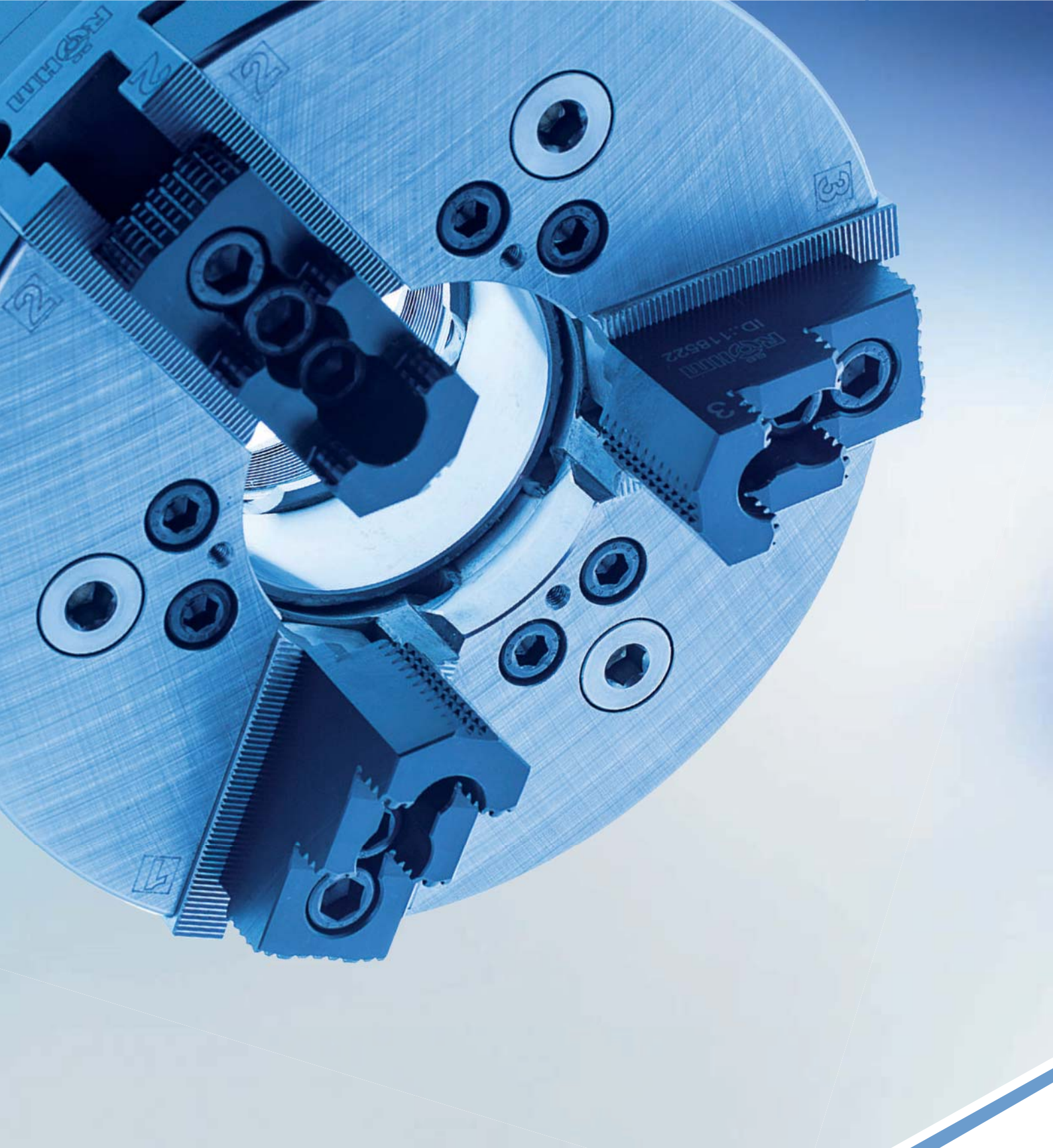
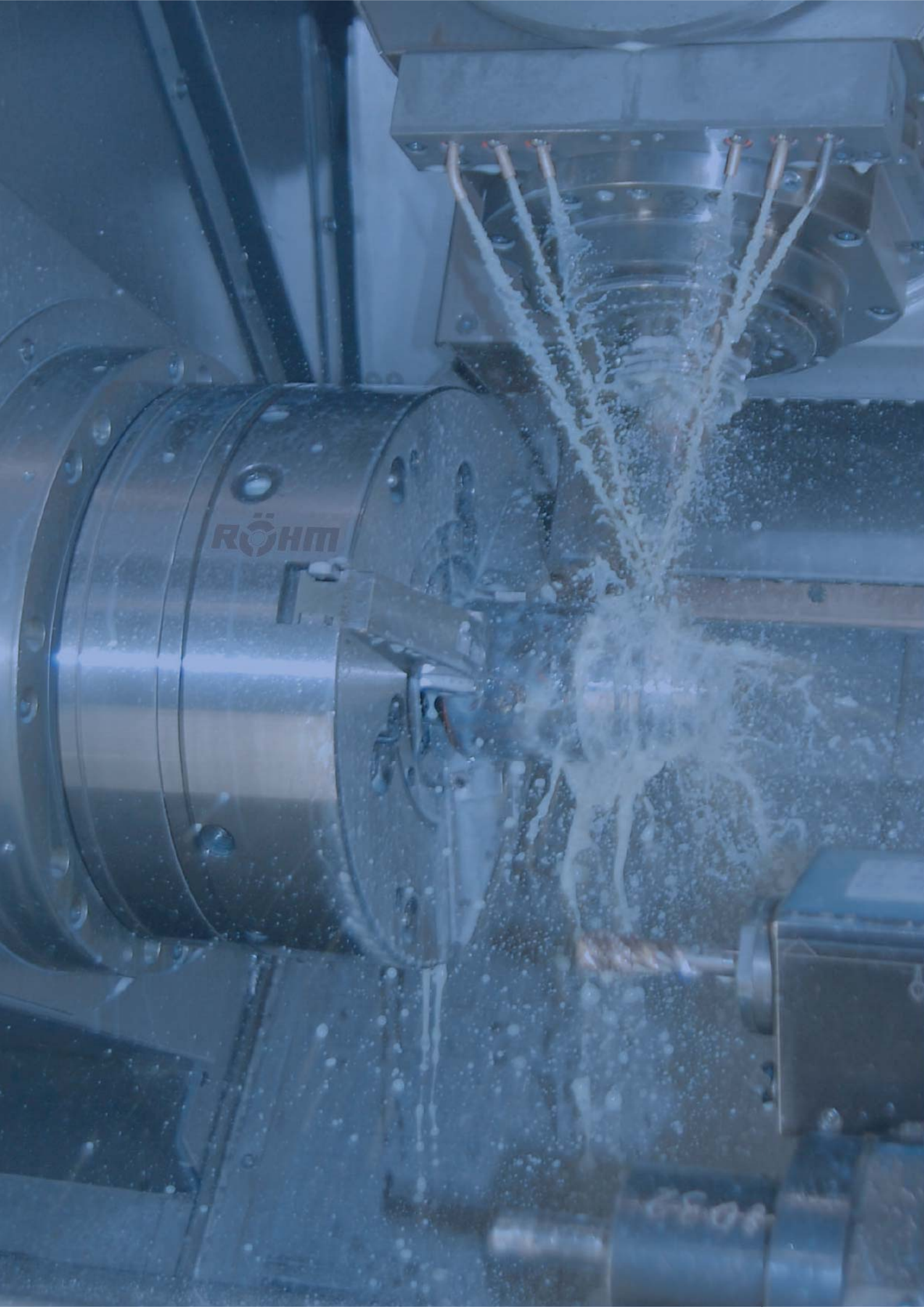




POWER CHUCKS CYLINDERS / STEADY RESTS

EDITION 8.1

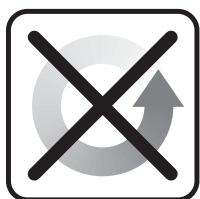
RÖHM
driven by technology





IDEAL FOR STATIONARY USE

The stationary power clamping devices from RÖHM are predestined for stationary, centric clamping of round and angular workpieces on milling machines or machining centers or for the rational clamping in automated work sequences.



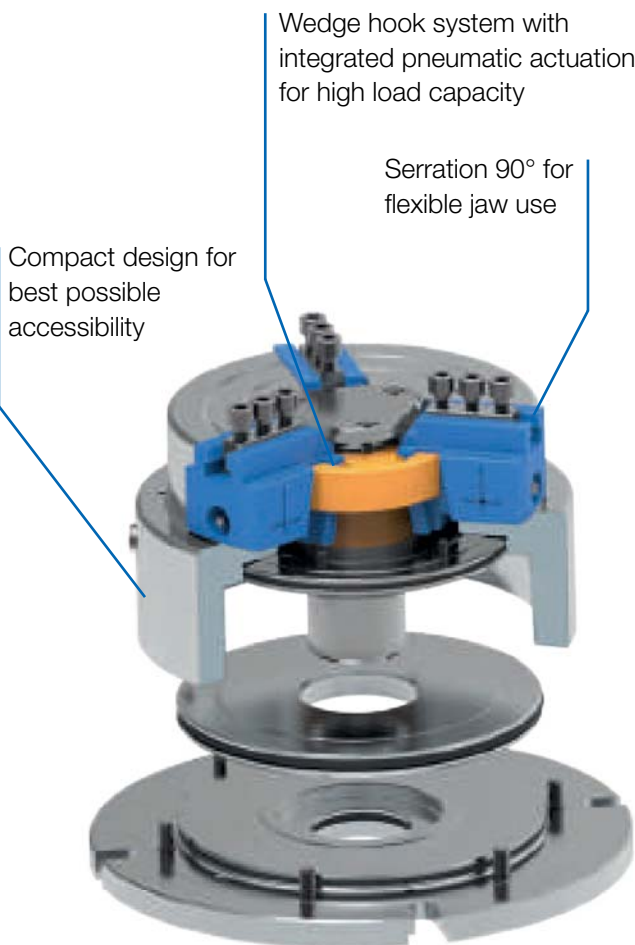
Stationary application

STATIONARY POWER CLAMPING DEVICES

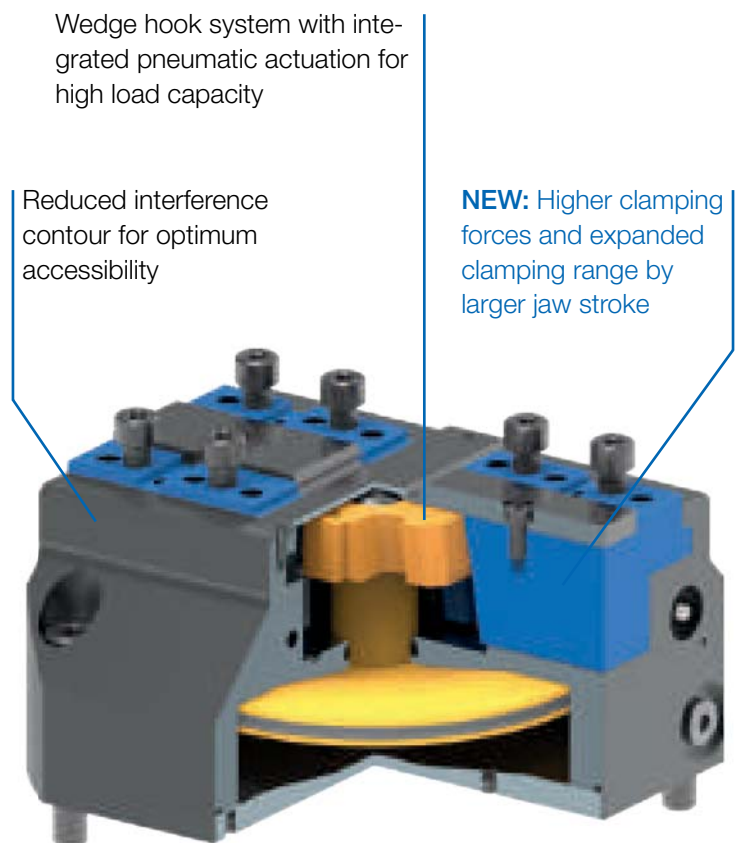
Stationary power clamping devices are characterized by many product advantages, which are essential for stationary, centric clamping on milling machines or machining centers or for the rational clamping in automated work sequences: Compact design for best possible work area utilization, high repeatability and constant clamping force at the same pressure, as well as maximum flexibility thanks to the centric clamping of round and angular workpieces.

ADVANTAGES AT A GLANCE

- ⌚ High efficiency thanks to automated and fast clamping in stationary use
- ⌚ Wedge hook system for high load capacity and clamping precision
- ⌚ Flexible use thanks to centric clamping of angular and round components



Stationary power chuck SSP



Pneumatically-operated centering vice KZS-P

KZS-P



APPLICATION

Optimally suited for use in 3-, 4- and 5-axis machining centers as well as on all common zero-point clamping systems

TYPE

Pneumatically actuated centering vice in standard design. Optionally with inductive sensors. 2-jaws version.

CUSTOMER BENEFITS

- ⊕ Jaw stroke expanded by up to 20% for a larger clamping range
- ⊕ Highest clamping forces of up to 55 kN, optimal results and process reliability through precision wedge hook system
- ⊕ Optimized lubrication system for constantly high clamping forces
- ⊕ Compact design with reduced interfering contours for optimum workpiece accessibility, ideal working space utilization and optimum chip flow
- ⊕ Sturdy and low-backlash jaw guides for high repeatability

TECHNICAL FEATURES

- Jaws with cross tenon and serration

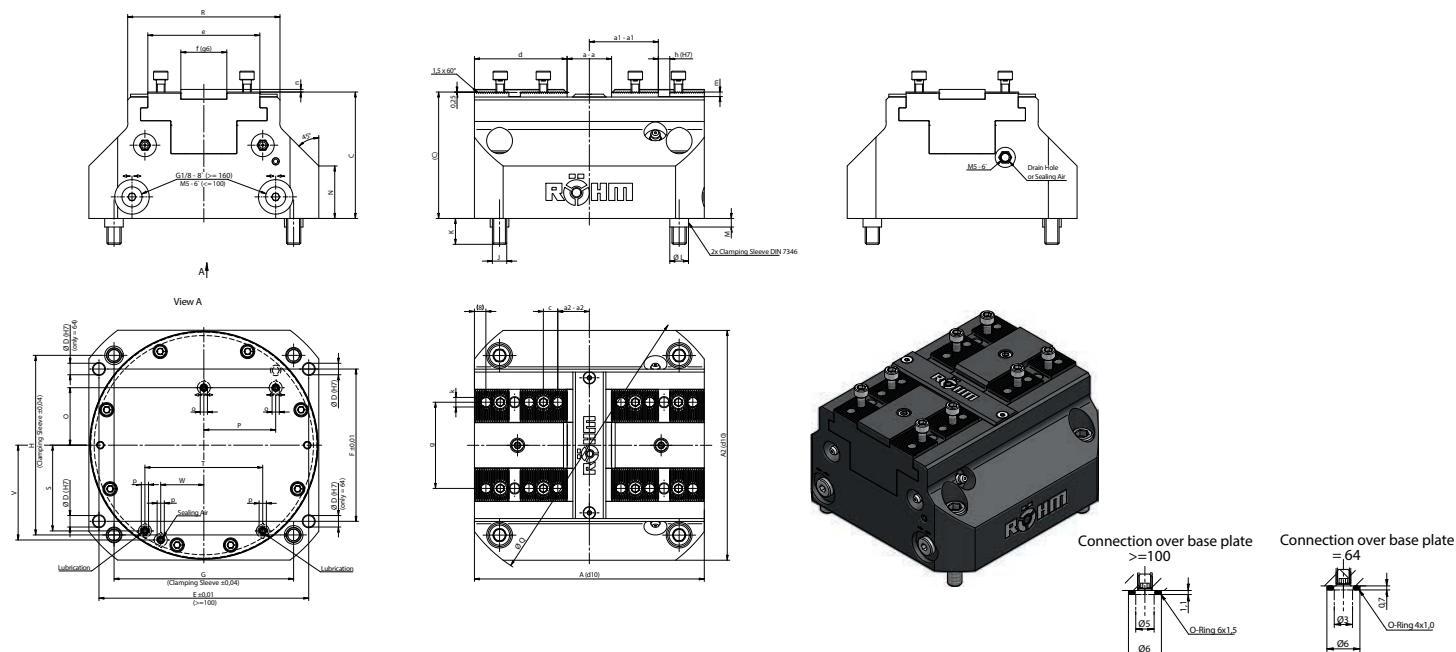
KZS-P = power-operated, centering, vice, pneumatically



The power-operated centering vices are also available with integrated stroke sensor, which serves for clamping control and ensures optimum process monitoring and thus optimal process reliability.



KZS-P



Power-operated centering vice **KZS-P** (standard jaw stroke), basic jaws with serration 1.5 x 60° and cross-tenon interface

Item No.	181480	181482	181486	181490	181494
Item No. with inductive sensors	181580 ▲	181582 ▲	181586 ▲	181590 ▲	181594 ▲
Size	KZS-P 64	KZS-P 100	KZS-P 160	KZS-P 200	KZS-P 250
A1 mm	64	100	160	200	250
Jaw stroke B mm	2.3	2.3	3.5	4.8	6
C mm	50.7	69.2	82.2	90.2	98.2
D H7 mm	4 - 7.5T	6 - 12T	8 - 14T	8 - 14T	10 - 20T
E±0.01 mm	36	90	146	184	230
F±0.01 mm	56	64	106	146	154
G±0.04 mm	50	80	125	160	200
H±0.04 mm	50	80	125	160	200
J mm	M6	M8	M10	M10	M12
K mm	12	15	18	18	20
L mm	8	11	13	13	16
M mm	4	4.5	6	6	6
N mm	26.2	34.8	31.5	34.2	35.7 (50°)
O mm	17	32	40	50	64
P mm	17	29.5	50	65	75
Q mm	84	130	200	250	310
R mm	45	68	106	140	166
S mm	21.1	34.5	59.7	72.5	92.6
T mm	33.6	55	82	110	139.6
V mm	-27.5	44	74	817.7	110.8
W mm	0	25.5	32	48	60
a mm	12.8 - 17.4	20.4 - 25	24 - 31	34.4 - 44	34 - 46
a1 mm	12.9 - 15.2	25.7 - 28	44.5 - 48	53.2 - 58	55 - 61
a2 mm	9.9 - 12.2	14.7 - 17	18.5 - 22	32 - 27.2	24 - 30
b mm	4.8	5	8	8	11
c mm	5	7	10	10	12
d mm	23.3	37.5	64.5	78	102
e mm	30	47	78	102	125
f ⁹⁶ mm	14	20	32	40	50
g mm	24	35	60	80	90
h ¹⁰⁷ mm	4	6	8	8	10
k	M4 - 7T	M6 - 9T	M8 - 12T	M8 - 16T	M10 - 19T
k1	4	5	6	7	8
m mm	2.7	2.7	3.2	3.2	4
n mm	1.8	1.8	1.8	2.3	2.3
o mm	M3	M4	M5	M6	M6
p mm	M3	M4	M5	M5	M5
Max. operating pressure bar	9	9	9	9	6
Max. total clamping force kN	4.6	18	45	52	55
Weight kg	1.15	3.6	10.3	18.5	30.4
Cylinder volume (double stroke) cm³	38	180	600	900	1760
Closing time s	0.1	0.25	0.5	0.6	1.1
Clamping repeatability mm	0.01	0.01	0.02	0.03	0.03

KZS-PG - large jaw stroke



APPLICATION

Optimally suited for use in 3-, 4- and 5-axis machining centers as well as on all common zero-point clamping systems

TYPE

Pneumatically actuated centering vice with large jaw stroke. Optionally with inductive sensors. 2-jaws version.

CUSTOMER BENEFITS

- ③ Jaw stroke expanded by up to 20% for a larger clamping range
- ③ Highest clamping forces of up to 55 kN, optimal results and process reliability through precision wedge hook system
- ③ Optimized lubrication system for constantly high clamping forces
- ③ Compact design with reduced interfering contours for optimum workpiece accessibility, ideal working space utilization and optimum chip flow
- ③ Sturdy and low-backlash jaw guides for high repeatability

TECHNICAL FEATURES

- Jaws with cross tenon and serration

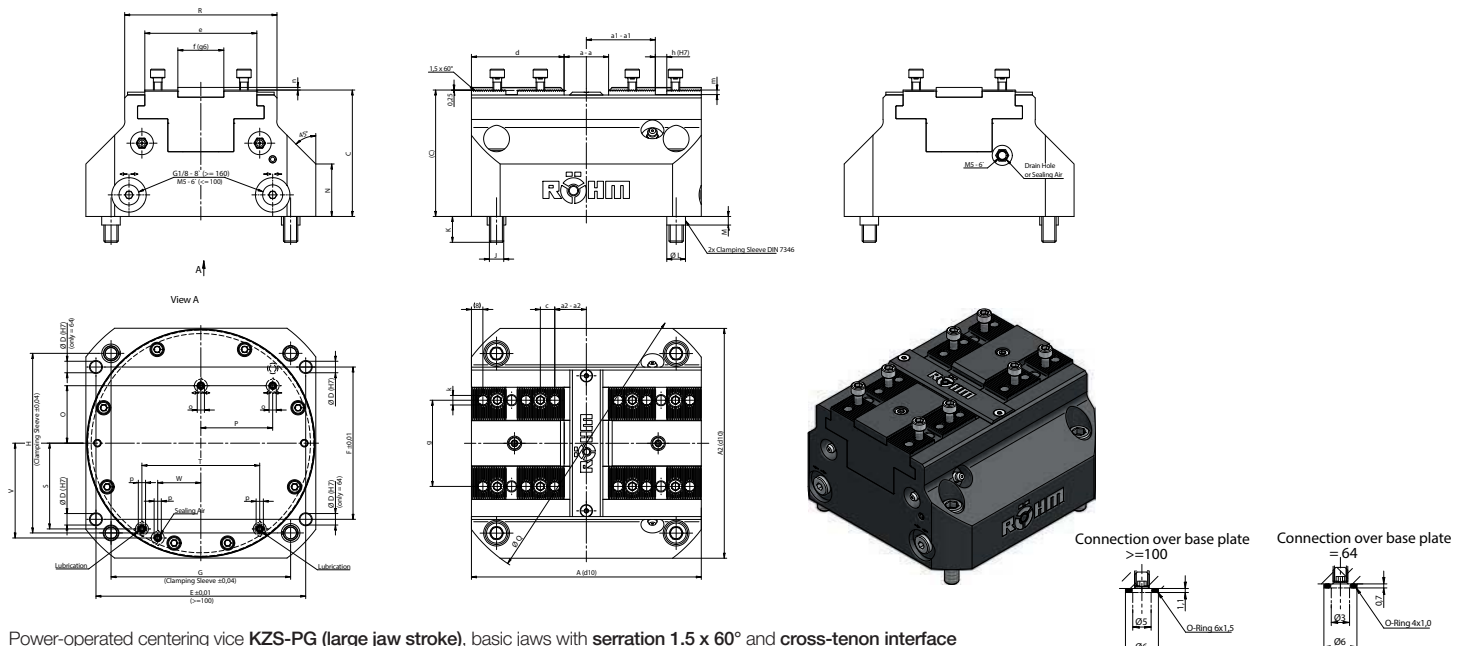
KZS-PG = power-operated, centering, vice, pneumatically, large jaw stroke



The power-operated centering vices are also available with integrated stroke sensor, which serves for clamping control and ensures optimum process monitoring and thus optimal process reliability.



KZS-PG - large jaw stroke



Power-operated centering vice **KZS-PG (large jaw stroke)**, basic jaws with **serration 1.5 x 60°** and **cross-tenon interface**

Item No.	181483	181487	181491	181495
Item No. with inductive sensors	181583 ▲	181587 ▲	181591 ▲	181595 ▲
Size	KZS-PG 100	KZS-PG 160	KZS-PG 200	KZS-PG 250
A1 mm	100	160	200	250
Jaw stroke B mm	7	9.5	12.1	17.6
C mm	69.2	82.2	90.2	98.2
D H7 mm	6 - 12T	8 - 14T	8 - 14T	10 - 20T
E±0.01 mm	90	146	184	230
F±0.01 mm	64	106	146	154
G±0.04 mm	80	125	160	200
H±0.04 mm	80	125	160	200
J mm	M8	M10	M10	M12
K mm	15	18	18	20
L mm	11	13	13	16
M mm	4.5	6	6	6
N mm	34.8	31.5	34.2	35.7 (50°)
O mm	32	40	50	64
P mm	29.5	50	65	75
Q mm	130	200	250	310
R mm	68	106	140	166
S mm	34.5	59.7	72.5	92.6
T mm	55	82	110	139.6
V mm	44	74	817.7	110.8
W mm	25.5	32	48	60
a mm	20.2 - 33	25 - 44	32 - 56.2	41 - 76.2
a1 mm	25.5 - 32.5	44.8 - 54.3	54.5 - 66.6	51.5 - 69.1
a2 mm	14.5 - 21.5	18.8 - 28.3	28.5 - 40.6	32.5 - 50.1
b mm	7.5	11.2	11.5	15
c mm	7	10	10	12
d mm	40.5	67.5	81	99
e mm	47	78	102	125
f ⁹⁵ mm	20	32	40	50
g mm	35	60	80	90
h ^{H7} mm	6	8	8	10
k	M6 - 9T	M8 - 12T	M8 - 16T	M10 - 19T
k1	5	6	7	7
m mm	2.7	3.2	3.2	4
n mm	1.8	1.8	2.3	2.3
o mm	M4	M5	M6	M6
p mm	M4	M5	M5	M5
Max. operating pressure bar	9	9	9	6
Max. total clamping force kN	8	20	24	21
Weight kg	3.65	10.5	18.9	30.4
Cylinder volume (double stroke) cm³	180	600	900	1760
Closing time s	0.25	0.5	0.6	1.1
Clamping repeatability mm	0.01	0.02	0.03	0.03

Jaws KZS-P / KZS-PG

C 21

Soft top jaws, 2-jaw set, can be hardened serration 60° - material: 16MnCr5



Item no.	Size	Jaw length mm	Jaw height mm	Jaw width mm
166138	64	25	20	34
166140	100	42	25	55
166142	160	60	40	80
166144	200	75	45	100
166146	250	90	50	125

C 21

Soft top jaws, 2-jaw set tongue and groove, high design, material: 16MnCr5



Item no.	Size	Jaw length mm	Jaw height mm	Jaw width mm
166126	64	28,5	35	34
166128	100	47	48	55
166130	160	76	77,5	80
166132	200	96	85	100
166134	250	120	100	125

Accessories KZS-P / KZS-PG

A09 Special grease F80 for lathe chucks

For lubrication and conservation of chucking power



Item no.	Design	Contents
308555	Cartridge (DIN 1284) Ø 53.5x235mm	0,5 kg
028975	Tin	1 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

KZS-H



APPLICATION

Optimally suited for use in 3-, 4- and 5-axis machining centers as well as on all common zero-point clamping systems

TYPE

Hydraulically actuated centering vice in standard design.
Optionally with inductive sensors. 2-jaws version.

CUSTOMER BENEFITS

- ⊕ Jaw stroke expanded by up to 20% for a larger clamping range
- ⊕ Highest clamping forces of up to 55 kN, optimal results and process reliability through precision wedge hook system
- ⊕ Optimized lubrication system for constantly high clamping forces
- ⊕ Compact design with reduced interfering contours for optimum workpiece accessibility, ideal working space utilization and optimum chip flow
- ⊕ Sturdy and low-backlash jaw guides for high repeatability

TECHNICAL FEATURES

- Jaws with cross tenon and serration

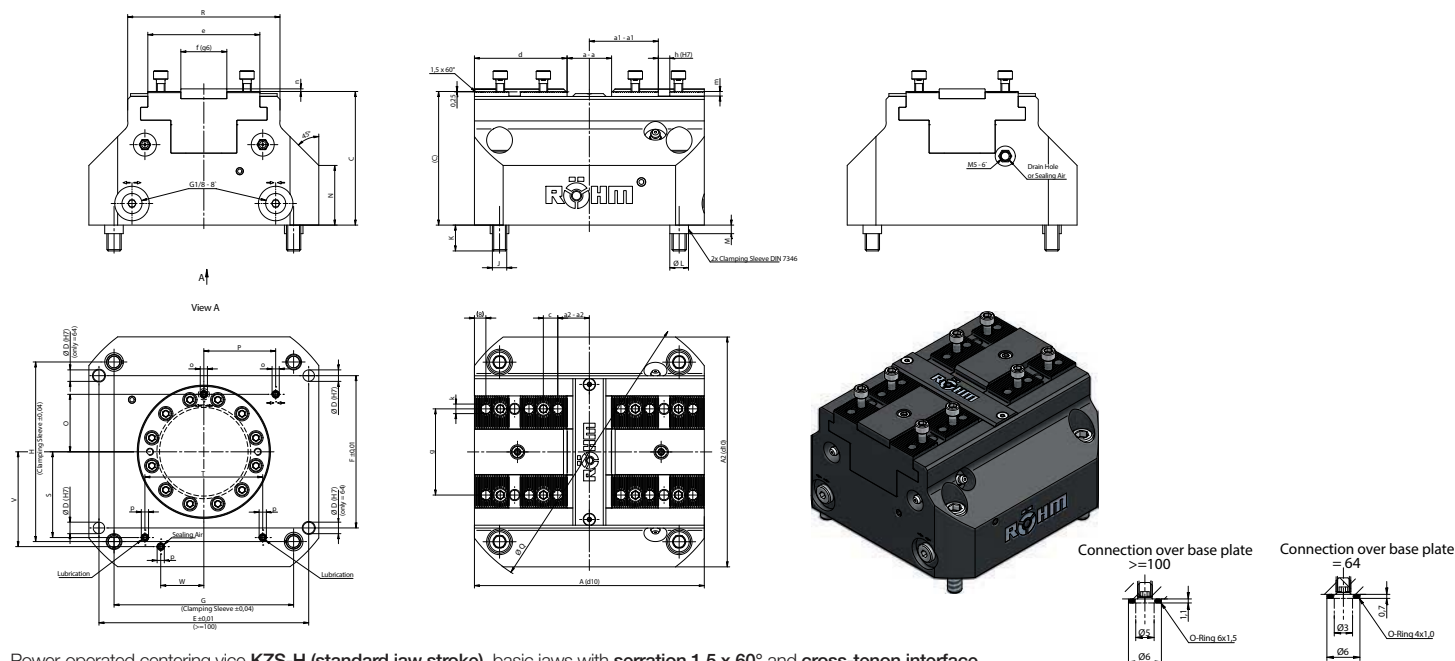
KZS-H = power-operated, centering, vice, hydraulically



The power-operated centering vices are also available with integrated stroke sensor, which serves for clamping control and ensures optimum process monitoring and thus optimal process reliability.



KZS-H



Power-operated centering vice KZS-H (standard jaw stroke), basic jaws with serration 1.5 x 60° and cross-tenon interface

Item No.	181481	181484	181488
Item No. with inductive sensors	181581 ▲	181584 ▲	181588 ▲
Size	KZS-H 64	KZS-H 100	KZS-H 160
A1 mm	64	100	160
Jaw stroke B mm	2.3	2.3	3.5
C mm	55.7	74.2	87.2
D H7 mm	4 - 7.5T	6 - 12T	8 - 14T
E±0.01 mm	36	90	146
F±0.01 mm	56	64	106
G±0.04 mm	50	80	125
H±0.04 mm	50	80	125
J mm	M6	M8	M10
K mm	12	15	18
L mm	8	11	13
M mm	4	4.5	6
N mm	31.2	39.8	36.5
O mm	17	32	40
P mm	17	29.5	50
Q mm	84	130	200
R mm	45	68	106
S mm	21.1	34.5	59.7
T mm	33.6	55	82
V mm	-27.5	44	74
W mm	0	25.5	32
a mm	12.8 - 17.4	20.4 - 25	24 - 31
a1 mm	12.9 - 15.2	25.7 - 28	44.5 - 48
a2 mm	9.9 - 12.2	14.7 - 17	18.5 - 22
b mm	4.8	5	8
c mm	5	7	10
d mm	23.3	37.5	64.5
e mm	30	47	78
f ⁹⁶ mm	14	20	32
g mm	24	35	60
h ¹⁷ mm	4	6	8
k	M4 - 7T	M6 - 9T	M8 - 12T
k1	4	5	6
m mm	2.7	2.7	3.2
n mm	1.8	1.8	1.8
o mm	M3	M4	M5
p mm	M3	M4	M5
Max. operating pressure bar	60	60	60
Max. total clamping force kN	4.5	18	45
Weight kg	1.45	4.55	13.3
Cylinder volume (double stroke) cm³	7	30	100
Closing time s	0.4	1.1	1.6
Clamping repeatability mm	0.01	0.01	0.02

KZS-HG - large jaw stroke



APPLICATION

Optimally suited for use in 3-, 4- and 5-axis machining centers as well as on all common zero-point clamping systems

TYPE

Hydraulically actuated centering vice with large jaw stroke. Optionally with inductive sensors. 2-jaws version.

CUSTOMER BENEFITS

- ③ Jaw stroke expanded by up to 20% for a larger clamping range
- ③ Highest clamping forces of up to 55 kN, optimal results and process reliability through precision wedge hook system
- ③ Optimized lubrication system for constantly high clamping forces
- ③ Compact design with reduced interfering contours for optimum workpiece accessibility, ideal working space utilization and optimum chip flow
- ③ Sturdy and low-backlash jaw guides for high repeatability

TECHNICAL FEATURES

- Jaws with cross tenon and serration

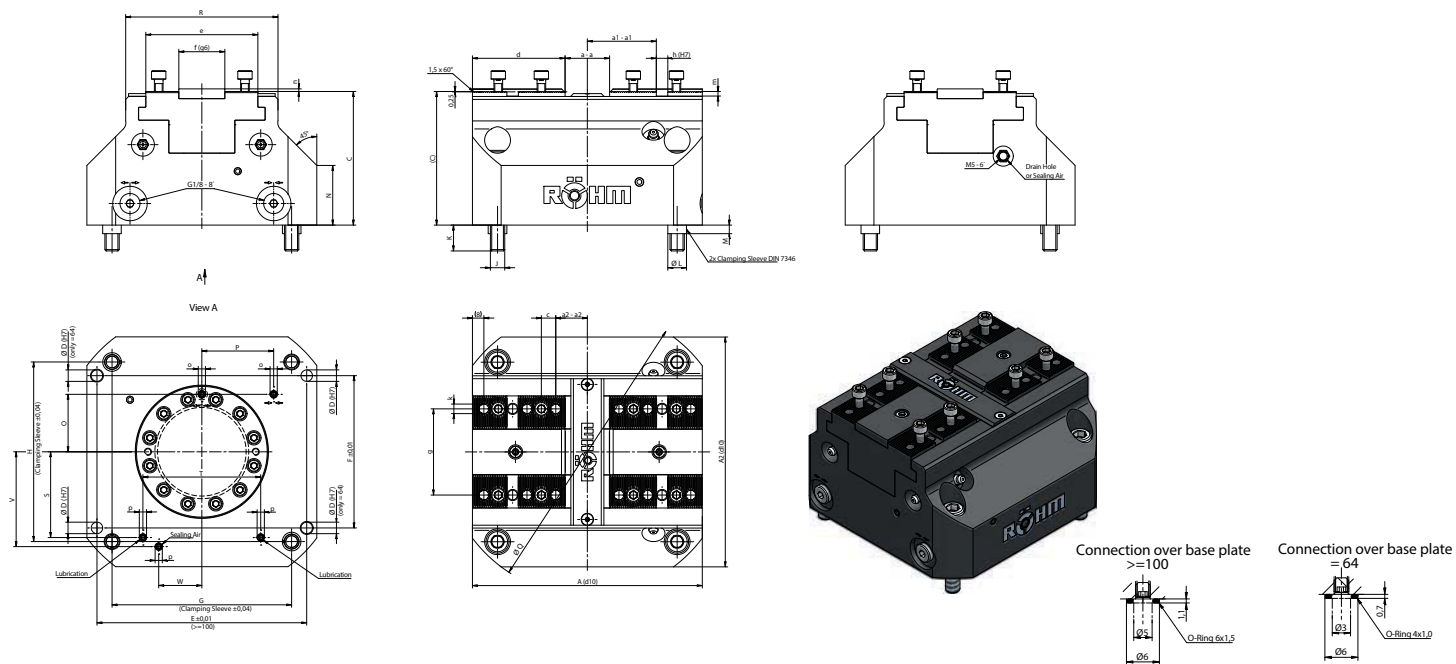
KZS-HG = power-operated, centering, vice, hydraulically, large jaw stroke



The power-operated centering vices are also available with integrated stroke sensor, which serves for clamping control and ensures optimum process monitoring and thus optimal process reliability.



KZS-HG - large jaw stroke



Power-operated centering vice **KZS-HG (large jaw stroke)**, basic jaws with **serration 1.5 x 60°** and **cross-tenon interface**

Item No.	181485	181489	181493	181497
Item No. with inductive sensors	181585 ▲	181589 ▲	181593 ▲	181597 ▲
Size	KZS-HG 100	KZS-HG 160	KZS-HG 200	KZS-HG 250
A1 mm	100	160	200	250
Jaw stroke B mm	7	9.5	12.1	17.6
C mm	74.2	87.2	95.2	103.2
D H7 mm	6 - 12T	8 - 14T	8 - 14T	10 - 20T
E±0.01 mm	90	146	184	180
F±0.01 mm	64	106	146	200
G±0.04 mm	80	125	160	180
H±0.04 mm	80	125	160	200
J mm	M8	M10	M10	M12
K mm	15	18	18	20
L mm	11	13	13	16
M mm	4.5	6	6	6
N mm	39.8	36.5	39.2	57.5 (50°)
O mm	32	40	50	80
P mm	29.5	50	65	45
Q mm	130	200	250	310
R mm	68	106	140	166
S mm	34.5	59.7	72.5	50
T mm	55	82	110	140
V mm	44	74	87.7	70
W mm	25.5	32	48	50
a mm	20.2 - 33	25 - 44	32 - 56.2	41 - 76.2
a1 mm	25.5 - 32.5	44.8 - 54.3	54.5 - 66.6	51.5 - 69.1
a2 mm	14.5 - 21.5	18.8 - 28.3	28.5 - 40.6	32.5 - 50.1
b mm	7.5	11.2	11.5	15
c mm	7	10	10	12
d mm	40.5	67.5	81	99
e mm	47	78	102	125
f ^Ø mm	20	32	40	50
g mm	35	60	80	90
h ^{H7} mm	6	8	8	10
k	M6 - 9T	M8 - 12T	M8 - 16T	M10 - 19T
k1	5	6	7	7
m mm	2.7	3.2	3.2	4
n mm	1.8	1.8	2.3	2.3
o mm	M4	M5	M6	M6
p mm	M4	M5	M5	M5
Max. operating pressure bar	120	120	60	60
Max. total clamping force kN	16	40	50	50
Weight kg	4.65	13.5	22.9	35.2
Cylinder volume (double stroke) cm ³	30	100	300	420
Closing time s	1.1	1.6	2.1	3
Clamping repeatability mm	0.01	0.02	0.03	0.03

Jaws KZS-H / KZS-HG

C 21

Soft top jaws, 2-jaw set, can be hardened serration 60° - material: 16MnCr5



Item no.	Size	Jaw length mm	Jaw height mm	Jaw width mm
166138	64	25	20	34
166140	100	42	25	55
166142	160	60	40	80
166144	200	75	45	100
166146	250	90	50	125

C 21

Soft top jaws, 2-jaw set tongue and groove, high design, material: 16MnCr5



Item no.	Size	Jaw length mm	Jaw height mm	Jaw width mm
166126	64	28,5	35	34
166128	100	47	48	55
166130	160	76	77,5	80
166132	200	96	85	100
166134	250	120	100	125

Accessories KZS-H / KZS-HG

A09 Special grease F80 for lathe chucks

For lubrication and conservation of chucking power



Item no.	Design	Contents
308555	Cartridge (DIN 1284) Ø 53.5x235mm	0,5 kg
028975	Tin	1 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



APPLICATION

For stationary centric clamping of workpieces on milling machines or machining centers.

TYPE

Clamping system consisting of a 3-jaw chuck, including an integrated pneumatic cylinder.
Serration 90°.

CUSTOMER BENEFITS

- ⊕ Compact design
- ⊕ Large variety of applications is possible by using different clamping jaws
- ⊕ Centric clamping of round and angular workpieces
- ⊕ High repeatability thanks to sturdy chuck construction and constant clamping force at same pressure
- ⊕ Purge air connection possible to prevent contamination

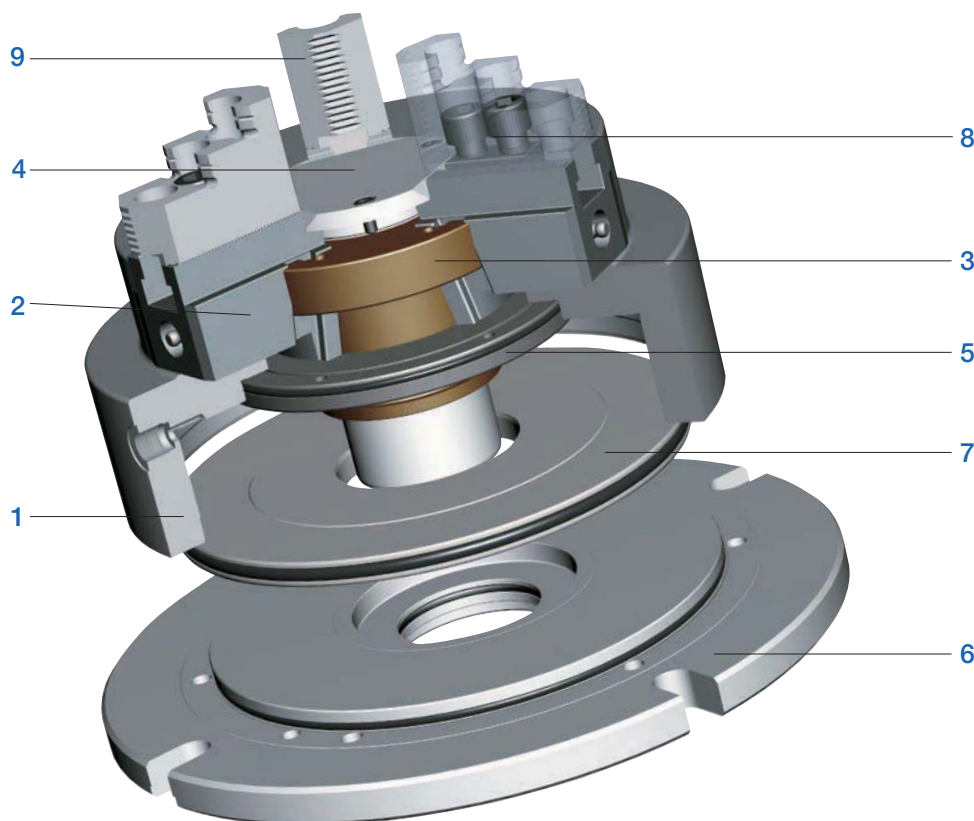
TECHNICAL FEATURES

- Wedge hook system with pneumatic actuation
- Clamping force can be regulated by changing the pressure

Note:

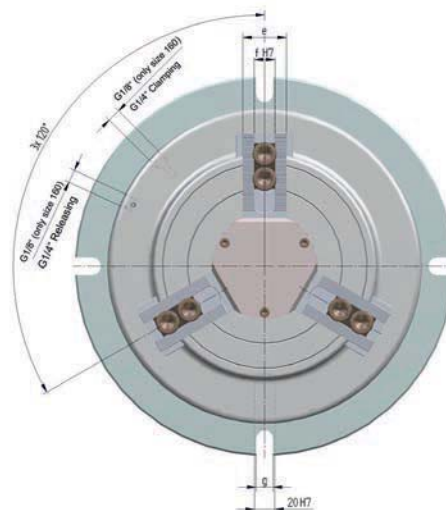
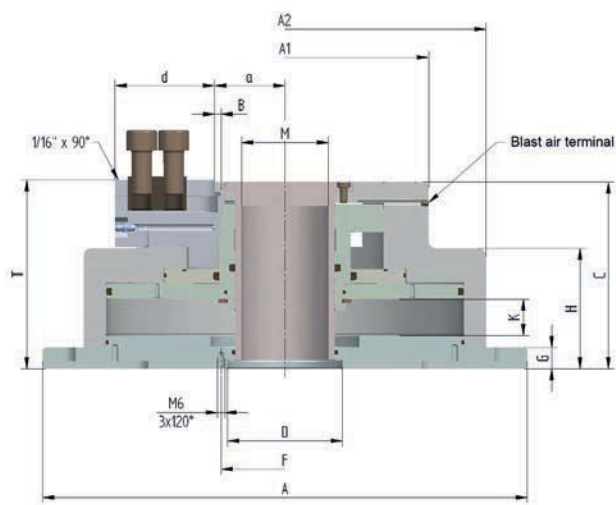
Hydraulic actuation on request

SSP = stationary, power chuck, pneumatically



Components:

1. Body
2. Base jaw
3. Piston
4. Protective bushing
5. Intermediate disc
6. Mount
7. Piston disc
8. T-nut
9. Top jaws



C 15
Stationary power chucks **SSP**, air operated 3-jaw chucks, without through-hole, serration 1/16" x 90°

Item No.	161505	161506 ▲	161507 ▲	161508
Size	160	200	250	315
Number of jaws	3	3	3	3
A mm	260	320	380	415
A1 mm	178	205	255	320
A2 mm	210	255	315	350
Jaw travel B mm	4,2	4,2	5	5
C mm	130,5	134	146	156,5
Mount D ⁴⁶	55	70	90	110
D	M8	M12	M16	M16
F mm	65	80	100	120
G mm	15	17	17	21,5
H mm	84,5	86	94	104,5
Wedge stroke K mm	24	23,8	28,4	28,4
Possible through-hole M mm	38	52	68	90
T mm	131,5	135,5	147,5	158
U	M8	M12	M16	M16
a min.	31,8	41,2	50	61,5
a max.	36	45,4	55	66,5
c mm	15	19	25	25
d mm	54,5	62	78	99
e mm	32	36	44	44
f ⁴⁷ mm	12	17	21	21
g mm	13	17	17	17
Piston area cm ²	209	323	532	654
Min. operating pressure bar	2	2	2	2
Max. operating pressure bar	8	8	8	8
Max. total clamping force at working pressure - External clamping kN	36 (bei 6 bar)	55 (bei 6 bar)	90 (bei 6 bar)	111 (bei 6 bar)
Max. total clamping force at working pressure - Internal clamping kN	38 (bei 6 bar)	60 (bei 5 bar)	96 (bei 6 bar)	118 (bei 6 bar)
Weight without jaws approx. kg	25	34	54	65

Jaws SSP

C 21

Reversible top jaws, 3-jaw set, hardened serration 90° - material: 16MnCr5



Item no.	Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
046404	160	56	37,5	26	1/16"x 90°
118522	200	75	49	36	1/16"x 90°
046414	250/315	103,5	58	50	1/16"x 90°

Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21

Soft top jaws, 3-jaw set, can be hardened serration 90° - material: 16MnCr5



Item no.	Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
046403	160	55	38	26,5	1/16"x 90°
133153	200	75	53	36,5	1/16"x 90°
133154	250	95	54,5	45	1/16"x 90°

C 21

Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 12



Item no.	Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
144320	160	66	38	52	1/16"x 90°
144321	160	56	38	34	1/16"x 90°
144322	160	66	38	25	1/16"x 90°

C 21

Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 17



Item no.	Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137031	200	67	45	53	1/16"x 90°
137032	200	65	45	46	1/16"x 90°
137039	200	55	45	40	1/16"x 90°
137034	200	50	45	31	1/16"x 90°
137035	200	55	45	27	1/16"x 90°
137036	200	65	45	19	1/16"x 90°
137037	200	65	45	26	1/16"x 90°
137038	200	55	45	24	1/16"x 90°
137033	200	55	45	39	1/16"x 90°

C 21

Claw-type jaws, 1 piece, hardened serration 90° - width of the groove 21



Item no.	Size	Jaw length mm	Jaw height mm	Claw length mm	Serration
137041	250/315	95	50	80	1/16"x 90°
137042	250/315	75	50	60	1/16"x 90°
137043	250/315	60	50	43	1/16"x 90°
137044	250/315	70	50	37	1/16"x 90°
137045	250/315	95	50	25	1/16"x 90°
137046	250/315	80	50	30	1/16"x 90°