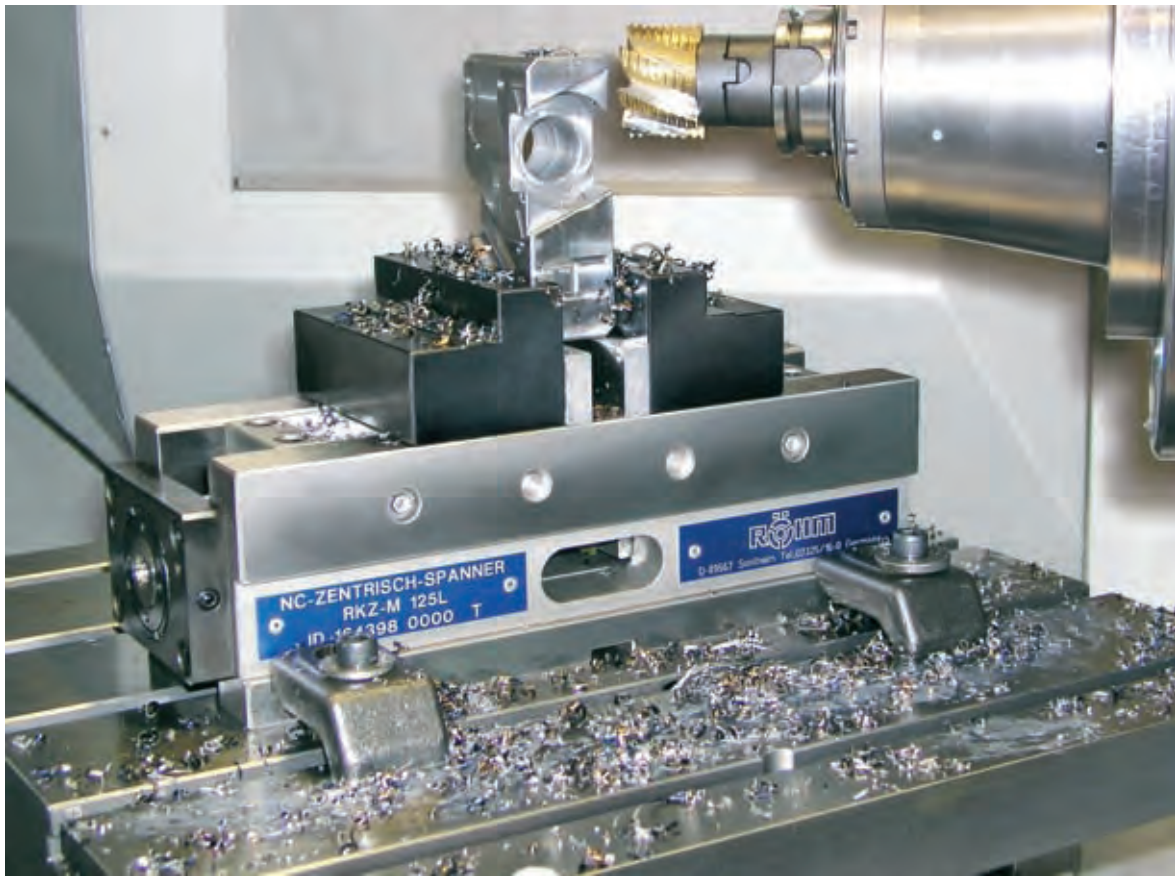
**Customer advantage:**

- equipped as standard with stepped interchangeable jaws
- special clamping jaws available on request

Tool group A32  
Type 726-00 **RKZ-M**  
**With stepped jaws**

| Item no.           | 164813 ●   | 164814 ●        | 164815 ●   | 164390 ●   | 164398 <sup>1)</sup> ● |
|--------------------|------------|-----------------|------------|------------|------------------------|
| Jaw width A        | 50         | 70              | 92         | 125        | 125                    |
| B1 slot 1          | 0-39       | 0 - 58          | 0 - 76     | 0 - 97     | 0 - 97                 |
| B1 slot 2          | 36-75      | 48-106          | 70-146     | 92-189     | 92-189                 |
| B2 slot 1          | 37-75      | 48-105          | 78-138     | 81-177     | 81-177                 |
| B2 slot 2          | 72-111     | 95-153          | 132-208    | 172-269    | 172-269                |
| C                  | 20         | 25              | 32         | 40         | 60                     |
| D <sub>max</sub>   | 157        | 209             | 283        | 353        | 353                    |
| E                  | 75         | 95              | 117        | 145        | 165                    |
| F                  | 140        | 190             | 260        | 330        | 330                    |
| G <sub>±0,02</sub> | 55         | 70              | 85         | 105        | 105                    |
| J                  | 32         | 41              | 56         | 70         | 70                     |
| K                  | 52         | 72              | 94         | 126        | 126                    |
| M                  | 14         | 17 <sup>5</sup> | 25         | 30         | 30                     |
| N <sub>±0,01</sub> | 10         | 12              | 16         | 20         | 40                     |
| O                  | 10         | 10              | 13         | 13         | 13                     |
| P                  | 1          | 1               | 2          | 2          | 2                      |
| Q                  | 31         | 40              | 41,5       | 53         | 53                     |
| W                  | 18         | 24              | 35         | 46         | 46                     |
| Z                  | 20,5       | 30              | 39         | 49,5       | 49,5                   |
| a                  | -          | -               | 63         | 80         | 80                     |
| b                  | -          | -               | 13,6       | 15,6       | 15,6                   |
| c1                 | -          | -               | M6x10      | M8x14      | M8x14                  |
| c2                 | M 4 x 8    | M 5 x 8         | M5x8       | M5x8       | M5x8                   |
| c3                 | -          | -               | M10x16     | M10x18     | M10x18                 |
| c4                 | M3x6       | M4x8            | M5x8       | M5x8       | M5x8                   |
| d                  | 26         | 37              | 48         | 60         | 60                     |
| e                  | 5          | 6               | 8          | 12         | 12                     |
| f                  | -          | -               | 14         | 18         | 18                     |
| l                  | 60         | 85              | 120        | 155        | 155                    |
| o                  | 32         | 52              | 55         | 55         | 55                     |
| p                  | 3,5        | 4,5             | 6          | 6          | 6                      |
| q                  | 38         | 52              | 55         | 55         | 55                     |
| r                  | 20         | 30              | 32         | 32         | 32                     |
| s                  | 15         | 19              | 20         | 20         | 20                     |
| t                  | 6 kt-SW 8  | 6 kt-SW 10      | 6 kt-SW 14 | 6 kt-SW 14 | 6 kt-SW 14             |
| u                  | 4 kt-SW 12 | 4 kt-SW 14      | 4 kt-SW 19 | 4 kt-SW 19 | 4 kt-SW 19             |
| Clamping force kN  | 10         | 15              | 20         | 25         | 25                     |
| Weight kg          | 3,5        | 7               | 18         | 32,5       | 35                     |

<sup>1)</sup> with enlarged stepped-jaws



## Accessories RKZ-M

Tool group A37  
Type 726-60 **Stepped jaws SB**  
reversible, with fixing screws



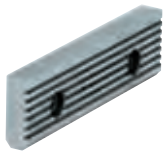
| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 164864 <span style="color: yellow;">■</span> | set                  | 50   | 50    | 20     |
| 164844 <span style="color: yellow;">■</span> | set                  | 70   | 70    | 25     |
| 161831 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     |
| 162631 <span style="color: yellow;">■</span> | set                  | 125  | 125   | 40     |

Tool group A37  
Type 726-60 **Raised stepped jaws ESB**



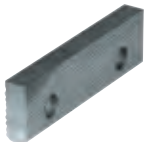
| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 164399 <span style="color: yellow;">■</span> | set                  | 125  | 125   | 60     |

Tool group A37  
Type 726-50 **Standard jaws SGN**  
one side smooth, one side  
grooved, hardened and ground



| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 165161 <span style="color: red;">▲</span>    | set                  | 50   | 50    | 19,6   |
| 165163 <span style="color: yellow;">■</span> | set                  | 70   | 70    | 24,6   |
| 162363 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     |
| 158897 <span style="color: green;">●</span>  | set                  | 125  | 125   | 39,7   |

Tool group A37  
Type 726-50 **Standard jaws fine checkered SGNf**  
one side fine checkered, one side  
grooved, hardened and ground



| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 165165 <span style="color: red;">▲</span>    | set                  | 50   | 50    | 19,6   |
| 165167 <span style="color: yellow;">■</span> | set                  | 70   | 70    | 24,6   |
| 163223 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     |
| 163225 <span style="color: green;">●</span>  | set                  | 125  | 125   | 39,7   |

Tool group A37  
Type 726-52 **V-jaw PB**  
horizontal and vertical



| Item no.                                     | Contents of delivery | Size | Width | Height | Thickness | Height prism | Clamping range |          |
|--|----------------------|------|-------|--------|-----------|--------------|----------------|----------|
|  |                      |      |       |        |           |              | horizontal     | vertical |
| 165169 <span style="color: yellow;">■</span> | set                  | 50   | 50    | 20     | 10        | 12           | 6-16           | 6-16     |
| 165171 <span style="color: yellow;">■</span> | set                  | 70   | 70    | 25     | 12        | 14           | 8-24           | 8-24     |
| 162365 <span style="color: yellow;">■</span> | set                  | 92   | 92    | 32     | 16        | 19,5         | 12-36          | 12-36    |
| 158641 <span style="color: yellow;">■</span> | set                  | 125  | 125   | 40     | 20        | 24           | 15-40          | 18-60    |

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



| Item no.                                    | Contents of delivery | Size | Octagon | L   |
|---|----------------------|------|---------|-----|
| 009150 <span style="color: green;">●</span> | piece                | 50   | 12      | 80  |
| 009152 <span style="color: green;">●</span> | piece                | 70   | 14      | 125 |
| 382112 <span style="color: green;">●</span> | piece                | 92   | 19      | 160 |
| 009154 <span style="color: green;">●</span> | piece                | 125  | 19      | 200 |

Tool group A37  
Type 726-00 **Drive adapter ATA**



| Item no.                                     | Contents of delivery | Size   | Square | Hexagon |
|--|----------------------|--------|--------|---------|
| 164971 <span style="color: yellow;">■</span> | piece                | 50     | 12     | 8       |
| 164842 <span style="color: yellow;">■</span> | piece                | 70     | 14     | 10      |
| 164625 <span style="color: yellow;">■</span> | piece                | 92/125 | 19     | 14      |

## General accessories

| Tool group A37<br>Type 743-00<br><b>Dual clamp DSP</b><br>complete, for connecting two compact vices base-to-base for mutual support | Item no. | Contents of delivery |
|--|----------|----------------------|
|  | 149125 ● | piece                |



| Tool group A37<br>Type 743-00<br><b>Single clamp SPE</b><br>complete, for mounting vices on the end and on the base | Item no. | Contents of delivery | T-slot | Thread |
|---|----------|----------------------|--------|--------|
|   | 149121 ● | piece                | 12     | M10x55 |
|   | 149122 ● | piece                | 14     | M12x55 |
|   | 149123 ● | piece                | 16     | M12x60 |
|   | 149124 ● | piece                | 18     | M16x60 |
|   | 155722 ● | piece                | 20     | M16x65 |
|   | 151507 ● | piece                | 22     | M16x65 |



| Tool group A37<br>Type 740-02<br><b>Work locator WSA</b><br>universally adjustable, to screw on the vice, M12 connecting screw | Item no. | Contents of delivery |
|--|----------|----------------------|
|  | 320400 ● | piece                |



| Tool group A37<br>Type 740-02<br><b>Work locator WSA</b><br>universally adjustable, can be mounted on the machine table (14 mm T-slot) or bolted onto the vice (M12) | Item no. | Contents of delivery |
|--|----------|----------------------|
|  | 320401 ● | piece                |



| Tool group A37<br>Type 740-02<br><b>Precision vice locator PSA</b><br>universally adjustable, to screw on the vice, M12 connecting screw | Item no. | Contents of delivery |
|--|----------|----------------------|
|  | 681192 ● | piece                |



| Tool group A37<br>Type 739<br><b>Fixed slot nuts NTS</b><br>hardened and ground, with fixing screw | Item no. | Contents of delivery | Size  | Length |
|--|----------|----------------------|-------|--------|
|  | 014823 ● | set                  | 20x12 | 22     |
|  | 014825 ● | set                  | 20x14 | 25     |
|  | 014827 ● | set                  | 20x16 | 25     |
|  | 014829 ● | set                  | 20x18 | 25     |
|  | 014831 ● | set                  | 20x20 | 22     |
|  | 014833 ● | set                  | 20x22 | 32     |





They are mainly used for highly accurate work on CNC milling machines and machining centers. Due to their compact and stable design especially large workpieces can be clamped.

Mounting on machine table or pallet, with clamps or directly by means of mounting bores (index measuring 50 mm).

**Clamping system mechanical, various operating possibilities.**

**Technical features:**

- with hand crank (without top jaws)
- high clamping force is supplied by ground spindle with left- and right-hand threading and roller born
- clamping accuracy repeatable to within 0,005 mm
- very high clamping and centering accuracy

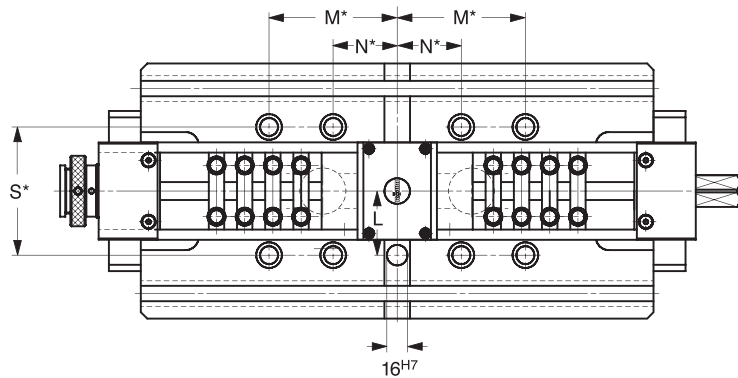
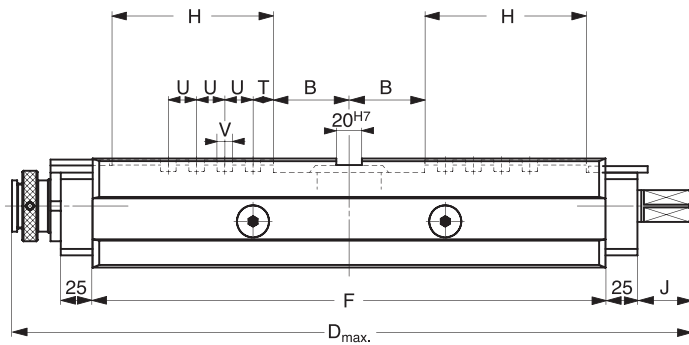
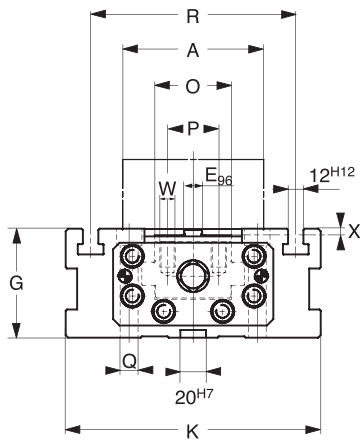
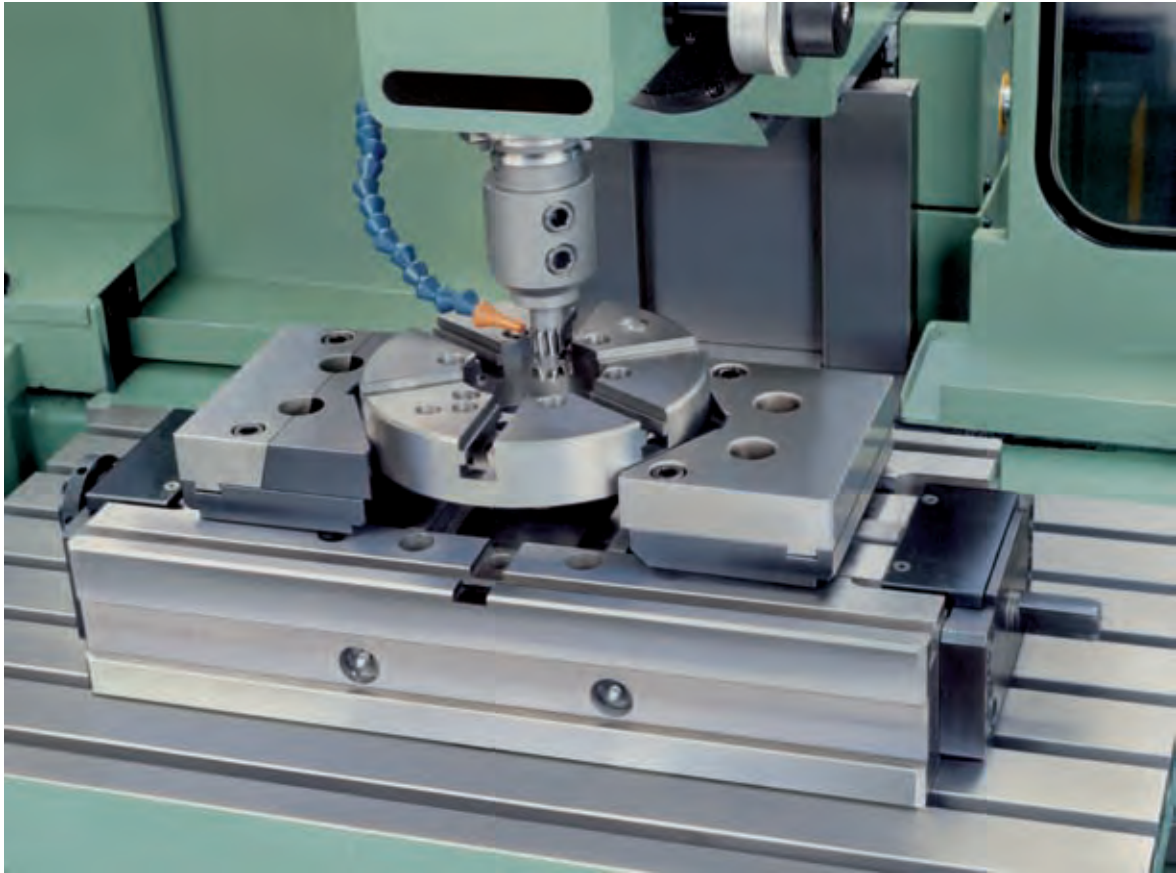
**Customer advantage:**

- clamps centrally with two movable basic jaws
- either one or two work-pieces can be clamped (one work piece with axially led rigid spindle, two work pieces with compensating spindle)
- suitable for internal and external clamping
- unusually large clamping range in relation to the overall length
- self-locking power transmission
- Easy to service: Four lubricating nipples are sufficient to lubricate all surfaces subject to wear

Tool group A32  
Type 726-00 **NCZ**  
With standard jaws

| Item no.          | 145661 <span style="color: yellow;">■</span> | 145660 <span style="color: yellow;">■</span> |
|-------------------|--|--|
| Size              | 2  | 4  |
| Jaw width A       | 110  | 160  |
| Bmax              | 59   | 77   |
| Bmin              | 34   | 43   |
| D                 | 532  | 638  |
| E                 | 14   | 20   |
| F                 | 400  | 500  |
| G <sub>0.03</sub> | 85   | 100  |
| H                 | 126  | 158  |
| J                 | 44   | 48   |
| K                 | 199  | 249  |
| L±0,05            | 50   | 75   |
| M1)               | 100  | 100  |
| N1)               | 50   | 50   |
| O                 | 60   | 100  |
| P                 | 40   | 60   |
| Q                 | Ø 14   | Ø 14   |
| R                 | 160  | 205  |
| S                 | 100  | 150  |
| T                 | 16   | 20   |
| U                 | 22   | 30   |
| V                 | 12   | 16   |
| W                 | M12  | M16  |
| X±0,01            | 5  | 6  |
| Clamping force kN | 25   | 50   |
| Jaw travel        | 25   | 34   |
| Weight kg         | 50   | 85   |

1) different dimensions on request



## Accessories NCZ

Tool group A37  
Type 726-50  
**Standard jaws SB complete**,  
with mounting screws  
reversible,  
**with SNS keep-down inserts**  
and a bolt-on surface for clamping  
jaws or special jaws; the upper  
side can also be used for bolting  
on special jaws

| Item no.                                     | Contents of delivery | Size | Width |
|--|----------------------|------|-------|
| 150556 <span style="color: yellow;">■</span> | set                  | 2    | 110   |
| 150557 <span style="color: yellow;">■</span> | set                  | 4    | 160   |



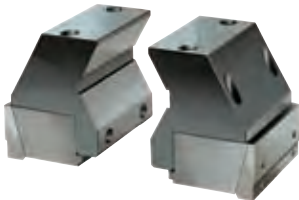
Tool group A37  
Type 726-73  
**V-jaw PB**, vertical  
one side rigid, one side floating  
transversal to the clamping  
direction, with fixing screws

| Item no.                                  | Contents of delivery | Size | Width | Height | Length | Size prism |
|---|----------------------|------|-------|--------|--------|------------|
| 146225 <span style="color: red;">▲</span> | set                  | 2    | 110   | 20     | 101    | 99         |
| 146065 <span style="color: red;">▲</span> | set                  | 4    | 160   | 30     | 119    | 145        |



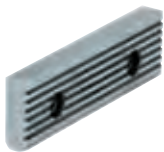
Tool group A37  
Type 726-52 **V-jaw PB**, horizontal  
for fastening at the standard jaws,  
with fixing screws

| Item no.                                  | Contents of delivery | Size | Width | Height | Length | Size prism |
|---|----------------------|------|-------|--------|--------|------------|
| 146221 <span style="color: red;">▲</span> | set                  | 2    | 110   | 105    | 108    | 80         |
| 146057 <span style="color: red;">▲</span> | set                  | 4    | 160   | 150    | 135    | 109        |



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 <span style="color: green;">●</span> | piece                | 2    | 113   | 31,6   |
| 152755 <span style="color: green;">●</span> | piece                | 4    | 160   | 49,6   |



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 <span style="color: yellow;">■</span> | piece                | 2    | 113   | 31,6   |
| 156197 <span style="color: green;">●</span>  | piece                | 4    | 160   | 49,6   |





## Accessories NCZ

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     |
| 082364 ● | piece                | 4    | 160   | 49,6   | 5-29           | 7-48     |



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   |
| 077106 ● | set                  | 4    | 160   | 49,6   |



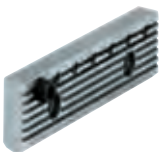
Tool group A37  
Type 728-00  
**V-jaw and standard jawSBO**  
soft and gunmetal-finished, with  
work support; for BOF and BSS

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



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   |
| 150741 ▲ | piece                | 4    | 160   | 49,6   |



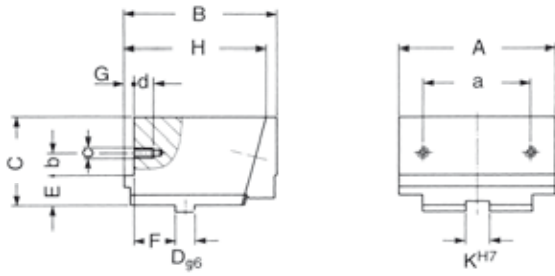
Tool group C15  
Type 7004-Y **Hand crank HKU**  
with octagon socket

| Item no. | Contents of delivery | Size | Octagon | L   |
|----------|----------------------|------|---------|-----|
| 382112 ● | piece                | 2    | 19      | 160 |
| 009154 ● | piece                | 4    | 19      | 200 |



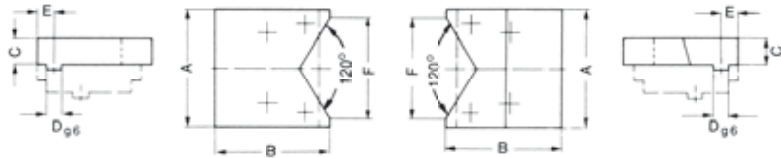
# Jaw dimensions NCZ

Type 726-50 **Standard jaw**



| Size | 2    | 4    |
|------|------|------|
| A    | 110  | 160  |
| B    | 98   | 128  |
| C    | 54   | 73   |
| D    | 12   | 16   |
| E    | 22,4 | 23,4 |
| F    | 30   | 37   |
| G    | 8    | 9    |
| H    | 91   | 118  |
| K    | 14   | 20   |
| a    | 63   | 100  |
| b    | 13,6 | 19,6 |
| c    | M6   | M8   |
| d    | 12   | 13   |

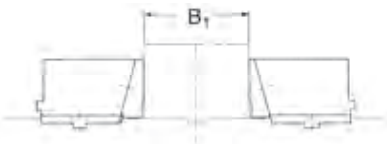
Type 726-73 **V-jaws (vertical)**



| Size | 2   | 4    |
|------|-----|------|
| A    | 110 | 160  |
| B    | 101 | 119  |
| C    | 20  | 30   |
| D    | 16  | 16   |
| E    | 17  | 17,5 |
| F    | 99  | 145  |

# Clamping ranges NCZ

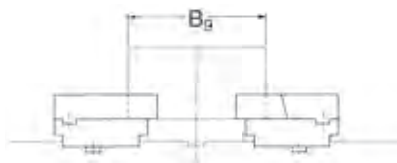
**Standard jaws (reversible)**



Standard jaws (reversible)

|                |        |        |
|----------------|--------|--------|
| B <sub>1</sub> | 38-172 | 42-222 |
|----------------|--------|--------|

**V-jaws (vertical) on support plates**



V-jaws (vertical) on support plates

|                |        |        |
|----------------|--------|--------|
| B <sub>9</sub> | 55-190 | 07-284 |
|----------------|--------|--------|

**V-jaws (horizontal) on standard jaws**



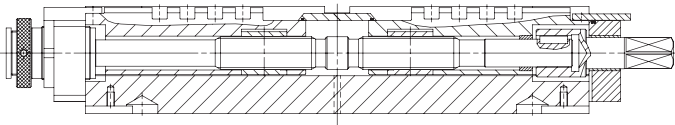
V-jaws (horizontal) on standard jaws

|                 |        |        |
|-----------------|--------|--------|
| B <sub>10</sub> | 55-150 | 80-200 |
|-----------------|--------|--------|

Clamping range is only possible if the workpieces are leaded sideways

# Clamping system / Drive types NCZ

**Mechanical NCZ clamping system:  
Mechanical drive with hand crank**



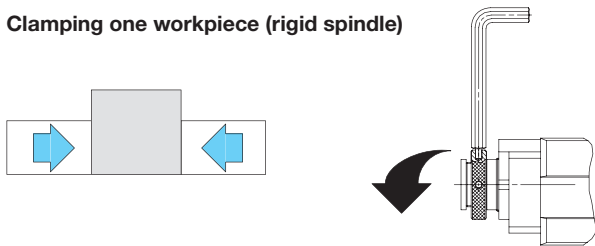
**Advantages:**

- High and reliable clamping force
- Clamps centrally with two movable basic jaws
- Clamping of one workpiece with axially led rigid spindle or clamping of two workpieces with compensating spindle and center locator
- Self-locking power transmission

**Clamping:**

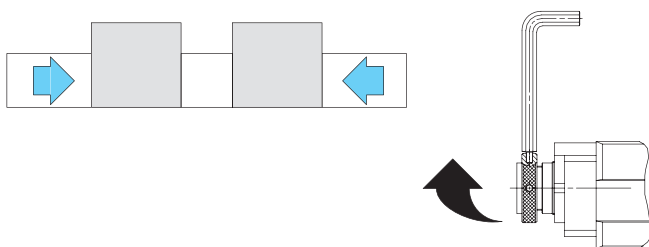
By rotating the spindle (with right-hand and left-hand thread) with the hand crank (or drive variants 2 – 5), the movable basic jaws with the appropriate top jaws centrally approach the workpiece and the clamping force is safely built up.

**Clamping one workpiece (rigid spindle)**



To clamp a workpiece centrally, the spindle with two opposing threads must be rigidly housed – adjusting nut turned to the right (as when delivered). In the factory, the center of the clamping device is aligned with the fitting groove in the center of the casing and can be corrected, if required.

**Clamping 2 workpieces (compensating spindle)**



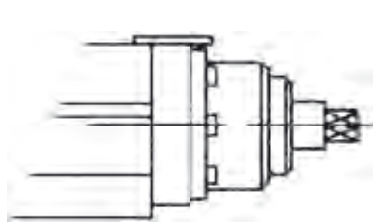
For clamping two workpieces, the center locator matching the clamping jaws used is generally mounted. This is rigidly fixed in the fitting groove. During these clamping operations, therefore, the clamping jaws must compensate the workpiece tolerances, i.e. the spindle must be axially movable. The jaws are thus uniformly brought up to both workpieces and the clamping pressure is built up to the same level for both of them.

**Converting the spindle from rigid to compensating**

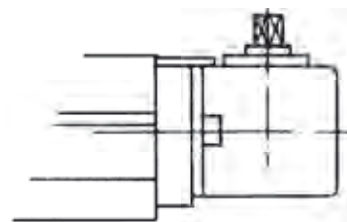
After loosening and turning the setting nuts to the left, the spindle and the basic jaws have an axial movement of 3 mm.

**5 different drive variants:**

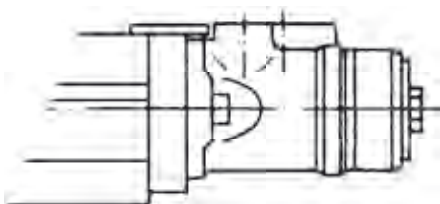
Depending on the application, RÖHM NCZ self-centering vices can, additional to the standard equipment (manual with hand crank, type of drive 1), be equipped with different types of drive:



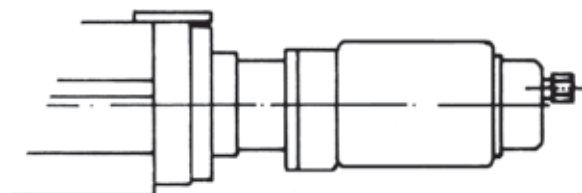
**2.** Manual with power intensifier and hand crank (i=1:4). The clamping force cannot be preset.



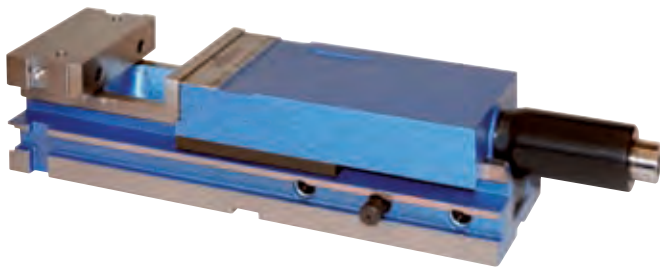
**3.** Manual with angle drive and hand crank, especially suitable for large machine tables or pallets.



**4.** Hydraulic motor, especially suitable for rationally clamping series parts in the minimum time.



**5.** Pneumatic motor, especially suitable for rationally clamping series parts in the minimum time.



For the universal application on milling machines and machining centers. Horizontal, vertical or side mounting with height adjustment  $\pm 0,02$ .

Standard version

High reliability, long working life and high precision

**Clamping system mechanical without power transmitter, manually operated.**

**Technical features:**

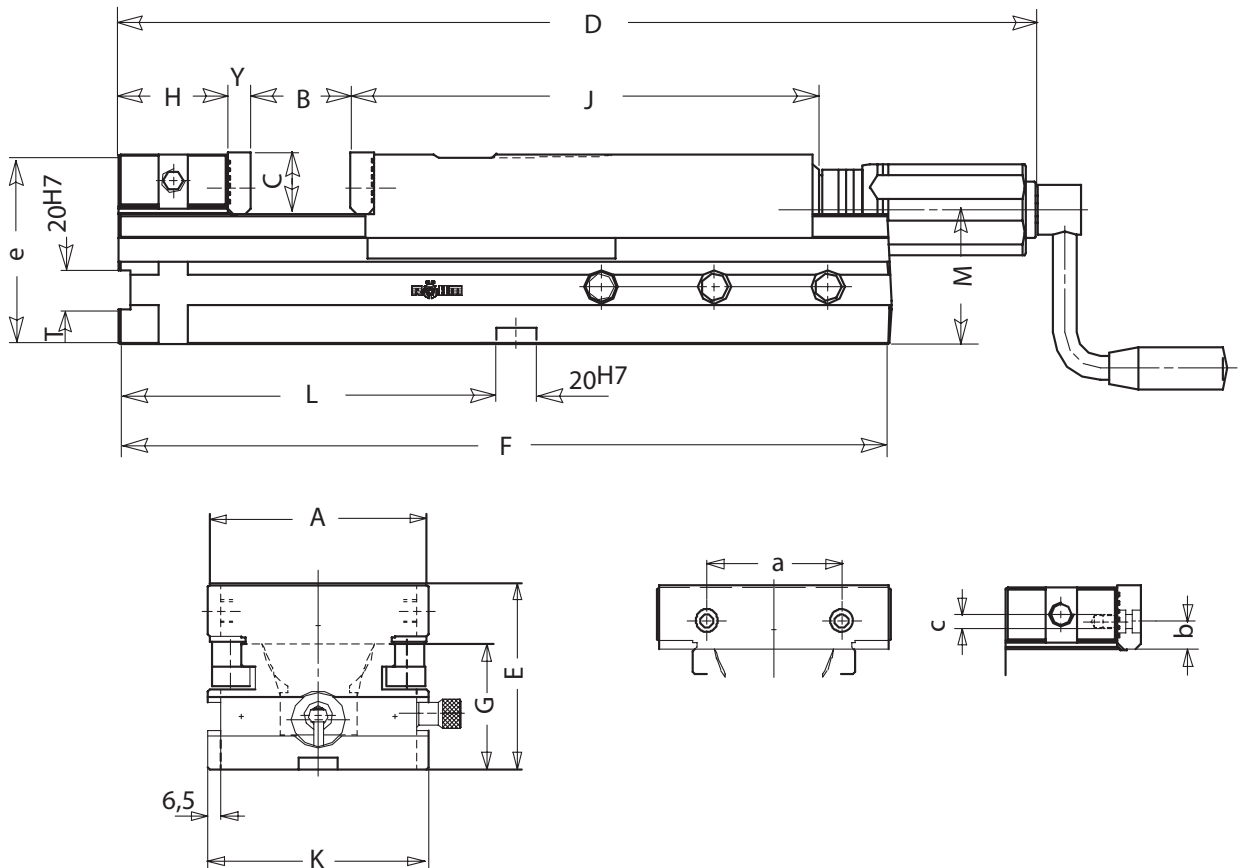
- steel body with stationary jaw, uniformly forged into the die
- locking device for the mechanical pre-clamping of workpieces
- automatic reclamping in the hydraulic unit via the installed belleville spring
- all wear parts, primarily the jaw guides, are hardened and ground
- robust guide surface of the movable jaw

**Customer advantage:**

- robust and maintenance-free spindle
- rapid-change hydraulic unit
- with normal jaws and hand crank
- locking pin is protected against dirt and chips
- rapid adjustment of the clamping range via locking pin

Tool group A27  
Type 746-10 **RBA**  
Standard version

| Item no.                           | 153394 <span style="color: yellow;">■</span> | 153395 <span style="color: green;">●</span> | 153396 <span style="color: green;">●</span> | 153397 <span style="color: yellow;">■</span> |
|------------------------------------|--|---|---|--|
| Size                               | 1  | 2   | 3   | 4  |
| Jaw width A                        | 92   | 113   | 135   | 160  |
| B                                  | 0-100  | 0-170                                       | 0-220                                       | 0-310  |
| C                                  | 31,6   | 31,6  | 39,6  | 49,6   |
| D <sub>max</sub>                   | 490  | 583   | 681   | 817  |
| E <sub><math>\pm 0,02</math></sub> | 91,2   | 97,7  | 112,7                                       | 133,7  |
| F                                  | 310  | 390   | 468   | 574  |
| G $\pm 0,02$                       | 59   | 65,5  | 72,5  | 83,5   |
| H $\pm 0,02$                       | 50   | 55  | 70  | 80   |
| J                                  | 218  | 236,5                                       | 262   | 298  |
| K $\pm 0,02$                       | 94   | 115   | 137   | 162  |
| L $\pm 0,02$                       | 130  | 190   | 190   | 240  |
| M                                  | 61,5   | 68  | 78  | 93   |
| T $\pm 0,02$                       | 12,5   | 175   | 175   | 22,5   |
| Y <sub>-0,01</sub>                 | 11,6   | 11,6  | 15,6  | 15,6   |
| a                                  | 63   | 63  | 80  | 100  |
| b                                  | 13,6   | 13,6  | 15,6  | 19,6   |
| c                                  | M6   | M6  | M8  | M8   |
| d                                  | 12   | 12  | 13  | 13   |
| e <sub><math>\pm 0,02</math></sub> | 89,5   | 96  | 111   | 132  |
| Clamping force kN                  | 25   | 30  | 40  | 50   |
| Weight kg                          | 15,5   | 24  | 39  | 60   |



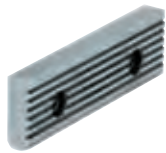
# Accessories RBA

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



| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 077104 <span style="color: yellow;">■</span> | set                  | 2    | 113   | 31,6   |
| 077105 <span style="color: green;">●</span>  | set                  | 3    | 135   | 39,6   |
| 077106 <span style="color: green;">●</span>  | set                  | 4    | 160   | 49,6   |

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 |
|---|----------------------|------|-------|--------|
| 152752 <span style="color: green;">●</span> | piece                | 1    | 92    | 31,6   |
| 152753 <span style="color: green;">●</span> | piece                | 2    | 113   | 31,6   |
| 152754 <span style="color: green;">●</span> | piece                | 3    | 135   | 39,6   |
| 152755 <span style="color: green;">●</span> | piece                | 4    | 160   | 49,6   |

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



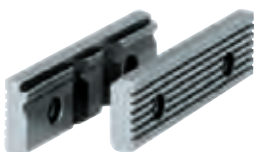
| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 163218 <span style="color: green;">●</span>  | piece                | 1    | 92    | 31,6   |
| 156195 <span style="color: yellow;">■</span> | piece                | 2    | 113   | 31,6   |
| 156196 <span style="color: green;">●</span>  | piece                | 3    | 135   | 39,6   |
| 156197 <span style="color: green;">●</span>  | piece                | 4    | 160   | 49,6   |

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 |
| 128770 <span style="color: green;">●</span> | piece                | 1    | 92    | 31,6   | 3-13           | 5-32     |
| 082362 <span style="color: green;">●</span> | piece                | 2    | 113   | 31,6   | 3-13           | 5-32     |
| 082363 <span style="color: green;">●</span> | piece                | 3    | 135   | 39,6   | 4-20           | 6-40     |
| 082364 <span style="color: green;">●</span> | piece                | 4    | 160   | 49,6   | 5-29           | 7-48     |

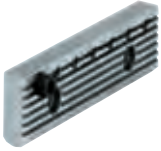
Tool group A37  
Type 728-00  
**V-jaw and standard jawsBO**  
soft and gunmetal-finished, with work support; for BOF and BSS



| Item no.                                    | Contents of delivery | Size | Width | Height | Clamping range |          |
|---|----------------------|------|-------|--------|----------------|----------|
|   |                      |      |       |        | Horizontal     | Vertical |
| 317259 <span style="color: green;">●</span> | set                  | 2    | 110   | 31,8   | 3-12           | 5-32     |
| 317260 <span style="color: green;">●</span> | set                  | 3    | 135   | 39,8   | 3-13           | 6-40     |
| 317261 <span style="color: green;">●</span> | set                  | 4    | 160   | 49,8   | 5-22           | 7-48     |

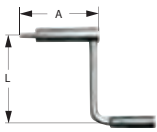
## Accessories RBA

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 <span style="color: yellow;">■</span> | piece                | 2    | 113   | 31,6   |
| 150740 <span style="color: yellow;">■</span> | piece                | 3    | 135   | 39,6   |
| 150741 <span style="color: yellow;">■</span> | 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 <span style="color: green;">●</span> | piece                | 1/2  | 12      | 48  | 80 |
| 134198 <span style="color: green;">●</span> | piece                | 3    | 12      | 60  | 90 |
| 134499 <span style="color: green;">●</span> | piece                | 4    | 12      | 117 | 90 |

Tool group A37  
Type 744-50 **Angle drive**  
for bolting onto the movable jaw  
(the movable jaw must be  
reworked), for activating the  
spindle screw from above (90°)



| Item no.                                     | Contents of delivery | Size |
|--|----------------------|------|
| 142351 <span style="color: yellow;">■</span> | piece                | 1-4  |

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

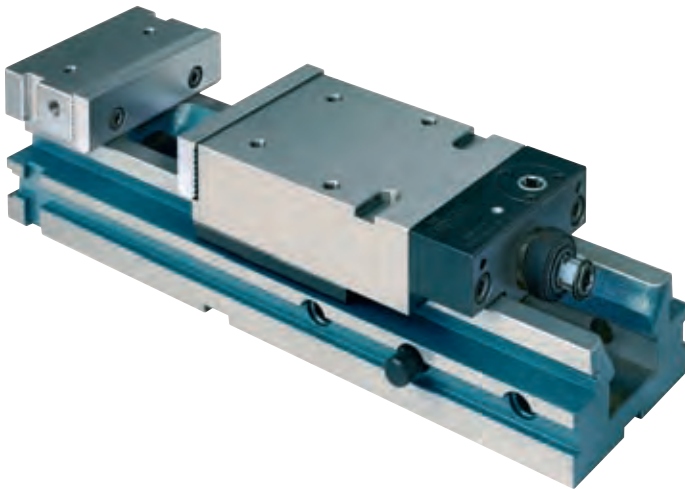


| Item no.                                    | Contents of delivery | Size | A   | B  |
|---|----------------------|------|-----|----|
| 094170 <span style="color: green;">●</span> | piece                | 1    | 102 | 56 |
| 226502 <span style="color: green;">●</span> | piece                | 2    | 109 | 62 |
| 226503 <span style="color: green;">●</span> | piece                | 3    | 114 | 70 |
| 226504 <span style="color: green;">●</span> | piece                | 4    | 115 | 70 |

Tool group A37  
Type 744 **Spindle** complete



| Item no.                                     | Contents of delivery | Size | L   |
|--|----------------------|------|-----|
| 134185 <span style="color: yellow;">■</span> | piece                | 1    | 91  |
| 134186 <span style="color: green;">●</span>  | piece                | 2    | 99  |
| 134187 <span style="color: green;">●</span>  | piece                | 3    | 116 |
| 134188 <span style="color: green;">●</span>  | piece                | 4    | 151 |

**RBAW**


For the universal application on milling machines and machining centers. Horizontal, vertical or side mounting with height adjustment  $\pm 0,02$ .

**With angle drive**

High reliability, long working life and high precision

**Clamping system mechanical-hydraulic with power transmitter, manually operated.**

**Technical features:**

- steel body with stationary jaw, uniformly forged into the die
- automatic reclamping in the hydraulic unit via the installed belleville spring
- all wear parts, primarily the jaw guides, are hardened and ground
- robust guide surface of the movable jaw
- with normal jaws and hand crank

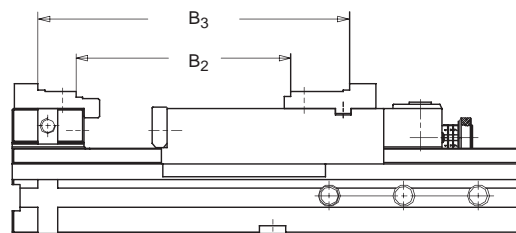
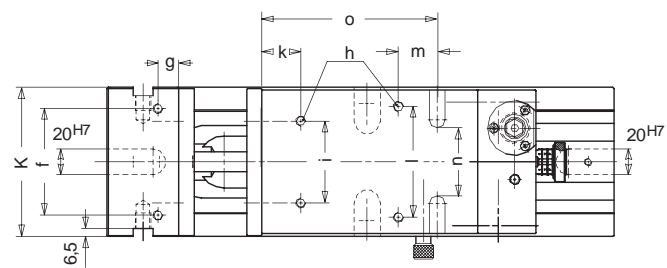
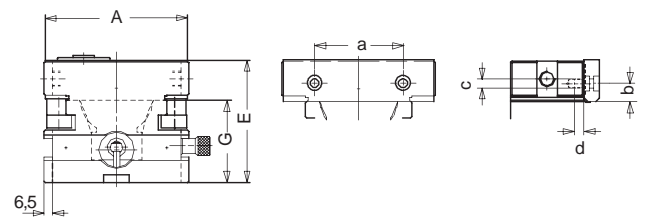
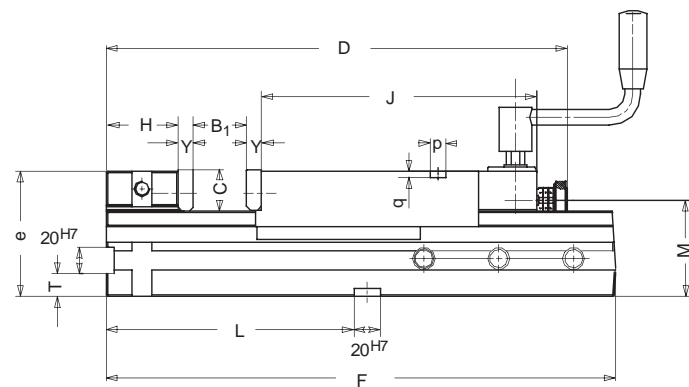
**Customer advantage:**

- robust and maintenance-free spindle
- the short design of the movable jaw (made of steel) allows a reduced overall length even by max. clamping width
- further stepped or special top jaws can be fixed on the top of the stationary and movable jaws
- locking pin is protected against dirt and chips
- large clamping range

Tool group A27  
Type 748-10 **RBAW**  
With angle drive

| Item no.                           | 154763 ● | 154764 ● | 154765 ● |
|------------------------------------|----------|----------|----------|
| Size                               | 2        | 3        | 4        |
| Jaw width A                        | 113      | 135      | 160      |
| B1                                 | 0-175    | 0-225    | 0-310    |
| B2                                 | 125-300  | 138-363  | 146-454  |
| B3                                 | 199-374  | 220-445  | 248-556  |
| C                                  | 31,6     | 39,6     | 49,6     |
| D <sub>max</sub>                   | 500      | 578      | 702      |
| E <sub><math>\pm 0,02</math></sub> | 97,7     | 112,7    | 133,7    |
| F                                  | 390      | 468      | 574      |
| G $\pm 0,02$                       | 65,5     | 72,5     | 83,5     |
| H $\pm 0,02$                       | 55       | 70       | 80       |
| J                                  | 211      | 213      | 240      |
| K $\pm 0,02$                       | 115      | 137      | 162      |
| L $\pm 0,02$                       | 190      | 190      | 240      |
| M                                  | 73,5     | 80,5     | 96       |
| T $\pm 0,02$                       | 175      | 175      | 22,5     |
| Y <sub>-0,01</sub>                 | 11,6     | 15,6     | 15,6     |
| a                                  | 63       | 80       | 100      |
| b                                  | 13,6     | 15,6     | 19,6     |
| c                                  | M6       | M8       | M8       |
| d                                  | 12       | 13       | 13       |
| e <sub><math>\pm 0,02</math></sub> | 96       | 111      | 132      |
| f                                  | 82       | 80       | 100      |
| g                                  | 16       | 30       | 30       |
| h                                  | M 8 x 14 | M10x16   | M12x20   |
| i                                  | 63       | 80       | 100      |
| k                                  | 30       | 30       | 30       |
| l                                  | 85       | 105      | 120      |
| m                                  | 30       | 35       | 35       |
| n                                  | 52       | 70       | 96       |
| o                                  | 135      | 135      | 142      |
| p <sup>H7</sup>                    | 12       | 14       | 14       |
| q                                  | 5        | 5        | 5        |
| Clamping force kN                  | 30       | 40       | 50       |
| Weight kg                          | 22       | 36       | 62       |





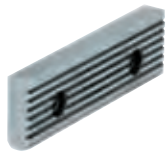
# Accessories RBAW

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



| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 077104 <span style="color: yellow;">■</span> | set                  | 2    | 113   | 31,6   |
| 077105 <span style="color: green;">●</span>  | set                  | 3    | 135   | 39,6   |
| 077106 <span style="color: green;">●</span>  | set                  | 4    | 160   | 49,6   |

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 <span style="color: green;">●</span> | piece                | 2    | 113   | 31,6   |
| 152754 <span style="color: green;">●</span> | piece                | 3    | 135   | 39,6   |
| 152755 <span style="color: green;">●</span> | piece                | 4    | 160   | 49,6   |

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



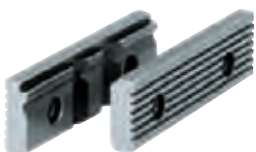
| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 156195 <span style="color: yellow;">■</span> | piece                | 2    | 113   | 31,6   |
| 156196 <span style="color: green;">●</span>  | piece                | 3    | 135   | 39,6   |
| 156197 <span style="color: green;">●</span>  | piece                | 4    | 160   | 49,6   |

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 <span style="color: green;">●</span> | piece                | 2    | 113   | 31,6   | 3-13           | 5-32     |
| 082363 <span style="color: green;">●</span> | piece                | 3    | 135   | 39,6   | 4-20           | 6-40     |
| 082364 <span style="color: green;">●</span> | piece                | 4    | 160   | 49,6   | 5-29           | 7-48     |

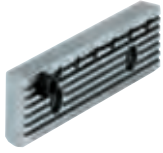
Tool group A37  
Type 728-00  
**V-jaw and standard jawSBO**  
soft and gunmetal-finished, with work support; for BOF and BSS



| Item no.                                    | Contents of delivery | Size | Width | Height | Clamping range |          |
|---|----------------------|------|-------|--------|----------------|----------|
|   |                      |      |       |        | Horizontal     | Vertical |
| 317259 <span style="color: green;">●</span> | set                  | 2    | 110   | 31,8   | 3-12           | 5-32     |
| 317260 <span style="color: green;">●</span> | set                  | 3    | 135   | 39,8   | 3-13           | 6-40     |
| 317261 <span style="color: green;">●</span> | set                  | 4    | 160   | 49,8   | 5-22           | 7-48     |

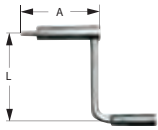
## Accessories RBAW

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 <span style="color: yellow;">■</span> | piece                | 2    | 113   | 31,6   |
| 150740 <span style="color: yellow;">■</span> | piece                | 3    | 135   | 39,6   |
| 150741 <span style="color: yellow;">■</span> | 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  |
|---|----------------------|-------|---------|-----|----|
| 134499 <span style="color: green;">●</span> | piece                | 2/3/4 | 12      | 117 | 90 |

# General accessories

Tool group A37  
Type 743-00  
**Dual clamp DSP**  
complete, for connecting two compact vices base-to-base for mutual support



| Item no. | Contents of delivery |
|----------|----------------------|
| 149125 ● | piece                |

Tool group A37  
Type 743-00  
**Single clamp SPE**  
complete, for mounting vices on the end and on the base



| Item no. | Contents of delivery | T-slot | Thread |
|----------|----------------------|--------|--------|
| 149121 ● | piece                | 12     | M10x55 |
| 149122 ● | piece                | 14     | M12x55 |
| 149123 ● | piece                | 16     | M12x60 |
| 149124 ● | piece                | 18     | M16x60 |
| 155722 ● | piece                | 20     | M16x65 |
| 151507 ● | piece                | 22     | M16x65 |

Tool group A37  
Type 740-02  
**Work locator WSA**  
universally adjustable, to screw on the vice, M12 connecting screw



| Item no. | Contents of delivery |
|----------|----------------------|
| 320400 ● | piece                |

Tool group A37  
Type 740-02  
**Work locator WSA**  
universally adjustable, can be mounted on the machine table (14 mm T-slot) or bolted onto the vice (M12)



| Item no. | Contents of delivery |
|----------|----------------------|
| 320401 ● | piece                |

Tool group A37  
Type 740-02  
**Precision vice locator PSA**  
universally adjustable, to screw on the vice, M12 connecting screw



| Item no. | Contents of delivery |
|----------|----------------------|
| 681192 ● | piece                |

Tool group A37  
Type 739 **Fixed slot nuts NTS**  
hardened and ground, with fixing screw



| Item no. | Contents of delivery | Size  | Length |
|----------|----------------------|-------|--------|
| 014823 ● | set                  | 20x12 | 22     |
| 014825 ● | set                  | 20x14 | 25     |
| 014827 ● | set                  | 20x16 | 25     |
| 014829 ● | set                  | 20x18 | 25     |
| 014831 ● | set                  | 20x20 | 22     |
| 014833 ● | set                  | 20x22 | 32     |

## Machine vices RB and RH

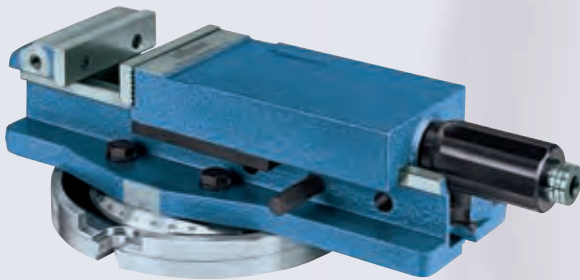
### For high clamping accuracy

#### 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.

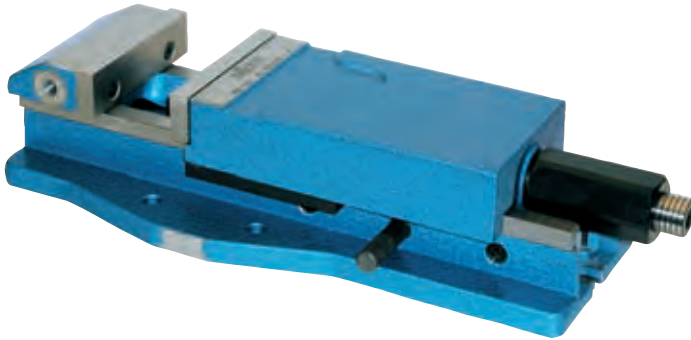
## RH



#### 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

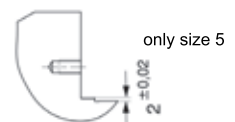
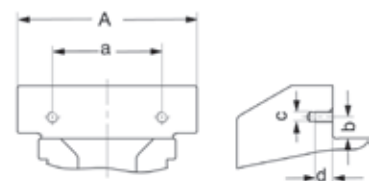
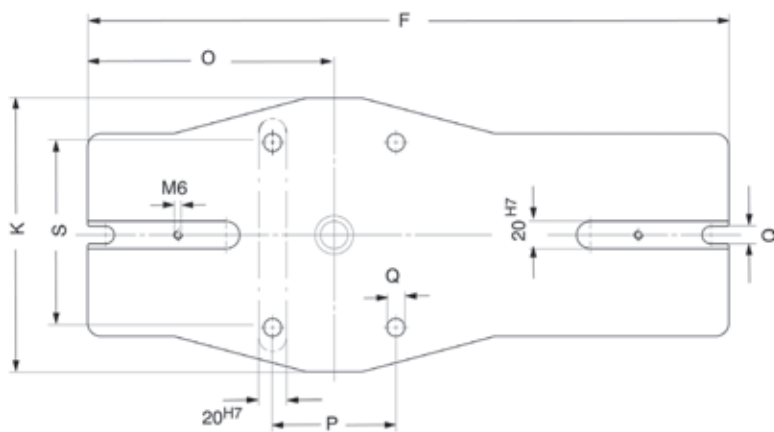
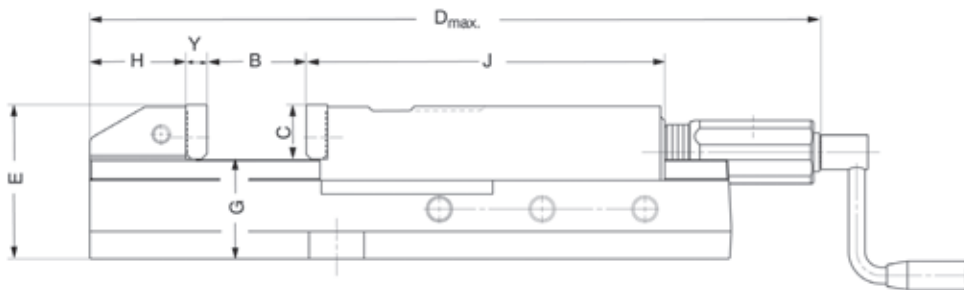
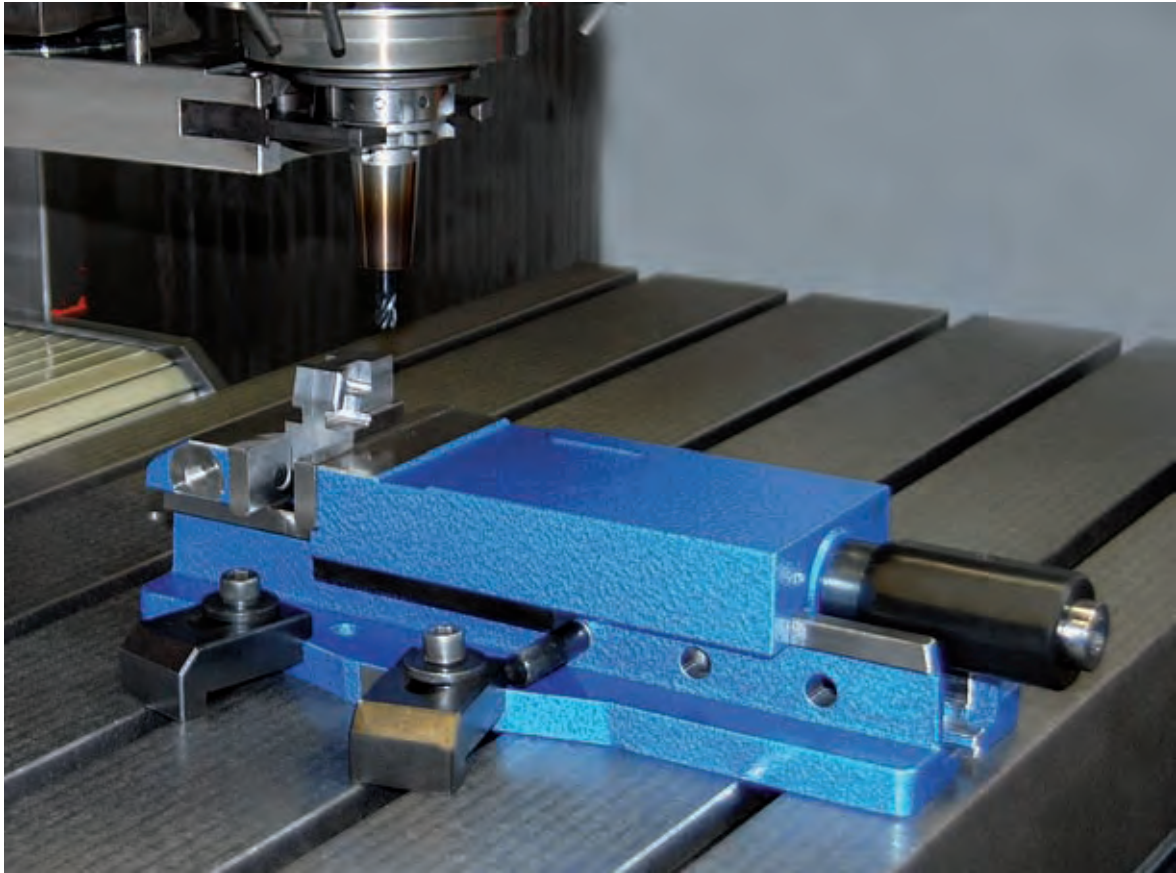
**Customer advantage:**

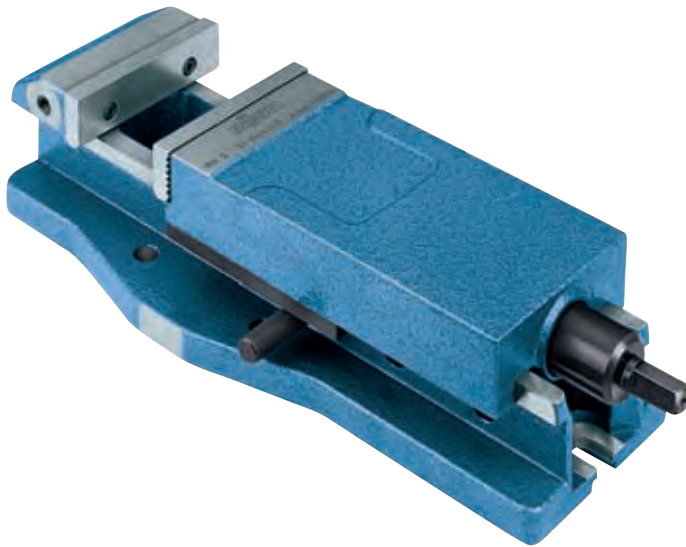
- no overloading of the vice at max. clamping force
- constant clamping force for increased repeating accuracy
- independent tension increase in the rapid-change hydraulic unit via integrated disc springs
- pre-setting of clamping force with blocking device for mechanical pre-clamping of workpiece stacks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





Particularly suitable for reciprocal milling via electric driven workholding pump unit for double acting cylinders or turbo air hydraulic-pump  
Rational clamping of series parts

Rapid adjustment of the clamping range via locking pin  
**Clamping system hydraulic with stroke, hydraulic connection for single-acting cylinders.**

**Technical features:**

- With SGN normal jaws and hydraulic connection
- jaw travel approx. 7,5 mm
- sizes 2, 3 and 4 steel body
- body made out of high-grade spherical graphite cast for size 5
- operating pressure for max. clamping force: 360 bar

**Customer advantage:**

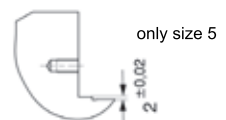
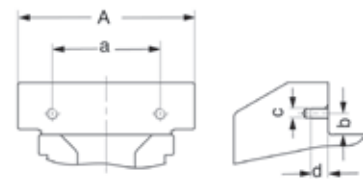
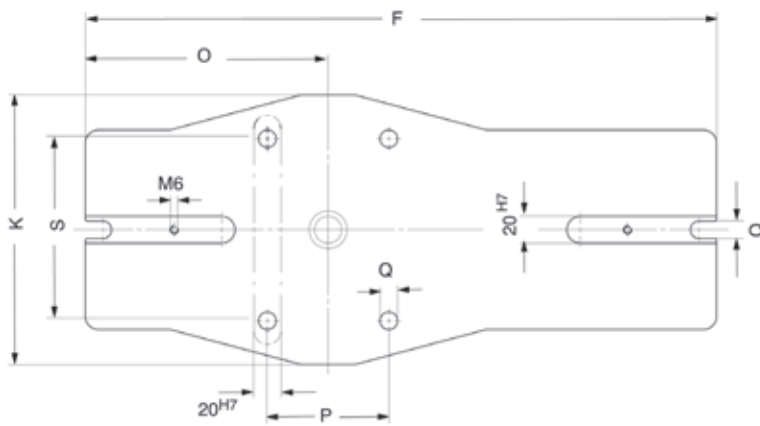
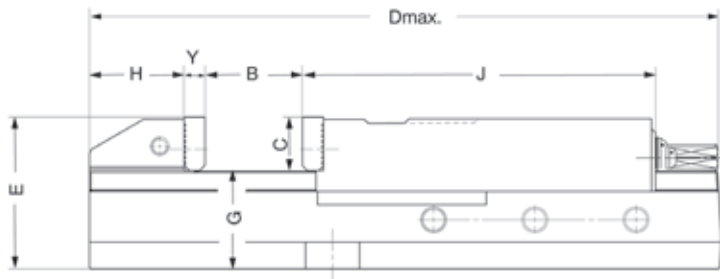
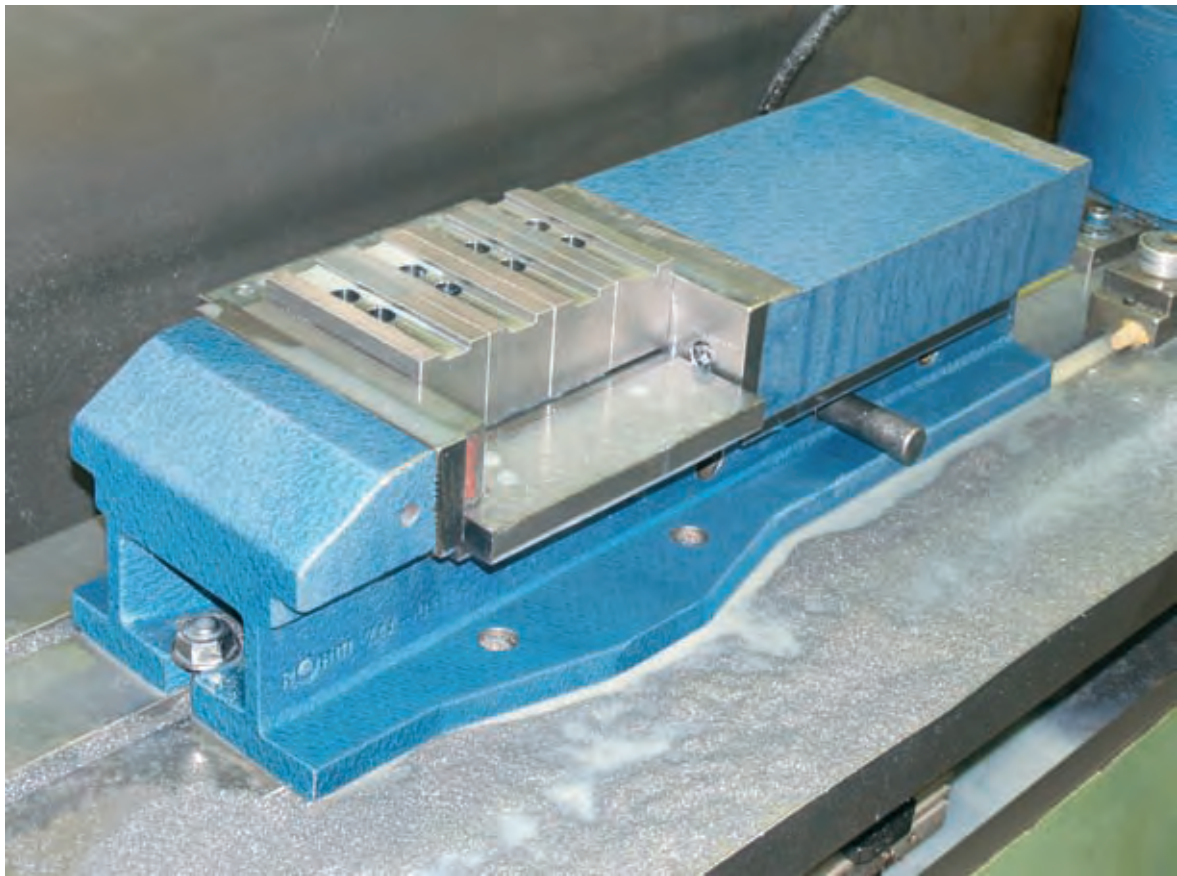
- infinitely variable and precise clamping force presetting
- constant clamping force for increased repeating accuracy
- clamping force is maintained even if pressure drops off
- can be used for automatic work cycles
- constant clamping force for the entire jaw travel

Tool group A10  
Type 747 **RH**  
With SGN normal jaws and hydraulic connection

| Item no.          | 158511 <span style="color: yellow;">■</span> | 158512 <span style="color: yellow;">■</span> | 158513 <span style="color: yellow;">■</span> | 129725 <span style="color: yellow;">■</span> |
|-------------------|--|--|--|--|
| Size              | 2  | 3  | 4  | 5  |
| Jaw width A       | 113  | 135  | 160  | 200  |
| B                 | 170  | 220  | 310  | 350  |
| C                 | 31,6   | 39,6   | 49,6   | 66,6   |
| D                 | 538  | 645  | 769  | 895  |
| E                 | 97   | 112  | 133  | 171  |
| F                 | 390  | 468  | 574  | 685  |
| G±0,02            | 65,5   | 72,5   | 83,5   | 104,5  |
| H                 | 55   | 70   | 80   | 90   |
| J                 | 236,5  | 262  | 298  | 375  |
| K                 | 160  | 200  | 240  | 280  |
| 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   |
| a                 | 63   | 80   | 100  | 140  |
| b                 | 13,6   | 15,6   | 19,6   | 23   |
| c                 | M6   | M8   | M8   | M10  |
| d                 | 12   | 13   | 13   | 16   |
| Clamping force kN | 25   | 40   | 60   | 100  |
| Jaw travel        | 7,5  | 7,5  | 7,5  | 7,5  |
| Weight kg         | 24   | 39   | 58   | 102  |

transversal slot for use in series in special version on request





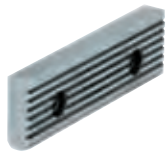
## Accessories RB / RH

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



| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 077104 <span style="color: yellow;">■</span> | set                  | 2    | 113   | 31,6   |
| 077105 <span style="color: green;">●</span>  | set                  | 3    | 135   | 39,6   |
| 077106 <span style="color: green;">●</span>  | set                  | 4    | 160   | 49,6   |
| 141794 <span style="color: yellow;">■</span> | 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 <span style="color: green;">●</span>  | piece                | 2    | 113   | 31,6   |
| 152754 <span style="color: green;">●</span>  | piece                | 3    | 135   | 39,6   |
| 152755 <span style="color: green;">●</span>  | piece                | 4    | 160   | 49,6   |
| 152756 <span style="color: green;">●</span>  | piece                | 5    | 200   | 64,6   |
| 152757 <span style="color: yellow;">■</span> | piece                | 6    | 250   | 79,6   |
| 152758 <span style="color: yellow;">■</span> | 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



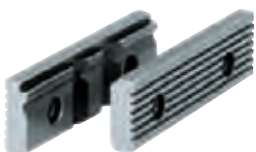
| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 156195 <span style="color: yellow;">■</span> | piece                | 2    | 113   | 31,6   |
| 156196 <span style="color: green;">●</span>  | piece                | 3    | 135   | 39,6   |
| 156197 <span style="color: green;">●</span>  | piece                | 4    | 160   | 49,6   |
| 156199 <span style="color: yellow;">■</span> | 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 <span style="color: green;">●</span>  | piece                | 2    | 113   | 31,6   | 3-13           | 5-32     |
| 082363 <span style="color: green;">●</span>  | piece                | 3    | 135   | 39,6   | 4-20           | 6-40     |
| 082364 <span style="color: green;">●</span>  | piece                | 4    | 160   | 49,6   | 5-29           | 7-48     |
| 129734 <span style="color: yellow;">■</span> | piece                | 5    | 200   | 64,6   | 6-37           | 8-56     |

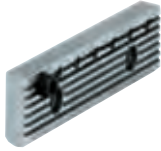
Tool group A37  
Type 728-00  
**V-jaw and standard jawSBO**  
soft and gunmetal-finished, with work support; for BOF and BSS



| Item no.                                    | Contents of delivery | Size | Width | Height | Clamping range |          |
|---|----------------------|------|-------|--------|----------------|----------|
|   |                      |      |       |        | Horizontal     | Vertical |
| 317259 <span style="color: green;">●</span> | set                  | 2    | 110   | 31,8   | 3-12           | 5-32     |
| 317260 <span style="color: green;">●</span> | set                  | 3    | 135   | 39,8   | 3-13           | 6-40     |
| 317261 <span style="color: green;">●</span> | set                  | 4    | 160   | 49,8   | 5-22           | 7-48     |

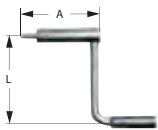
# Accessories RB / RH

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 <span style="color: yellow;">■</span> | piece                | 2    | 113   | 31,6   |
| 150740 <span style="color: yellow;">■</span> | piece                | 3    | 135   | 39,6   |
| 150741 <span style="color: yellow;">■</span> | 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 <span style="color: green;">●</span> | piece                | 2     | 12      | 48  | 80  |
| 134198 <span style="color: green;">●</span> | piece                | 3     | 12      | 60  | 90  |
| 134499 <span style="color: green;">●</span> | piece                | 4     | 12      | 117 | 90  |
| 134600 <span style="color: green;">●</span> | 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 <span style="color: yellow;">■</span> | piece                | 2/3  | 12      | 90 |
| 009150 <span style="color: green;">●</span>  | piece                | 4/5  | 12      | 80 |

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



| Item no.                                     | Contents of delivery | Size | A   | B   |
|--|----------------------|------|-----|-----|
| 226502 <span style="color: green;">●</span>  | piece                | 2    | 109 | 62  |
| 226503 <span style="color: green;">●</span>  | piece                | 3    | 114 | 70  |
| 226504 <span style="color: green;">●</span>  | piece                | 4    | 115 | 70  |
| 226505 <span style="color: green;">●</span>  | piece                | 5    | 147 | 98  |
| 332827 <span style="color: yellow;">■</span> | piece                | 6-7  | 165 | 130 |

Tool group A37  
Type 744 **Spindle complete**



| Item no.                                     | Contents of delivery | Size | L   |
|--|----------------------|------|-----|
| 134186 <span style="color: green;">●</span>  | piece                | 2    | 99  |
| 134187 <span style="color: green;">●</span>  | piece                | 3    | 116 |
| 134188 <span style="color: green;">●</span>  | piece                | 4    | 151 |
| 134189 <span style="color: green;">●</span>  | piece                | 5    | 182 |
| 142323 <span style="color: yellow;">■</span> | 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 <span style="color: green;">●</span> | 2    | 242        | 30     | 28       | 75     |
| 082442 <span style="color: green;">●</span> | 3    | 280        | 30     | 28       | 11     |
| 082443 <span style="color: green;">●</span> | 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 <span style="color: green;">●</span>  | 5    | 420        | 40     | 28       | 23     |
| 137316 <span style="color: yellow;">■</span> | 6/7  | 520        | 50     | 28       | 80     |

# General accessories

| Tool group A37<br>Type 740-02<br><b>Work locator WSA</b><br>universally adjustable, to screw on the vice, M12 connecting screw | Item no. | Contents of delivery |
|--|----------|----------------------|
|  | 320400 ● | piece                |



| Tool group A37<br>Type 740-02<br><b>Work locator WSA</b><br>universally adjustable, can be mounted on the machine table (14 mm T-slot) or bolted onto the vice (M12) | Item no. | Contents of delivery |
|--|----------|----------------------|
|  | 320401 ● | piece                |



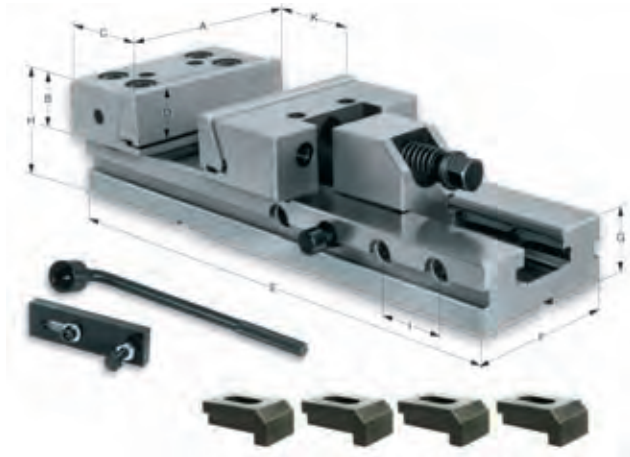
| Tool group A37<br>Type 740-02<br><b>Precision vice locator PSA</b><br>universally adjustable, to screw on the vice, M12 connecting screw | Item no. | Contents of delivery |
|--|----------|----------------------|
|  | 681192 ● | piece                |



| Tool group A37<br>Type 739<br><b>Fixed slot nuts NTS</b><br>hardened and ground, with fixing screw | Item no. | Contents of delivery | Size  | Length |
|--|----------|----------------------|-------|--------|
|  | 014823 ● | set                  | 20x12 | 22     |
|  | 014825 ● | set                  | 20x14 | 25     |
|  | 014827 ● | set                  | 20x16 | 25     |
|  | 014829 ● | set                  | 20x18 | 25     |
|  | 014831 ● | set                  | 20x20 | 22     |
|  | 014833 ● | set                  | 20x22 | 32     |



MSR



For milling machines, machining centres and standard machines.

**Clamping system mechanical without power transmitter, manually operated.**

**Technical features:**

- made from alloy steel, hardened and ground
- with draw-down jaws
- hardened steel body (60 HRC)
- repeating accuracy 0,02 mm

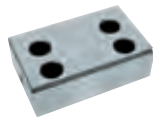
**Contents of delivery:**

With hand crank, workpart locator and four clamps

Tool group A11  
Type 706 **MSR**  
With draw-down jaws

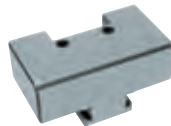
| Item no. | Jaw width A | B  | C  | D  | E   | E max | F   | G  | H   | I  | K   | Clamping force kN | Weight kg |
|----------|-------------|----|----|----|-----|-------|-----|----|-----|----|-----|-------------------|-----------|
| 161828 ● | 125         | 40 | 78 | 32 | 345 | 401   | 95  | 40 | 80  | 50 | 150 | 30                | 12,7      |
| 161827 ● | 150         | 50 | 90 | 40 | 420 | 487   | 125 | 50 | 100 | 50 | 200 | 50                | 25,6      |
| 161826 ● | 150         | 50 | 90 | 40 | 520 | 587   | 125 | 50 | 100 | 50 | 300 | 50                | 29,5      |
| 161825 ● | 175         | 60 | 97 | -  | 655 | 701   | 145 | 58 | 118 | 50 | 400 | 60                | 51,2      |

Tool group A37  
Type 706 **Step jaw SB**  
for stationary jaw



| Item no.  | Contents of delivery | Size | Width | Height |
|-----------|----------------------|------|-------|--------|
| 1043226 ■ | piece                | 125  | 120   | 38     |
| 1043228 ● | piece                | 150  | 146   | 48     |
| 1043230 ■ | piece                | 175  | 171   | 58     |

Tool group A37  
Type 706 **Step jaw SB**  
for movable jaw



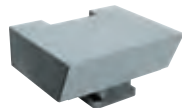
| Item no.  | Contents of delivery | Size | Width | Height |
|-----------|----------------------|------|-------|--------|
| 1043227 ■ | piece                | 125  | 120   | 38     |
| 1043229 ● | piece                | 150  | 146   | 48     |
| 1043231 ■ | piece                | 175  | 171   | 58     |

Tool group A37  
Type 706 **V-jaw PB** with jaw steps  
for movable jaw



| Item no.  | Contents of delivery | Size | Width | Height |
|-----------|----------------------|------|-------|--------|
| 1043409 ● | piece                | 125  | 120   | 38     |
| 1043410 ● | piece                | 150  | 146   | 48     |
| 1043411 ● | piece                | 175  | 171   | 58     |

Tool group A37  
Type 706 **Incline jaw WB**  
(for circular parts)  
for movable jaw



| Item no.  | Contents of delivery | Size | Width | Height |
|-----------|----------------------|------|-------|--------|
| 1043412 ■ | piece                | 125  | 120   | 38     |
| 1043413 ■ | piece                | 150  | 146   | 48     |
| 1043414 ■ | piece                | 175  | 171   | 58     |

Tool group A37  
Type 706-00 **Single clamp SPE**



| Item no. | Contents of delivery | Size    | T-slot | Thread |
|----------|----------------------|---------|--------|--------|
| 163329 ● | piece                | 125     | 12     | M10x45 |
| 163330 ● | piece                | 125     | 14     | M12x50 |
| 163331 ● | piece                | 125     | 16     | M12x50 |
| 163332 ● | piece                | 125     | 18     | M16x50 |
| 163333 ● | piece                | 150/175 | 12     | M10x50 |
| 163334 ● | piece                | 150/175 | 14     | M12x55 |
| 163335 ● | piece                | 150/175 | 16     | M12x55 |
| 163336 ● | piece                | 150/175 | 18     | M16x60 |

Tool group A37  
Type 706-10 **Rotation plate DP**



| Item no. | Size | External Ø | Height |
|----------|------|------------|--------|
| 476867 ● | 125  | 226        | 47     |
| 476868 ● | 150  | 290        | 58     |
| 476870 ● | 175  | 320        | 58     |

**RS-SG**


Made from special cast metal for flexible application  
These machine vices are particularly suitable for application on conventional machine tools.

**Clamping system mechanical without power transmitter, manually operated.**

**Technical features:**

- with SGN normal jaws and hand crank
- force transmission via spindle thread
- long guidance of movable jaw
- swivel bases in standard and universal design with ground contact edge for supporting the vice

**Customer advantage:**

- entire clamping range within reach by turning the hand crank
- spindle protective against dirt and chips
- extensive, interchangeable assortment of jaws
- can be used on a rotation plate with graduation

Tool group A11  
Type 711 **RS**  
With SGN normal jaws  
and hand crank

| Item no. | Size | Jaw width A | B   | C    | D   | F   | G  | H  | J   | K   | O   | P   | Q  | R  | S     | Y  | a   | b    | c   | Clamping force kN | Weight kg |
|----------|------|-------------|-----|------|-----|-----|----|----|-----|-----|-----|-----|----|----|-------|----|-----|------|-----|-------------------|-----------|
| 128031 ● | 1    | 92          | 85  | 31,6 | 362 | 260 | 48 | 50 | 174 | 160 | 115 | 60  | 13 | 14 | 120   | 12 | 63  | 13,6 | M6  | 18                | 12        |
| 128032 ● | 2    | 113         | 105 | 31,6 | 423 | 300 | 58 | 55 | 200 | 160 | 125 | 60  | 13 | 14 | 120   | 12 | 63  | 13,6 | M6  | 25                | 13,5      |
| 128033 ● | 3    | 135         | 125 | 39,6 | 510 | 365 | 64 | 70 | 242 | 200 | 155 | 70  | 13 | 14 | 146   | 16 | 80  | 15,6 | M8  | 35                | 25        |
| 128034 ● | 4    | 160         | 145 | 49,6 | 575 | 410 | 70 | 80 | 273 | 240 | 175 | 80  | 17 | 18 | 184,5 | 16 | 100 | 19,6 | M8  | 45                | 40        |
| 111648 ● | 5    | 200         | 185 | 62,6 | 675 | 460 | 82 | 90 | 322 | 280 | 200 | 118 | 21 | 22 | 210   | 20 | 125 | 24,6 | M10 | 55                | 65        |

Made from special cast metal for flexible application  
These machine vices are particularly suitable for application on conventional machine tools.

**Clamping system mechanical without power transmitter, manually operated.**

**Technical features:**

- with SGN normal jaws and hand crank
- long guidance of movable jaw
- swivel bases in standard and universal design with ground contact edge for supporting the vice
- simple adjustments for the clamping range by moving a pin
- high clamping force due to a heat-treated and bearing-supported spindle

**Customer advantage:**

- extensive, interchangeable assortment of jaws
- can be used on a rotation plate with graduation
- disposal of chips and coolant via a groove in the stationary clamping jaw area
- spindle protective against dirt and chips
- wide clamping range

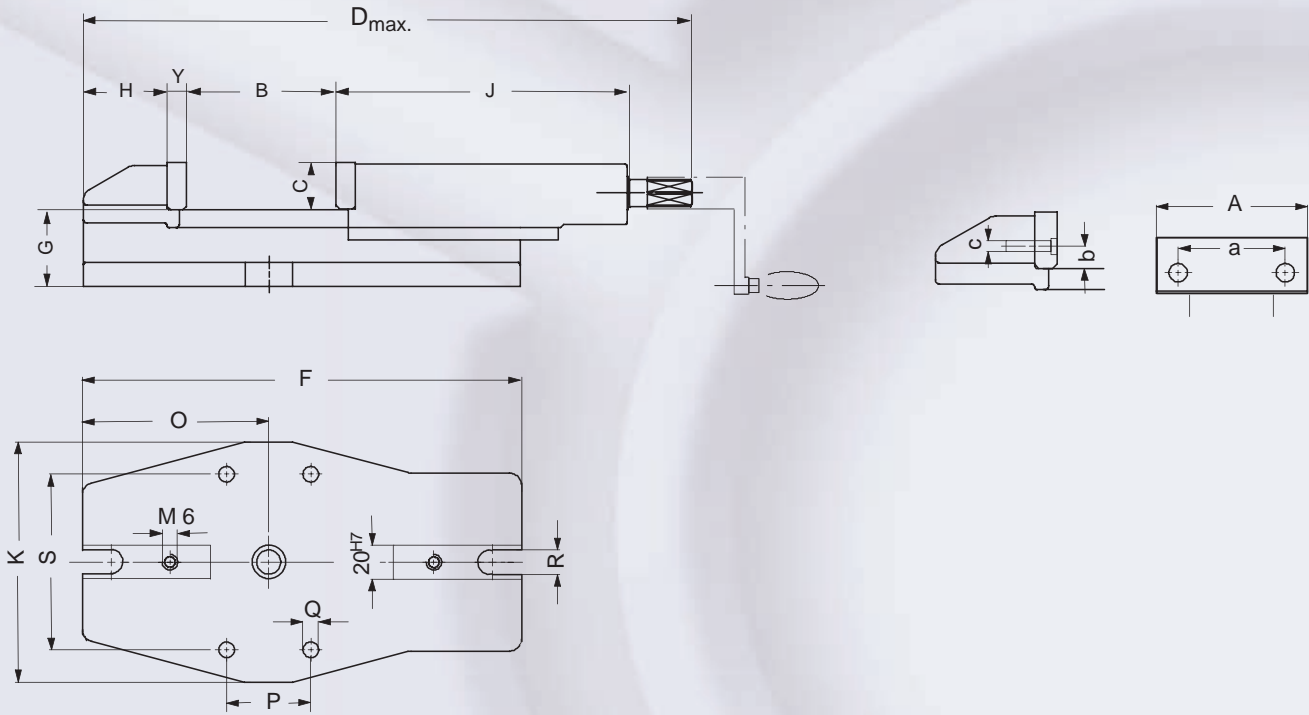


Tool group A11  
Type 705 **SG**  
With SGN normal jaws  
and hand crank

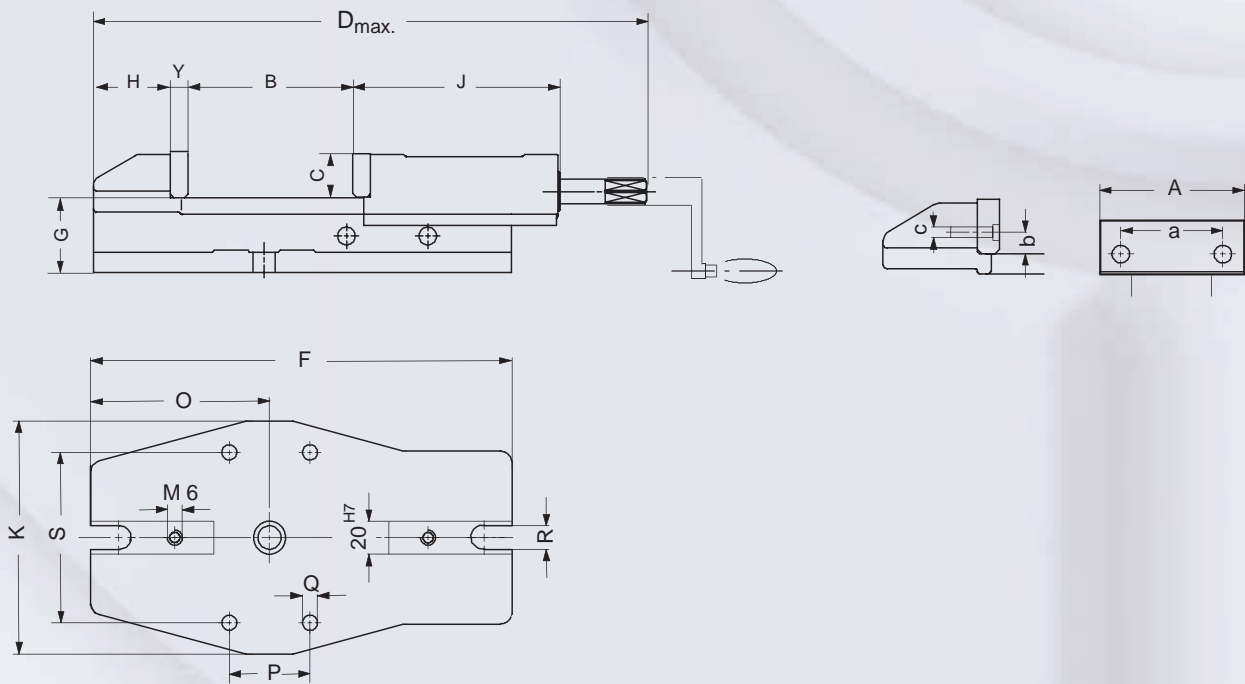
| Item no. | Size | Jaw width A | B   | C    | D   | F   | G     | H  | J   | K   | O   | P   | Q  | R  | S   | Y  | a   | b    | c   | Clamping force kN | Weight kg |
|----------|------|-------------|-----|------|-----|-----|-------|----|-----|-----|-----|-----|----|----|-----|----|-----|------|-----|-------------------|-----------|
| 125284 ■ | 1    | 92          | 100 | 31,6 | 417 | 310 | 59    | 50 | 158 | 160 | 115 | 90  | 13 | 13 | 100 | 12 | 63  | 13,6 | M6  | 20                | 13        |
| 124521 ● | 2    | 113         | 125 | 31,6 | 458 | 320 | 64    | 55 | 172 | 160 | 125 | 90  | 13 | 13 | 100 | 12 | 63  | 13,6 | M6  | 25                | 17        |
| 124536 ● | 3    | 135         | 150 | 39,6 | 503 | 380 | 67    | 70 | 186 | 200 | 155 | 90  | 13 | 13 | 135 | 16 | 80  | 15,6 | M8  | 35                | 24        |
| 124925 ● | 4    | 160         | 180 | 49,6 | 570 | 430 | 74    | 80 | 214 | 240 | 175 | 90  | 17 | 17 | 180 | 16 | 100 | 19,6 | M8  | 45                | 35        |
| 124941 ● | 5    | 200         | 215 | 62,6 | 660 | 500 | 82    | 90 | 262 | 280 | 200 | 160 | 21 | 21 | 180 | 20 | 125 | 24,6 | M10 | 55                | 67        |
| 125122 ■ | 6    | 250         | 345 | 65   | 853 | 685 | 104,5 | 90 | 292 | 280 | 230 | 160 | 21 | 21 | 180 | 50 | 125 | 24,6 | M10 | 60                | 94        |

**RS-SG**

**Machine vices RS**



**Machine vices SG**



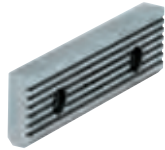
# Accessories RS-SG

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



| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 077104 <span style="color: yellow;">■</span> | set                  | 2    | 113   | 31,6   |
| 077105 <span style="color: green;">●</span>  | set                  | 3    | 135   | 39,6   |
| 077106 <span style="color: green;">●</span>  | set                  | 4    | 160   | 49,6   |
| 077107 <span style="color: yellow;">■</span> | set                  | 5    | 200   | 62,6   |

Tool group A37  
Type 705 **Standard jaws SGN**  
one side smooth, one side grooved, hardened and ground



| Item no.   | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 152752 <span style="color: green;">●</span>                | piece                | 1    | 92    | 31,6   |
| 152753 <span style="color: green;">●</span>                | piece                | 2    | 113   | 31,6   |
| 152754 <span style="color: green;">●</span>                | piece                | 3    | 135   | 39,6   |
| 152755 <span style="color: green;">●</span>                | piece                | 4    | 160   | 49,6   |
| 152759 <span style="color: green;">●</span>                | piece                | 5    | 200   | 62,6   |
| 152761 <sup>1)</sup> <span style="color: yellow;">■</span> | piece                | 6    | 250   | 65     |

<sup>1)</sup> both sides ground

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 |
|--|----------------------|------|-------|--------|
| 163218 <span style="color: green;">●</span>  | piece                | 1    | 92    | 31,6   |
| 156195 <span style="color: yellow;">■</span> | piece                | 2    | 113   | 31,6   |
| 156196 <span style="color: green;">●</span>  | piece                | 3    | 135   | 39,6   |
| 156197 <span style="color: green;">●</span>  | piece                | 4    | 160   | 49,6   |
| 156198 <span style="color: yellow;">■</span> | piece                | 5    | 200   | 62,6   |

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 |
| 128770 <span style="color: green;">●</span>  | piece                | 1    | 92    | 31,6   | 3-13           | 5-32     |
| 082362 <span style="color: green;">●</span>  | piece                | 2    | 113   | 31,6   | 3-13           | 5-32     |
| 082363 <span style="color: green;">●</span>  | piece                | 3    | 135   | 39,6   | 4-20           | 6-40     |
| 082364 <span style="color: green;">●</span>  | piece                | 4    | 160   | 49,6   | 5-29           | 7-48     |
| 082365 <span style="color: green;">●</span>  | piece                | 5    | 200   | 62,6   | 6-37           | 8-56     |
| 137838 <span style="color: yellow;">■</span> | piece                | 6    | 250   | 65     | 7-45           | 9-65     |

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

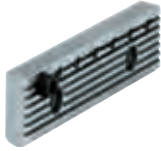


| Item no.                                    | Contents of delivery | Size | Width | Height | Clamping range |          |
|---|----------------------|------|-------|--------|----------------|----------|
|   |                      |      |       |        | Horizontal     | Vertical |
| 317259 <span style="color: green;">●</span> | set                  | 2    | 110   | 31,8   | 3-12           | 5-32     |
| 317260 <span style="color: green;">●</span> | set                  | 3    | 135   | 39,8   | 3-13           | 6-40     |
| 317261 <span style="color: green;">●</span> | set                  | 4    | 160   | 49,8   | 5-22           | 7-48     |



# Accessories RS-SG

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 <span style="color: yellow;">■</span> | piece                | 2    | 113   | 31,6   |
| 150740 <span style="color: yellow;">■</span> | piece                | 3    | 135   | 39,6   |
| 150741 <span style="color: yellow;">■</span> | piece                | 4    | 160   | 49,6   |

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



| Item no.                                    | Contents of delivery | Size | Octagon | L   |
|---|----------------------|------|---------|-----|
| 009150 <span style="color: green;">●</span> | piece                | 1    | 12      | 80  |
| 009152 <span style="color: green;">●</span> | piece                | 2    | 14      | 125 |
| 009153 <span style="color: green;">●</span> | piece                | 3    | 17      | 160 |
| 009154 <span style="color: green;">●</span> | piece                | 4/5  | 19      | 200 |

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



| Item no.                                    | Contents of delivery | Size | Octagon | L   |
|---|----------------------|------|---------|-----|
| 009150 <span style="color: green;">●</span> | piece                | 1    | 12      | 80  |
| 009152 <span style="color: green;">●</span> | piece                | 2    | 14      | 125 |
| 124550 <span style="color: green;">●</span> | piece                | 3    | 17      | 160 |
| 124937 <span style="color: green;">●</span> | piece                | 4/5  | 19      | 200 |
| 009156 <span style="color: green;">●</span> | piece                | 6    | 24      | 250 |

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



| Item no.                                    | Size | External Ø | Height | Center Ø | Weight |
|---|------|------------|--------|----------|--------|
| 129814 <span style="color: green;">●</span> | 1/2  | 242        | 30     | 28       | 75     |
| 082442 <span style="color: green;">●</span> | 3    | 280        | 30     | 28       | 11     |
| 082443 <span style="color: green;">●</span> | 4    | 340        | 34     | 28       | 18     |

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



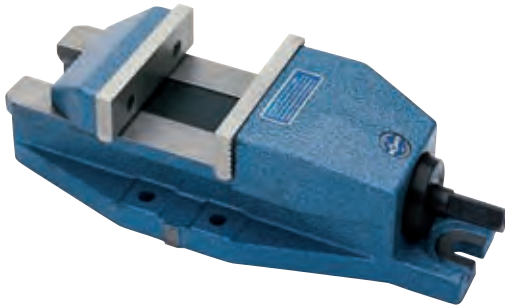
| Item no.                                    | Size | External Ø | Height | Center Ø | Weight |
|---|------|------------|--------|----------|--------|
| 082441 <span style="color: green;">●</span> | 2    | 242        | 30     | 28       | 75     |
| 129814 <span style="color: green;">●</span> | 1/2  | 242        | 30     | 28       | 75     |
| 082442 <span style="color: green;">●</span> | 3    | 280        | 30     | 28       | 11     |
| 082443 <span style="color: green;">●</span> | 4    | 340        | 34     | 28       | 18     |

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



| Item no.                                    | Size | External Ø | Height | Center Ø | Weight |
|---|------|------------|--------|----------|--------|
| 090854 <span style="color: green;">●</span> | 5/6  | 420        | 40     | 28       | 23     |

# UH-UZ



Made from special cast metal for flexible application  
These machine vices are particularly suitable for application on conventional machine tools.

**Clamping system mechanical without power transmitter, manually operated.**

**Technical features:**

- with SGN normal jaws and hand crank
- high clamping force through roller bearing supported spindle
- low design made of special cast metal
- swivel bases as universal type with ground contact edge for supporting the vice
- vice body and swivel bases are equipped with longitudinal grooves for accurate alignment

**Customer advantage:**

- entire clamping range within reach by turning the hand crank
- spindle covered in operating range
- adjusting V-jaw guidance
- extensive, interchangeable assortment of jaws
- can be used on a rotation plate with graduation

Tool group A11  
Type 721 **UH**  
Draw-down-vice

| Item no. | Size | Jaw width A | B   | C    | D   | F   | G    | H   | J  | K   | O     | P   | Q  | R  | S     | Y  | a   | b    | c   | Clamping force kN | Weight kg |
|----------|------|-------------|-----|------|-----|-----|------|-----|----|-----|-------|-----|----|----|-------|----|-----|------|-----|-------------------|-----------|
| 014516   | 1    | 90          | 90  | 24,6 | 283 | 263 | 48   | 119 | 13 | 107 | 111   | 40  | 9  | 11 | 82    | 12 | 46  | 11,6 | M6  | 20                | 6,7       |
| 014542   | 2    | 113         | 110 | 31,6 | 337 | 314 | 55,5 | 142 | 14 | 132 | 135   | 50  | 11 | 13 | 101   | 12 | 63  | 13,6 | M6  | 25                | 10,3      |
| 014565   | 3    | 135         | 140 | 39,6 | 393 | 367 | 61   | 154 | 15 | 152 | 161,5 | 60  | 11 | 13 | 118,5 | 16 | 80  | 15,6 | M8  | 35                | 17,2      |
| 014590   | 4    | 160         | 180 | 49,6 | 465 | 436 | 69,5 | 180 | 16 | 180 | 193   | 60  | 17 | 17 | 142   | 16 | 100 | 19,6 | M8  | 40                | 26,2      |
| 014612   | 5    | 200         | 250 | 62,6 | 570 | 539 | 73,5 | 202 | 16 | 200 | 244,5 | 70  | 17 | 17 | 158   | 20 | 125 | 24,6 | M10 | 50                | 40,2      |
| 014635   | 6    | 250         | 300 | 62,6 | 676 | 641 | 81,5 | 251 | 18 | 220 | 290   | 80  | 17 | 21 | 175   | 20 | 160 | 24,6 | M10 | 60                | 54        |
| 014655   | 7    | 300         | 400 | 79,6 | 792 | 754 | 89,5 | 251 | 19 | 280 | 346,5 | 120 | 17 | 21 | 208   | 25 | 200 | 31,6 | M12 | 70                | 80        |

Made from special cast metal for flexible application  
These machine vices are particularly suitable for application on conventional machine tools.

Centric clamping for milling and planing of forms, slots and grooves of all kinds.

**Clamping system mechanical without power transmitter, manually operated.**

**Technical features:**

- with SGN normal jaws and hand crank
- low design made of special cast metal
- the side jaw guides enable simple and exact positioning of the vice
- swivel bases as universal type with ground contact edge for supporting the vice
- centric clamping by right-hand and left-hand threaded spindle

**Customer advantage:**

- spindle covered in operating range
- extensive, interchangeable assortment of jaws
- can be used on a rotation plate with graduation

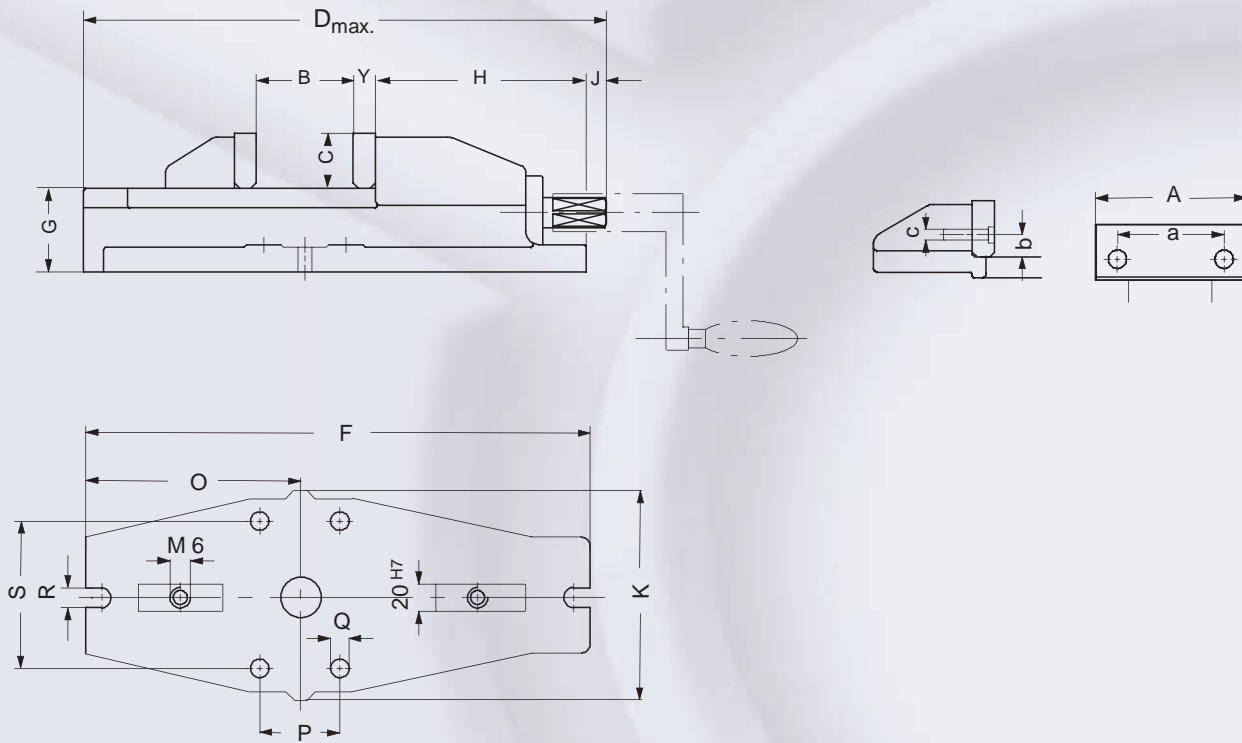


Tool group A11  
Type 725 **UZ**  
Self-centering vice

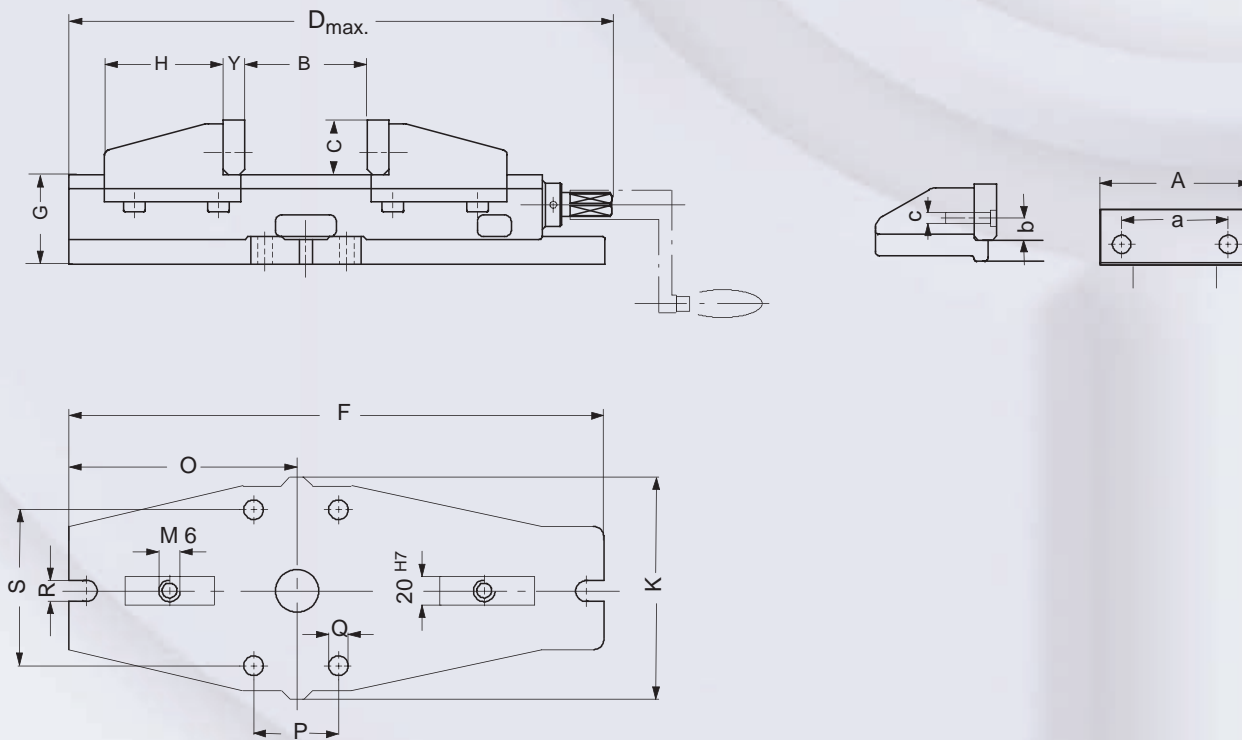
| Item no. | Size | Jaw width A | B   | C    | D   | F   | G    | J   | K   | O   | P  | Q  | R  | S     | Y  | a   | b    | c   | Clamping force kN | Weight kg |
|----------|------|-------------|-----|------|-----|-----|------|-----|-----|-----|----|----|----|-------|----|-----|------|-----|-------------------|-----------|
| 014523   | 2    | 113         | 110 | 31,6 | 358 | 344 | 61   | 81  | 132 | 149 | 50 | 11 | 13 | 101   | 12 | 63  | 13,6 | M6  | 15                | 12,4      |
| 014740   | 3    | 135         | 140 | 39,6 | 408 | 394 | 65,5 | 87  | 152 | 174 | 60 | 11 | 13 | 118,5 | 16 | 80  | 15,6 | M8  | 22                | 19        |
| 014752   | 4    | 160         | 180 | 49,6 | 495 | 480 | 74   | 107 | 180 | 214 | 60 | 17 | 17 | 142   | 16 | 100 | 19,6 | M8  | 24                | 31        |
| 014802   | 5    | 200         | 300 | 62,6 | 655 | 640 | 79   | 123 | 200 | 294 | 70 | 17 | 17 | 158   | 20 | 125 | 24,6 | M10 | 25                | 52        |
| 014807   | 6    | 250         | 400 | 62,6 | 767 | 751 | 85   | 123 | 220 | 344 | 80 | 17 | 21 | 175   | 20 | 160 | 24,6 | M10 | 28                | 71        |

**UH-UZ**

**Machine vices UH**



**Machine vices UZ**



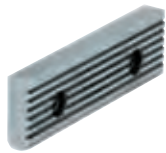
# Accessories UH - UZ

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



| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 077103 <span style="color: yellow;">■</span> | set                  | 1    | 90    | 24,6   |
| 077104 <span style="color: yellow;">■</span> | set                  | 2    | 113   | 31,6   |
| 077105 <span style="color: green;">●</span>  | set                  | 3    | 135   | 39,6   |
| 077106 <span style="color: green;">●</span>  | set                  | 4    | 160   | 49,6   |
| 077107 <span style="color: yellow;">■</span> | set                  | 5    | 200   | 62,6   |

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 |
|--|----------------------|------|-------|--------|
| 152767 <span style="color: yellow;">■</span> | piece                | 1    | 90    | 24,6   |
| 152753 <span style="color: green;">●</span>  | piece                | 2    | 113   | 31,6   |
| 152754 <span style="color: green;">●</span>  | piece                | 3    | 135   | 39,6   |
| 152755 <span style="color: green;">●</span>  | piece                | 4    | 160   | 49,6   |
| 152759 <span style="color: green;">●</span>  | piece                | 5    | 200   | 62,6   |
| 152760 <span style="color: yellow;">■</span> | piece                | 6    | 250   | 62,6   |
| 152762 <span style="color: yellow;">■</span> | piece                | 7    | 300   | 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



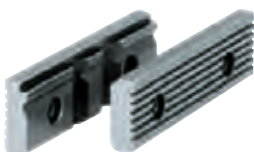
| Item no.                                     | Contents of delivery | Size | Width | Height |
|--|----------------------|------|-------|--------|
| 156195 <span style="color: yellow;">■</span> | piece                | 2    | 113   | 31,6   |
| 156196 <span style="color: green;">●</span>  | piece                | 3    | 135   | 39,6   |
| 156197 <span style="color: green;">●</span>  | piece                | 4    | 160   | 49,6   |
| 156198 <span style="color: yellow;">■</span> | piece                | 5    | 200   | 62,6   |

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 |
| 082361 <span style="color: yellow;">■</span> | piece                | 1    | 90    | 24,6   | 3-13           | 5-32     |
| 082362 <span style="color: green;">●</span>  | piece                | 2    | 113   | 31,6   | 3-13           | 5-32     |
| 082363 <span style="color: green;">●</span>  | piece                | 3    | 135   | 39,6   | 4-20           | 6-40     |
| 082364 <span style="color: green;">●</span>  | piece                | 4    | 160   | 49,6   | 5-29           | 7-48     |
| 082365 <span style="color: green;">●</span>  | piece                | 5    | 200   | 62,6   | 6-37           | 8-56     |
| 082366 <span style="color: yellow;">■</span> | piece                | 6    | 250   | 62,6   | 7-45           | 9-65     |

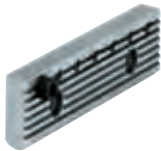
Tool group A37  
Type 728-00  
**V-jaw and standard jawSBO**  
soft and gunmetal-finished, with work support; for BOF and BSS



| Item no.                                    | Contents of delivery | Size | Width | Height | Clamping range |          |
|---|----------------------|------|-------|--------|----------------|----------|
|   |                      |      |       |        | Horizontal     | Vertical |
| 317259 <span style="color: green;">●</span> | set                  | 2    | 110   | 31,8   | 3-12           | 5-32     |
| 317260 <span style="color: green;">●</span> | set                  | 3    | 135   | 39,8   | 3-13           | 6-40     |
| 317261 <span style="color: green;">●</span> | set                  | 4    | 160   | 49,8   | 5-22           | 7-48     |

## Accessories UH - UZ

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 <span style="color: yellow;">■</span> | piece                | 2    | 113   | 31,6   |
| 150740 <span style="color: yellow;">■</span> | piece                | 3    | 135   | 39,6   |
| 150741 <span style="color: yellow;">■</span> | piece                | 4    | 160   | 49,6   |

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



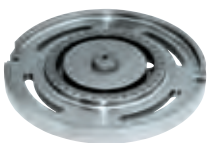
| Item no.                                    | Contents of delivery | Size  | Octagon | L   |
|---|----------------------|-------|---------|-----|
| 009150 <span style="color: green;">●</span> | piece                | 1     | 12      | 80  |
| 009152 <span style="color: green;">●</span> | piece                | 2/3   | 14      | 125 |
| 009153 <span style="color: green;">●</span> | piece                | 3/4   | 17      | 160 |
| 009154 <span style="color: green;">●</span> | piece                | 4/5/6 | 19      | 200 |
| 009156 <span style="color: green;">●</span> | piece                | 6     | 24      | 250 |
| 009157 <span style="color: green;">●</span> | piece                | 7     | 24      | 315 |

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



| Item no.                                    | Contents of delivery | Size  | Octagon | L   |
|---|----------------------|-------|---------|-----|
| 009152 <span style="color: green;">●</span> | piece                | 2/3   | 14      | 125 |
| 009153 <span style="color: green;">●</span> | piece                | 3/4   | 17      | 160 |
| 009154 <span style="color: green;">●</span> | piece                | 4/5/6 | 19      | 200 |

Tool group A37  
Type 722  
**Universal rotation plate DP**  
with T-slot screws and nuts  
ground contact edge, graduation



| Item no.                                     | Size | External Ø | Height | Center Ø | Weight |
|--|------|------------|--------|----------|--------|
| 014706 <span style="color: yellow;">■</span> | 1    | 210        | 22,5   | 28       | 3,5    |
| 014709 <span style="color: yellow;">■</span> | 2    | 245        | 25     | 28       | 5      |
| 014712 <span style="color: yellow;">■</span> | 3    | 295        | 27     | 38       | 8      |
| 014715 <span style="color: yellow;">■</span> | 4    | 345        | 30     | 38       | 11,5   |
| 014718 <span style="color: yellow;">■</span> | 5    | 450        | 30     | 38       | 16,5   |
| 014721 <span style="color: yellow;">■</span> | 6    | 450        | 30     | 38       | 173    |
| 014723 <span style="color: yellow;">■</span> | 7    | 495        | 34     | 38       | 23     |

## General accessories

Tool group A37  
Type 740-02 **Work locator WSA**  
universally adjustable, can be mounted on the machine table (14 mm T-slot)  
or bolted onto the vice (M12)



| Item no.                                    | Contents of delivery |
|---|----------------------|
| 320401 <span style="color: green;">●</span> | piece                |

Tool group A37  
Type 739 **Fixed slot nuts NTS**  
hardened and ground, with fixing screw



| Item no.                                    | Contents of delivery | Size  | Length |
|---|----------------------|-------|--------|
| 014823 <span style="color: green;">●</span> | set                  | 20x12 | 22     |
| 014825 <span style="color: green;">●</span> | set                  | 20x14 | 25     |
| 014827 <span style="color: green;">●</span> | set                  | 20x16 | 25     |
| 014829 <span style="color: green;">●</span> | set                  | 20x18 | 25     |
| 014831 <span style="color: green;">●</span> | set                  | 20x20 | 22     |
| 014833 <span style="color: green;">●</span> | set                  | 20x22 | 32     |



Reliable clamping and mounting of workpieces on drilling and measuring machines.

Standard version

**Clamping system mechanical, manually operated**

**Technical features:**

- body made out of special cast metal
- mounting possibilities on the side and frontal
- long guidance for movable jaw also in outer clamping range
- both jaws with contact surface for clamping flat workpieces
- clamping jaws reversible: one size smooth, respectively with longitudinal and transversal prisms, one side grooved, both sides ground

**Customer advantage:**

- low, stable design with thread spindle
- entire clamping range within reach by turning

Tool group A12  
Type 728-00 **BOF**  
With V-jaw and normal jaw SBO

| Item no. | Size | Jaw width | Clamping capacity | Jaw height | Length | Height | Length body | Weight kg |
|----------|------|-----------|-------------------|------------|--------|--------|-------------|-----------|
| 142835 ● | 1    | 90        | 90                | 25         | 356    | 60     | 195         | 5,5       |
| 111595 ● | 2    | 110       | 130               | 32         | 470    | 72,5   | 315         | 9,5       |
| 111596 ● | 3    | 135       | 160               | 40         | 550    | 80,5   | 365         | 13,5      |
| 111597 ● | 4    | 160       | 220               | 50         | 692    | 95,5   | 445         | 25        |



Reliable clamping and mounting of workpieces on drilling and measuring machines.  
For rapid clamping and unclamping, especially for series machining of workpieces.

Quick action vice

**Clamping system mechanical-mechanical with power transmitter, manually operated**

**Technical features:**

- body made out of special cast metal
- mounting possibilities on the side and frontal
- long guidance for movable jaw also in outer clamping range
- both jaws with contact surface for clamping flat workpieces
- clamping jaws reversible: one size smooth, respectively with longitudinal and transversal prisms, one side grooved, both sides ground

**Customer advantage:**

- one-hand operation
- positive locking

Tool group A12  
Type 728-20 **BSS**  
With V-jaw and normal jaw SBO

| Item no. | Size | Jaw width | Clamping capacity | Jaw height | Length | Height | Length body | Weight kg |
|----------|------|-----------|-------------------|------------|--------|--------|-------------|-----------|
| 134158 ● | 2    | 110       | 130               | 32         | 510    | 72,5   | 315         | 9,5       |
| 134159 ● | 3    | 135       | 160               | 40         | 587    | 80,5   | 365         | 13,5      |



Reliable clamping and mounting of workpieces on drilling and measuring machines.

Standard version

**Clamping system mechanical, manually operated**

**Technical features:**

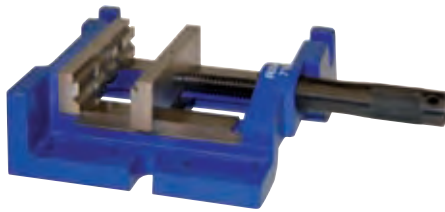
- body made out of cast metal
- movable jaw, mounted on side
- stationary jaw with three vertical and one horizontal prism
- both jaws with contact surface for clamping flat workpieces
- jaws and spindle gunmetal-finished

**Customer advantage:**

- the thread spindle is covered by a protecting sleeve
- entire clamping range within reach by turning
- constant unit length, spindle moves protected inside the handle
- solid and handy version

Tool group A12  
Type 729-60 **DPV**  
With V-jaw and normal jaw SBO

| Item no.  | Size | Jaw width | Clamping capacity | Jaw height | Length | Height | Length body | Width | Weight kg |
|-----------|------|-----------|-------------------|------------|--------|--------|-------------|-------|-----------|
| 863421 ●  | 1    | 80        | 70                | 30         | 234    | 58     | 154         | 142   | 3,6       |
| 863422 ●  | 2    | 100       | 92                | 30         | 272    | 63,5   | 175         | 152   | 4,3       |
| 863423 ●  | 3    | 120       | 110               | 30         | 345    | 63,5   | 225         | 180   | 6,3       |
| 1132597 ● | 4    | 150       | 125               | 30         | 378    | 65     | 238         | 198   | 8,1       |



Reliable clamping and mounting of workpieces on drilling and measuring machines.  
3 mounting options via two additional contact surfaces machined at right angles: base, right-hand and end-side.

Standard version  
**Clamping system mechanical, manually operated**

**Technical features:**

- body made out of cast metal
- movable jaw, mounted on side
- stationary jaw with three vertical and one horizontal prism
- both jaws with contact surface for clamping flat workpieces
- jaws and spindle gunmetal-finished

**Customer advantage:**

- the thread spindle is covered by a protecting sleeve
- entire clamping range within reach by turning
- constant unit length, spindle moves protected inside the handle
- solid and handy version

Tool group A12  
Type 729-20 **DPV 3-W**  
With V-jaw and normal jaw SBO

| Item no. | Size | Jaw width | Clamping capacity | Jaw height | Length | Height | Length body | Width | Weight kg |
|----------|------|-----------|-------------------|------------|--------|--------|-------------|-------|-----------|
| 007182 ● | 2    | 100       | 93                | 30         | 279    | 65     | 189         | 159   | 5,1       |



D. I. Y. design for small drill stands.  
Reliable clamping and mounting of workpieces on drilling and measuring machines.

**Clamping system mechanical, manually operated**

**Technical features:**

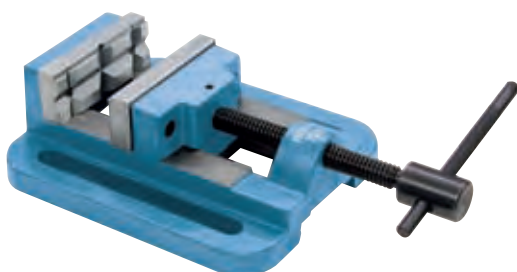
- body made out of cast metal
- long mounting slots
- jaws and spindle gunmetal-finished
- fixed jaw with vertical and horizontal V-jaw

**Customer advantage:**

- lever movable
- both jaws have a seat for retaining flat workpieces

Tool group A12  
Type 729-60 **BSH**  
Small, light **D. I. Y. design**

| Item no. | Size | Jaw width | Clamping capacity | Length body | Width body | Height | Jaw height | Weight kg |
|----------|------|-----------|-------------------|-------------|------------|--------|------------|-----------|
| 007193 ● | 1    | 63        | 65                | 125         | 105        | 43     | 25         | 1,2       |
| 007194 ● | 2    | 80        | 85                | 150         | 130        | 46     | 25         | 1,7       |
| 007196 ● | 3    | 100       | 80                | 170         | 175        | 57     | 25         | 4,2       |



Sturdy craftsman design for drill stands, bench drills and drill presses. Also suitable for milling machines and shapers.

**Clamping system mechanical, manually operated**

**Technical features:**

- long mounting slots
- jaws and spindle gunmetal-finished
- fixed jaw with vertical and horizontal V-jaw
- the moveable steel jaw is supported by a cast jaw with internal guidance
- body made out of cast metal

**Customer advantage:**

- both jaws have a seat for retaining flat workpieces
- long lever for maximal clamping force

Tool group A12  
Type 729-60 **BSH**  
**Sturdy craftsman design**

| Item no. | Size | Jaw width | Clamping capacity | Length body | Width body | Height | Jaw height | Weight kg |
|----------|------|-----------|-------------------|-------------|------------|--------|------------|-----------|
| 007197 ● | 4    | 80        | 80                | 200         | 140        | 70     | 40         | 5         |
| 007201 ● | 5    | 100       | 95                | 215         | 175        | 75     | 40         | 7         |
| 007202 ● | 6    | 120       | 110               | 260         | 215        | 85     | 40         | 11        |
| 007207 ● | 7    | 140       | 150               | 300         | 220        | 85     | 40         | 12,5      |

## Accessories BMS

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 |
| 332714 ● | set                  | 1    | 90    | 24,8   | 4-17           | 4-25     |
| 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     |

Tool group A37  
Type 729-00

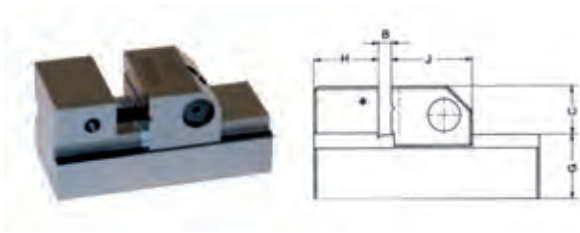
**V-jaw and standard jaw SBO**  
soft and gunmetal-finished, with  
work support, for DPV



| Item no.                | Contents of delivery | Width |
|-------------------------|----------------------|-------|
| 1128341 ●               | set                  | 85    |
| 1128342 ●               | set                  | 100   |
| 1128344 <sup>1)</sup> ▲ | set                  | 100   |
| 1128343 ●               | set                  | 120   |
| 1193108 ▲               | set                  | 150   |

<sup>1)</sup> only for DPV 3-W





Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

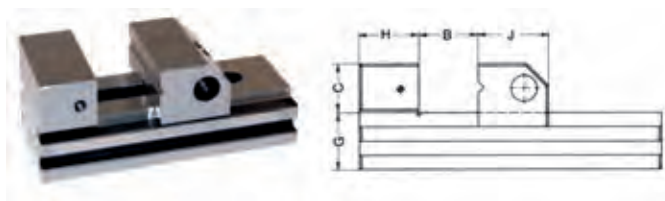
Simple clamping and releasing with the inner hexagon key. Clamping jaws adjustable in steps, lock in automatically.

**Technical features:**

- with draw-down effect
- made out of alloyed tool steel, hardened and precision ground
- horizontal and vertical ground prism
- no spindle which, for example, could become clogged during erosion

Tool group A29  
Type 735-60 **PL-S micro**  
with quick adjustment

| Item no.  | Size | Squareness | Parallelism | Jaw width | B  | C  | Length body | G  | H  | J  | Work locator | Weight kg |
|-----------|------|------------|-------------|-----------|----|----|-------------|----|----|----|--------------|-----------|
| 1179514 ● | 1    | 0,005      | 0,002       | 34        | 25 | 15 | 75          | 20 | 20 | 25 | M5x17        | 0,35      |
| 1179515 ● | 2    | 0,005      | 0,002       | 45        | 50 | 20 | 110         | 25 | 25 | 35 | M5x17        | 1         |



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

Simple clamping and releasing with the inner hexagon key. Clamping jaws adjustable in steps, lock in automatically.

**Technical features:**

- with draw-down effect
- made out of alloyed tool steel, hardened and precision ground
- horizontal and vertical ground prism
- no spindle which, for example, could become clogged during erosion

Tool group A29  
Type 735-65 **PL-S**  
with quick adjustment

| Item no.  | Size | Squareness | Parallelism | Jaw width | B   | C  | Length body | G  | H  | J  | Work locator | Weight kg |
|-----------|------|------------|-------------|-----------|-----|----|-------------|----|----|----|--------------|-----------|
| 1179516 ● | 1    | 0,005      | 0,002       | 70        | 80  | 30 | 160         | 32 | 33 | 45 | M6           | 3         |
| 1179517 ● | 2    | 0,005      | 0,002       | 90        | 120 | 40 | 210         | 40 | 40 | 50 | M5           | 5,8       |
| 1179518 ● | 3    | 0,005      | 0,002       | 120       | 150 | 40 | 280         | 50 | 60 | 70 | M5           | 13,5      |



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

Clamping and releasing with locking screws on the top side. Clamping jaws adjustable in steps, lock in automatically.

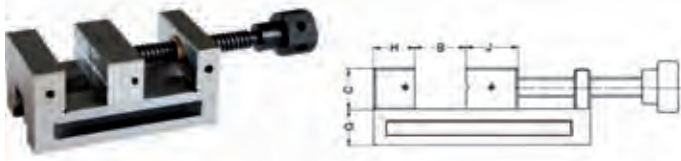
**Technical features:**

- with draw-down effect
- made out of alloyed tool steel, hardened and precision ground
- horizontal and vertical ground prism
- no spindle which, for example, could become clogged during erosion

Tool group A29  
Type 735-70 **PLF**  
with quick adjustment in accuracy to gauge

| Item no.  | Size | Squareness | Parallelism | Jaw width | B   | C  | Length body | Weight kg |
|-----------|------|------------|-------------|-----------|-----|----|-------------|-----------|
| 1111185 ● | 0    | 0,005      | 0,005       | 50        | 65  | 25 | 140         | 1,4       |
| 1111186 ● | 1    | 0,005      | 0,005       | 73        | 100 | 35 | 190         | 4,1       |
| 1111187 ● | 2    | 0,005      | 0,005       | 100       | 125 | 45 | 245         | 7,3       |

# PZS



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

Clamping and releasing with threaded spindle

**Technical features:**

- horizontal and vertical ground prism
- made out of alloyed tool steel, hardened and precision ground

Tool group A29  
Type 735-50 **PL-G**  
Precision vices

| Item no.  | Size | Squareness | Parallelism | Jaw width | B   | C  | Length body | G  | H  | J  | Weight kg |
|-----------|------|------------|-------------|-----------|-----|----|-------------|----|----|----|-----------|
| 1111182 ● | 0    | 0,005      | 0,002       | 60        | 55  | 25 | 110         | 25 | 25 | 33 | 1,6       |
| 1111183 ● | 1    | 0,005      | 0,002       | 73        | 100 | 35 | 210         | 32 | 33 | 45 | 4         |
| 1111184 ● | 2    | 0,005      | 0,002       | 88        | 125 | 40 | 250         | 48 | 40 | 50 | 7,6       |



For accurate jig operation of workpieces on grinding machines, jig grinding machines and other precision machines.

The angle of this model allows the use of the vice on 4 different faces (on the base, on the face and on both sides).  
Simple clamping and releasing with hand crank

**Technical features:**

- made from alloy steel, hardened and ground
- the horizontally ground prism in the movable jaw guarantees the safe clamping even of formed parts
- with spindle

Tool group A29  
Type 735-00 **PSK-S**  
with 0.005 mm accuracy to gauge  
and keep-down effect

| Item no. | Size | Jaw width | Clamping capacity | Jaw height | Length | Height | Weight kg |
|----------|------|-----------|-------------------|------------|--------|--------|-----------|
| 768772 ■ | 1    | 45        | 65                | 20         | 150    | 45     | 1,4       |
| 768773 ■ | 2    | 65        | 100               | 28         | 210    | 65     | 4         |
| 768774 ■ | 3    | 100       | 130               | 38         | 270    | 78     | 10        |
| 768775 ■ | 4    | 125       | 150               | 40         | 300    | 85     | 15        |



For accurate jig operation of workpieces on grinding machines, jig grinding machines and other precision machines.  
Without spindle for erosion, grinding and inspection work.

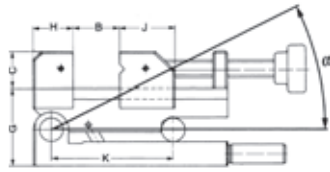
The angle of this model allows the use of the vice on 4 different faces (on the base, on the face and on both sides).

**Technical features:**

- made from high-grade tool-steel, completely hardened, all sides precision ground
- the horizontally ground prism in the movable jaw guarantees the safe clamping even of formed parts
- without spindle

Tool group A29  
Type 735-10 **PSK-O**  
precision grinding and control  
vice with 0,003 mm accuracy  
to gauge

| Item no. | Size | Jaw width | Clamping capacity | Jaw height | Length | Height | Weight kg |
|----------|------|-----------|-------------------|------------|--------|--------|-----------|
| 768777 ■ | 1    | 45        | 60                | 20         | 150    | 45     | 1,4       |
| 768778 ■ | 2    | 65        | 90                | 28         | 210    | 65     | 4         |
| 768779 ■ | 3    | 100       | 120               | 38         | 270    | 78     | 10        |
| 768780 ■ | 4    | 125       | 140               | 40         | 300    | 85     | 15        |



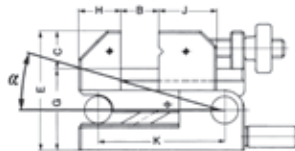
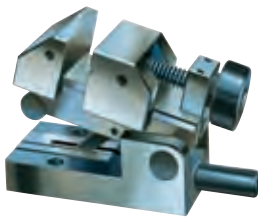
Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

**Technical features:**

- made out of alloyed tool steel, hardened and precision ground
- bearing pins and headed dowels hardened and ground with accuracy of 0,001 mm
- the clamping device can be positively locked in every angular position

Tool group A29  
Type 736-20 **PS-SV**  
front swivelling axis

| Item no. | Size | Squareness | Parallelism | Angular accuracy | Jaw width | B   | C  | Length body | G  | H  | J  | K   | $\beta$ | $\alpha$ | W       | Weight kg |
|----------|------|------------|-------------|------------------|-----------|-----|----|-------------|----|----|----|-----|---------|----------|---------|-----------|
| 370778   | 1    | 0,005      | 0,002       | bei 45° ± 15"    | 70        | 80  | 30 | 160         | 63 | 33 | 45 | 100 | -       | 0° - 46° | 2xM5x15 | 5,3       |
| 370779   | 2    | 0,005      | 0,002       | bei 45° ± 15"    | 90        | 120 | 40 | 210         | 73 | 40 | 50 | 150 | -       | 0° - 46° | 2xM5x15 | 11        |



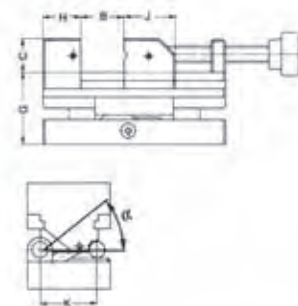
Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

**Technical features:**

- bearing pins and headed dowels hardened and ground with accuracy of 0,001 mm
- the clamping device can be positively locked in every angular position
- made out of alloyed tool steel, hardened and precision ground

Tool group A29  
Type 736-30 **PS-SH**  
rear swivelling axis

| Item no. | Size | Squareness | Parallelism | Angular accuracy | Jaw width | B  | C  | Length body | G  | H  | J  | K   | $\alpha$ | W       | Weight kg |
|----------|------|------------|-------------|------------------|-----------|----|----|-------------|----|----|----|-----|----------|---------|-----------|
| 370780   | 1    | 0,005      | 0,002       | bei 45° ± 15"    | 70        | 50 | 30 | 130         | 63 | 33 | 45 | 100 | 0° - 46° | 2xM5x15 | 4,5       |



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

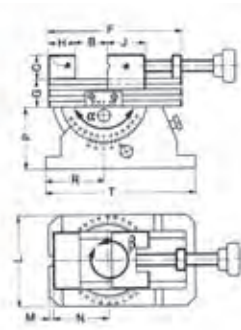
**Technical features:**

- bearing pins and headed dowels hardened and ground with accuracy of 0,001 mm
- the clamping device can be positively locked in every angular position
- made out of alloyed tool steel, hardened and precision ground

Tool group A29  
Type 736-40 **PS-SL**  
longitudinal swivelling axis

| Item no. | Size | Squareness | Parallelism | Angular accuracy | Jaw width | B  | C  | Length body | G  | H  | J  | K  | $\alpha$ | W       | Weight kg |
|----------|------|------------|-------------|------------------|-----------|----|----|-------------|----|----|----|----|----------|---------|-----------|
| 370781   | 1    | 0,005      | 0,002       | bei 45° ± 15"    | 75        | 80 | 30 | 160         | 63 | 33 | 45 | 50 | 0° - 46° | 2xM5x15 | 5,9       |

PZS



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

2-dimensional angle adjustment via vernia, for size 1 with 3'-vernier, for size 2 with 5'-vernier. The fine adjustment screw in the base permits accurate angle setting. Size 2 for particularly heavy machining work.

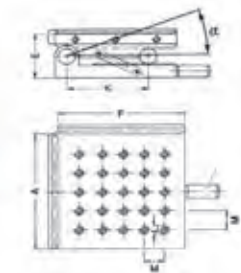
**Technical features:**

- positive locking in every angle position desired via locking screws
- made out of alloyed tool steel, hardened and precision ground
- 360° turnable

Tool group A29  
Type 736-50  
**Precision sine vice PS-ZD**  
2-dimensional

| Item no. | Size | Squareness | Parallelism | Jaw width | B   | C  | Length body | G  | H  | J  | L   | M  | N   | P   | R   | T   | $\beta$ | $\alpha$  | W       | Weight kg |
|----------|------|------------|-------------|-----------|-----|----|-------------|----|----|----|-----|----|-----|-----|-----|-----|---------|-----------|---------|-----------|
| 370782 ● | 1    | 0,005      | 0,002       | 70        | 80  | 30 | 160         | 32 | 33 | 45 | 110 | 5  | 65  | 75  | 70  | 180 | 360°    | 0° - 120° | 2xM5x15 | 11,1      |
| 370783 ● | 2    | 0,005      | 0,002       | 120       | 150 | 40 | 270         | 50 | 55 | 70 | 160 | 10 | 105 | 120 | 105 | 270 | 360°    | 0° - 70°  | 2xM6x20 | 43        |

Precision vices PZS



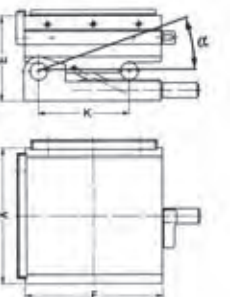
Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

**Technical features:**

- tapped index holes
- spaced 25 mm apart
- bearing pins and headed dowels hardened and ground with accuracy of 0,001 mm
- the clamping device can be positively locked in every angular position
- made out of alloyed tool steel, hardened and precision ground

Tool group A29  
Type 737-50  
**Precision sine angle plates SW-R**

| Item no. | Size | Squareness | Parallelism | Angular accuracy | A   | E  | F   | K   | L  | M  | $\alpha$ | Weight kg |
|----------|------|------------|-------------|------------------|-----|----|-----|-----|----|----|----------|-----------|
| 370784 ▲ | 1    | 0,005      | 0,002       | bei 45° ± 15"    | 150 | 63 | 150 | 100 | M6 | 25 | 0° - 45° | 11,3      |



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

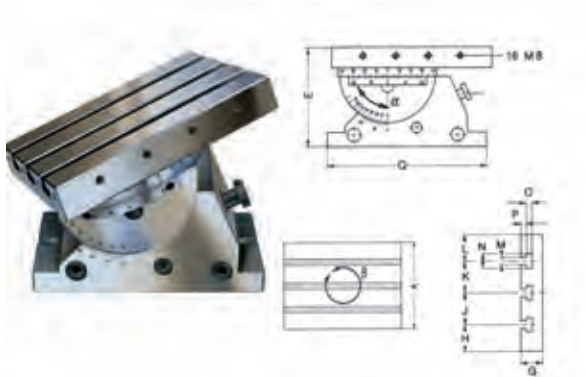
**Technical features:**

- with magnetic plate
- manually operated by means of a lever
- bearing pins and headed dowels hardened and ground with accuracy of 0,001 mm
- the clamping device can be positively locked in every angular position
- made out of alloyed tool steel, hardened and precision ground

Tool group A29  
Type 737-80  
**Precision sine angle plates SW-M**

| Item no. | Size | Squareness | Parallelism | Angular accuracy | A   | E    | F   | K   | M | $\alpha$ | Weight kg |
|----------|------|------------|-------------|------------------|-----|------|-----|-----|---|----------|-----------|
| 370785 ● | 1    | 0,005      | 0,002       | bei 45° ± 15"    | 150 | 81,5 | 150 | 100 | - | 0° - 45° | 12        |

PZS



Used on grinding, milling and engraving machines, jig boring machines, for measurement and inspection work.

With angle plate with T-slots arranged side by side, as per DIN 650. The mounting plate can be exactly adjusted in two dimensions by means of a 5'-vernier. The fine adjustment screw in the base permits accurate angle setting.

**Technical features:**

- with tilt and rotation axis
- bearing pins hardened and ground to an accuracy of 0,001 mm
- positive locking in every angle position desired via locking screws
- made out of alloyed tool steel, hardened and precision ground

Tool group A29  
Type 737-70  
**Precision angle plates SW-ND**  
2-dimensional

| Item no. | Size | Mounting surface | A   | E   | F   | G  | H  | J  | K  | L  | M  | N  | O  | P  | Q   | α        | β    | Weight kg |
|----------|------|------------------|-----|-----|-----|----|----|----|----|----|----|----|----|----|-----|----------|------|-----------|
| 370786 ■ | 1    | 0,004            | 220 | 180 | 300 | 40 | 50 | 60 | 60 | 50 | 14 | 28 | 12 | 10 | 270 | 0° - 45° | 360° | 47        |



For accurate setting of any angle between 0° and 90° on production and measuring machines.

Two base surfaces with folding magnets for horizontal and vertical use.

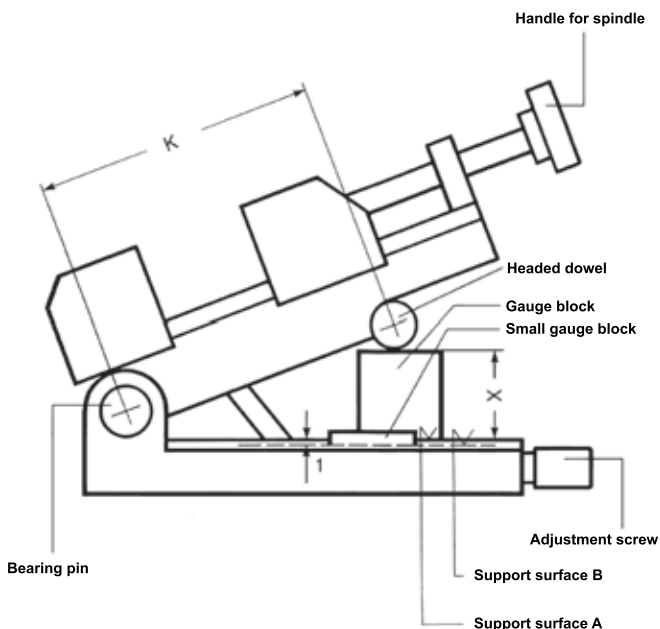
**Technical features:**

- all parts made out of alloyed steel, hardened and precision ground
- angle setting according to the sine principle with gauge blocks
- 3" angular accuracy

Tool group A37  
Type 737-00  
**Precision sine angle setting device PSE**  
3" angular accuracy

| Item no. | Size | A   | B  | C   | K   | α      |
|----------|------|-----|----|-----|-----|--------|
| 890706 ▲ | 0    | 75  | 34 | 70  | 50  | 0°-90° |
| 220715 ▲ | 1    | 160 | 63 | 131 | 100 | 0°-90° |

System description precision sine vices



The sine vice can be pivoted upwards by turning the adjustment screw. The gauge block is inserted between surface A and the headed dowel and the adjustment screw is turned back. Thus, the sine vice is pressed against the gauge block and positively locked.

When adjusting small angles, you place the appropriate gauge block on support surface B. Since this surface is 1 mm lower than the support surface A, an additional 1 mm must be taken into account for the tabula value determined.

**Formula for calculating the gauge block x**

$$x = \sin \alpha \cdot K \quad \text{for locating surface A}$$

$$x = \sin \alpha \cdot K + 1 \quad \text{for locating surface B}$$

**Example:**

Searched: gauge block for angle setting 24° 15' for precision sine vice PS-SV

Given: K = 100; sin α = 0,4107

Calculation: x = 0,4107 · 100 = 41,07

The height of the gauge block is 41,07mm



Clamping numerous workpieces on a pallet or a machine table. Clamping of numerous small and big workpieces on few space.

**Delivery includes:**

1 x Locating jaw, 4 x Intermediate jaw, 1 x Clamping rail, 2 x T-slot nut for nut 16 mm, 4 x Single clamp, 4 x Work locator  
The basic elements are designed for highly versatile use and adaptation to different workpiece sizes.  
Optimum utilization of the working range of the machine is achieved by mounting several clamping rails in the longitudinal or transverse direction.

**Technical features:**

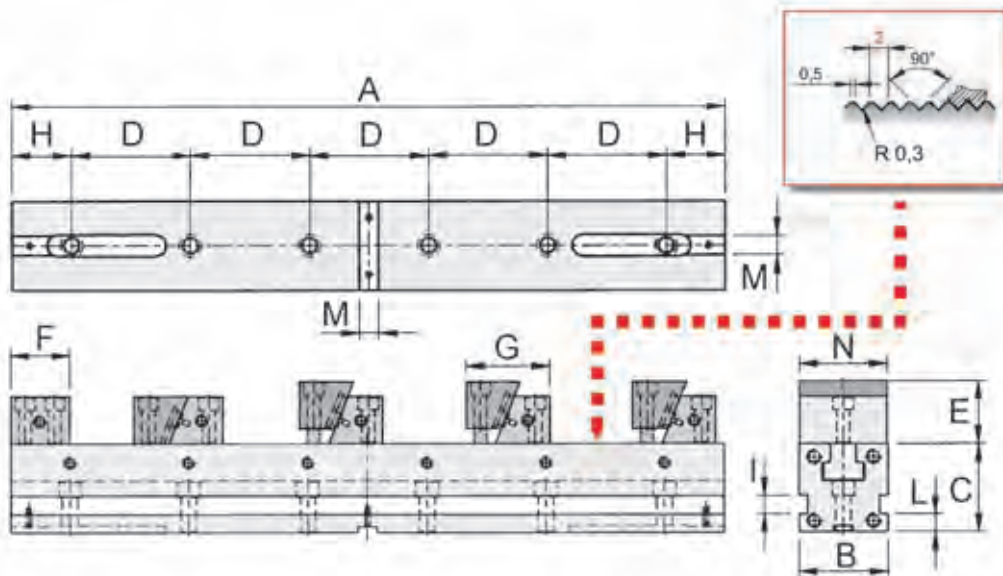
- the scale on the rail allows reading off the exact jaw position and thus repeatability at any time
- constant clamping force during every clamping operation and high repeating accuracy if torque wrenches are used
- serrations on top face for absolutely safe and accurate fastening of jaws

**Customer advantage:**

- T-slot nuts in size 10mm - 36mm available
- high clamping accuracy
- great machine durability
- reduced tool changing times

Tool group A27  
Type 796-90  
**Multiple clamping system MS complete**  
modular system

| Item no. | 1118789     | 1118790     | 1118791     | 1118792     | 1118793     | 1118794     | 1118795     |
|----------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Size     | MS 50 x 400 | MS 50 x 500 | MS 50 x 600 | MS 75 x 400 | MS 75 x 500 | MS 75 x 600 | MS 75 x 700 |
| A        | 400         | 500         | 600         | 400         | 500         | 600         | 700         |
| B        | 50          | 50          | 50          | 75          | 75          | 75          | 75          |
| C        | 50          | 50          | 50          | 75          | 75          | 75          | 75          |
| D        | 100         | 100         | 100         | 100         | 100         | 100         | 100         |
| E        | 32/25       | 32/25       | 32/25       | 53/40       | 53/40       | 53/40       | 53/40       |
| F        | 34          | 34          | 34          | 50          | 50          | 50          | 50          |
| G        | 55/58       | 55/58       | 55/58       | 70/75       | 70/75       | 70/75       | 70/75       |
| H        | 50          | 50          | 50          | 50          | 50          | 50          | 50          |
| I        | 12          | 12          | 12          | 16          | 16          | 16          | 16          |
| L        | 15          | 15          | 15          | 20          | 20          | 20          | 20          |
| M        | 16          | 16          | 16          | 16          | 16          | 16          | 16          |
| N        | 49          | 49          | 49          | 74          | 74          | 74          | 74          |



## Accessories MS

Tool group A27  
Type 796-90 **Clamping rail SL**



| Item no.  | Size        | A   | B  | C  | D   | H  | I  | L  | M  |
|-----------|-------------|-----|----|----|-----|----|----|----|----|
| 1145245 ▲ | MS 50 x 400 | 400 | 50 | 50 | 100 | 50 | 12 | 15 | 16 |
| 1145246 ▲ | MS 50 x 500 | 500 | 50 | 50 | 100 | 50 | 12 | 15 | 16 |
| 1145247 ▲ | MS 50 x 600 | 600 | 50 | 50 | 100 | 50 | 12 | 15 | 16 |
| 1145250 ▲ | MS 75 x 400 | 400 | 75 | 75 | 100 | 50 | 16 | 20 | 16 |
| 1145251 ▲ | MS 75 x 500 | 500 | 75 | 75 | 100 | 50 | 16 | 20 | 16 |
| 1145252 ▲ | MS 75 x 600 | 600 | 75 | 75 | 100 | 50 | 16 | 20 | 16 |
| 1145253 ▲ | MS 75 x 700 | 700 | 75 | 75 | 100 | 50 | 16 | 20 | 16 |

Tool group A37  
Type 796-90 **Locating jaw MS**



| Item no.  | For   | Width | Height | Length |
|-----------|-------|-------|--------|--------|
| 1145243 ▲ | MS 50 | 49    | 25     | 34     |
| 1145248 ▲ | MS 75 | 74    | 40     | 50     |

Tool group A37  
Type 796-90 **Intermediate jaw MS**



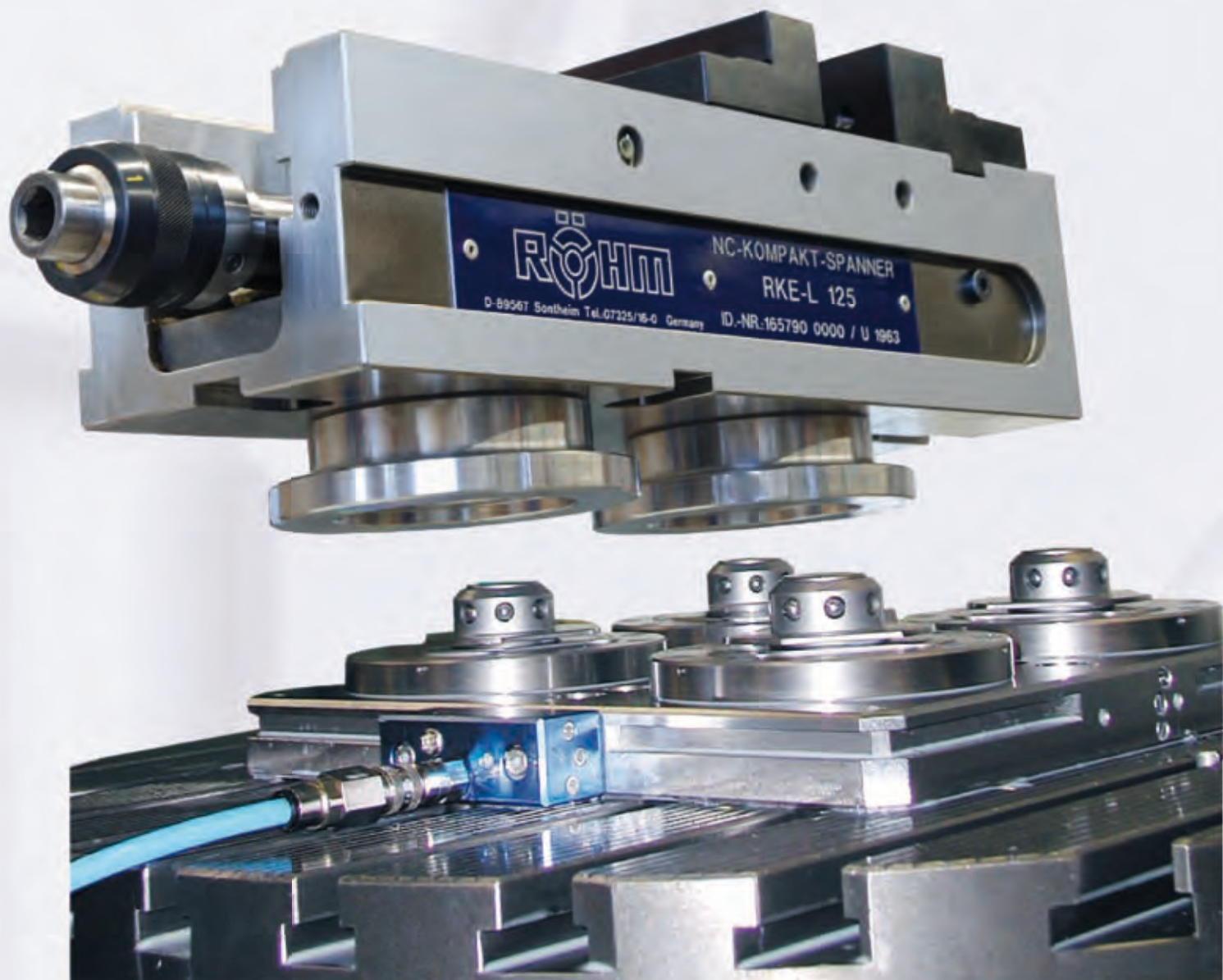
| Item no.  | For   | Width | Height min | Height max | Length min | Length max |
|-----------|-------|-------|------------|------------|------------|------------|
| 1145244 ■ | MS 50 | 49    | 25         | 32         | 55         | 58         |
| 1145249 ■ | MS 75 | 74    | 40         | 53         | 70         | 75         |

## POWER-GRIP

### Userfriendly modular pallet system

- rugged, productivity increasement
- mount and adjust only once
- machine on all machine tables

„Multifunctional machining possibilities in connection with RÖHM clamping tools.“





# POWER-GRIP

## Your production will be like a walk in the park

Nothing can compare to the POWER-GRIP system. It easily fits into any production process – even automated ones – and is simply different from others and works in a more customer-oriented way:

The dimensions of the palleting system are standardized here via different inside micrometers. A major advantage for you! After the correct design of the inside micrometer, your devices are no longer bound to single machines. Where and on which machine you now machine your workpiece will no longer play any role.

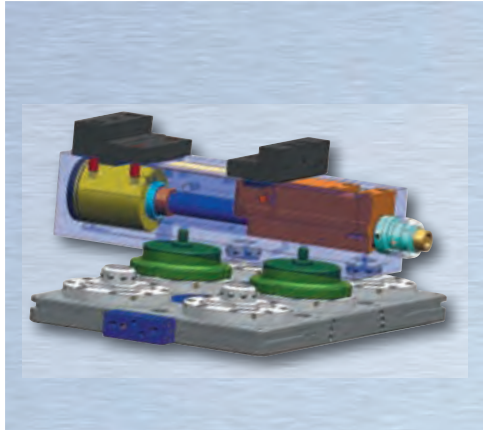
With POWER-GRIP, your device can be used throughout your factory without difficulties – as easily as a walk in the park!

## All good things come in threes

1. It doesn't matter whether you measure, mill, turn, wire-cut/cavity sink by EDM, face/circular grind, drill or laser-cut – POWER-GRIP puts an end to the jumble of incompatible systems and clamping tapers. POWER-GRIP: A single interface for your entire production sequence!
2. The POWER-GRIP system clamps gently on material at 17.000 N and up.  
On request, there is extra power available up to 30.000 N per spring unit.
3. POWER-GRIP is made of high-quality material. The reference surfaces are thoroughly hardened. The basic support consists of 1.2085 steel, the spring unit is made of M333 (Böhler, Gillette blade steel). The entire system is rust-resistant. The material fatigue is negligibly low, the lifetime of the components almost unlimited!

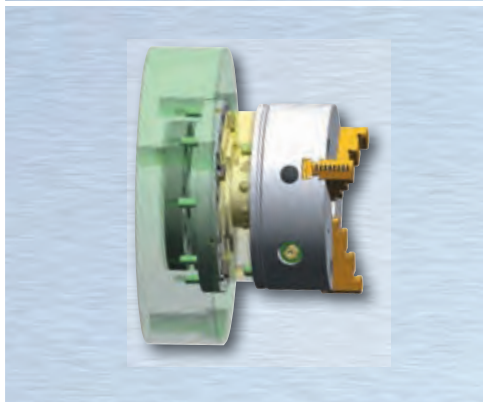


## POWER-GRIP application areas



### Milling

The modular structure allows all machine tables to be loaded individually. Machining of cylindrical and square workpieces by changing the workpiece pallets super-fast.



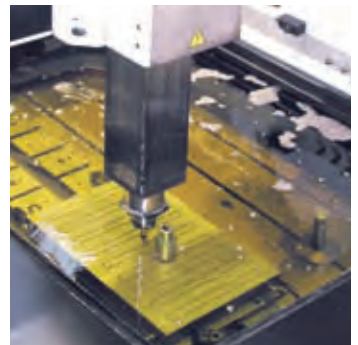
### Turning

Simple coupling of the workpiece from milling to turning machining.



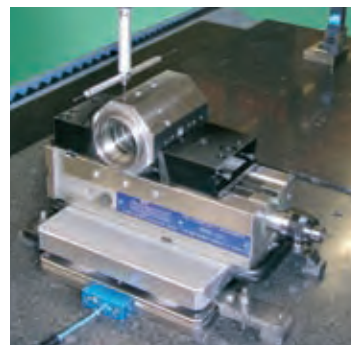
### Eroding

Taking the workpiece from turning and milling to eroding. Checking the machining progress is always possible on the measuring machine.



### Measuring

In order to check after every machining operation, the machined workpiece can be quickly taken up at any time without reference loss.



# POWER-GRIP structure

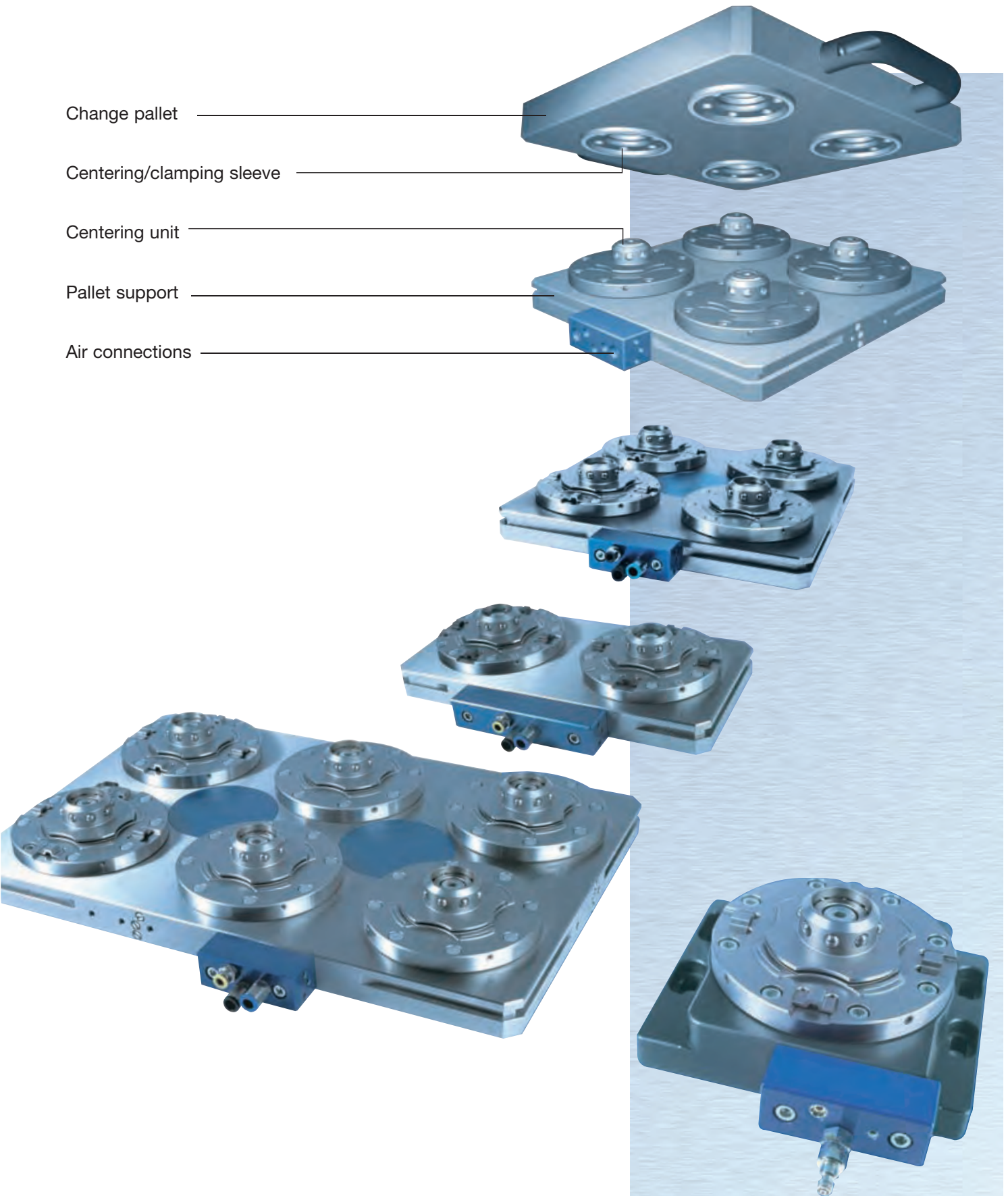
Change pallet

Centering/clamping sleeve

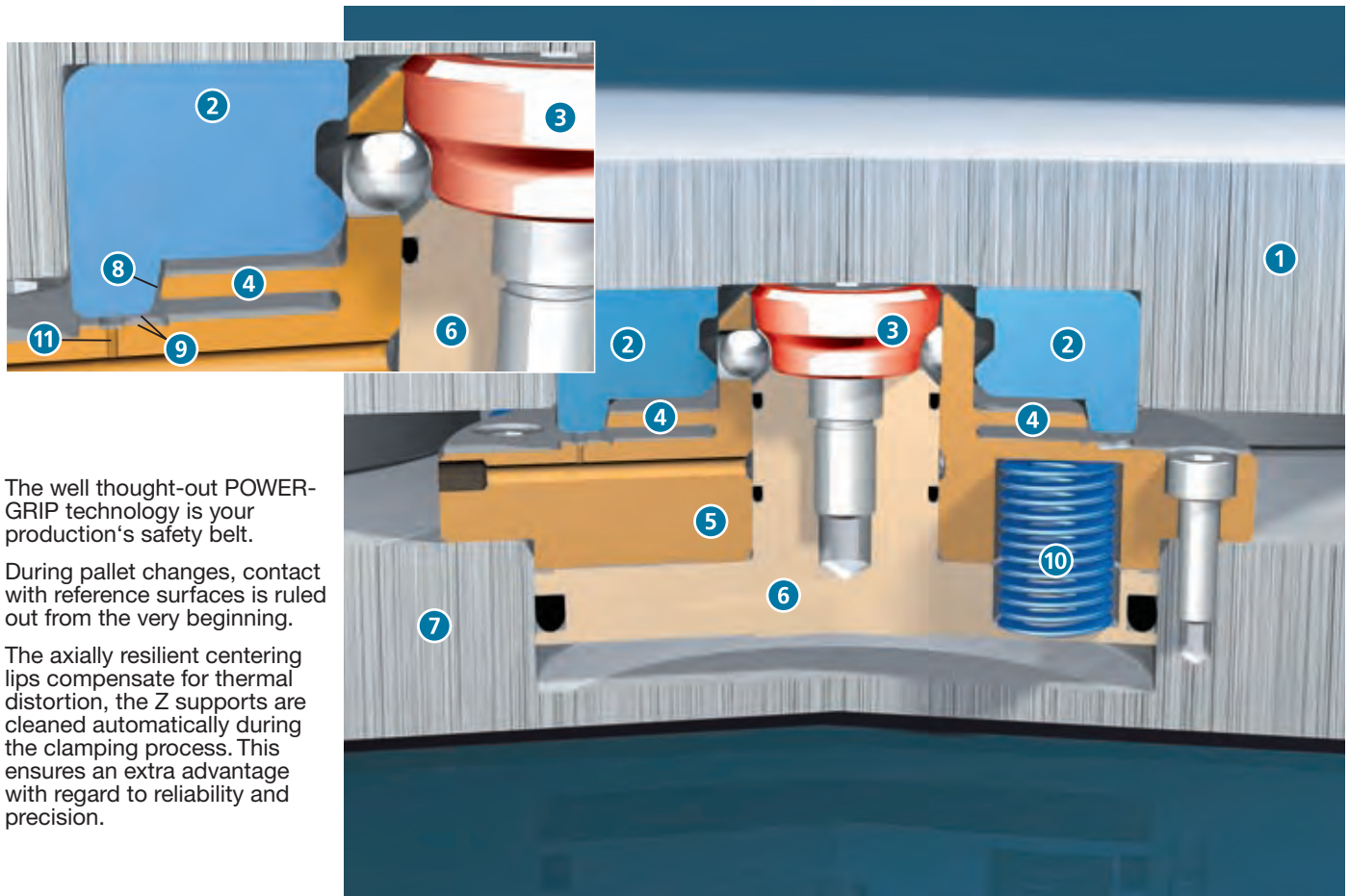
Centering unit

Pallet support

Air connections



## Sectional view of the POWER-GRIP-System



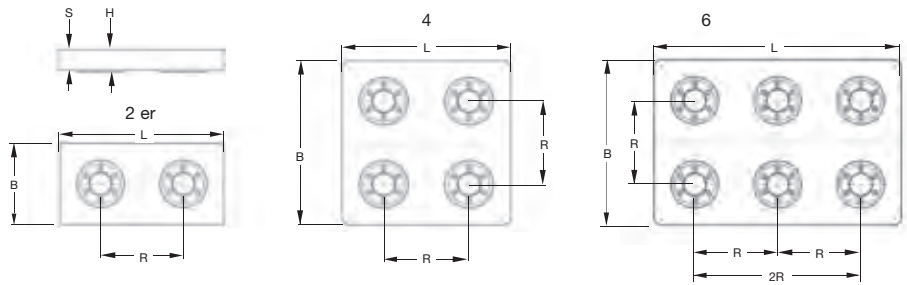
The well thought-out POWER-GRIP technology is your production's safety belt.

During pallet changes, contact with reference surfaces is ruled out from the very beginning.

The axially resilient centering lips compensate for thermal distortion, the Z supports are cleaned automatically during the clamping process. This ensures an extra advantage with regard to reliability and precision.

1. Change pallet
2. Centering / clamping collets
3. Clamping cone
4. Axially resilient centering lip
5. Centering unit
6. Piston
7. Pallet carrier
8. XY-reference surfaces
9. Z-reference surfaces
10. Spring
11. Bore for Z-support cleaning

# Dimensions

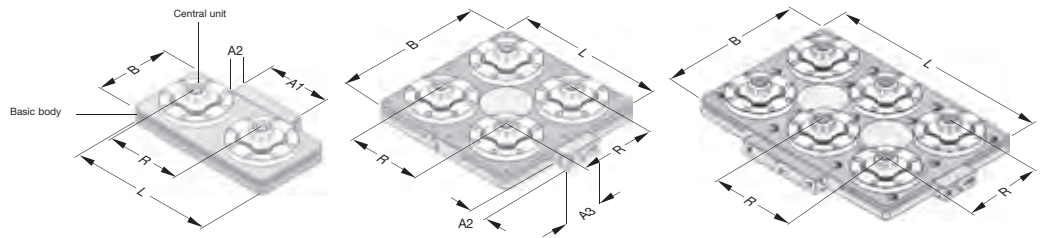


## Pallets

Tool group A22

|                       |                 |                             |        |
|-----------------------|-----------------|-----------------------------|--------|
| milled                | Item no. 488743 | 488747                      | 488764 |
| grounded              | Item no. 488744 | 488748                      | 488765 |
| L ±0,2                | 318             | 318                         | 478    |
| B ±0,2                | 158             | 318                         | 318    |
| R ±0,01               | 160             |                             |        |
| S Thickness of pallet |                 | 38,1±0,02 / 38 ±0,01 milled |        |
| H Height of pallet    |                 | 42,1/42 ±0,01 grounded      |        |

The involved centering and clamping sleeves are also available in single pieces to fit into any pallets.

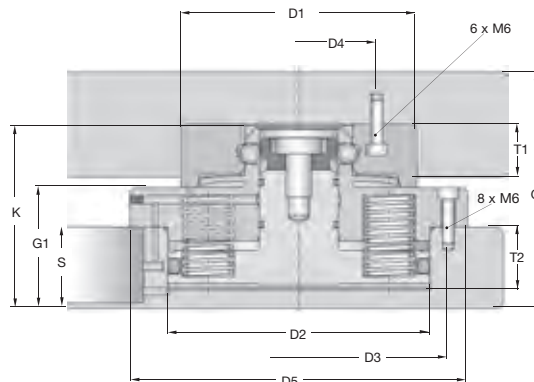


## Pallet carrier

Tool group A22

|                           |         |          |        |
|---------------------------|---------|----------|--------|
| Item no.                  | 1011207 | 488716   | 488724 |
| L ±0,2                    | 316     | 316      | 476    |
| B ±0,2                    | 156     | 316      | 316    |
| R ±0,01                   |         | 160      |        |
| A1 connection block long  |         | 140 ±0,1 |        |
| A2 connection block       |         | 30 ±0,1  |        |
| A3 connection block short |         | 80 ±0,1  |        |

Mounting holes in 50, 63, 100 and 125 mm grid as well as customized available. Basic body and centering unit also available in single pieces for fitting.



## Complete system clamped

|                     |                     |          |         |                  |          |         |    |               |          |          |
|---------------------|---------------------|----------|---------|------------------|----------|---------|----|---------------|----------|----------|
| D1                  | D2                  | D3       | D4      | D5               | T1       | T2      | G  | G1            | K        | S        |
| 92 +0,012<br>+0,004 | 100 +0,02<br>+0,005 | 112 ±0,1 | 62 ±0,1 | Ø129 +0<br>-0,02 | 19 ±0,01 | 25 ±0,1 | 88 | 46 +0,01<br>0 | 69 ±0,01 | 31 ±0,01 |

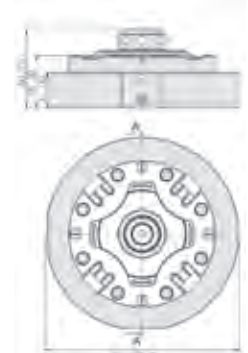
Dimensions in mm



Centering unit index 90° prevents twisting when using the centering sleeve index 90° for 1 x change pallets.



Centering unit Standard

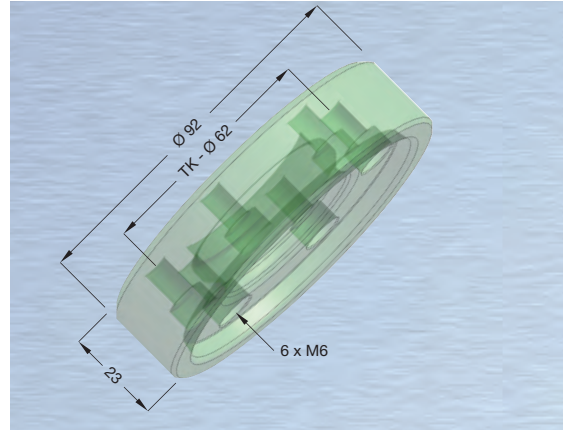


# Centering and clamping sleeves

Take advantage of the pallet savings potential by means of direct device fastening with different centering and clamping sleeves



**Standard**  
for installation in pallets  
and devices  
Item no. 488742



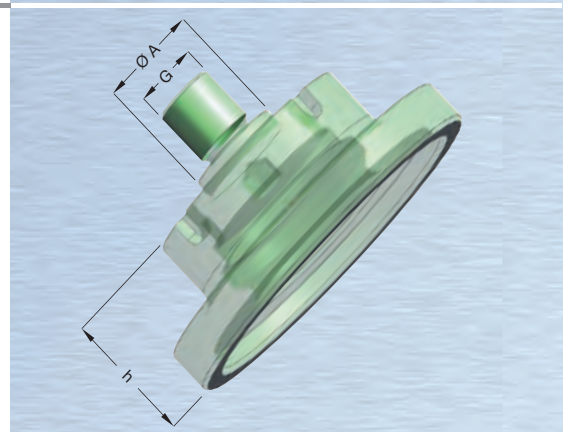
## With threaded bolt

Flat design for directly fastening in the clamping device and fixtures

Tool group A22

| G   | A  | h  | Item no.              |
|-----|----|----|-----------------------|
| M12 | 25 | 32 | 1081407 <sup>1)</sup> |
| M16 | 25 | 32 | 1084431               |
|     | 32 | 32 | 1084432               |

<sup>1)</sup> Ø A32 on request



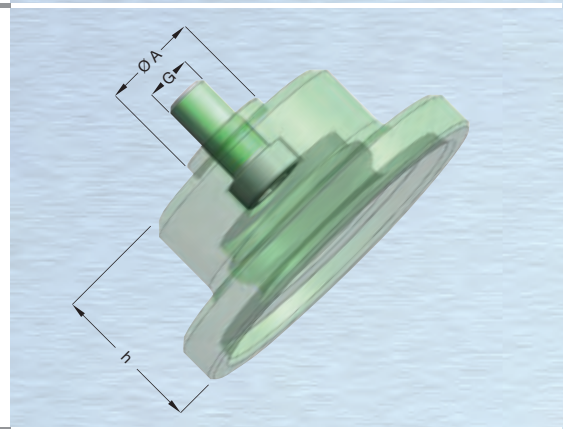
## With standard screw

Simple design for direct installation in fixtures and clamping device

Tool group A22

| G   | A  | h  | Item no.              |
|-----|----|----|-----------------------|
| M12 | 25 | 38 | 1081405 <sup>1)</sup> |
| M16 | 25 | 40 | 1084434               |
|     | 32 | 40 | 1084437               |

<sup>1)</sup> Ø A32 on request



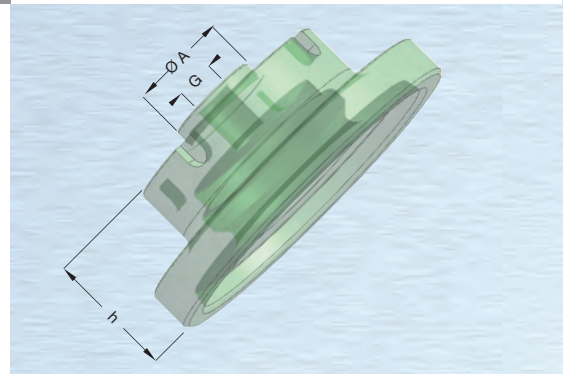
## With inner thread

for fastening from above through clamping device or fixture

Tool group A22

| G   | A  | h  | Item no.              |
|-----|----|----|-----------------------|
| M12 | 25 | 32 | 1084439 <sup>1)</sup> |
| M16 | 25 | 42 | 1084440               |
|     | 32 | 42 | 1084441               |

<sup>1)</sup> Ø A32 on request



## Accessories



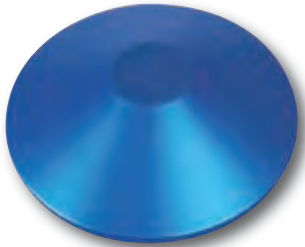
### Pneumatic operating unit

For up to 3 air connections. Allows pallets to be released, Z-support cleaning, pneumatic reclamping and air purge supply.



### Gasket

For protecting from contamination during machining and to seal during erosion.



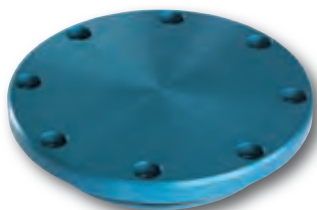
### Protection caps

Optimum protection for non-active centering units.



### Support

For gentle depositing and fixing of pallets on rotary tables.

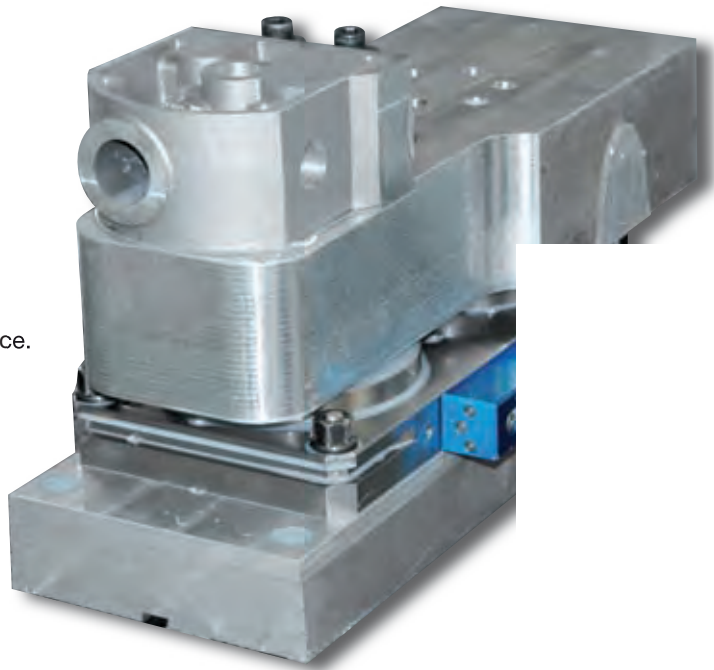


### Basic body cover

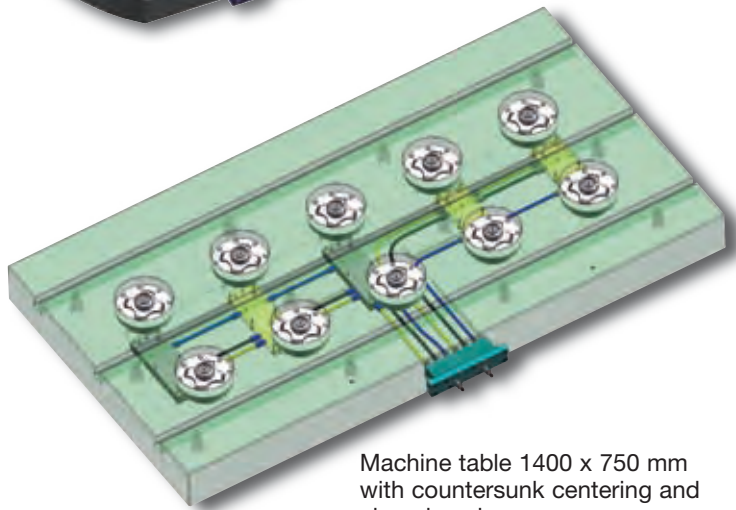
For covering the pallet support instead of a centering unit. As an inexpensive option for later retrofitting of the pallet support with a centering unit.

## Special solutions

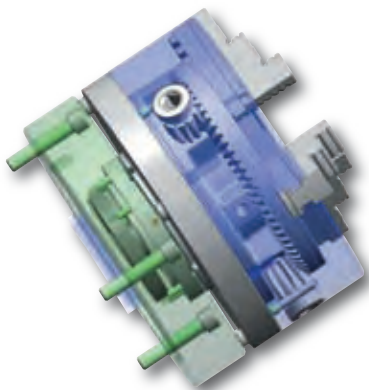
2x pallet support for direct mounting of a special clamping device.



Machine rotary table 860 mm for machine Hedelius with countersunk centering and clamping sleeves.



Machine table 1400 x 750 mm with countersunk centering and clamping sleeves.



Lathe chuck Ø 200 mm with integrated POWER-GRIP flange.



Special solutions



Machine table of a profile-grinding machine with 8 centering and clamping sleeves integrated into the machine table, with special pallet.

POWER-GRIP 6x clamping device for the machining of crankshafts.



Ø 510 mm face plate with POWER-GRIP centering and clamping sleeves for machining of turbine blades in the aircraft industry.

