



THE PREMIUM VISE FOR ANY AREA OF APPLICATION



The NC-compact vises from RÖHM are excellently suited for use in single or series production. Different types and constructional lengths enable the optimal adaptation to the work area, workpiece and machining task.



Video RKE

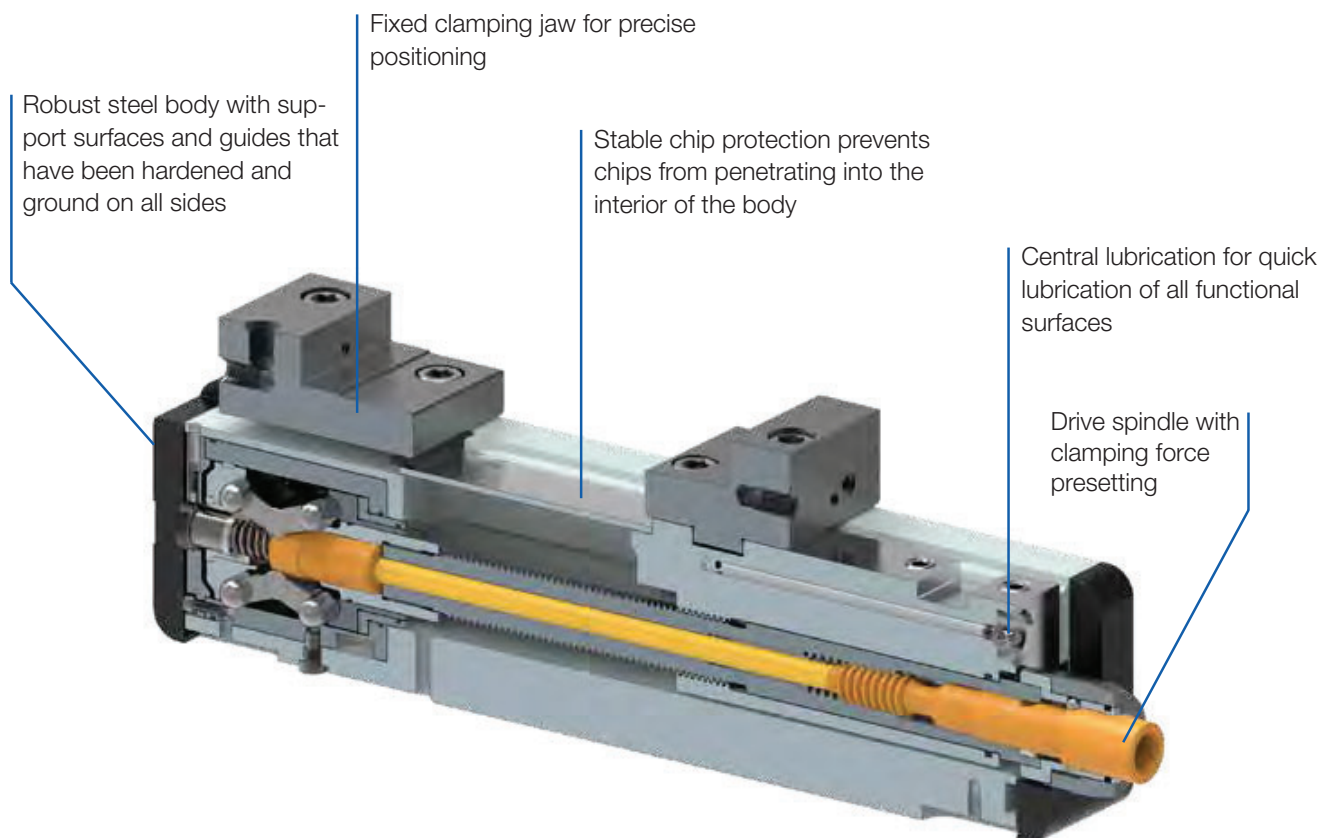
NC-COMPACT VISES

NC-compact vises are particularly suited for use on machining centers, milling machines and are ideal for 5-axis machining. These premium vises are very impressive with their stable and compact design for maximum clamping accuracy and optimal workpiece accessibility. By simply turning the clamping force presetting, a clamping force of up to 60 kN can be achieved. With workpieces that are sensitive to deformation, the force amplification can be disabled.

ADVANTAGES AT A GLANCE

- ③ Large clamping range and precise positioning due to fixed clamping jaw
- ③ The compact design resists deformation for the greatest possible clamping precision
- ③ Consistent clamping force and maximum repeatability of 0.01 mm

NC-Compact vises



RKE - with power transmitter



APPLICATION

Particularly suitable for use on machining centers.

TYPE

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.
Hydraulic actuation on request.

CUSTOMER BENEFITS

- ⊕ Horizontal, side or in connection with a base plate vertical mounting, for example as DUO clamping tower (back to back)
- ⊕ Sturdy chip protection prevents chips from penetrating
- ⊕ Drive spindle with clamping force presetting
- ⊕ Clamping surface for clamping claws
- ⊕ Central lubrication of guides and spindle thread
- ⊕ Thread for fastening angle drive

TECHNICAL FEATURES

- Sturdy steel body and all guides are hardened and ground on all sides
- Long clamping slide with cross slots, hardened on all sides, functional surfaces ground
- Threaded bores for taking up all RÖHM flat clamping jaws with jaw width 125/160 mm

RKE = RÖHM, compact, single clamping

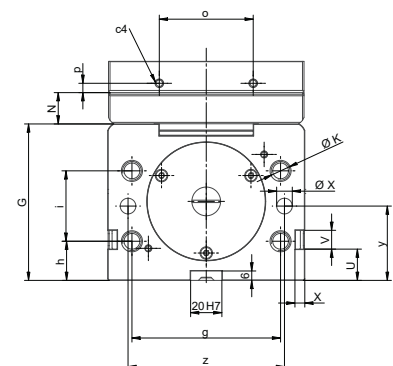
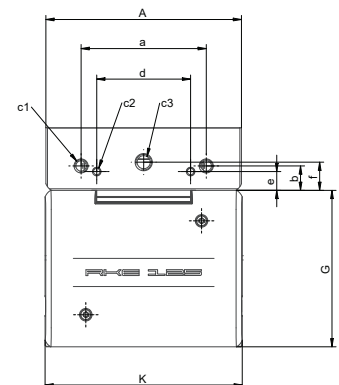
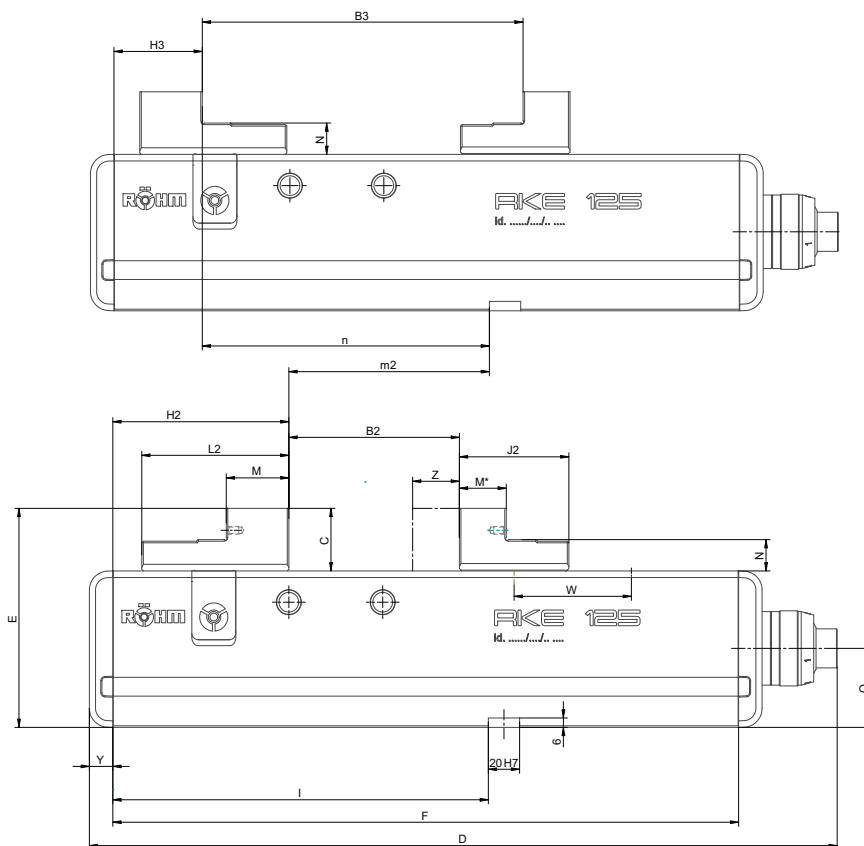
A32
RKE, with stepped jaws

Item no.	178411	178412	178413	178414
Jaw width A mm	92	125	160	200
Jaw design	stepped jaws	stepped jaws	stepped jaws	stepped jaws
B2 mm	0 - 138	0 - 216	0 - 320	0 - 315
B3 mm	71 - 208	97 - 312	131 - 451	131 - 451
C mm	32	40	50	60
D mm	345	478	633	633
E mm	112	140	165	175
F mm	276	400	530	530
G _{0,02} mm	80	100	115	115
H2 mm	80	112,5	130	135
H3 mm	41	56,5	64	64
J2 mm	56	70	97	97
K mm	94	126	162	162
L2 mm	64	94	98	103
M mm	25	40	34	39
M* mm	25	30	32,5	32,5
N _{0,01} mm	16	20	25	25
Q	39	50,5	59,5	59,5
U mm	20	20	20	20
V mm	12	12	12	12
W mm	68	1x108	2x102,5	2x102,5
X mm	10	10	10	10
Y mm	15	15	15	15
Z mm	70	109	117	117
a mm	63	80	100	125
b mm	13,6	15,6	19,6	24,6
c1	M 6x14	M 8x14	M 8x14	M 10x15
c2	M 5x9	M 5x10	M 5x9	M 5x10
c3	M 10x16	M 10x18	M 10x18	M 14x20
c4	M5	M5	M5	M5
d mm	48	60	80	110
e mm	8	12	12	12
f mm	14	18	20	25
g mm	70	95	125	125
h mm	20	25	17,5	17,5
i mm	40	45	80	80
Ø k	M10x18	M12x22	M16x25	M16x25
l mm	140	240	200	200
m2±0,02 mm	60	127,5	70	65
n±0,02 mm	99	183,5	136	136
Ø x	Ø 10 ^{H7}	Ø 10 ^{H7}	Ø 10 ^{H7}	Ø 10 ^{H7}
o	48	60	88	110
p	6	6	6	12
y ^{0,01} mm	40	47,5	57,5	57,5
z mm	72	100	135	135
Clamping force kN	25	40	60	60
Weight kg	15	41	79	85

RKE - with power transmitter



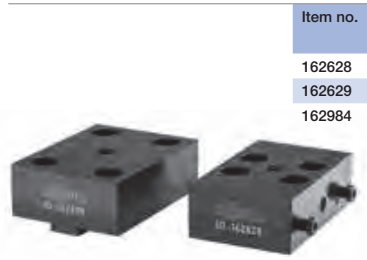
NC-Compact vises
RKE



Accessories RKE

A37

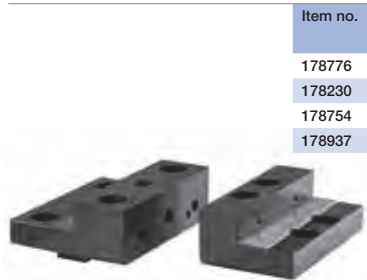
Standard top jaws SA, reversible



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

A37

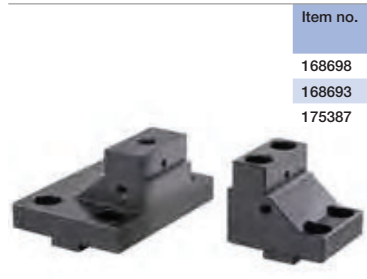
Stepped jaws SB, reversible



Item no.	Contents of delivery	Size	Width mm	Height mm
178776	set	92	92	32
178230	set	125	125	40
178754	set	160	160	50
178937	set	200	200	60

A37

Double stepped jaws DSB, „smooth“



Item no.	Contents of delivery	Size	Width mm	Height mm
168698	set	92	50	48
168693	set	125	62	60
175387	set	160	160	75

A37

Carrier jaws TB, without swivelling claw inserts



Item no.	Contents of delivery	Size	Width mm	Height mm
165856	set	125	125	20
166218	set	160/200	160	25

A37

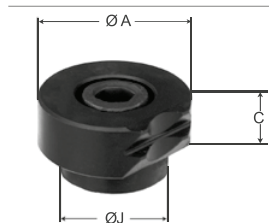
Carrier jaws, without claw inserts



Item no.	Contents of delivery	Size	Width mm	Height mm
169383	set	92	115	20
165861	set	125	160	20
166223	set	160/200	200	25

A37

Swivelling claw inserts, for carrier jaws 743-72

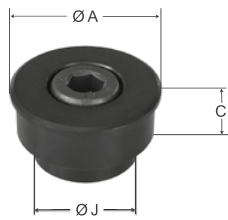


Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	Height mm
165854	piece	92/125	28	20	10
166216	piece	160/200	30	22	10

Accessories RKE

A37

Tensioner, for carrier jaws 743-72



Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	Height mm
169389	piece	92/125	28	20	10
169391	piece	160/200	30	22	10

A37

One-piece steel top jaws, for self-production of formed jaws or for clamping formed parts



Item no.	Contents of delivery	Size	Width mm	Height mm
160352	set	125	125	60
160353	set	160	160	70

A37

Normal jaw SGN, one side smooth, one side grooved, both sides ground



Item no.	Contents of delivery	Size	Width mm	Height mm
152752	piece	92	92	31,6
178112	piece	125	125	39,7
152755	piece	160	160	49,6
152759	piece	200	200	62,6

Including fixing screws

A37

Normal jaw finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved



Item no.	Contents of delivery	Size	Width mm	Height mm
163218	piece	92	92	31,6
180679	piece	125	125	39,7
156197	piece	160	160	49,6
156198	piece	200	200	62,6

Including fixing screws

A37

Claw jaws SKB with fine step, 2.5 mm clamping depth



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166514	set	92	92	32	14
166520	set	125	125	40	16
166522	set	160	160	50	18

Including fixing screws

A37

Workpiece stop with mounting thread



Item no.	description
320400	Workpiece stop with M12 mounting thread

A37

Werkstückanschlag magnetisch



Id.-Nr.	Bezeichnung
184740	Workpiece stop with magnetic attachment - Premium (incl. base module)

Accessories RKE

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661	set	92	92	32	14
166667	set	125	125	40	16
166669	set	160	160	50	18

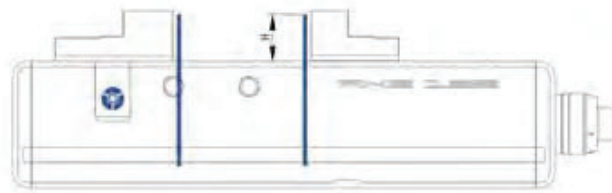
Including fixing screws

A37

Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box



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



Accessories NC-Compact vises RKE

A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					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

Including fixing screws

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground



Item no.	Contents of delivery	Width mm	Height mm
150740	piece	135	39,6
150741	piece	160	49,6

Including fixing screws

A37

Draw-down jaws SNF, with spring plate, hardened and ground



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

Including fixing screws

Accessories RKE

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



Item no.	Contents of delivery	Size	Width mm	Height mm	Step	Chuckling capacity mm	
						Horizontal	Vertical
317259	set	92	110	31,8	3,5x3,3	3-12	5-32
317260	set	125	135	39,8	4x4,3	3-13	6-40
317261	set	160	160	49,8	4x4,8	5-22	7-48

Including fixing screws

A37

Draw-down jaws RNG, with two permanent magnets



Item no.	Contents of delivery	Size	Width mm	Height mm
155237	set	92	92	32
159227	set	125	125	39,5
155240	set	160	160	50
163782	set	200	200	60

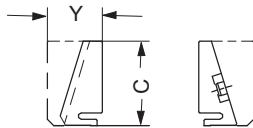
Including fixing screws

A37

Standard insert RNS, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242	set	92	92	32	21
159232	set	125	125	40	26
155245	set	160	160	50	30
163783	set	200	200	60	34

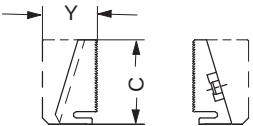


A37

Standard insert finely checkered RNSf, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163270	set	92	92	32	21
163267	set	125	125	40	26
163273	set	160	160	50	30
163784	set	200	200	60	34

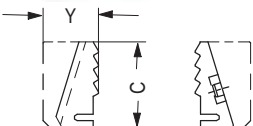


A37

Claw insert RNK, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155247	set	92	92	32	21
159235	set	125	125	40	26
155250	set	160	160	50	30
163785	set	200	200	60	34



Accessories RKE

A37

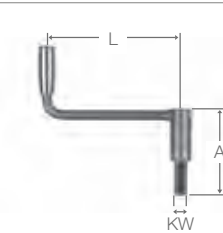
Floating jaw horizontal PEB, for clamping non-parallel workpieces



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
156190	piece	92	113	32	36
156191	piece	125	135	40	40
156192	piece	160	160	50	45
156193	piece	200	200	63	55

A37

Hand crank, turnable handle



Item no.	Contents of delivery	Size	External hexagon Key-wight (KW)	A	L
134198	piece	92	12	60	90
134600	piece	125/160/200	14	104	160

A37

Angle drive 90°



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

A37

Single clamp SPE, for mounting vises on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw



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

C15

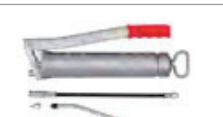
Grease F91 for vises, for lubrication and conservation of chucking power



Item no.	Design	Contents
777021	Cartridge	0,4 kg

C15

Grease gun DIN1283



Item no.	Connection	Contents of delivery
329093	M10x1	150 mm nozzle tube bent, needlepoint mouthpiece, top mouthpiece, 300 mm high pressure hose with 4 jaw hydraulics cross mouthpiece



Notes

Notes

RKE-M - without power transmitter



APPLICATION

Particularly suitable for use on machining centers and palletisers.

TYPE

Clamping system mechanical without power transmitter, manually operated.

CUSTOMER BENEFITS

- ③ Horizontal, side or in connection with a base plate vertical mounting, for example as DUO clamping tower (back to back)
- ③ Sturdy chip protection prevents chips from penetrating
- ③ Large clamping stroke
- ③ Clamping surface for clamping claws
- ③ Central lubrication of guides and spindle thread
- ③ Constant clamping force for every clamping operation and high clamping repeatability when a torque wrench is used

TECHNICAL FEATURES

- Sturdy steel body and all guides are hardened and ground on all sides
- Long clamping slide with cross slots, hardened on all sides, functional surfaces ground
- Threaded bores for taking up all RÖHM flat clamping jaws with jaw width 125/160 mm

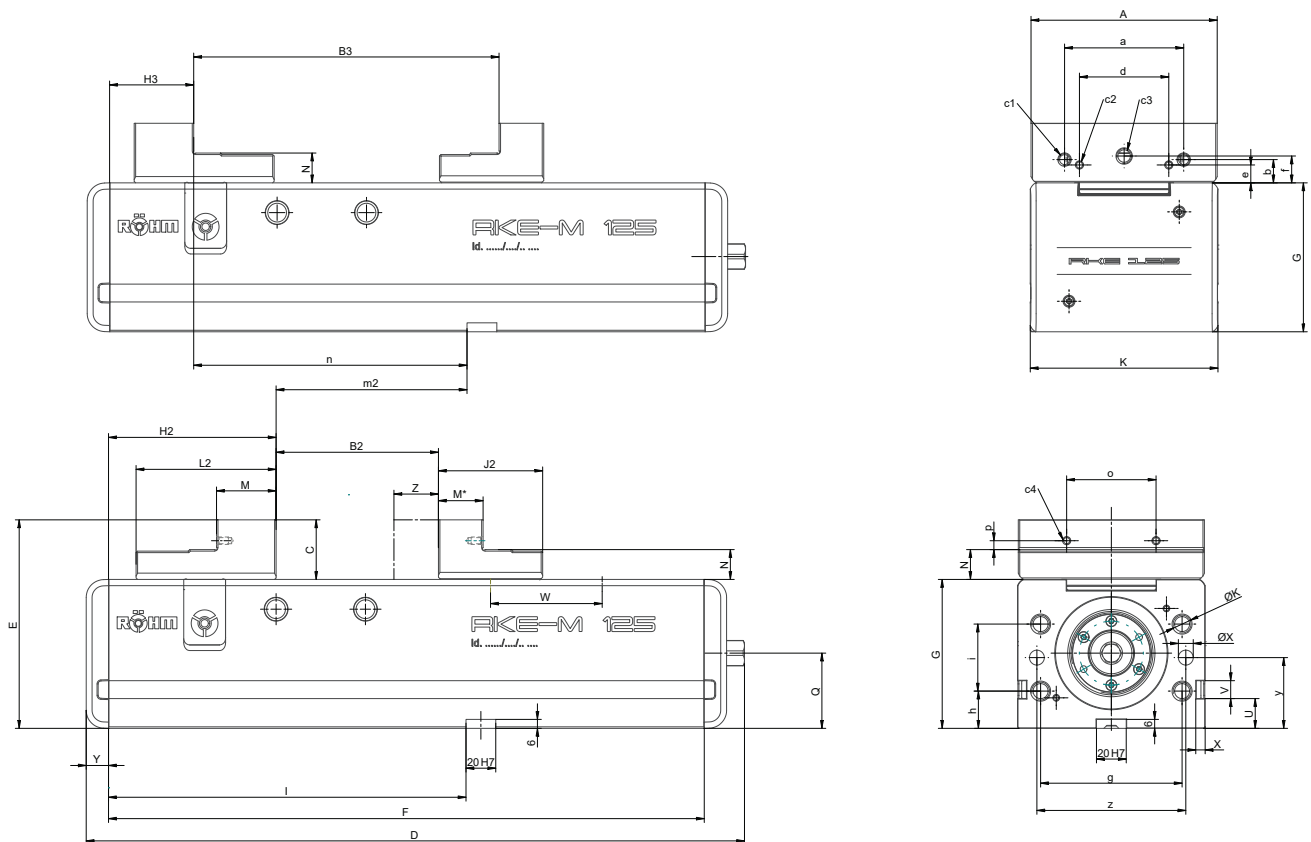
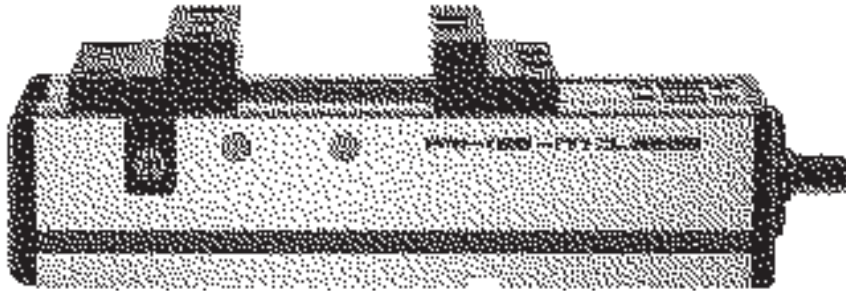
RKE-M = RÖHM, compact, single clamping, manual

A32

RKE-M, with stepped jaws

Item no.	182137	182138	182139	182140
Jaw width A mm	92	125	160	200
Jaw design	stepped jaws	stepped jaws	stepped jaws	stepped jaws
B2 mm	0-138	0 - 216	0 - 320	0 - 315
B3 mm	71-208	97 - 312	131 - 451	131 - 451
C mm	32	40	50	60
D mm	315	442	607	607
E mm	112	140	165	175
F mm	276	400	530	530
G _{-0,02} mm	80	100	115	115
H2 mm	80	112,5	130	135
H3 mm	41	56,5	64	64
J2 mm	56	70	97	97
K mm	94	126	162	162
L2 mm	64	94	98	103
M mm	25	40	34	39
M* mm	25	30	32,5	32,5
N _{-0,01} mm	16	20	25	25
Q	39	50,5	59,5	59,5
U mm	20	20	20	20
V mm	12	12	12	12
W mm	68	1x108	2x102,5	2x102,5
X mm	15	15	15	15
Y mm	10	10	10	10
Z mm	70	109	117	117
a mm	63	80	100	125
b mm	13,6	15,6	19,6	24,6
c1	M 6x14	M 8x14	M 8x14	M 10x15
c2	M 5x9	M 5x10	M 5x9	M 5x10
c3	M 10x16	M 10x18	M 10x18	M 14x20
c4	M5	M5	M5	M5
d mm	48	60	80	110
e mm	8	12	12	12
f mm	14	18	20	25
g mm	70	95	125	125
h	20	25	17,5	17,5
i	40	45	80	80
Ø k	M10x18	M 12x22	M 16x25	M 16x25
l mm	140	240	200	200
m2±0,02 mm	60	127,5	70	65
n±0,02 mm	99	183,5	136	136
o	48	60	88	110
p	6	6	6	12
y ^{+0,01} mm	40	47,5	57,5	57,5
z mm	72	100	135	135
Square AF	12	14	19	19
Ø X ⁺¹⁷	10	10	10	10
Clamping force kN	25	40	60	60
Weight kg	15	41	79	85

RKE-M - without power transmitter



Accessories RKE-M

A37

Standard top jaws SA, reversible

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



A37

Stepped jaws SB, reversible

Item no.	Contents of delivery	Size	Width mm	Height mm
178776	set	92	92	32
178230	set	125	125	40
178754	set	160	160	50
178937	set	200	200	60



A37

Double stepped jaws DSB, „smooth“

Item no.	Contents of delivery	Size	Width mm	Height mm
168698	set	92	50	48
175387	set	160	160	50
168693	set	125	62	60



A37

Carrier jaws TB, without swivelling claw inserts

Item no.	Contents of delivery	Size	Width mm	Height mm
166601	set	92	100	20
165856	set	125	125	20
166218	set	160/200	160	25



A37

Carrier jaws, movable jaw pendular, without claw inserts

Item no.	Contents of delivery	Size	Width mm	Height mm
169383	set	92	115	20
165861	set	125	160	20
166223	set	160/200	200	25



A37

Swivelling claw inserts, for carrier jaws 743-72

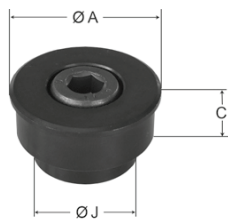
Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	Height mm
165854	piece	92/125	28	20	10
166216	piece	160/200	30	22	10



Accessories RKE-M

A37

Tensioner, for carrier jaws 743-72



Item no.	Contents of delivery	Size	Ø A mm	Ø J mm	Height mm
169389	piece	92/125	28	20	10
169391	piece	160/200	30	22	10

A37

One-piece steel top jaws, for self-production of formed jaws or for clamping formed parts



Item no.	Contents of delivery	Size	Width mm	Height mm
160352	set	125	125	60
160353	set	160	160	70

A37

Normal jaw SGN, one side smooth, one side grooved, both sides ground



Item no.	Contents of delivery	Size	Width mm	Height mm
152752	piece	92	92	31,6
178112	piece	125	125	39,7
152755	piece	160	160	49,6
152759	piece	200	200	62,6

Including fixing screws

A37

Normal jaw finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved



Item no.	Contents of delivery	Size	Width mm	Height mm
163218	piece	92	92	31,6
180679	piece	125	125	39,7
156197	piece	160	160	49,6
156198	piece	200	200	62,6

Including fixing screws

A37

Claw jaws SKB with fine step, 2,5 mm clamping depth



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166514	set	92	92	32	14
166520	set	125	125	40	16
166522	set	160	160	50	18

Including fixing screws

A37

Workpiece stop with mounting thread



Item no.	description
320400	Workpiece stop with M12 mounting thread

A37

Werkstückanschlag magnetisch



Id.-Nr.	Bezeichnung
184740	Workpiece stop with magnetic attachment - Premium (incl. base module)

Accessories RKE-M

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661	set	92	92	32	14
166667	set	125	125	40	16
166669	set	160	160	50	18

Including fixing screws

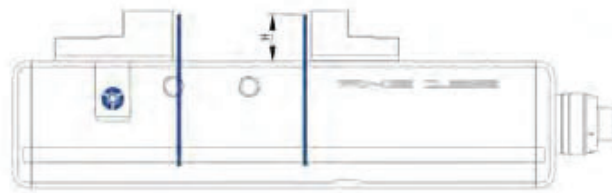
A37

Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box



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

Accessories NC-Compact vises RKE-M



A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuck capacity mm	
					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

Including fixing screws

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
150740	piece	125	135	39,6
150741	piece	160	160	49,6

Including fixing screws

A37

Draw-down jaws SNF, with spring plate, hardened and ground



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

Including fixing screws

Accessories RKE-M

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



Item no.	Contents of delivery	Size	Width mm	Height mm	Step	Chuck capacity mm	
						Horizontal	Vertical
317259	set	92	110	31,8	3,5x3,3	3-12	5-32
317260	set	125	135	39,8	4x4,3	3-13	6-40
317261	set	160	160	49,8	4x4,8	5-22	7-48

Including fixing screws

A37

Draw-down jaws RNG, with two permanent magnets



Item no.	Contents of delivery	Size	Width mm	Height mm
155237	set	92	92	32
159227	set	125	125	39,5
155240	set	160	160	50
163782	set	200	200	60

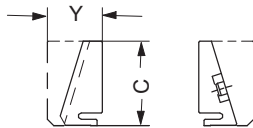
Including fixing screws

A37

Standard insert RNS, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242	set	92	92	32	21
159232	set	125	125	40	26
155245	set	160	160	50	30
163783	set	200	200	60	34

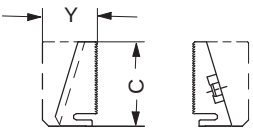


A37

Standard insert finely checkered RNSf, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163270	set	92	92	32	21
163267	set	125	125	40	26
163273	set	160	160	50	30
163784	set	200	200	60	34

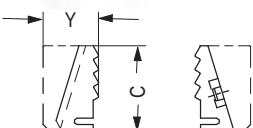


A37

Claw insert RNK, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155247	set	92	92	32	21
159235	set	125	125	40	26
155250	set	160	160	50	30
163785	set	200	200	60	34



Accessories RKE-M

A37

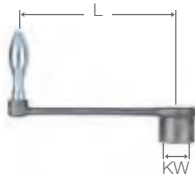
Floating jaw horizontal PEB, for clamping non-parallel workpieces



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
156190	piece	92	113	32	36
156191	piece	125	135	40	40
156192	piece	160	160	50	45
156193	piece	200	200	63	55

C15

Hand crank HKU



Item no.	Contents of delivery	Size	Inside octagon Key-width (KW)	L
009151	piece	92	12	100
009152	piece	125	14	125
009154	piece	160/200	19	200

A26

Torque wrench



Item no.	Torque Nm	Length mm	Output	Working accuracy
10004116	20-120	435	12,7=1/2"	3%
10004117	60-320	659	12,7=1/2"	3%

A37

Drive adapter ATA



Item no.	Contents of delivery	Size	Square
168721	piece	92	12-1/2"
161103	piece	125	14-1/2"
161730	piece	160/200	19-1/2"

A37

Single clamp SPE, for mounting vises on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

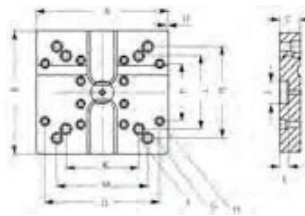
A37

Fixed slot nuts NTS, hardened and ground, with fixing screw



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

Accessories RKE / RKE-M / RKK



APPLICATION

Suitable for the complete setup of two NC compact clamps, back-to-back.

TYPE

With centering for machine table/pallet.
Without mounting or height adjustment of the clamps.
Incl. T-nuts, clamping claws and screws for aligning and fastening the clamps on the basic plate.

TECHNICAL FEATURES

- Bores for modular grid 40/50/63
- Without aligning groove/bore (machine side)

A37

Standard basic plate GP, for DUO-tower for NC-compact vises

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

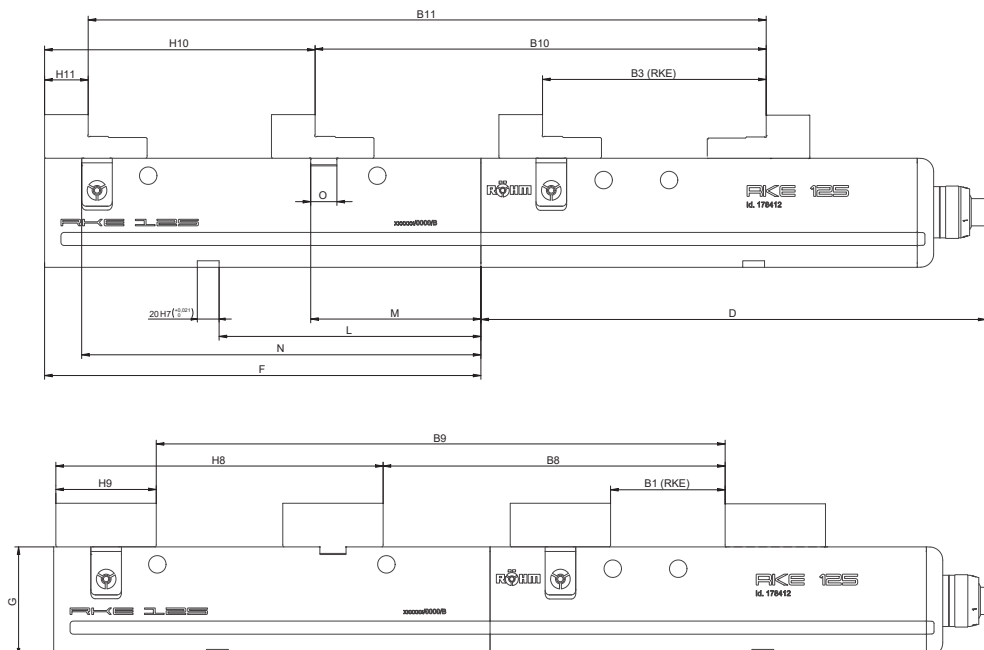
Accessories RKE / RKE-M



A37

Extension GKV, for extension of clamping capacity for extra-long workpieces (**only RKE, RKE-M**) Fastening with screws (included in the scope of delivery)

Item no.	178418	178419	178420	178421	178422	178423
For	RKE 125 / RKE-M 125	RKE 125 / RKE-M 125	RKE 125 / RKE-M 125	RKE 160 / RKE-M 160	RKE 160 / RKE-M 160	RKE 160 / RKE-M 160
D	463	463	463	618	618	618
F	105	200	400	190	295	530
G	100	100	100	115	115	115
L	-	-	240	-	-	200
M	-	-	156	-	-	225
N	68	160	364	150	253	493
O	24	24	24	30	30	30
B1	0-215	0-215	0-215	0-320	0-320	0-320
B3 mm	97-312	97-312	97-312	131-451	131-451	131-451
B8	-	-	208-422	-	-	290-605
B9	121-335	213-427	416-630	215-535	318-638	560-875
B10	-	-	306-520	-	-	421-736
B11	218-432	310-524	514-728	346-666	449-769	681-1006
H8	-	-	302	-	-	370
H9	95	98	94	105	107	102
H10	-	-	248	-	-	304
H11	41	44	40	39	41	36
Weight kg	6,5	13	26	18	27	49



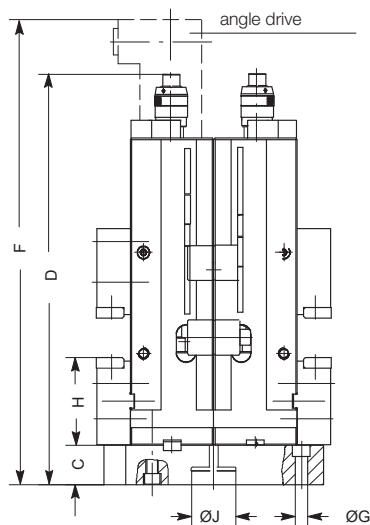


Notes

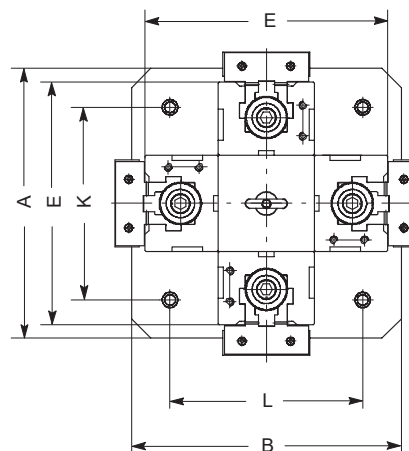
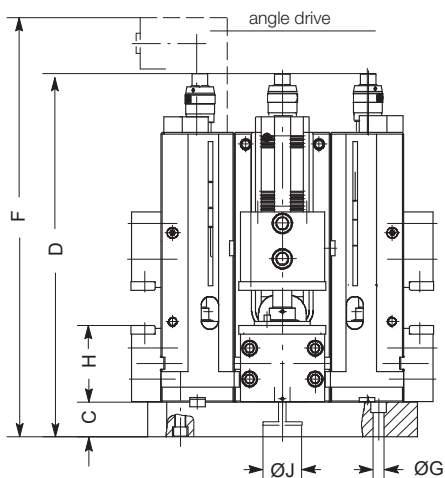
Notes

Duo and Quattro clamping towers RKE / RKE-M

Duo-clamping towers (on request)



Quattro-clamping towers (on request)



Technical data

Size	125	160 / 200
Jaw width	125	160
A	250	350
B	250	350
C	45	45
D	508	663
E	200	230
F	578	741
G*		
H	110,5	130
J*		
K*		
L*		
kg	105	200

* On inquiry insert dimensions please

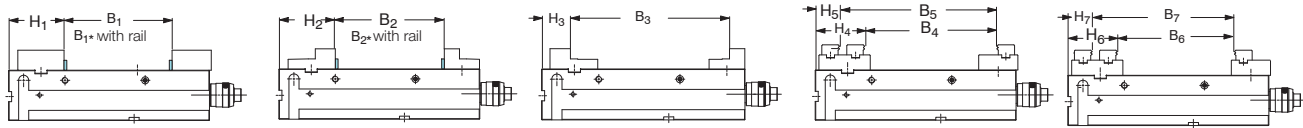
Technical data

Size	125	160 / 200
Jaw width	125	160
A	350	400
B	350	400
C	45	45
D	508	663
E	325	392
F	578	741
G*		
H	110,5	130
J*		
K*		
L*		
kg	210	375

* On inquiry insert dimensions please

Find dual clamp in the sector General accessories.

Clamping range RKE / RKE-M

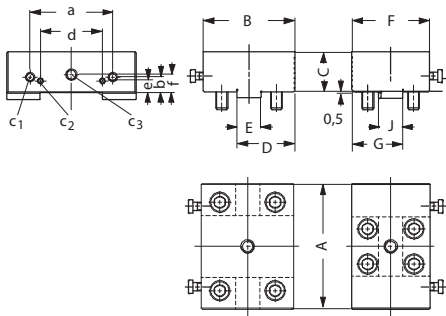


	Standard jaws		Stepped jaws		Carrier jaws with pronged inserts					
	H1	B1 B1* with rail	H2	B2 B2* with rail	H3	B3	H4/H5	B4/B5	H6/H7	B6/B7
Size 125	110,5	0-215	112,5	0-216	56,5	97-312	H ₄ : 98 H ₅ : 48	B ₄ : 50-262 B ₅ : 100-321	H ₆ : 98 H ₇ : 48	B ₆ : 20-232 B ₇ : 70-282
Size 160	130	0-320	130	0-320	64	131-451	H ₄ : 122	B ₄ : 67-383	H ₆ : 122	B ₆ : 18-334

Clamping jaw dimensions for NC-Compact vises

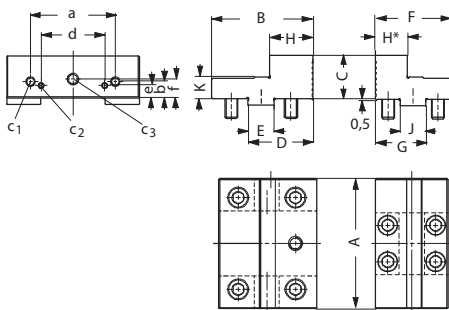
Clamping range RKE

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 _{h17}	24	30	30
F	78	100	100
G	51	65	65
J _{g6}	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

Stepped jaws - set



Jaw width	92	125	160	200
Item No.	178776	178230	178754	178937
B	64	94	98	103
C	32	40	50	60
D	42	60	65	70
E _{h17}	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 _{g6}	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

RKE-LV - with power transmitter, short design



APPLICATION

Optimized for collision-free 5-axis machining in one set-up.
Specially suited for 5-axis machines in combination with a base plate.

TYPE

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

CUSTOMER BENEFITS

- ③ With tension clamping, zero point of the workpiece on the operator side
- ③ Large clamping range
- ③ High-precision positioning
- ③ Stable chip guard for longer life

TECHNICAL FEATURES

- Sturdy steel body and all guides are hardened and ground on all sides
- Carrier jaws incl. swivelable claw inserts for round and rectangular workpieces
- **Clamping ranges carrier jaws:**
Rightangular workpieces: 35 - 215 mm
Circular workpieces: 65 - 225 mm

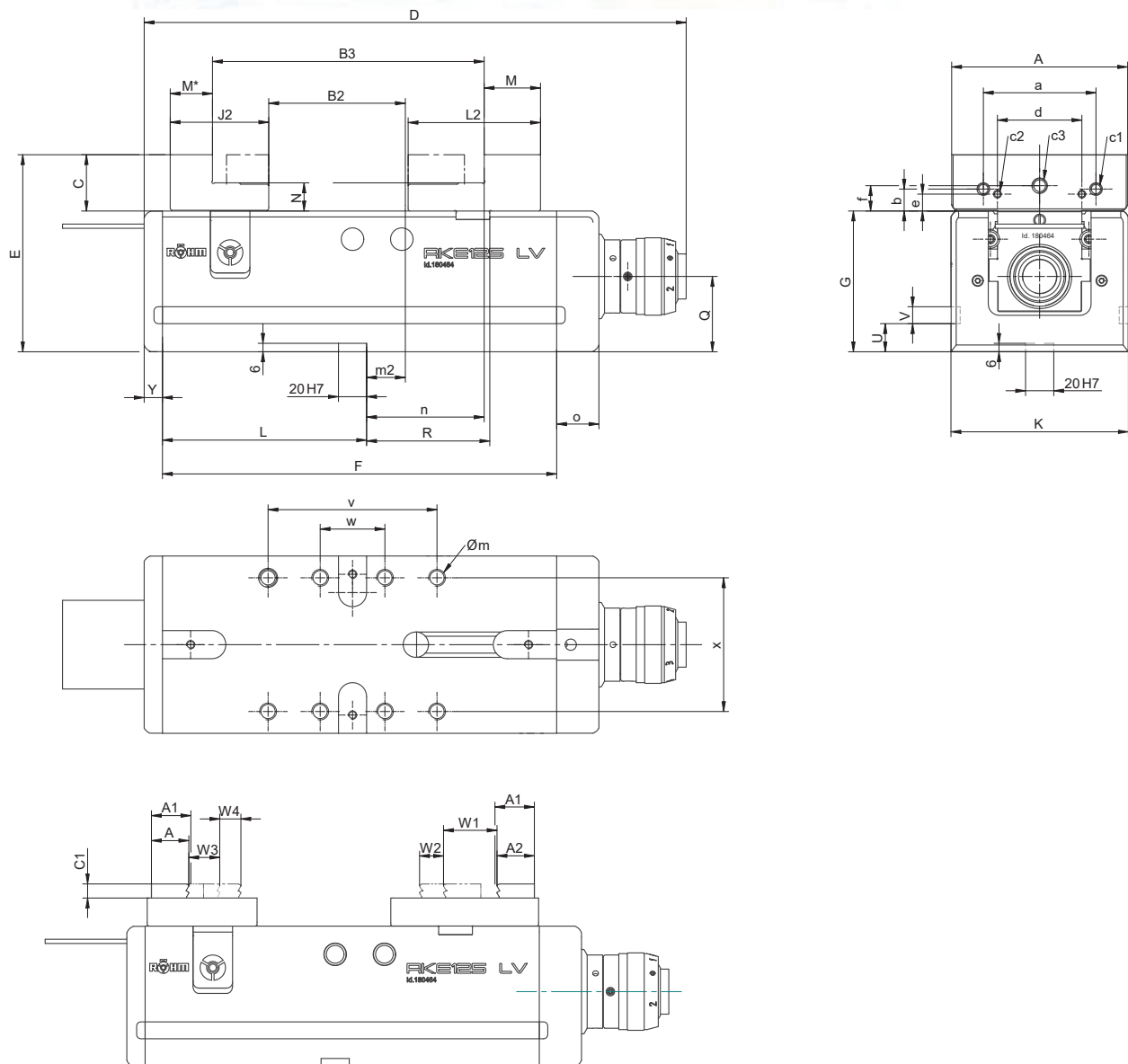
RKE-LV = RÖHM, compact, single clamping, light design, short design

A32

RKE-LV, with reversible stepped jaws or carrier jaws

Item no.	180464	180465
Jaw width A mm	125	125
Jaw design	stepped jaws	carrier jaws
B2 mm	0-96	35-215
B3 mm	96-192	65-225
C mm	40	20
D mm	385	385
E mm	140	130
F mm	280	280
G _{0,02} mm	100	100
J2 mm	70	78
K mm	126	126
L mm	145	145
L2 mm	94	105
M mm	40	-
M* mm	30	-
N _{0,01} mm	20	20
O mm	30	30
Q mm	53,5	53,5
R mm	87,5	87,5
U mm	20	20
V mm	12	12
Y mm	13	13
a mm	60	-
b mm	15,6	-
c1	M8	-
c2	M5	-
c3	M10	-
d mm	80	-
e mm	12	-
f mm	18	-
m2±0,02 mm	27,5	-
n±0,02 mm	83,5	-
o mm	30	30
v mm	120	120
w mm	46	46
x mm	95	95
Øm x depth	M12x20	M12x20
Clamping force kN	40	40
A1 mm	-	28
A2 mm	-	26,5
C1 mm	-	10
W1 mm	-	38
W2 mm	-	17
W3 mm	-	22
W4 mm	-	15
Weight kg	29	29

RKE-LV - with power transmitter, short design



Accessories RKE-LV

A37

Standard base plate GP



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

A37

Standard top jaws SA, reversible



Item no.	Contents of delivery	Size	Width mm	Height mm
162628	set	125	125	40

A37

One-piece steel top jaws, for self-production of formed jaws or for clamping formed parts



Item no.	Contents of delivery	Size	Width mm	Height mm
160352	set	125	125	60

A37

Stepped jaws SB, reversible



Item no.	Contents of delivery	Size	Width mm	Height mm
178230	set	125	125	40

A37

Double stepped jaws DSB, „smooth“



Item no.	Contents of delivery	Size	Width mm	Height mm
168693	set	125	62	60

A37

Carrier jaws TB, without swivelling claw inserts



Item no.	Contents of delivery	Size	Width mm	Height mm
165856	set	125	125	20

A37

Carrier jaws, without claw inserts

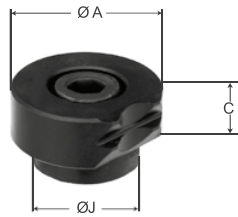


Item no.	Contents of delivery	Size	Width mm	Height mm
165861	set	125	160	20

Accessories RKE-LV

A37

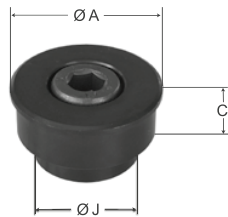
Swivelling claw inserts, for carrier jaws 743-72



Item no.	Contents of delivery	Size	Height mm
165854	piece	125	10

A37

Tensioner, for carrier jaws 743-72



Item no.	Contents of delivery	Size	Height mm
169389	piece	125	10

A37

Claw jaws SKB with fine step, 2.5 mm clamping depth



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166520	set Including fixing screws	125	125	40	16

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm



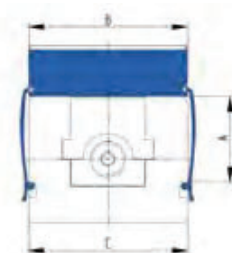
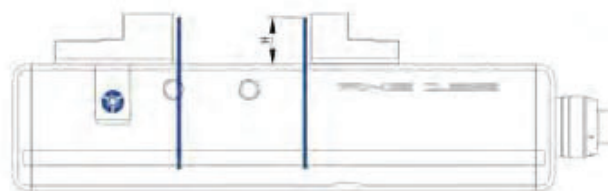
Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166667	set Including fixing screws	125	125	40	16

A37

Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box



Item no.	Web height A	Jaw width B mm	Rail height H	Guiding width C	Spare clamp (Set = 4 pieces)
1269622	68	125	10/15/20/25/28/30/33/35/36/37	126	1269625



Accessories RKE-LV

A37

Standard jaws SGN, one side smooth, one side grooved, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
158897	set	125	125	39,7

A37

Standard jaws finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved



Item no.	Contents of delivery	Size	Width mm	Height mm
163225	set	125	125	39,7

A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
082363	piece	125	135	39,6	4-20	6-40

Including fixing screws

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
150740	piece	125	135	39,6

Including fixing screws

A37

Draw-down jaws SNF, with spring plate, hardened and ground



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

Including fixing screws

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



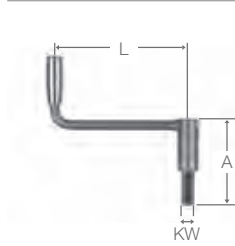
Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm		Step
					Horizontal	Vertical	
317260	set	125	135	39,8	3-13	6-40	4x4,3

Including fixing screws

Accessories RKE-LV

A37

Hand crank, turnable handle, hexagon socket



Item no.	Contents of delivery	Size	External hexagon Key-wight (KW)	A	L
134600	piece	125	14	104	160

A37

Angle drive 90°



Item no.	Contents of delivery	Size	A	B	C
158339	piece	125	133	106	98

A37

Single clamp SPE, for mounting vises on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw



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

A37

Workpiece stop with mounting thread



Item no.	description
320400	Workpiece stop with M12 mounting thread

A37

Werkstückanschlag magnetisch



Id.-Nr.	Bezeichnung
184740	Workpiece stop with magnetic attachment - Premium (incl. base module)

RKK - with power transmitter, high precision



APPLICATION

Optimized for modern CNC milling machines and machining centers with very high working precision.

TYPE

Size 3-5: clamping system mechanical-mechanical with power transmitter, manually operated.

CUSTOMER BENEFITS

- ③ Drive spindle with clamping force presetting
- ③ Deformation-resistant design for maximum clamping precision
- ③ Fastening thread for workpiece stop
- ③ Clamping surface for clamping claws
- ③ With grease nipples installed on both sides, that all guides and the spindle thread can be lubricated quickly and easily

TECHNICAL FEATURES

- Sturdy steel body and all guides are hardened and ground on all sides
- **Sizes 3-5:** long clamping slide with toothing

RKK = RÖHM, compact, power amplified

A32

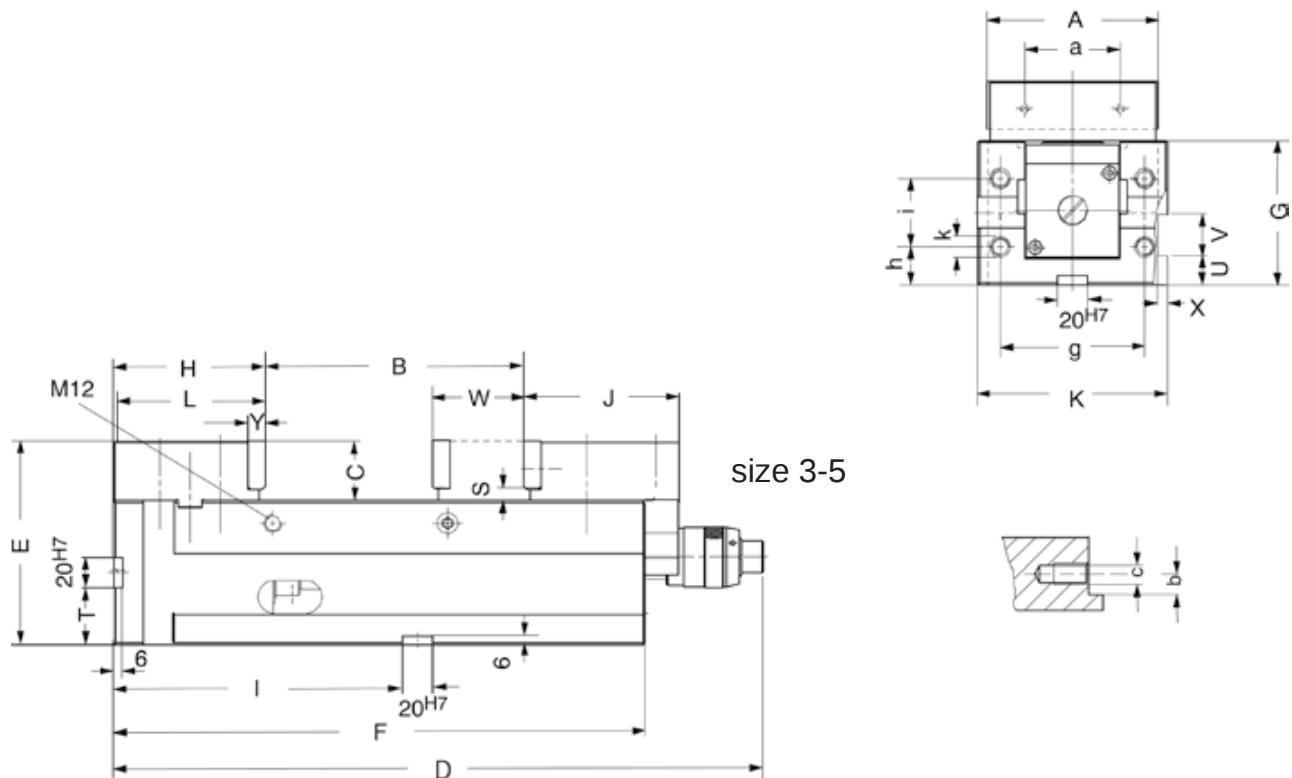
RKK, with standard jaws SA and SGN normal jaw

Item no.	148545	148682	149371
Size	3	4	5
Jaw width A mm	135	160	200
Clamping capacity B mm	0-215	0-340	0-340
C mm	49	60	70
D mm	483	618	618
E mm	148	179	189
F mm	400	525	525
G _{-0,02} mm	100	120	120
H-0,05 mm	110,5	130	130
J mm	102	110	110
K mm	150	205	205
L mm	109	128	128
S mm	9,4	10,4	7,4
T _{-0,02} mm	40	50	50
U mm	20	20	20
V mm	40	40	40
W mm	168	235	235
X mm	6,5	6,5	6,5
Y mm	15,6	15,6	19,6
Clamping travel mm	60	108	108
a mm	80	100	125
b mm	15,6	19,6	24,6
c mm	M8x13	M8x13	M10x15
g mm	110	145	145
h mm	22,5	20	20
i mm	55	80	80
k x depth	M12x22	M16x20	M16x20
I _{-0,02} mm	240	365	365
Clamping force kN	40	60	60
Weight kg	50	107	108

RKK - with power transmitter, high precision



NC-Compact vises
RKK



Accessories RKK

A37

Standard top jaws SA, reversible, for screwing on clamping jaws, with fixing screws

Item no.	Contents of delivery	Size	Width mm	Height mm
149236	set	3	132	49
149373	set	4	157	60
149374	set	5	197	70



A37

Top jaws SN, reversible, for hooking in quick-change clamping inserts and for screwing on clamping jaws, with fixing screws

Item no.	Contents of delivery	Size	Width mm	Height mm
149240	set	3	133	53
149375	set	4	158	67
149376	set	5	198	67



A37

Carrier jaws TB, reversible, for screwing on claw inserts or special jaws, with fixing screws

Item no.	Contents of delivery	Size	Width mm	Height mm
147748	set	3	135	30
148688	set	4	160	30
149384	set	5	200	30



A37

Claw insert KRE, for carrier jaws 743-70, with fixing screw

Item no.	Contents of delivery	Size	Width mm	Height mm
146070	piece	3/4/5	30	20



A37

Claw jaws SKB with fine step, 2.5 mm clamping depth

Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166520	set	3	125	40	16
166522	set	4	160	50	18

Including fixing screws



A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm

Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166667	set	3	125	40	16
166669	set	4	160	50	18

Including fixing screws



Accessories RKK

A37

Normal jaw SGN, one side smooth, one side grooved, both sides ground



Item no.	Contents of delivery	Size	Width mm	Height mm
152754	piece	3	135	39,6
152755	piece	4	160	49,6
152759	piece	5	200	62,6

Including fixing screws

A37

Normal jaw finely checkered SGNf, reversible, to increase the specific contact pressure (higher holding forces), one side finely checkered, one side longitudinally grooved



Item no.	Contents of delivery	Size	Width mm	Height mm
156196	piece	3	135	39,6
156197	piece	4	160	49,6
156198	piece	5	200	62,6

Including fixing screws

A37

V-jaw SPR, with vertically and horizontally ground-in prisms, hardened, for combination with SGN



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm	
					Horizontal	Vertical
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

Including fixing screws

A37

Draw-down jaws SNF, with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
077106	set	4	160	49,6
077107	set	5	200	62,6

Including fixing screws

A37

V-jaw and standard jaw SBO, unhardened and burnished, with workpiece support



Item no.	Contents of delivery	Size	Width mm	Height mm	Chuckling capacity mm		Step
					Horizontal	Vertical	
317260	set	3	135	39,8	3-13	6-40	4x4.3
317261	set	4	160	49,8	5-22	7-48	4x4.8

Including fixing screws

A37

Workpiece stop with mounting thread



Item no.	description
320400	Workpiece stop with M12 mounting thread

A37

Werkstückanschlag magnetisch

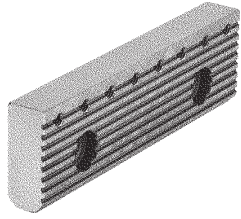


Id.-Nr.	Bezeichnung
184740	Workpiece stop with magnetic attachment - Premium (incl. base module)

Accessories RKK

A37

Normal jaw SGNA, with movable workpiece stop, hardened and ground

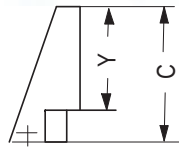


Item no.	Contents of delivery	Size	Width mm	Height mm
150740	piece	3	135	39,6
150741	piece	4	160	49,6

Including fixing screws

A37

Standard inserts NCS, hardened and ground, for machined workpieces without angular error

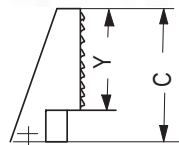


Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
147954	set	3	135	53	40
147955	set	4	160	67	50
158823	set	5	200	67	50

Accessories NC-
Compact vises RKK

A37

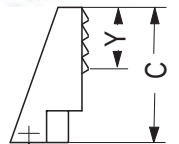
Standard inserts finely checkered NCSf, with small surface area to increase the specific surface clamping (higher holding Forces)



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163228	set	3	135	53	40
163229	set	4	160	67	50
163230	set	5	200	67	50

A37

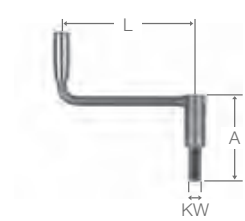
Claw inserts NCK, hardened and ground, for unmachined workpieces



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
148917	set	3	135	53	24
148918	set	4	160	67	45
159447	set	5	200	67	45

Accessories RKK

A37
Hand crank, turnable handle



Item no.	Contents of delivery	Size	External hexagon Key-wight (KW)	A	L
134198	piece	92	12	60	90

A37
90°Angle drive, for RKK 3-5



Item no.	Contents of delivery	Size	A	B	C
151651	piece	3	161	101	98
151652	piece	4/5	174	111	98

A37
Single clamp SPE, for mounting vises on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	piece	12	M10x50
149122	piece	14	M12x55
149123	piece	16	M12x60
149124	piece	18	M16x60
155722	piece	20	M16x65
151507	piece	22	M16x65

A37
Fixed slot nuts NTS, hardened and ground, with fixing screw



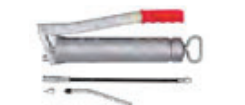
Item no.	Contents of delivery	Size	Length mm
014823	set	20x12	22
014825	set	20x14	25
014827	set	20x16	25
014829	set	20x18	25
014831	set	20x20	22
014833	set	20x22	32

C15
Grease F91 for vises, for lubrication and conservation of chucking power



Item no.	Design	Contents
777021	Cartridge	0,4 kg

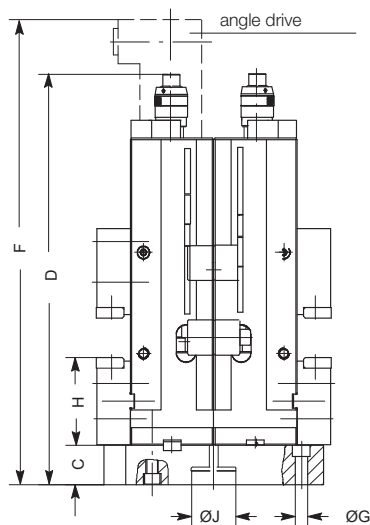
C15
Grease gun DIN1283



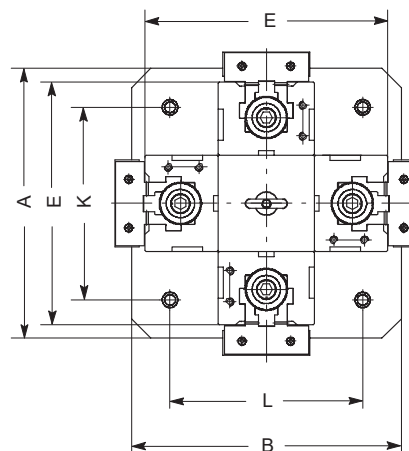
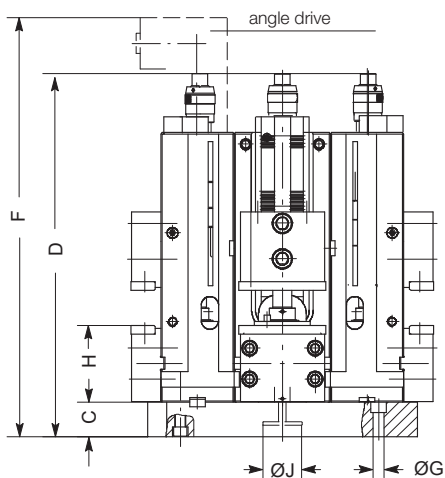
Item no.	Connection	Contents of delivery
329093	M10x1	150 mm nozzle tube bent, needlepoint mouthpiece, top mouthpiece, 300 mm high pressure hose with 4 jaw hydraulics cross mouthpiece

Duo and Quattro clamping towers RKK

Duo-clamping towers (on request)



Quattro-clamping towers (on request)



Technical data

Size	RKK 135	RKK 160	RKK 200
Jaw width	135	160	200
A	290	350	350
B	270	350	350
C	45	45	45
D	528	663	663
E	200	240	240
F	606	744	744
G*			
H	110,5	130	130
J*			
K*			
L*			
kg	125	260	260

* On inquiry insert dimensions please

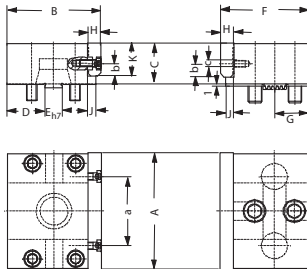
Technical data

Size	RKK 135	RKK 160	RKK 200
Jaw width	135	160	200
A	400	500	500
B	400	500	500
C	45	45	45
D	528	663	663
E	350	445	445
F	606	744	744
G*			
H	110,5	130	130
J*			
K*			
L*			
kg	250	530	530

* On inquiry insert dimensions please

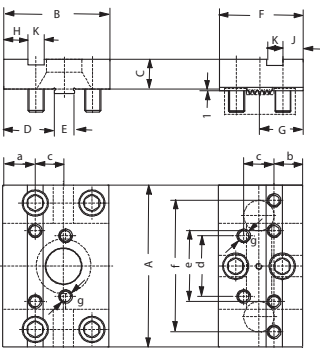
Jaw dimensions and clamping range RKK

Standard top jaws SA, reversible



Size	3	4	5
A	135	160	200
B	109	128	128
C	49	60	70
D	44	50	50
E _{h7}	20	20	20
F	102	110	110
G	39	42	42
H	15,6	15,6	19,6
J	9,6	9,6	13,6
K	39,6	49,6	62,6
a	80	100	125
b	15,6	19,6	24,6
c	M8	M8	M10

Carrier jaws, reversible



Size	3	4	5
A	135	160	200
B	95	105	105
C	30	30	30
D	44	50	50
E _{h7}	20	20	20
F	83	83	83
G	43	43	43
H	21	24	24
J	20	20	20
K _{H7}	16	16	16
a	29	32	32
b	28	28	28
c	25	30	30
d	60	70	70
e	60	70	110
f	110	130	160
g	M12	M12	M12

Jaw dimensions /
clamping range RKE

Clamping ranges: External clamping RKK

	Carrier jaws with pronged inserts	Carrier jaws with pronged inserts
Size		
3	30-257	110-337
4+5	59-395	144-481

General accessories - Cliparc



Fixed during machining and when released!

The precision support rails with the Cliparc-System remain in their original position during the machining and releasing process. No more time intensive repositioning necessary. Insert the Cliparc clamps into the rails and snap them into the vise. No tools necessary.

Technical features:

- Different height steppings
- Width only 3 mm (from size 160: 4 mm width)
- Rim near through holes can be machined without step jaws or problems due the slim precision support rails.
- Precision and quality parallelism better than 0.005 mm
- Quick cleaning

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

Support rails Cliparc

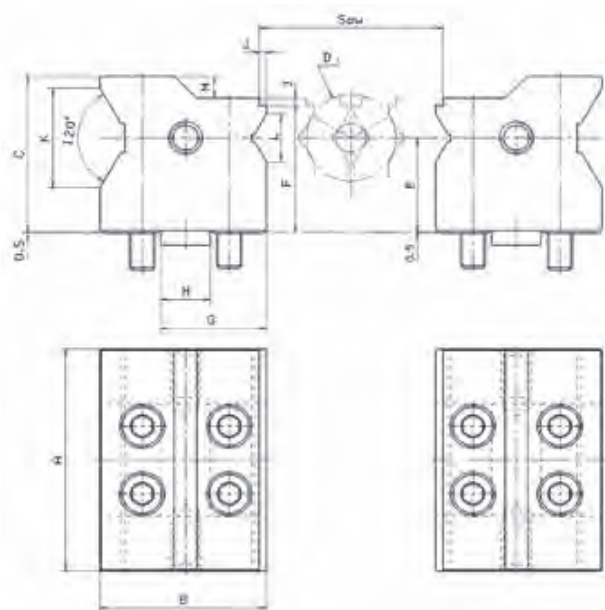


Item no.	1269621	1269622	1269623	1295913	1295914
For	RKE 92 / RKE-M 92	RKE 125 / RKE-M 125 / RKE-LV 125	RKE 160/200 / RKE-M 160/200	RKD-M, RKZ-M 92	RKD-M, RKZ-M 125
Web height A	48	68	83	53	73
Jaw width B	92	125	160	92	125
Rail height H	10/16/18/20/23/25/26/27/28/29	10/15/20/25/28/30/33/35/36/37	10/15/20/25/30/35/40/43/45/47	10/16/18/20/23/25/26/27/28/29	10/15/20/25/28/30/33/35/36/37
Guidance width C	94	126	162	94	126
Spare clamp (Set = 4 pieces)	1269624	1269625	1269626	1295916	1295917



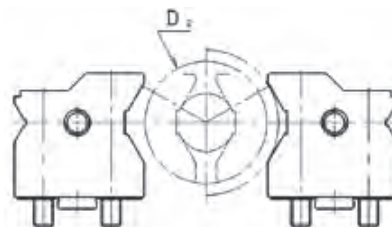
Jaw dimensions

Double V-jaw, reversible, with fine step



Item no.	169754	169756
Content of delivery	set	set
Size A	92	125
B	67	86
C	64,5	84,5
D1	Nut 1 12-36	15-40
	Nut 2 -	-
D2	Nut 1 30-75*	30-92**
	Nut 2 -	89-105
E	39	54
F	52,5	69,5
G	42,5	51,5
H	20	24
J	3	3
K	41,3	56
L	20	22,6
M	9	12
Clamping range ¹⁾	7-143	7-186

* Ø 63-75 side loading only ** Ø 72-92 side loading only ¹⁾ Clamping range example RKZ-M



General accessories

A37

Dual clamp DSP for mutual support in the case of front-sided set-up, in pairs

Item no.		Contents of delivery
		
149125		piece

A37

Single clamp SPE, for mounting vises on end and on the base

Item no.		Contents of delivery	T-slot	Thread
				
149121	piece		12	M10x50
149122	piece		14	M12x55
149123	piece		16	M12x60
149124	piece		18	M16x60
155722	piece		20	M16x65
151507	piece		22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw

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

A37

Workpiece stop with mounting thread

Item no.		description
		
320400		Workpiece stop with M12 mounting thread

A37

Werkstückanschlag magnetisch

Id.-Nr.		Bezeichnung
		
184740		Workpiece stop with magnetic attachment - Premium (incl. base module)

A37

Workpiece stop WSA, universally adjustable, for fastening to the machine table (size 14 T-slot) or for screwing onto the NC-compact vise / machine vise (M12)

Item no.		Contents of delivery
		
320401		piece

A37

Precision vise locator PSA, universally adjustable, for screwing onto the NC-compact vise or machine vise, connecting thread M12

Item no.		Contents of delivery
		
681192		piece



SET-UP AND WORKING TIME REDUCTION BY TWIN CLAMPING



Function description

Two movable clamping jaws and a fixed middle jaw allow a set-up and working time reducing twin clamping. The movable clamping jaw is placed by turning the spindle with the crank against the workpiece and held with about 1 kN (third-hand function).

Then the crank is turned further, the other movable clamping jaw is placed against the workpiece, fixed and force is built up via the mechanical spindle.

Balance springs compensate dimensional discrepancies from up to ± 3 mm between workpiece I and workpiece II.

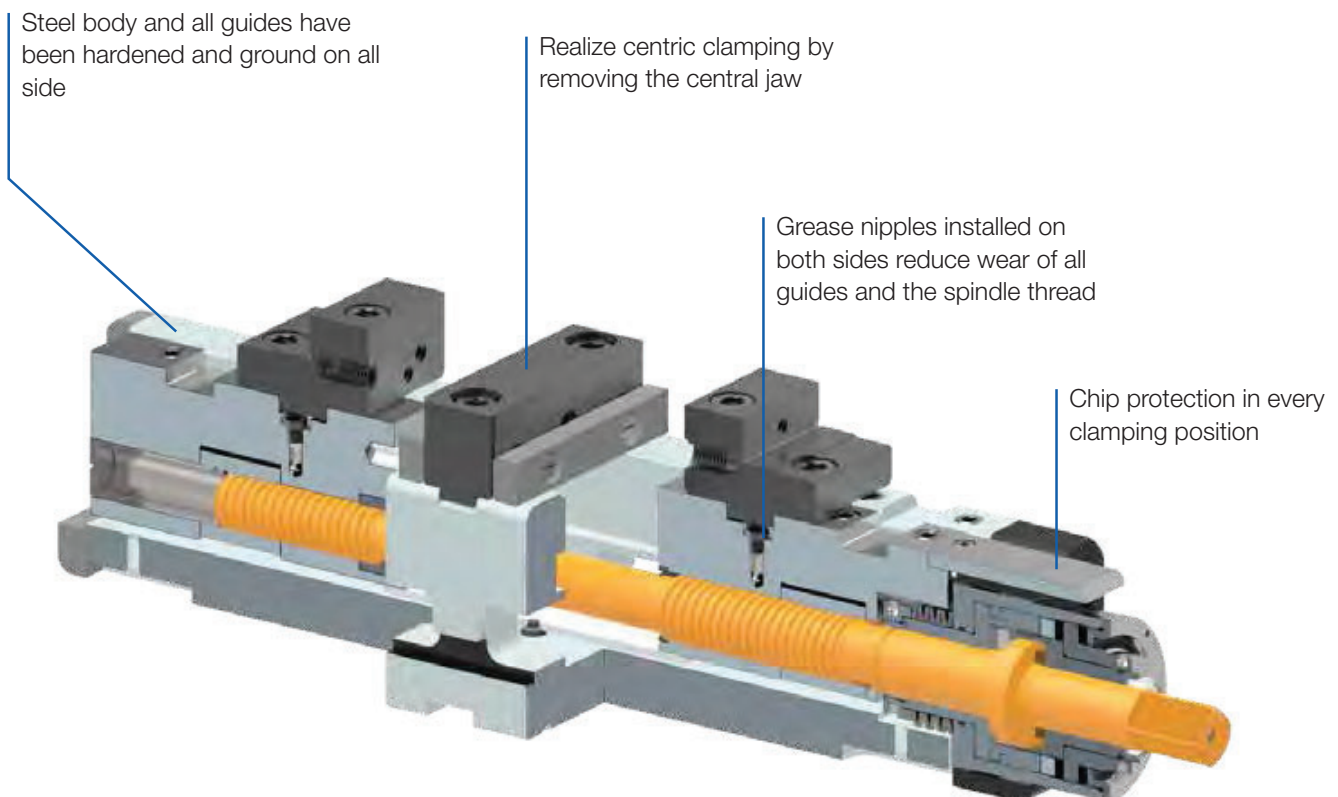
NC-COMPACT TWIN VISES

Especially for the series production, setting up and cycle times are the critical factors. Due to their twin clamping, the NC-compact twin vises from RÖHM are ideally suited for efficient machining. Two movable clamping jaws and a fixed middle jaw enable a high repeatability of 0.01 mm and constant clamping force during every clamping operation.

ADVANTAGES AT A GLANCE

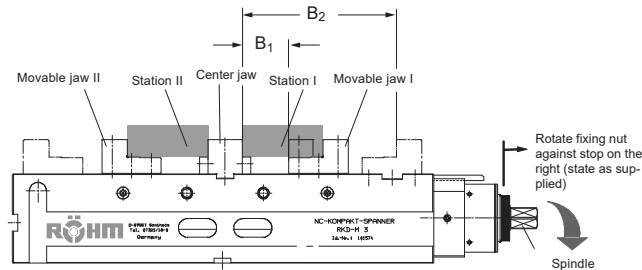
- ⌚ Maximum flexibility and versatile thanks to the possibility of 3-sided clamping
- ⌚ High repeatability of 0.01 mm as well as consistent clamping force for each clamping process
- ⌚ Set-up and working time reduction by double clamping

NC-Compact twin
vises



Clamping versions RKD-M

Clamping ranges: Twin clamping



Function:

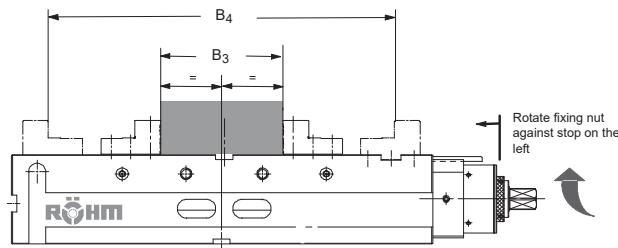
To adjust mobile jaw I with regard to the workpiece of station I turn the spindle to the right by means of the handle (left-right handed thread). About 1 kN are applied to keep the jaw in the adjusted position (third-hand function). By further turning the lever, mobile jaw II is adjusted with regard 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: 50 mm
Station II: 56 mm

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

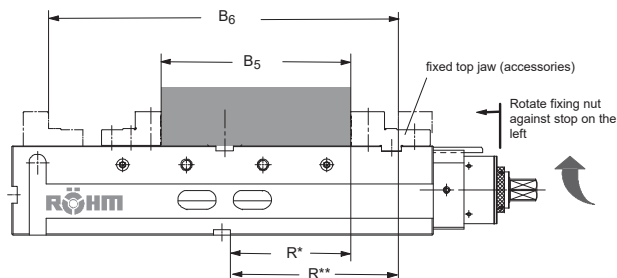
Clamping ranges: Centric clamping



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

Size		92	125
B ₃	Groove 1	30 - 132	40 - 142
	Groove 2	126 - 228	132 - 235
	Groove 3	-	224 - 327
B ₄	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" 53 mm

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



Notes

Notes

RKD-M - double clamping, without power transmitter



APPLICATION

For flexible clamping tasks on machining centers and other production systems.
Triple clamping function: Double clamping - Centric clamping - Single clamping.

TYPE

Clamping system mechanical without power transmitter, manually operated.

With one-sided drive spindle.

CUSTOMER BENEFITS

- ③ Large clamp stroke (50 mm per jaw)
- ③ The clamping thread of the spindle is protected from dirt and chips in every basic jaw position
- ③ With grease nipples installed on both sides, that all guides and the spindle thread can be lubricated quickly and easily
- ③ Horizontal, vertical or side mounting

TECHNICAL FEATURES

- Vise with two movable clamping jaws and a stationary center jaw
- Steel basic body as well as all guides hardened and ground on all sides
- Fastening only possible with clamping claws (direct fastening on request)
- Constant clamping force for every clamping operation and high repeatability when a torque wrench is used

RKD-M = RÖHM, compact, double clamping, manual

A32

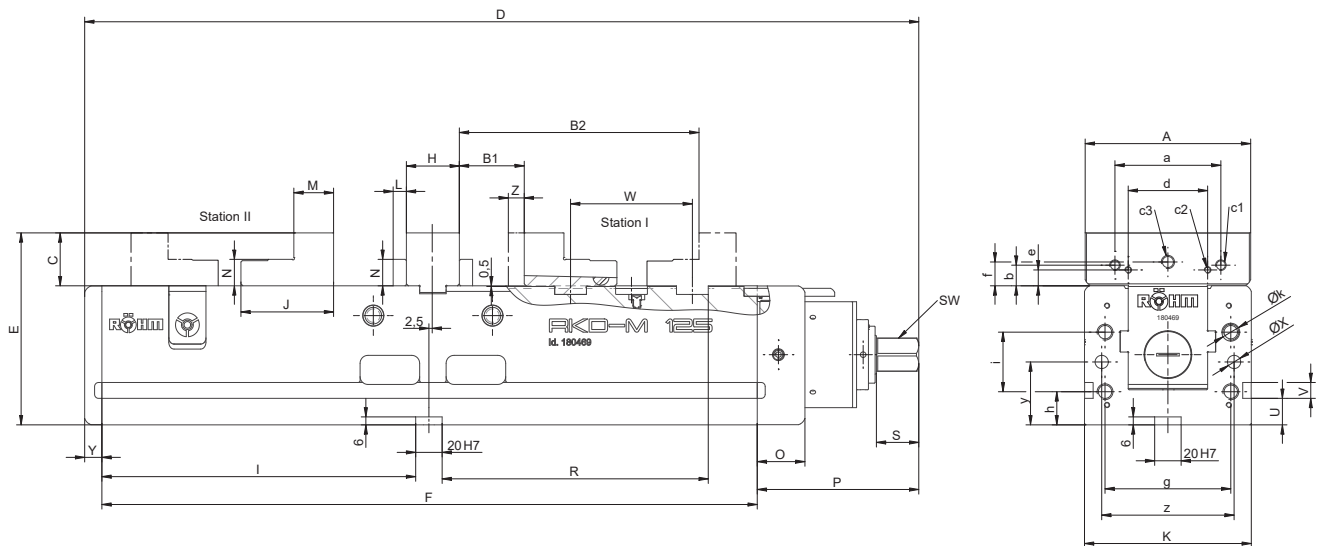
RKD-M, with reversible stepped jaws and centre jaw

Item no.	180468	180469
Jaw width A mm	92	125
B1 slot 1 mm	0-48	0-48
B1 slot 2 mm	48-96	46-94
B1 slot 3 mm	-	92-140
B2 slot 1 mm	42-79	51-88
B2 slot 2 mm	79-127	86-134
B2 slot 3 mm	-	132-180
C mm	32	40
D mm	492	630
E mm	117	145
F mm	366	495
G _{-0,02} mm	85	105
H _{-0,02} mm	30	40
J mm	56	70
K mm	94	126
L mm	10	10
M mm	25	30
N _{-0,01} mm	16	20
O mm	36	36
P mm	114	122
R mm	143	201
S mm	31	32
T _{-0,02} mm	30	37,5
U mm	20	20
V mm	12	12
W mm	1 x 48	2 x 46
Y mm	12	13
Z mm	50/53	50/53
Key-width SW	17	19
a mm	63	80
b mm	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 mm	48	60
e mm	8	12
f mm	14	18
g mm	70	95
h mm	20	25
i mm	50	45
k x depth	M10 x 18	M12 x 22
l _{-0,02} mm	177	237
y±0,01 mm	40	47,5
z mm	72	100
Clamping force kN	25	40
Weight kg	24	52

RKD-M - double clamping, without power transmitter



NC-Compact vises RKD-M



Accessories RKD-M

A37

Stepped jaws SB, reversible, with fixing screws


Item no.	Contents of delivery	Size	Width mm	Height mm
161831	set	92	92	32
162631	set	125	125	40

A37

Standard jaws SGN, one side smooth, one side grooved, hardened and ground


Item no.	Contents of delivery	Size	Width mm	Height mm
162363	set	92	92	32
158897	set	125	125	39,7

A37

Standard jaws finely checkered SGNf, one side finely checkered, one side grooved, hardened and ground


Item no.	Contents of delivery	Size	Width mm	Height mm
163223	set	92	92	32
163225	set	125	125	39,7

A37

V-jaw PB, horizontal and vertical


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm	Height prism mm	Chuckling capacity mm	
							horizontal	vertical
162365	set	92	92	32	16	19,5	12-36	12-36
158641	set	125	125	40	20	24	15-40	18-60

A37

Claw jaws SKB with fine step, 2.5 mm clamping depth


Item no.	Contents of delivery	Width mm	Height mm	Thickness mm
166514	set	92	32	14
166520	set	125	40	16

Including fixing screws

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm


Item no.	Contents of delivery	Width mm	Height mm	Thickness mm
166661	set	92	32	14
166667	set	125	40	16

Including fixing screws

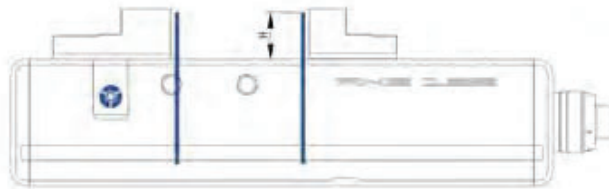
Accessories RKD-M

A37

Support rails Cliparc, set with 10 different pairs of rails and 4 clamps in wooden box



Item no.	Web height A	Jaw width B mm	Rail height H	Spare clamp (Set = 4 pieces)
1295913	53	92	10/16/18/20/23/25/26/27/28/29	1295916
1295914	73	125	10/15/20/25/28/30/33/35/36/37	1295917



A37

Draw-down jaws RNG, with two permanent magnets

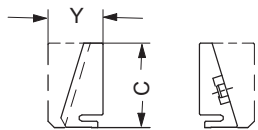


Item no.	Contents of delivery	Width mm	Height mm
155237	set	92	32
159227	set	125	39,5

Including fixing screws

A37

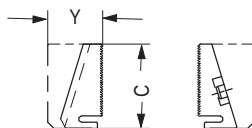
Standard insert RNS, held by two permanent magnets



Item no.	Contents of delivery	Width mm	C mm	Y mm
155242	set	92	32	21
159232	set	125	40	26

A37

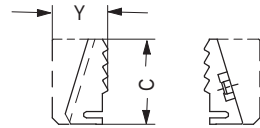
Standard insert finely checkered RNSf, held by two permanent magnets



Item no.	Contents of delivery	Width mm	C mm	Y mm
163270	set	92	32	21
163267	set	125	40	26

Accessories RKD-M

A37

Claw insert RNK, held by two permanent magnets


Item no.	Contents of delivery	Width mm	C mm	Y mm
155247	set	92	32	21
159235	set	125	40	26

A37

Fixed stepped jaw FSB, for single clamping, reversible


Item no.	Contents of delivery	Size	Width mm
178777	piece	92	92
178231	piece	125	125

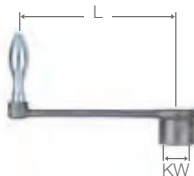
Accessories NC-Compact vises RKD-M

A37

Center jaws MBA


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
161833	piece	92	92	32	30
162632	piece	125	125	40	40

C15

Hand crank HKU


Item no.	Contents of delivery	Size	Inside octagon Key-width (KW)	L
009153	piece	92	17	160
009154	piece	125	19	200

A37

Drive adapter ATA


Item no.	Contents of delivery	Size	Square
162192	piece	92	17-1/2"
161730	piece	125	19-1/2"

Accessories RKD-M

A26 Torque wrench



Item no.	Torque Nm	Length mm	Output	Working accuracy
10004116	20-120	435	12,7=1/2"	3%
10004117	60-320	659	12,7=1/2"	3%

A37 Single clamp SPE, for mounting vises on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	Stück	12	M10x50
149122	Stück	14	M12x55
149123	Stück	16	M12x60
149124	Stück	18	M16x60
155722	Stück	20	M16x65
151507	Stück	22	M16x65

A37 Fixed slot nuts NTS, hardened and ground, with fixing screw



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

A37 Workpiece stop with mounting thread



Item no.	description
320400	Workpiece stop with M12 mounting thread

A37 Werkstückanschlag magnetisch



Id.-Nr.	Bezeichnung
184740	Workpiece stop with magnetic attachment - Premium (incl. base module)

RKZ-M - central, without power transmitter



APPLICATION

Optimized for 5-axis machining.

TYPE

Clamping system mechanical without power transmitter, manually operated.

Centric clamping with two moving jaws.

CUSTOMER BENEFITS

- ③ Short, compact design
- ③ Large clamping stroke
- ③ Constant clamping force for every clamping operation and high clamping repeatability when a torque wrench is used
- ③ Clamping accuracy at the centre: ± 0.02 - clamping repeatability: 0.01

TECHNICAL FEATURES

- Steel basic body as well as all guides hardened and ground on all sides
- Standard-equipped with stepped top jaws

RKZ-M = RÖHM, compact, central, manual

A32

RKZ-M, with stepped jaws

NC-Compact vises
RKZ-M

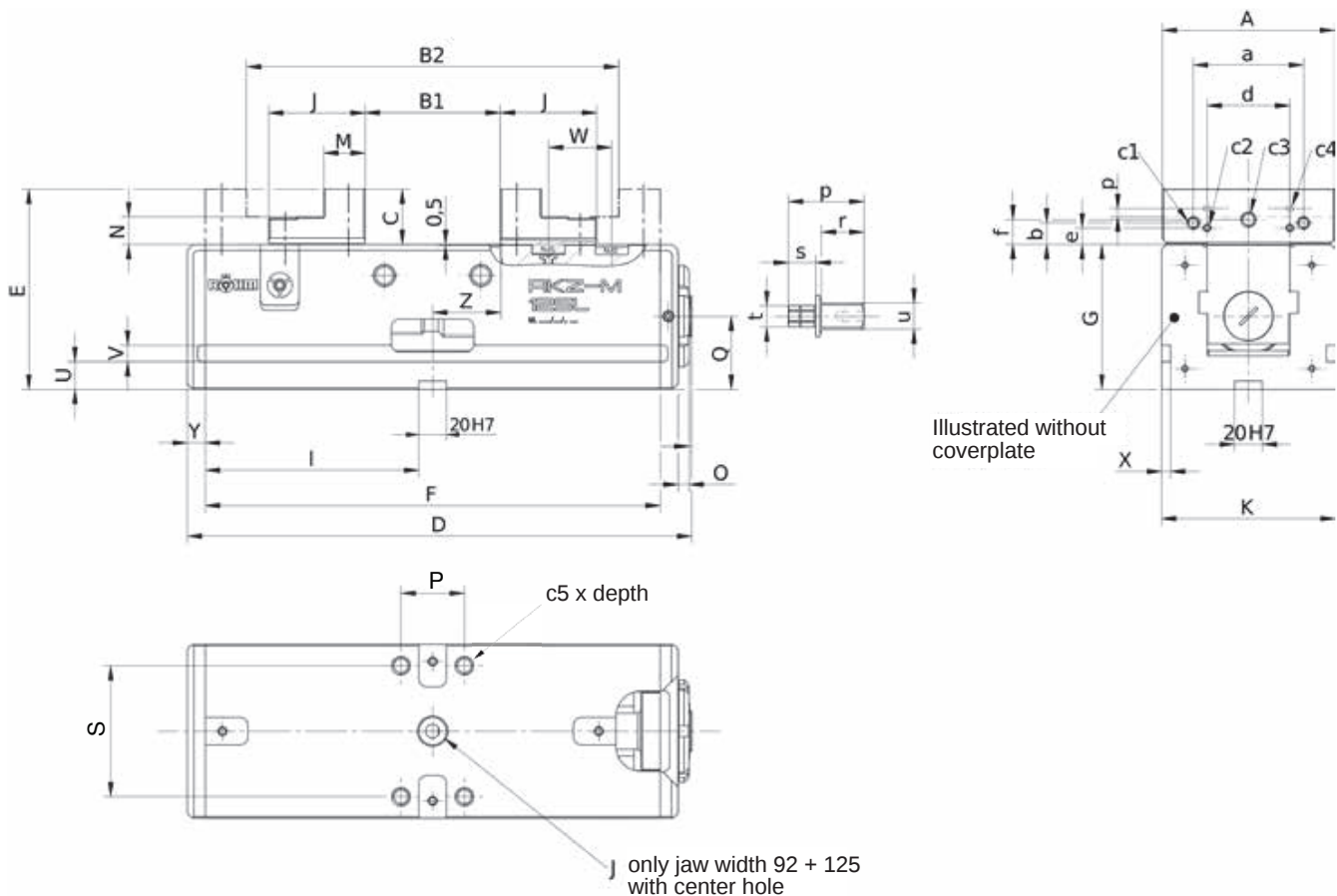
Item no.	180190	180191	180192	180193 ¹⁾
Jaw width A mm	50	70	92	125
B1 slot 1 mm	0-39	0 - 58	0 - 76	0 - 97
B1 slot 2 mm	36-75	48-106	70-146	92-189
B2 slot 1 mm	37-75	48-105	78-138	81-177
B2 slot 2 mm	72-111	95-153	132-208	172-269
C mm	20	25	32	40
Dmax mm	167	219	295	366
E mm	75	95	117	145
F mm	140	190	260	330
G _{-0,02} mm	55	70	85	105
J mm	32	41	56	70
K mm	52	72	94	126
M mm	14	17,5	25	30
N _{-0,01} mm	10	12	16	20
O mm	10	10	13	13
P mm	1	1	2	2
Q mm	31	40	41,5	53
U mm	15	20	20	20
V mm	12	12	12	12
W mm	18	24	35	46
Y mm	10	10	12	13
Z mm	20,5	30	39	49,5
a mm	-	-	63	80
b mm	-	-	13,6	15,6
c1	-	-	M6x10	M8x14
c2	M 4 x 8	M 5 x 8	M5x8	M5x8
c3	-	-	M10x16	M10x18
c4	M3x6	M4x8	M5x8	M5x8
d mm	26	37	48	60
e mm	5	6	8	12
f mm	-	-	14	18
l mm	60	85	120	155
p mm	3,5	4,5	6	6
q mm	38	52	55	55
r mm	20	30	32	32
s mm	15	19	20	20
t mm	hex.-KW 8	hex.-KW 10	hex.-KW 14	hex.-KW 14
u mm	sq.-KW 12	sq.-KW 14	sq.-KW 19	sq.-KW 19
Ø J x depth mm	-	-	Ø20H/8	Ø20H/8
Clamping force kN	10	15	20	25
Weight kg	3,5	7	18	32,5
x	3	4,5	4,5	6,5
p	-	-	75	46
S	-	-	70	95
c5	-	-	M 10-16 deep	M 12-20 deep

¹⁾ With enlarged stepped-jaws $\approx$ 180194

RKZ-M - central, without power transmitter



NC-Compact vises
RKZ-M



Accessories RKZ-M

A37

Stepped jaws SB, reversible, with fixing screws

Item no.	Contents of delivery	Size	Width mm	Height mm
164864	set	50	50	20
164844	set	70	70	25
161831	set	92	92	32
162631	set	125	125	40



A37

Raised stepped jaws ESB

Item no.	Contents of delivery	Size	Width mm	Height mm
164399	set	125	125	60



A37

Double V-jaw, reversible, with fine step, for jaw dimensions of the double V-jaws please see page 4054!

Item no.	Contents of delivery	Size	Width mm	Height mm	Length mm	Height prism mm	Size prism mm	Clamping dia. D1 mm		Clamping dia. D2 mm	
								slot 1	slot 2	slot 1	slot 2
169754	set	92	92	64,5	67	39	41,3	12-36	-	30-75*	-
169756	set	125	125	84,5	86	54	56	15-40	-	30-92**	89-105



*Ø 63-75 can only be fed from the side
**Ø 72-92 can only be fed from the side

A37

Standard jaws SGN, one side smooth, one side grooved, hardened and ground

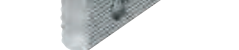
Item no.	Contents of delivery	Size	Width mm	Height mm
165161	set	50	50	19,6
165163	set	70	70	24,6
162363	set	92	92	32
158897	set	125	125	39,7



A37

Standard jaws finely checkered SGNf, one side finely checkered, one side grooved, hardened and ground

Item no.	Contents of delivery	Size	Width mm	Height mm
165165	set	50	50	19,6
165167	set	70	70	24,6
163223	set	92	92	32
163225	set	125	125	39,7



Accessories RKZ-M

A37

V-jaw PB, horizontal and vertical



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm	Height prism mm	Chuckling capacity mm	
							horizontal	vertical
165169	set	50	50	20	10	12	6-16	6-16
165171	set	70	70	25	12	14	8-24	8-24
162365	set	92	92	32	16	19,5	12-36	12-36
158641	set	125	125	40	20	24	15-40	18-60

A37

Claw jaws SKB with fine step, 2.5 mm clamping depth



Item no.	Contents of delivery	Width mm	Height mm	Thickness mm
166514	set	92	32	14
166520	set	125	40	16

Including fixing screws

A37

Claw jaws SKB without step, universal for clamping depth > 2.5 mm

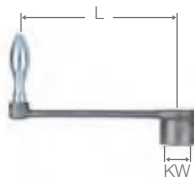


Item no.	Contents of delivery	Width mm	Height mm	Thickness mm
166661	set	92	32	14
166667	set	125	40	16

Including fixing screws

C15

Hand crank HKU



Item no.	Contents of delivery	Size	Inside octagon Key-width (KW)	L
009150	piece	50	12	80
009152	piece	70	14	125
382112 ¹⁾	piece	92	19	160
009154	piece	125	19	200

1) designed as a square

A37

Drive adapter ATA



Item no.	Contents of delivery	Size	Square	Hexagon
164971	piece	50	12	8
164842	piece	70	14	10
164625	piece	92/125	19	14

Accessories RKZ-M

A26

Torque wrench



Item no.	Torque Nm	Length mm	Output	Working accuracy
10004116	20-120	435	12,7=1/2"	3%
10004117	60-320	659	12,7=1/2"	3%

A37

Drive adapter ATA



Item no.	Contents of delivery	Size	Square
168721	piece	92	12-1/2"
161103	piece	125	14-1/2"
161730	piece	125	19-1/2"

A99

Screwdriver bit for torque wrench



Item no.	Size	Key-width SW	Output
1339727	50	8	1/2"
1339728	70	10	1/2"
1339730	92 / 125	14	1/2"

A37

Single clamp SPE, for mounting vises on end and on the base



Item no.	Contents of delivery	T-slot	Thread
149121	Stück	12	M10x50
149122	Stück	14	M12x55
149123	Stück	16	M12x60
149124	Stück	18	M16x60
155722	Stück	20	M16x65
151507	Stück	22	M16x65

A37

Fixed slot nuts NTS, hardened and ground, with fixing screw



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

A37

Workpiece stop with mounting thread



Item no.	description
320400	Workpiece stop with M12 mounting thread

A37

Werkstückanschlag magnetisch



Id.-Nr.	Bezeichnung
184740	Workpiece stop with magnetic attachment - Premium (incl. base module)



Notes

Notes