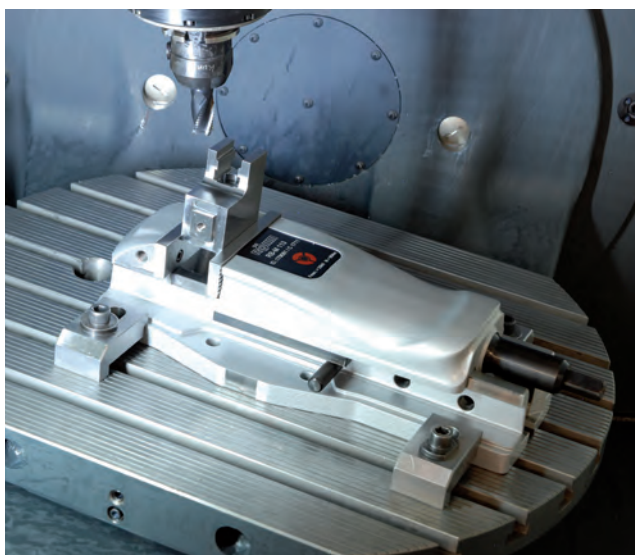


## UNIVERSALLY USABLE AND PROVEN MANY TIMES OVER



The RÖHM machine vice is suitable for universal application on milling machines and machining centers. The base is equipped with grooves to ensure a precise fastening on the machine table.



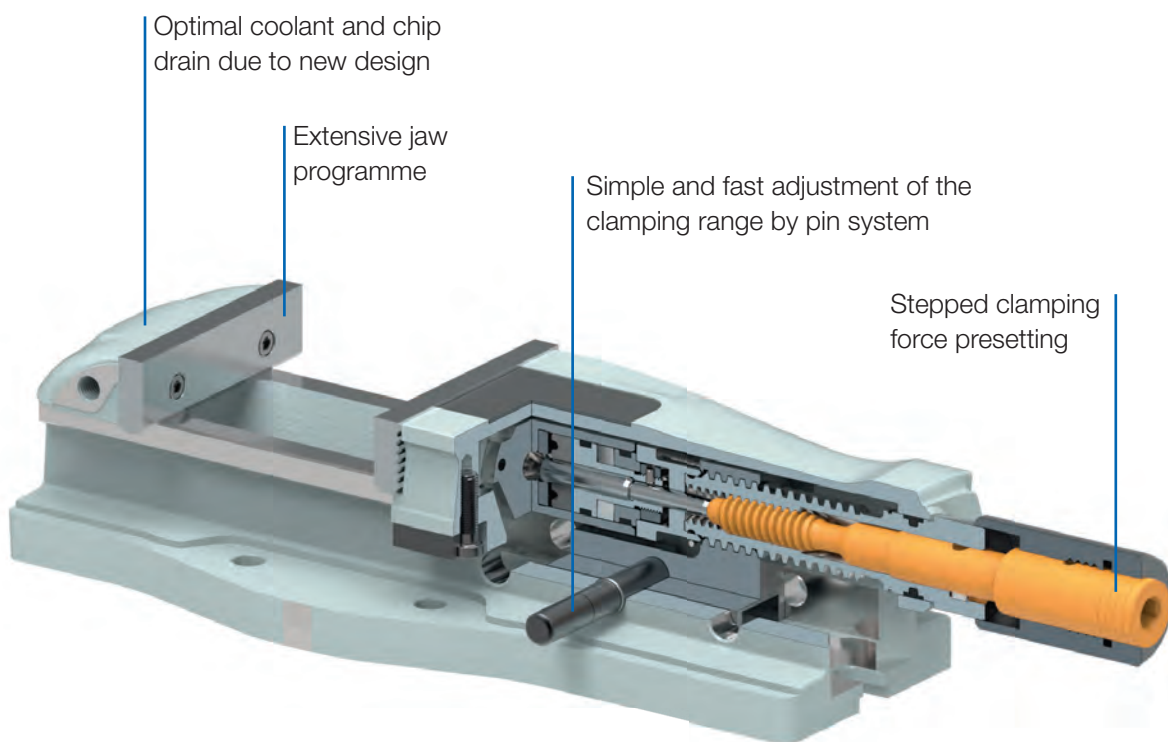
# MACHINE VICES

RÖHM machine vices are ideally suited for universal use on milling machines and machining centers and feature impressively high reliability and long service lives. The clamping area above the pin system can be quickly and easily adjusted and the precise jaw guide enables great precision.

## ADVANTAGES AT A GLANCE

- ⊕ Universally usable and proven many times over for numerous machining processes
- ⊕ Impressive reliability, service life and precision
- ⊕ Fast and simple adjustment of the clamping range by pin system

Machine vices





Machine vices

ORANGE LINE

# RB-K - with power transmitter



### APPLICATION

For universal use on milling machines and machining centers.

### TYPE

Manual clamping system with power transmitter.  
Hydraulic actuation on request.

### CUSTOMER BENEFITS

- ② Stepped clamping force presetting
- ② High precision thanks to precise jaw guides
- ② Fast clamping range adjustment via bolt system
- ② Optimal coolant and chip drain
- ② High wear-resistance thanks to hardened jaw guides
- ② Use without force amplification possible for sensitive clamping

### TECHNICAL FEATURES

- Base with longitudinal and transversal groove for exact fixation on the machine table
- Use on rotary plate with graduation
- Set-up option with clamping claws
- Encapsulated spindle

A10  
RB-K, with SGN normal jaws and hand crank

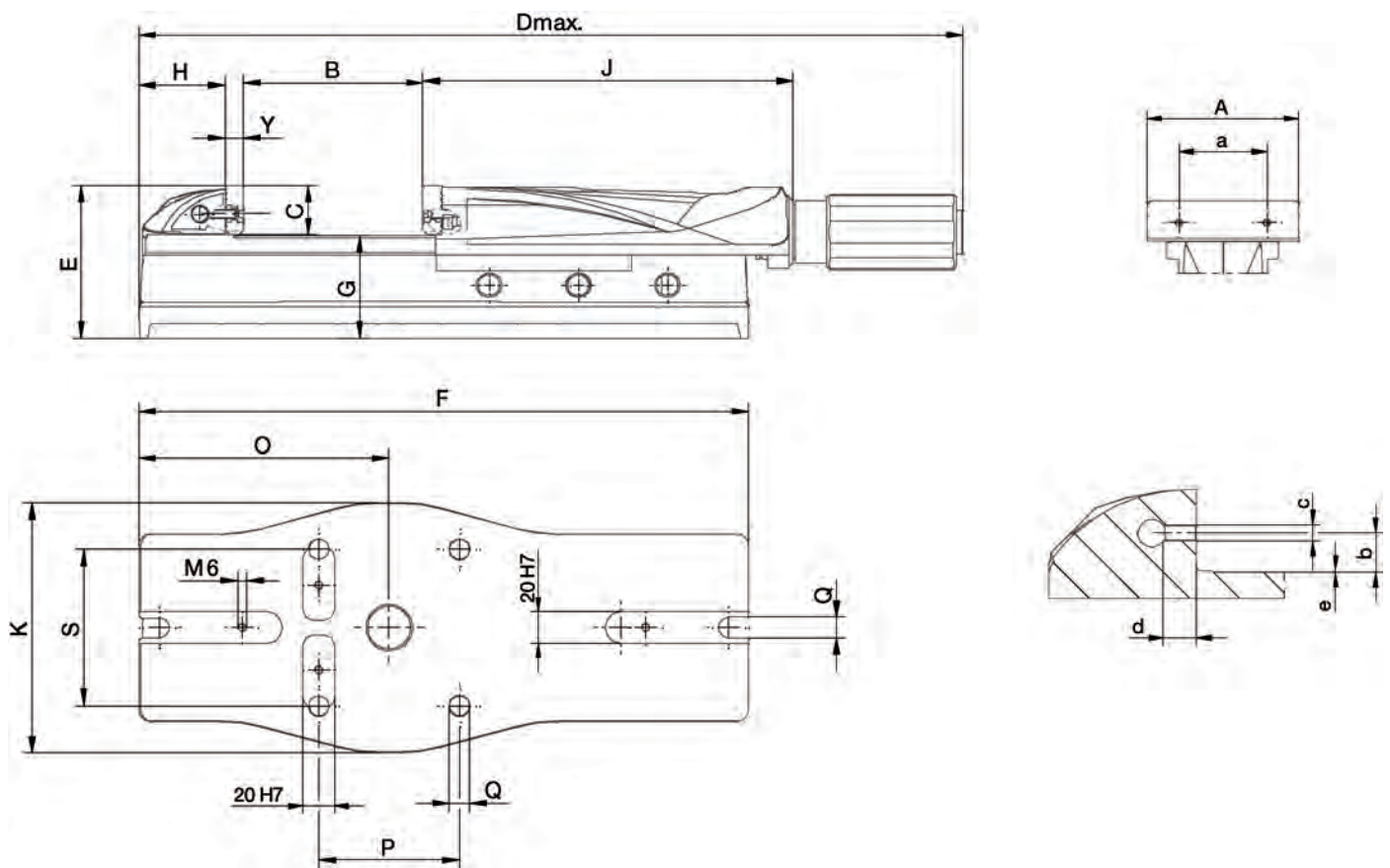
Item no.	179075	179076	179077	179078	179079
Size	1	2	3	4	5
Jaw width A mm	92	113	135	160	200
Clamping capacity B mm	100	170	220	310	350
C mm	31,6	31,6	39,6	49,6	66,6
D mm	493	583	679	817	1022
E mm	95	97	112	133	171
F mm	320	390	468	574	685
G±0,02 mm	63	65,5	72,5	83,5	104,5
H mm	54	55	70	80	90
J mm	218	236,5	262	298	375
K mm	160	160	200	240	280
O mm	119	160	180	220	230
P mm	90	90	90	90	160
Q mm	13	13	13	17	21
S mm	100	100	135	180	180
Y mm	12	12	16	16	20
a mm	63	63	80	100	140
b mm	13,6	13,6	15,6	19,6	25
c	M6	M6	M8	M8	M10
d mm	12	12	13	13	16
Clamping force kN	25	30	40	50	100
Weight kg	15,5	24	39	60	112

Machine vices Orange Line

# RB-K - with power transmitter



Machine vices Orange Line





Machine vices

# Accessories RB-K

A37

Draw-down jaws RNG, with two permanent magnets



Item no.	Contents of delivery	Size	Width mm	Height mm
155237 ▲	set	1	92	32
155238	set	2	110	32
155239 ▲	set	3	135	40
155240	set	4	160	50
155241	set	5	200	67

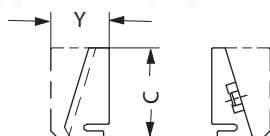
Including fixing screws

A37

Standard insert RNS, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155242 ▲	set	1	92	32	21
155243	set	2	110	32	21
155244 ▲	set	3	135	40	26
155245 ▲	set	4	160	50	30
155246	set	5	200	67	36

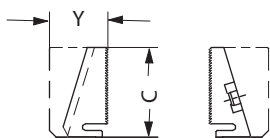


A37

Standard insert finely checkered RNSf, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
163270	set	1	92	32	21
163271	set	2	110	32	21
163272	set	3	135	40	26
163273 ▲	set	4	160	50	30
163274	set	5	200	67	36

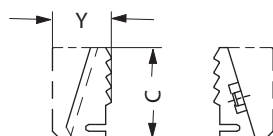


A37

Claw insert RNK, held by two permanent magnets

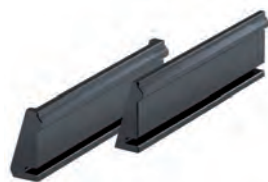


Item no.	Contents of delivery	Size	Width mm	C mm	Y mm	a mm
155247	set	1	92	32	21	
155248	set	2	110	32	21	
155249	set	3	135	40	26	80
155250 ▲	set	4	160	50	30	
155251	set	5	200	67	36	



## Accessories RB-K

A37  
Insert with round clamping shoulder RNR, held by two permanent magnets



Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
155252▲	set	1	92	32	21
155253▲	set	2	110	32	21
155254▲	set	3	135	40	26
155255▲	set	4	160	50	30
155256▲	set	5	200	67	36

A37  
Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
134826▲	set	2	110	32
134830▲	set	3	135	40
134834▲	set	4	160	50
134854▲	set	5	200	67

A37  
Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors



Item no.	Contents of delivery	Size	Width mm	Height mm
077097▲	set	2	110	38
077098▲	set	3	135	46
077099▲	set	4	160	56
141791▲	set	5	200	68

A37  
Draw-down jaws SNF, with spring plate, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
077104▲	set	2	113	31,6
077105▲	set	3	135	39,6
077106▲	set	4	160	49,6
141794▲	set	5	200	64,6

Including fixing screws

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	1	92	31,6
152753	piece	2	113	31,6
152754	piece	3	135	39,6
152755	piece	4	160	49,6
152756	piece	5	200	64,6

Including fixing screws

## Accessories RB-K

A37

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

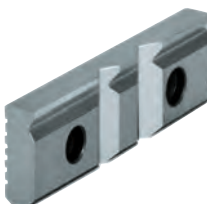


Item no.	Contents of delivery	Size	Width mm	Height mm
163218 ▲	piece	1	92	31,6
156195	piece	2	113	31,6
156196	piece	3	135	39,6
156197	piece	4	160	49,6
156199 ▲	piece	5	200	64,6

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	Chucking capacity mm	
					Horizontal	Vertical
128770	piece	1	92	31,6	3-13	5-32
082362	piece	2	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
129734 ▲	piece	5	200	64,6	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
150739 ▲	piece	2	113	31,6
150740 ▲	piece	3	135	39,6
150741 ▲	piece	4	160	49,6

Including fixing screws

A37

**Floating jaw horizontal PEB**, for clamping non-parallel workpieces



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
156190 ▲	piece	2	113	32	36
156191	piece	3	135	40	40
156192 ▲	piece	4	160	50	45

A37

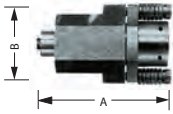
**Hand crank**, turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A	L
134593	piece	1/2	12	48	80
134198	piece	3	12	60	90
134499	piece	4	12	117	90
134600	piece	5	14	104	160

## Accessories RB-K

### A37 Hydraulic unit HDE



Item no.	Contents of delivery	Size	A	B
094170	piece	1	102	56
226502	piece	2	109	62
226503	piece	3	114	70
226504	piece	4	115	70
226505	piece	5	147	98

### A37 Spindle, complete



Item no.	Contents of delivery	Size	L
134185	piece	1	91
134186	piece	2	99
134187	piece	3	116
134188	piece	4	151
134189	piece	5	182

### A37 Standard rotation plate DP, with fixing screws and T-slot nuts ground contact edge, graduation



Item no.	Size	External Ø mm	Height	Center Ø	Weight
082441	1/2	242	30	28	7,5
082442	3	280	30	28	11
082443	4	340	34	28	18

### A37 Universal rotation plate DP, with fixing screws and T-slot nuts ground contact edge, graduation



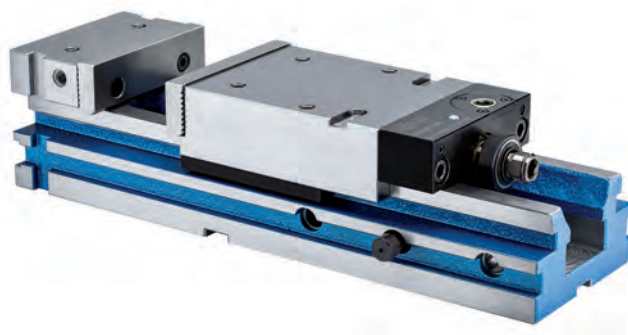
Item no.	Size	External Ø mm	Height	Center Ø	Weight
090854▲	5	420	40	28	23





NC power vices

# RBAW - with angle drive, with power transmitter



## APPLICATION

For universal use on milling machines and machining centers.

## TYPE

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

## CUSTOMER BENEFITS

- ⊕ Horizontal, vertical and laterally clampable with height adjustment  $\pm 0.02$
- ⊕ Sturdy, maintenance-free spindle
- ⊕ Additional stepped jaws or special form jaws can be fastened to the surface of the stationary and moving jaw
- ⊕ Drive spindle is protected against dirt and chips
- ⊕ Large clamping range
- ⊕ Short version of moving jaw (made of steel) results in short design length, even for max. clamping width
- ⊕ With angle drive

## TECHNICAL FEATURES

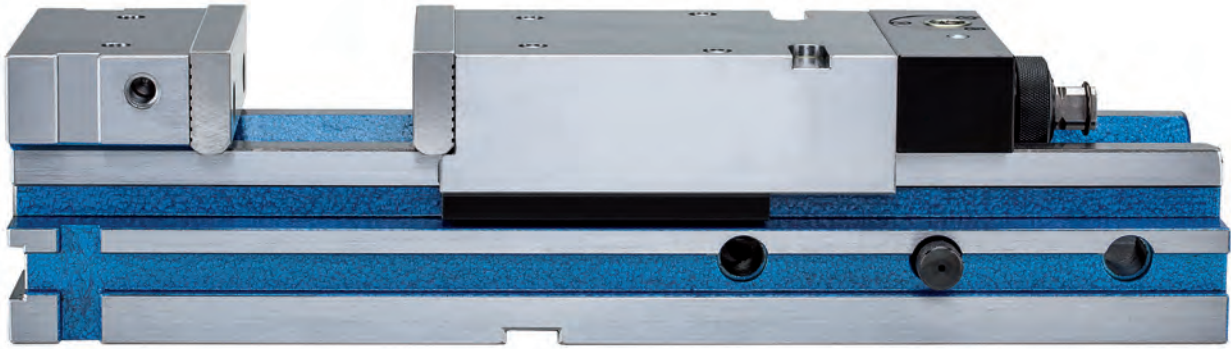
- Steel body with stationary clamping jaw, drop forged
- Automatic reclamping in the hydraulic unit by means of built-in disc springs
- All wear parts, especially the jaw guides, are hardened and ground
- Robust flat-trajectory guide of moving jaw
- With normal jaws and hand crank

NC power vices RBAW

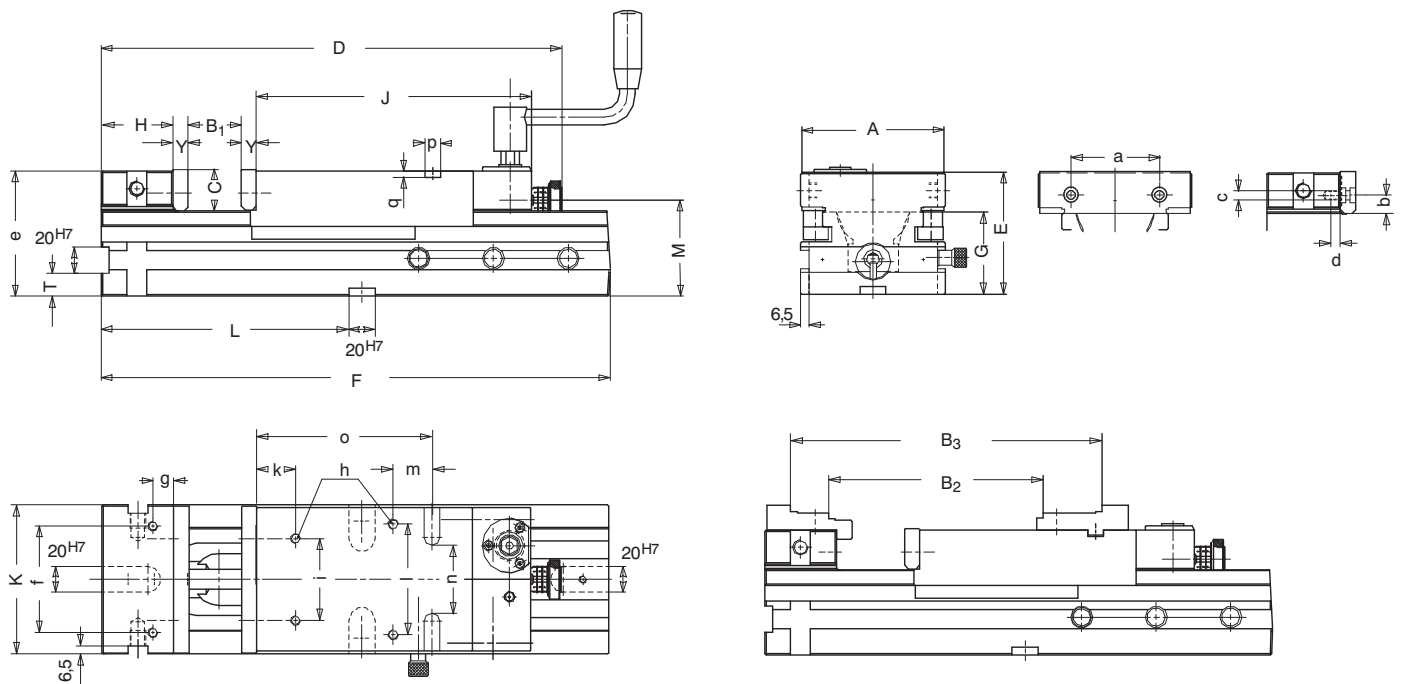
A27  
RBAW, with SGN normal jaws, hand crank and angle drive

Item no.	154763	154764	154765 ▲
Size	2	3	4
Jaw width A mm	113	135	160
B1 mm	0-175	0-225	0-310
B2 mm	125-300	138-363	146-454
B3 mm	199-374	220-445	248-556
C mm	31,6	39,6	49,6
Dmax mm	500	578	702
E $\pm 0,02$ mm	97,7	112,7	133,7
F mm	390	468	574
G $\pm 0,02$ mm	65,5	72,5	83,5
H $\pm 0,02$ mm	55	70	80
J mm	211	213	240
K $\pm 0,02$ mm	115	137	162
L $\pm 0,02$ mm	190	190	240
M mm	73,5	80,5	96
T $\pm 0,02$ mm	17,5	17,5	22,5
Y <sub>0,01</sub> mm	11,6	15,6	15,6
a mm	63	80	100
b mm	13,6	15,6	19,6
c mm	M6	M8	M8
d mm	12	13	13
e $\pm 0,02$ mm	96	111	132
f mm	82	80	100
g mm	16	30	30
h mm	M 8 x 14	M10x16	M12x20
i mm	63	80	100
k mm	30	30	30
l mm	85	105	120
m mm	30	35	35
n mm	52	70	96
o mm	135	135	142
pH7 mm	12	14	14
q mm	5	5	5
Clamping force kN	30	40	50
Weight kg	22	36	62

# RBAW - with angle drive, with power transmitter



NC power vices RBAW





NC power vices

## Accessories RBAW

A37

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



Item no.	Contents of delivery	Size	Width mm	Height mm
077104 ▲	set	2	113	31,6
077105 ▲	set	3	135	39,6
077106 ▲	set	4	160	49,6

Including fixing screws

A37

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



Item no.	Contents of delivery	Size	Width mm	Height mm
152753	piece	2	113	31,6
152754	piece	3	135	39,6
152755	piece	4	160	49,6

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
156195	piece	2	113	31,6
156196	piece	3	135	39,6
156197	piece	4	160	49,6

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	Chuck capacity mm	
					Horizontal	Vertical
082362	piece	2	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

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	Chuck capacity mm		Step
					Horizontal	Vertical	
317259	set	2	110	31,8	3-12	5-32	3.5x3.3
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

Accessories NC power vices RBAW

## Accessories RBAW

A37  
Normal jaw SGNA, with movable workpiece stop, hardened and ground



Item no.	Contents of delivery	Size	Width mm	Height mm
150739▲	piece	2	113	31,6
150740▲	piece	3	135	39,6
150741▲	piece	4	160	49,6

Including fixing screws

A37  
Draw-down jaws STB, for parallel, angular or flat workpieces, hardened and ground



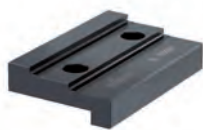
Item no.	Contents of delivery	Size	Width mm	Height mm
134826▲	set	2	110	32
134830▲	set	3	135	40
134834▲	set	4	160	50

A37  
Floating jaws SRP, hardened and ground, for workpieces with/without angular and parallelism errors



Item no.	Contents of delivery	Size	Width mm	Height mm
077097▲	set	2	110	38
077098▲	set	3	135	46
077099▲	set	4	160	56

A37  
Stepped top jaw ASB, for stationary jaw



Item no.	Contents of delivery	Size	Width mm	Height mm
153403▲	piece	2	113	19
153405▲	piece	3	135	22
153407▲	piece	4	160	25

A37  
Stepped top jaw ASB, for movable jaw



Item no.	Contents of delivery	Size	Width mm	Height mm
153404▲	piece	2	113	19
153406▲	piece	3	135	22
153408	piece	4	160	25

A37  
Floating jaw horizontal PEB, for clamping non-parallel workpieces



Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
156190▲	piece	2	113	32	36
156191	piece	3	135	40	40
156192▲	piece	4	160	50	45



NC power vices

## Accessories RBAW

A37

**Hand crank**, turnable handle, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A	L
134499	piece	2/3/4	12	117	90

A37

**Single clamp SPE**, for mounting vices 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 NC power vices RBAW

## 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 vices 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  
**Work locator WSA**, universally adjustable, for screwing onto the NC-compact vice or machine vice, connecting thread M12



Item no.	Contents of delivery
320400	piece

A37  
**Work locator WSA**, universally adjustable, for fastening to the machine table (size 14 T-slot) or for screwing onto the NC-compact vice / machine vice (M12)



Item no.	Contents of delivery
320401	piece

A37  
**Precision vice locator PSA**, universally adjustable, for screwing onto the NC-compact vice or machine vice, connecting thread M12



Item no.	Contents of delivery
681192▲	piece