



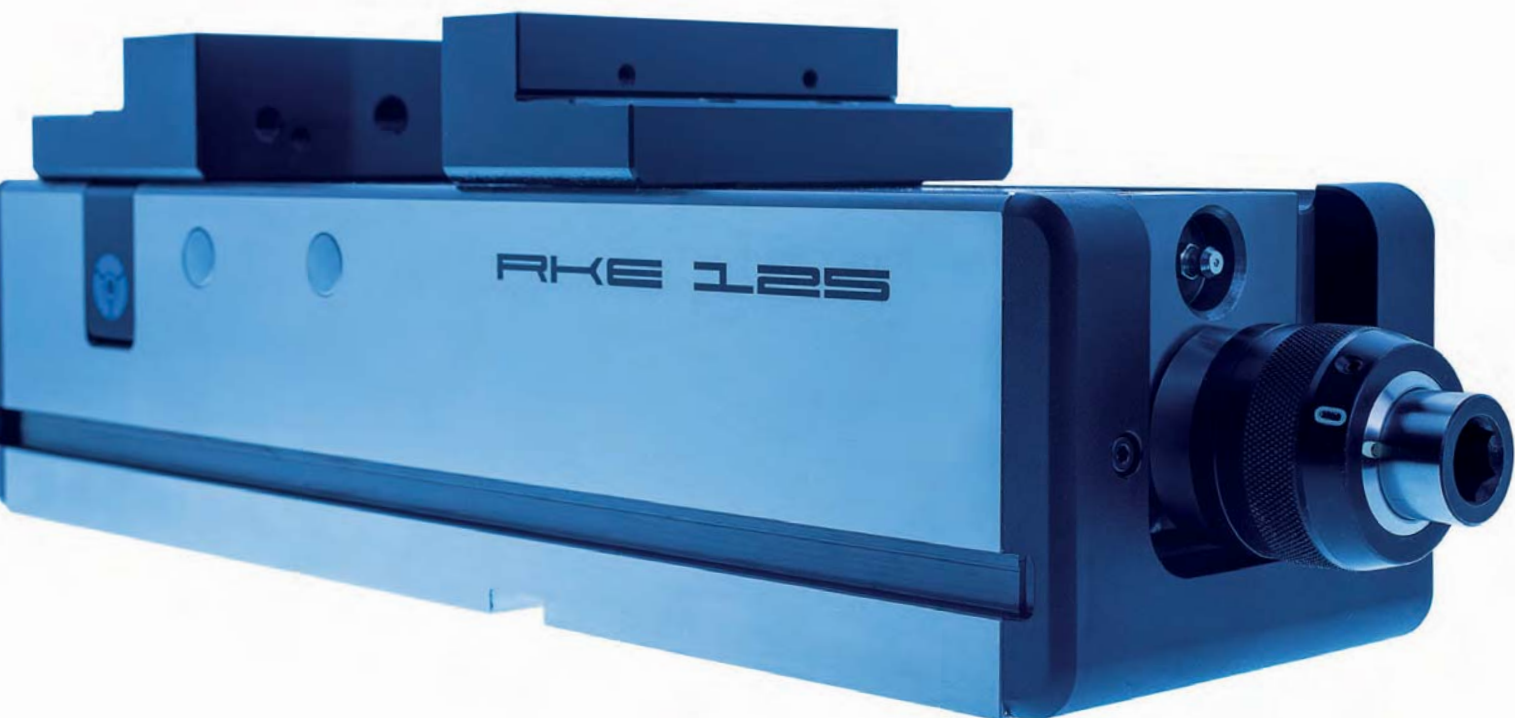
VICES

EDITION 8.1

RÖHM
driven by technology



RKE 125



THE PREMIUM VICE FOR ANY AREA OF APPLICATION



The NC-compact vices 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.



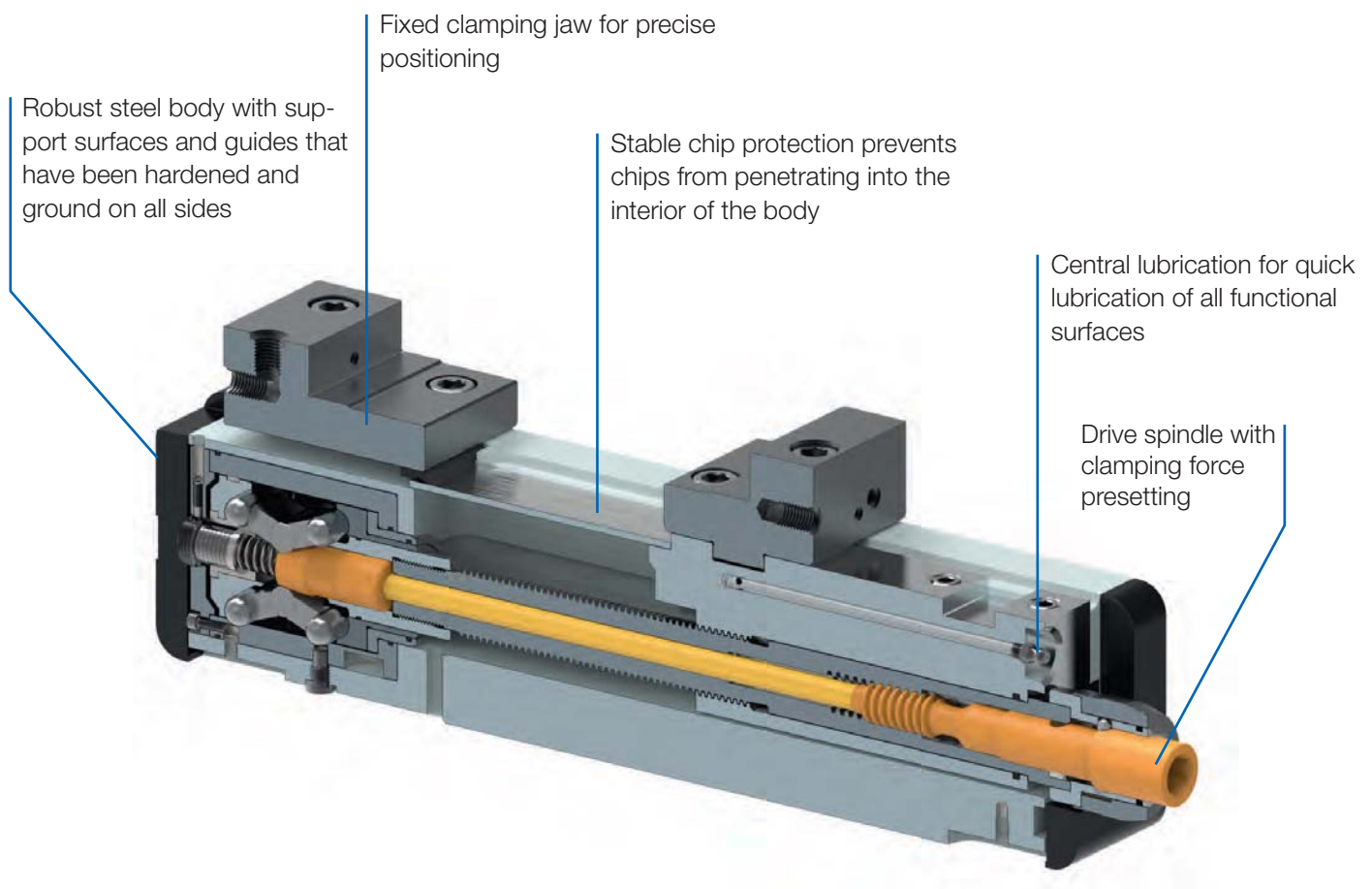
Video RKE

NC-COMPACT VICES

NC-compact vices are particularly suited for use on machining centers, milling machines and are ideal for 5-axis machining. These premium vices 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

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



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 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

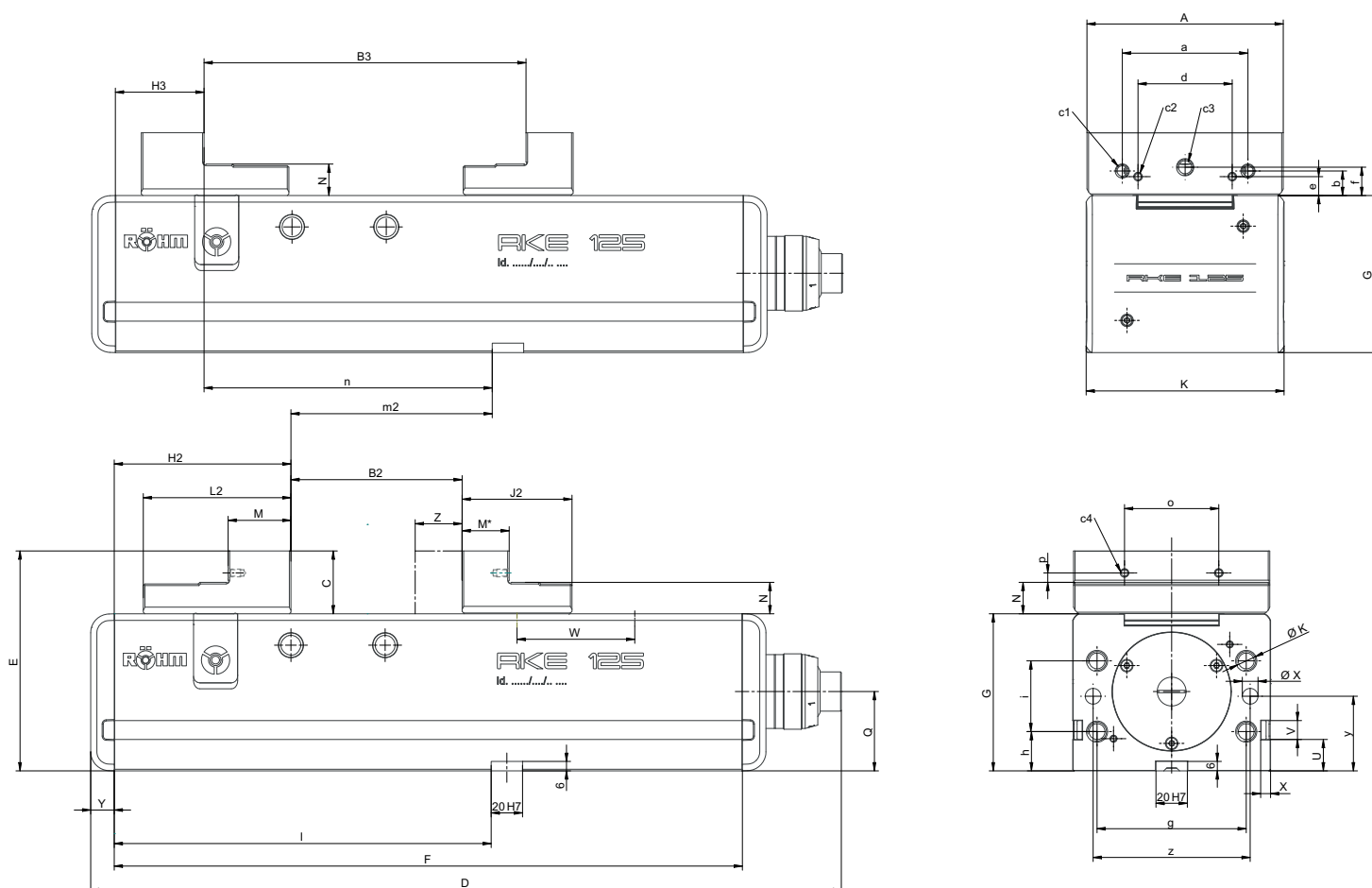
- Sturdy steel body and all guides are hardened and ground on all sides
- Long clamping slide with cross slots, hardened on all sides, functional surfaces ground
- Threaded bores for taking up all RÖHM flat clamping jaws with jaw width 125/160 mm

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 ⁺¹⁷	Ø 10 ⁺¹⁷	Ø 10 ⁺¹⁷	Ø 10 ⁺¹⁷
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



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

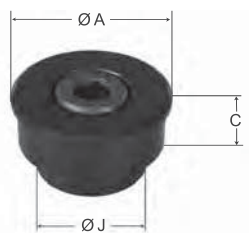
Swivelling claw inserts, for carrier jaws 743-72

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

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

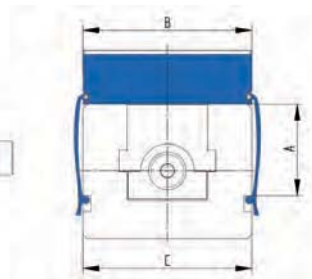
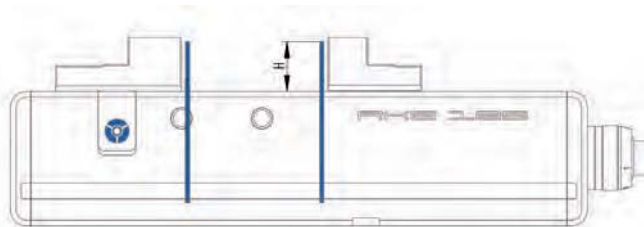
Including fixing screws

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



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

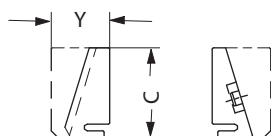
Including fixing screws

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

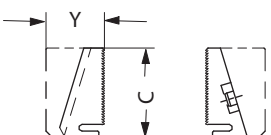


A37

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

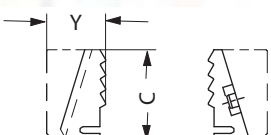


A37

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, 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

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 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

C15

Grease F91 for vices, 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

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

- 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
- Large clamping stroke
- Clamping surface for clamping claws
- Central lubrication of guides and spindle thread
- 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

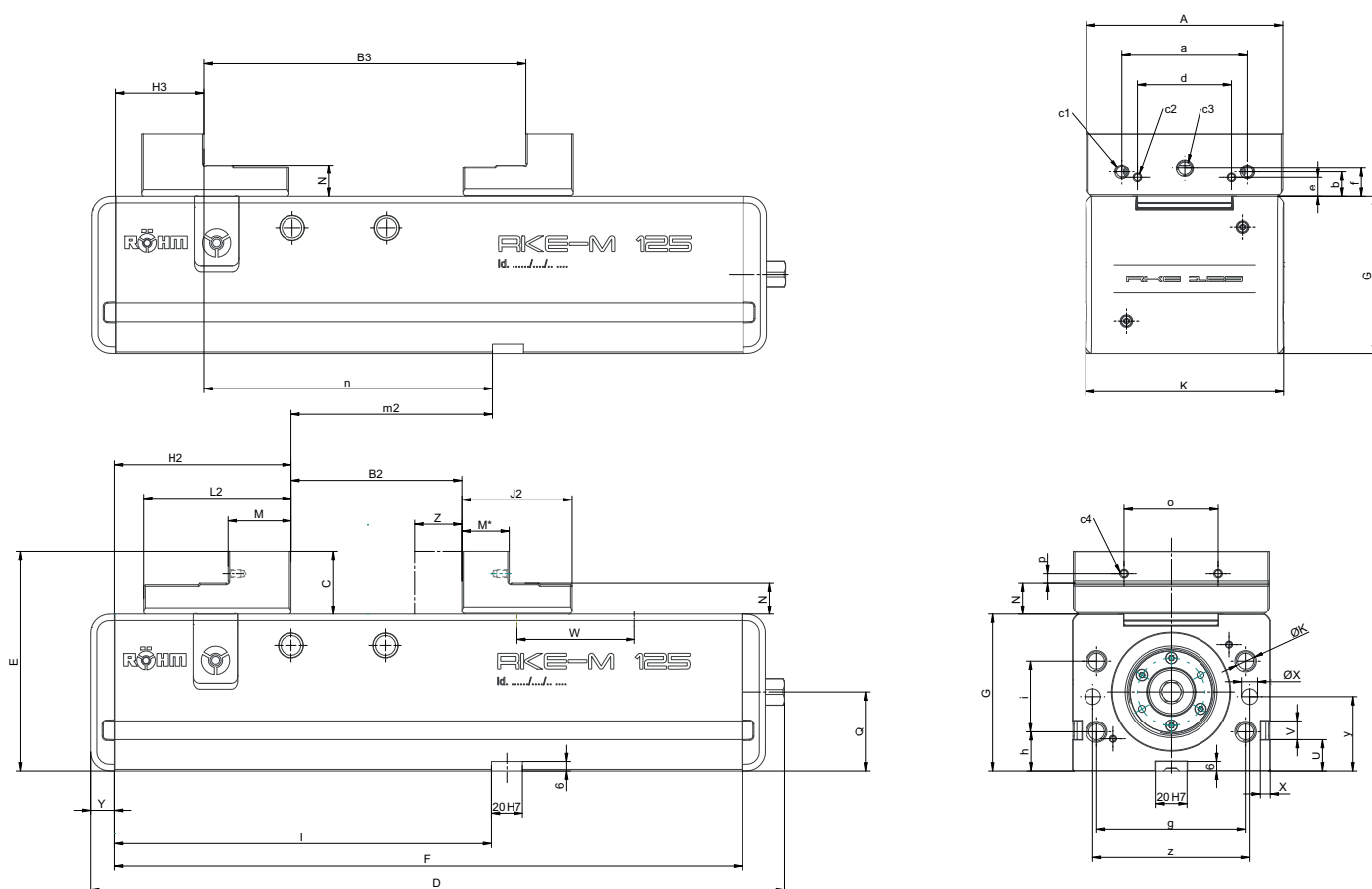
A32

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“

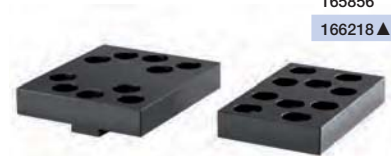
Item no.	Contents of delivery	Size	Width mm	Height mm
168698	set	92	50	48
175387 ▲	set	160	160	50
168693 ▲	set	125	62	60



A37

Carrier jaws TB, without swivelling claw inserts

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



A37

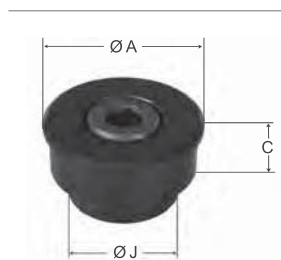
Swivelling claw inserts, for carrier jaws 743-72

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

Accessories RKE-M

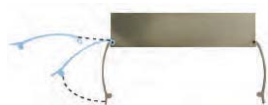
A37

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

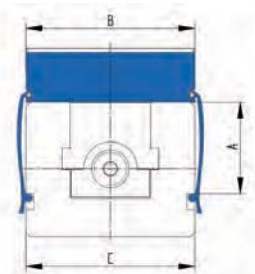
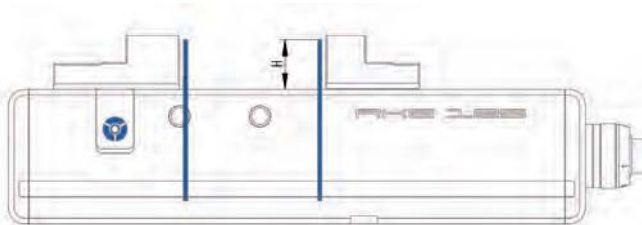

Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166661 ▲	set	92	92	32	14
166667	set	125	125	40	16
166669	set	160	160	50	18

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



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	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

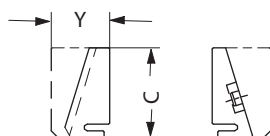
Including fixing screws

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

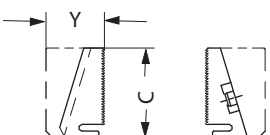


A37

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

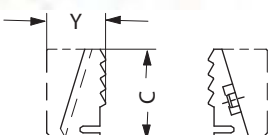


A37

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-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, with octagon socket


Item no.	Contents of delivery	Size	Octagon	Key-width SW	L
009151 ▲	piece	92	12		100
009152	piece	125	14	Octagon	125
009154	piece	160/200	19	Octagon	200

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

A26

Torque wrench

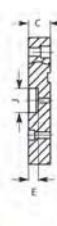
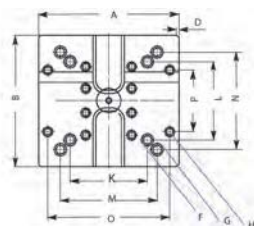

Item no.	Torque Nm	Length mm	Output	Working accuracy
10004116	20-120	435	12,7=1/2"	3%
10004117	60-320	659	12,7=1/2"	3%

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"

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 vices

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

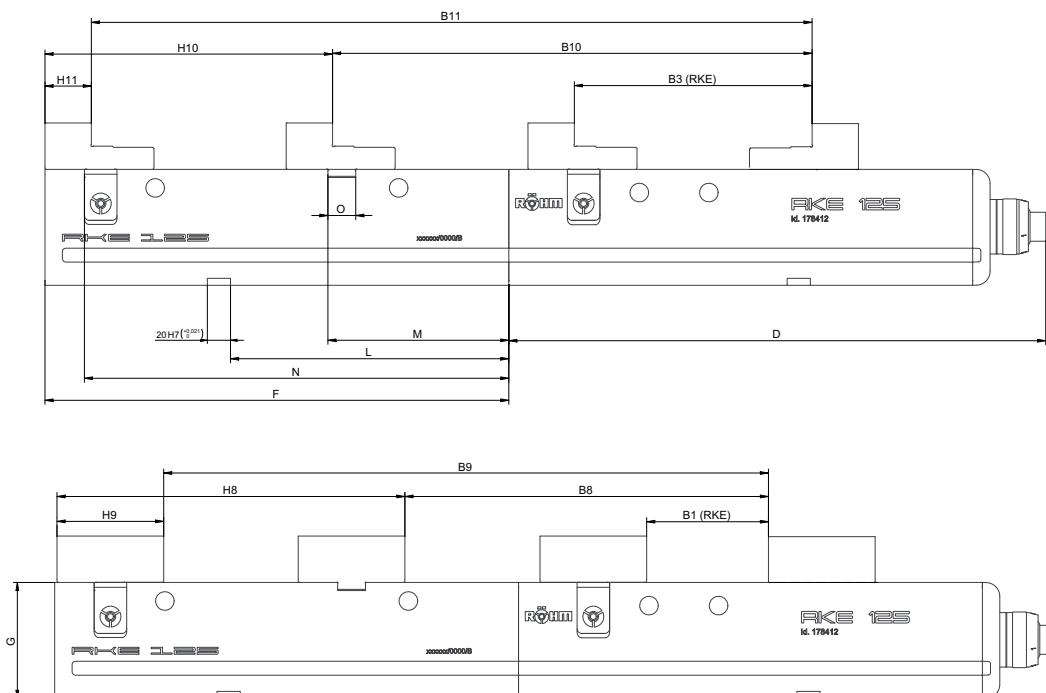
Accessories RKE / RKE-M



A37

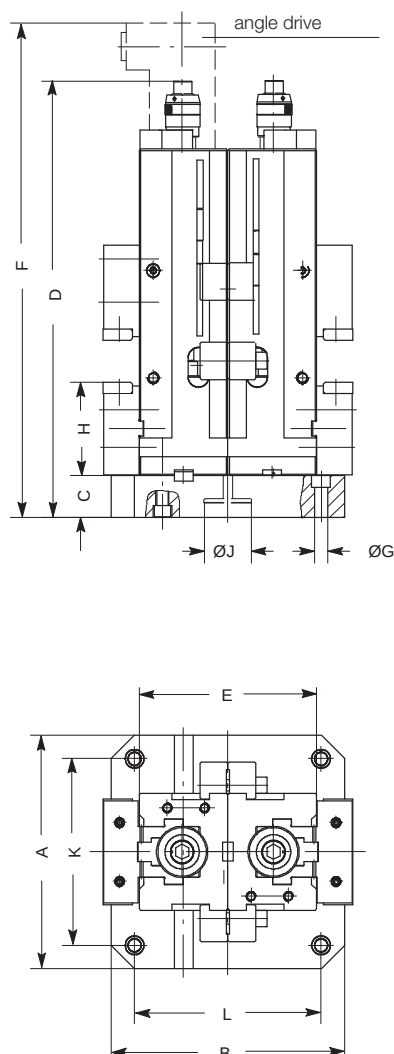
Extension GKV, for extension of clamping capacity for extra-long workpieces (**only RKE, RKE-M**) Fastening with screws (included in the scope of delivery)

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

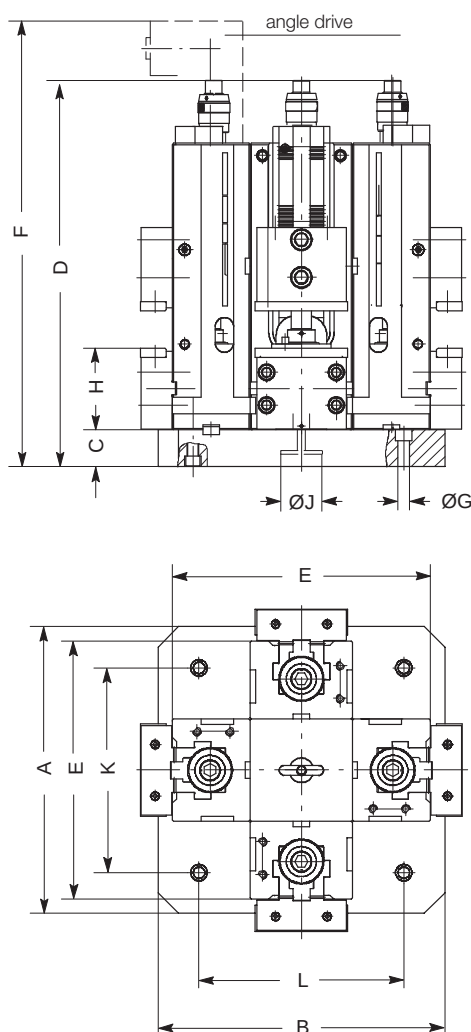


Duo and Quattro clamping towers RKE / RKE-M

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

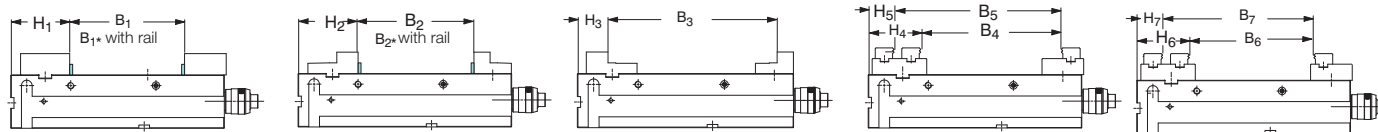
Technical data

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.

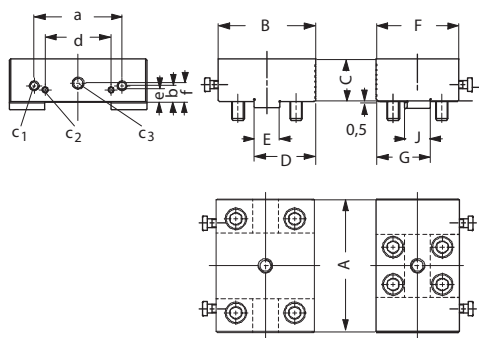
Clamping range RKE / RKE-M



	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	H4: 98 H5: 48	B4: 50-262 B5: 100-321	H6: 98 H7: 48	B6: 20-232 B7: 70-282
Size 160	130	0-320	130	0-320	64	131-451	H4: 122	B4: 67-383	H6: 122	B6: 18-334

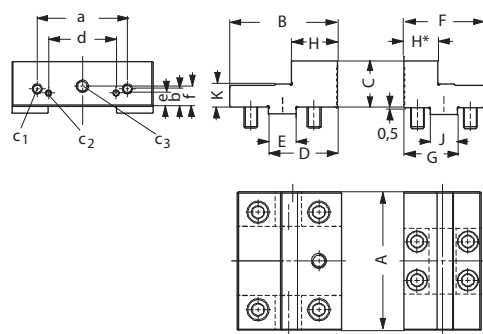
Clamping jaw dimensions for NC-Compact vices

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 _{H7}	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 _{H7}	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

- With tension clamping, zero point of the workpiece on the operator side
- Large clamping range
- High-precision positioning
- 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

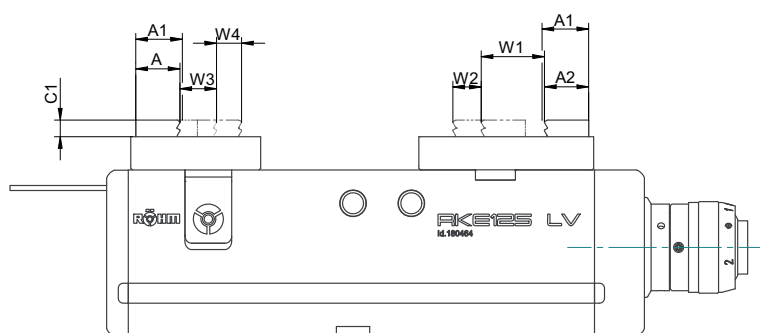
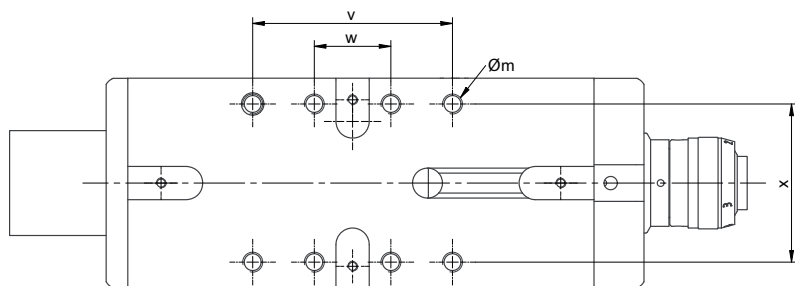
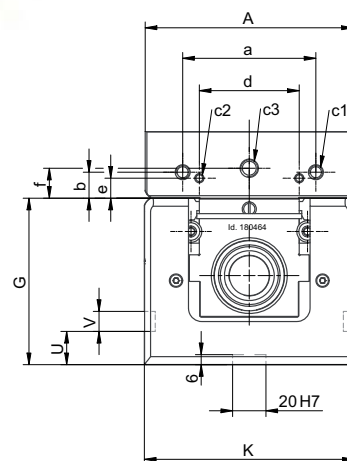
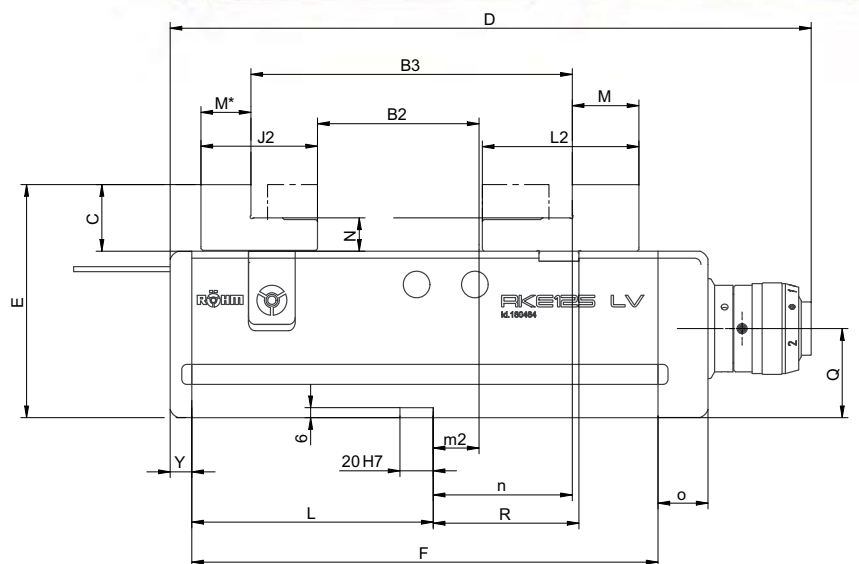
RKE-LV = RÖHM, compact, single clamping, light design, short design

A32

RKE-LV, with reversible stepped jaws or carrier jaws

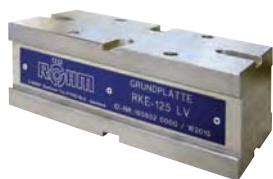
Item no.	180464 ▲	180465 ▲
Jaw width A mm	125	125
Jaw design	stepped jaws	carrier jaws
B2 mm	0-96	35-215
B3 mm	96-192	65-225
C mm	40	20
D mm	385	385
E mm	140	130
F mm	280	280
G _{0,02} mm	100	100
J2 mm	70	78
K mm	126	126
L mm	145	145
L2 mm	94	105
M mm	40	-
M* mm	30	-
N _{0,01} mm	20	20
O mm	30	30
Q mm	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

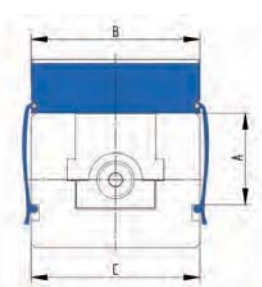
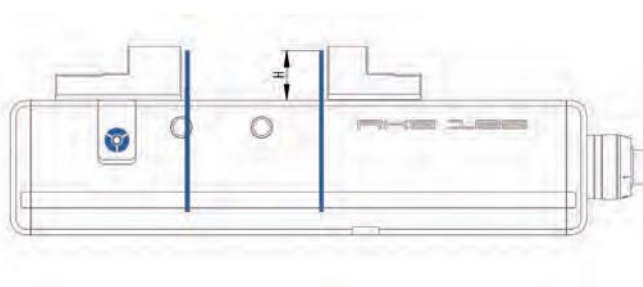


Item no.	Contents of delivery	Size	Width mm	Height mm	Thickness mm
166667	set Including fixing screws	125	125	40	16

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	Hexagon	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 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

RKK - with power transmitter, high precision



APPLICATION

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

TYPE

Size 1: clamping system mechanical-hydraulic.

Size 2-5: clamping system mechanical-mechanical.

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
- **Size 1:** long clamping slide with slot and tenon, hardened on all sides, functional surface ground
- **Sizes 2-5:** long clamping slide with toothing

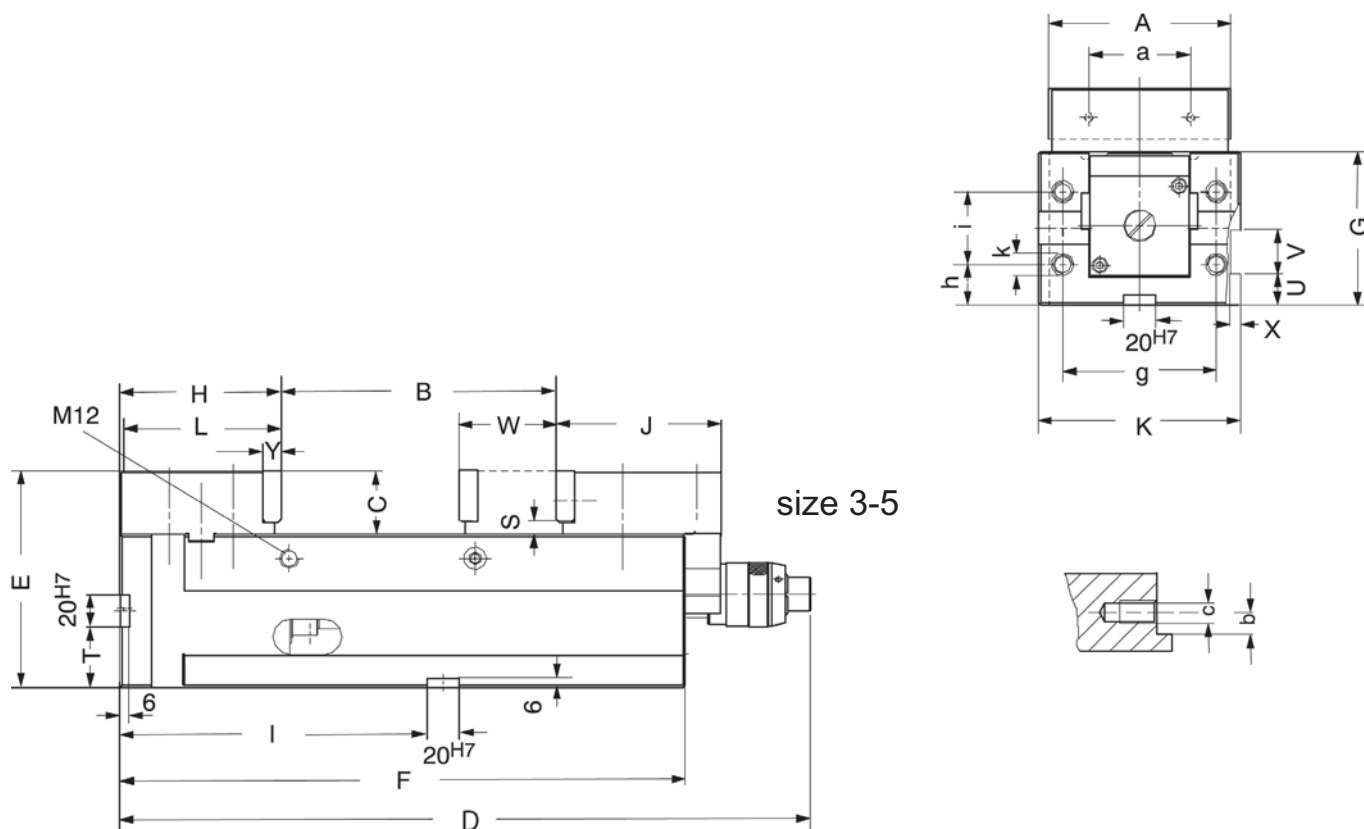
RKK = RÖHM, compact, power amplified

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



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

Accessories RKK

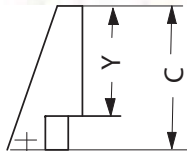
A37

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

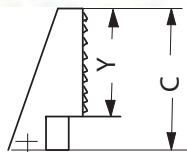
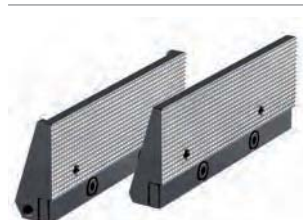
Including fixing screws

A37

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


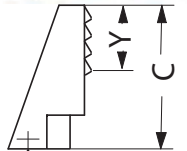
Item no.	Contents of delivery	Size	Width mm	C mm	Y mm
147954	set	3	135	53	40
147955	set	4	160	67	50
158823	set	5	200	67	50

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, hexagon socket



Item no.	Contents of delivery	Size	Hexagon	A	L
134600	piece	3/4/5	14	104	160

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 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

C15

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



Item no.	Design	Contents
777021 ▲	Cartridge	0,4 kg

C15

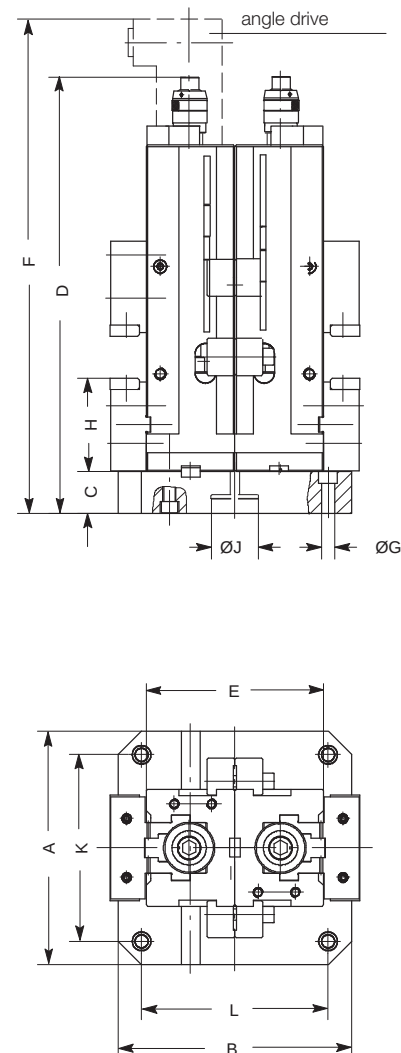
Grease gun DIN1283



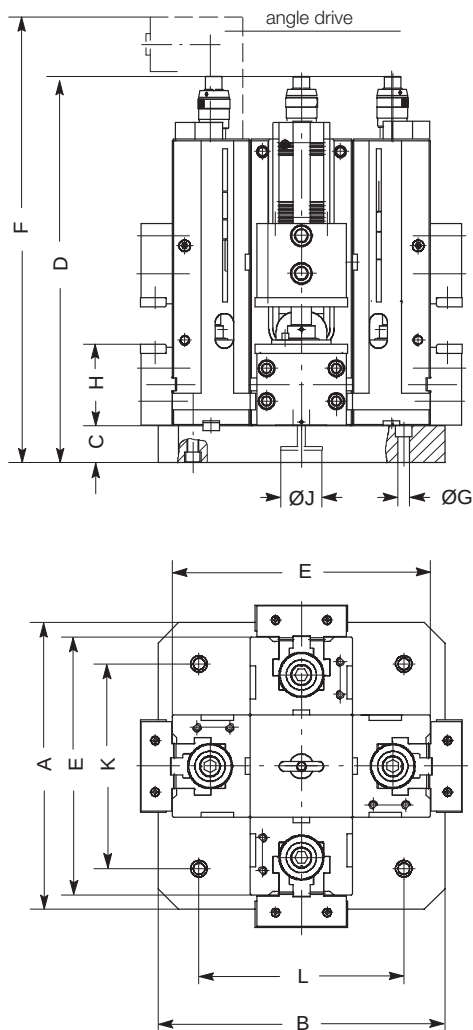
Item no.	Connection	Contents of delivery
329093	M10x1	150 mm nozzle tube bent, needlepoint mouthpiece, top mouthpiece, 300 mm high pressure hose with 4 jaw hydraulics cross mouthpiece

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

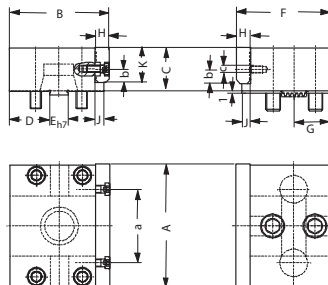
Technical data

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

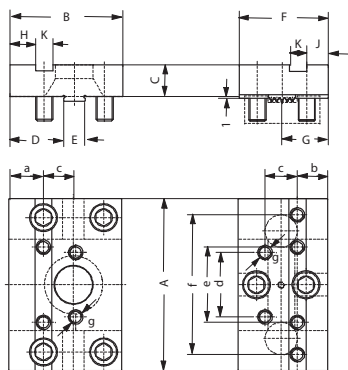
Jaw dimensions and clamping range RKK

Standard top jaws SA, reversible



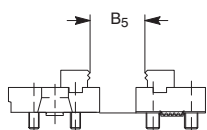
Size	3	4	5
A	135	160	200
B	109	128	128
C	49	60	70
D	44	50	50
E _{h7}	20	20	20
F	102	110	110
G	39	42	42
H	15,6	15,6	19,6
J	9,6	9,6	13,6
K	39,6	49,6	62,6
a	80	100	125
b	15,6	19,6	24,6
c	M8	M8	M10

Carrier jaws, reversible

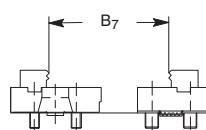


Size	3	4	5
A	135	160	200
B	95	105	105
C	30	30	30
D	44	50	50
E _{h7}	20	20	20
F	83	83	83
G	43	43	43
H	21	24	24
J	20	20	20
K _{H7}	16	16	16
a	29	32	32
b	28	28	28
c	25	30	30
d	60	70	70
e	60	70	110
f	110	130	160
g	M12	M12	M12

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