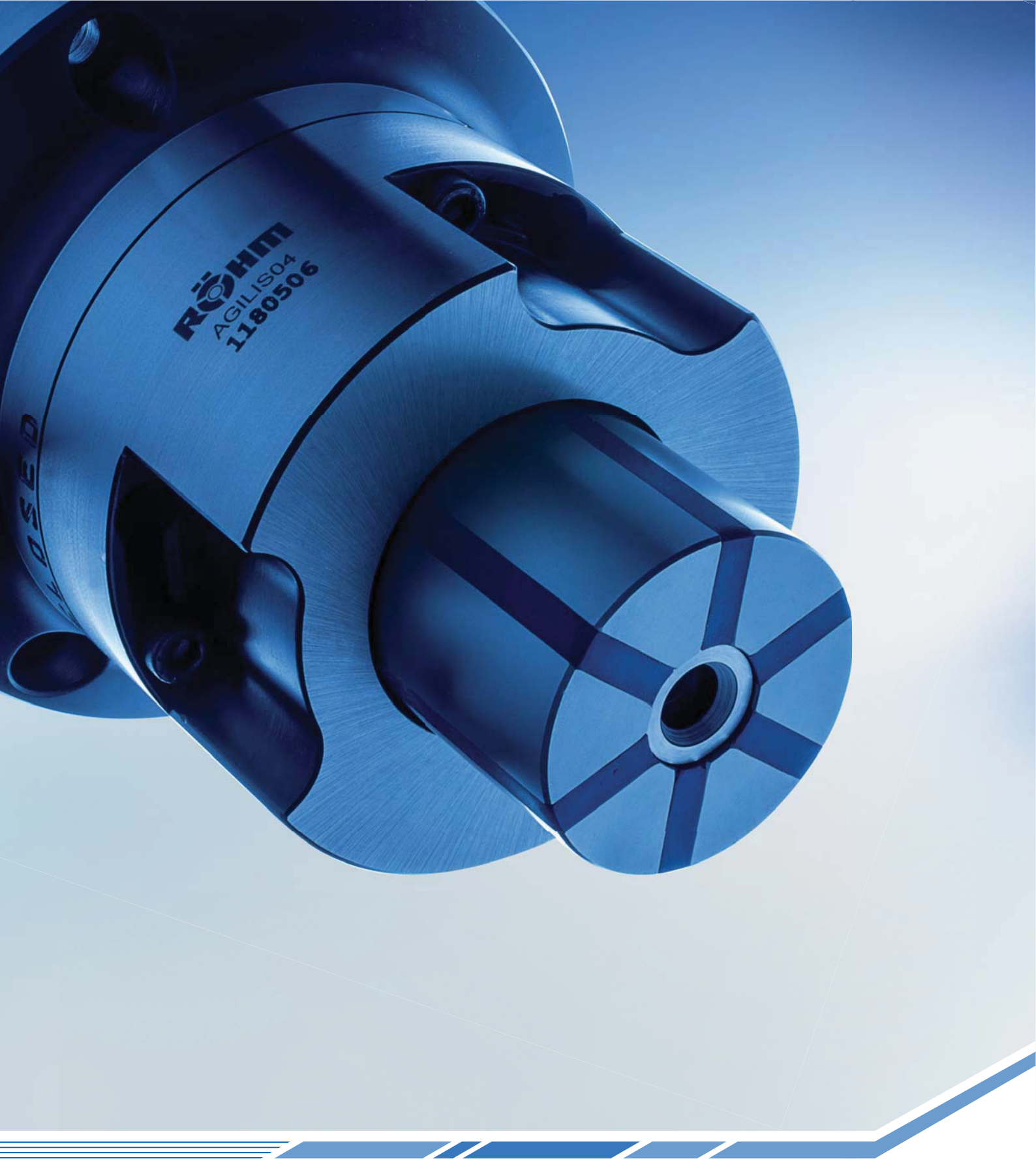
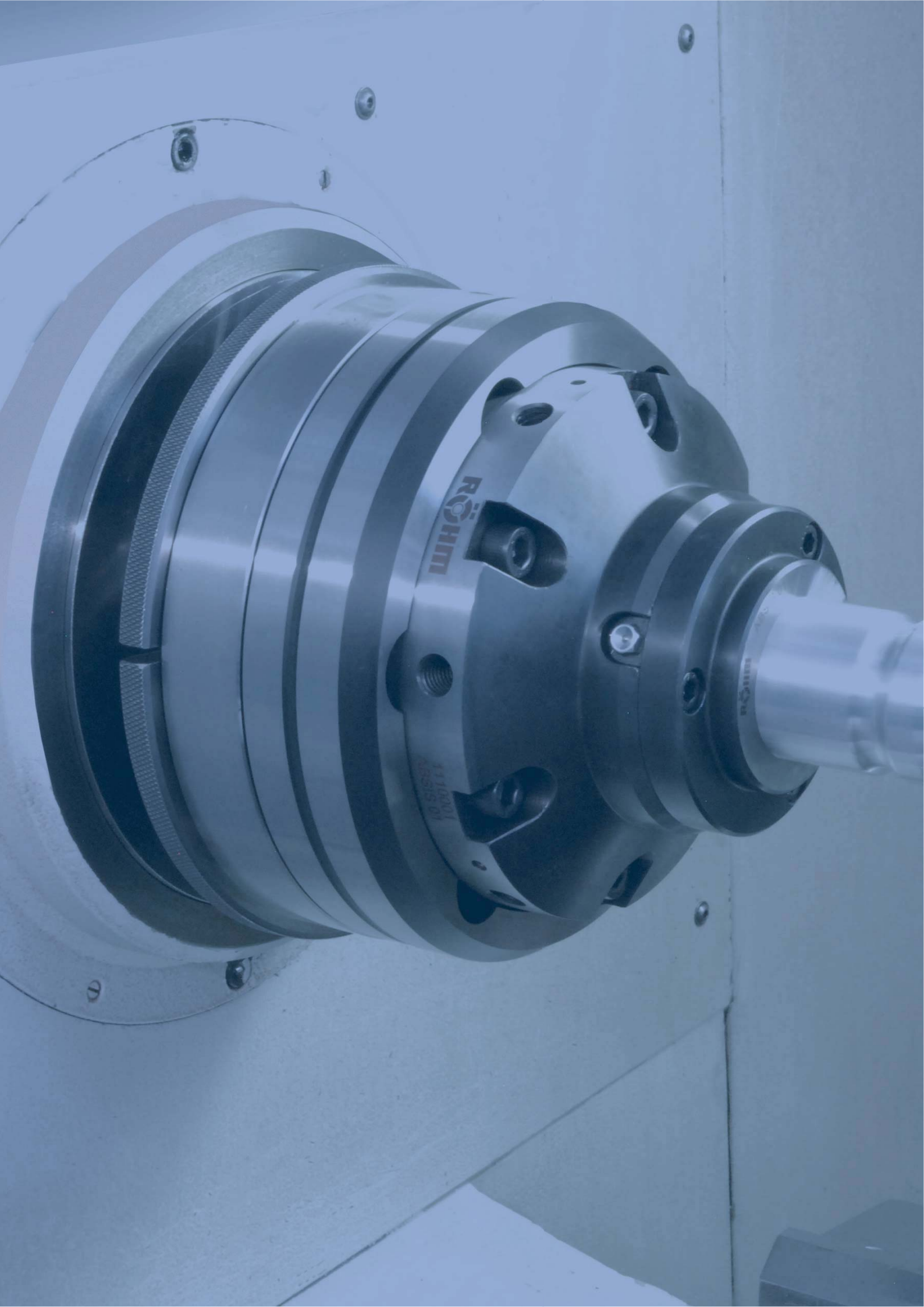


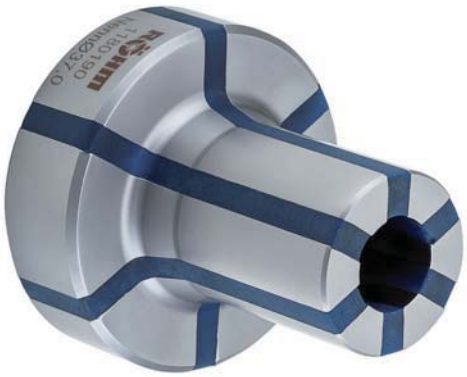
MANDRELS
COLLET CHUCKS

EDITION 8

RÖHM
driven by technology


RÖHM

INNOVATIVE VULCANISATE IN THE SEGMENT CLAMPING SLEEVE



- Segment clamping sleeve with innovative vulcanisate for great elongation, longest service life and vibration dampening
- Hardened and ground steel segments for high resistance to wear

Video ABSIS

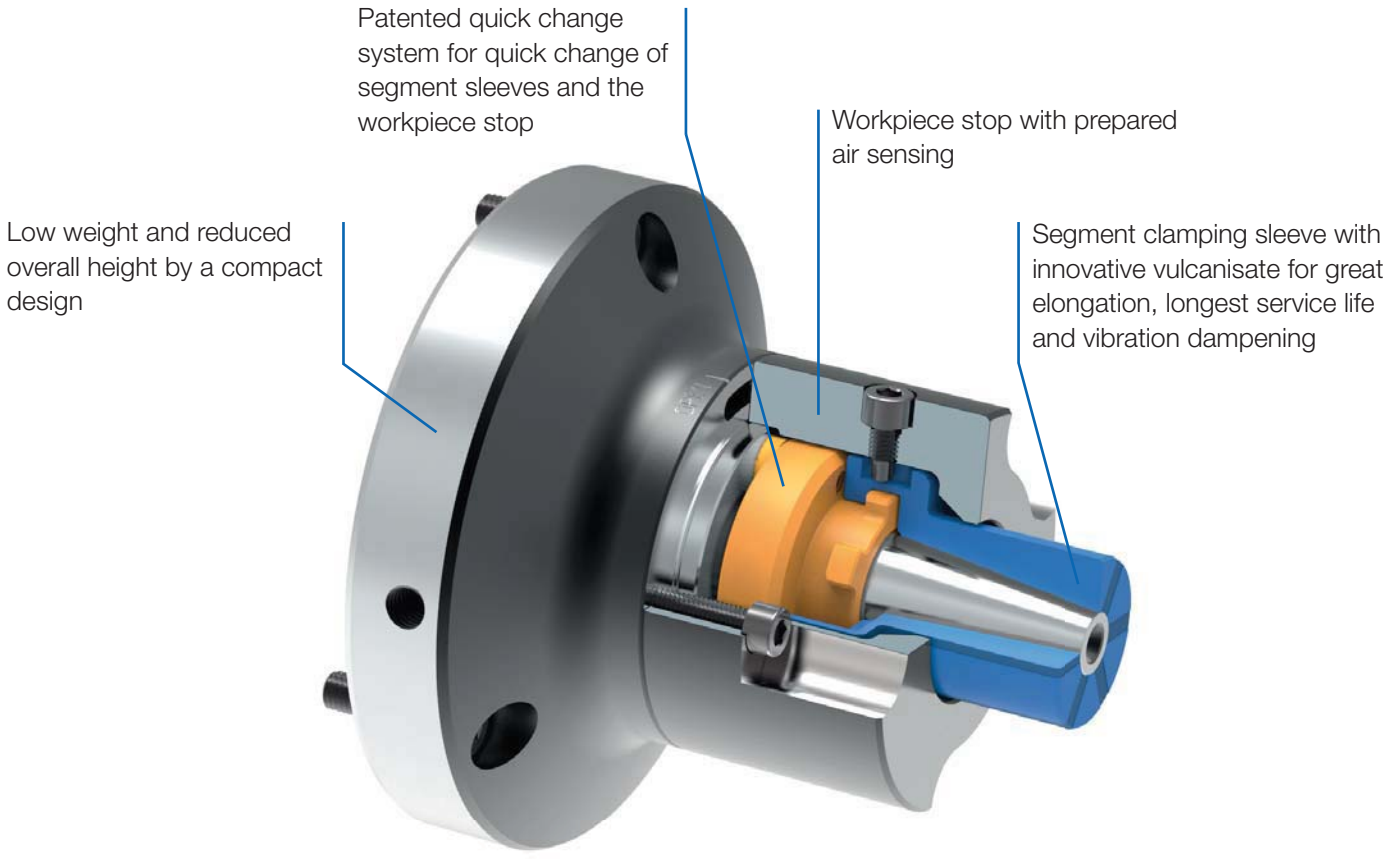
Video AGILIS

SEGMENT CLAMPING MANDREL

Modern manufacturing technology can hardly do without the use of segment clamping mandrels. In the fields of precision machining, turning, grinding, gear cutting and checking, segment clamping mandrels assume important tasks that are associated with challenging conditions. The innovative rubber segments enable a great elongation of the clamping sleeve to 1.2 mm.

ADVANTAGES AT A GLANCE

- Short tooling and non-productive times thanks to the great elongation of the clamping sleeve up to 1.2 mm
- Vibration dampening and long service life thanks to innovative vulcanisate of the clamping sleeves
- Fast replacement of the clamping mandrel thanks to the patented bayonet quick change system



ABSIS - for long clamping lengths, with axial tightening

APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring.
Ideal for clamping in through holes.

TYPE

Force-actuated.

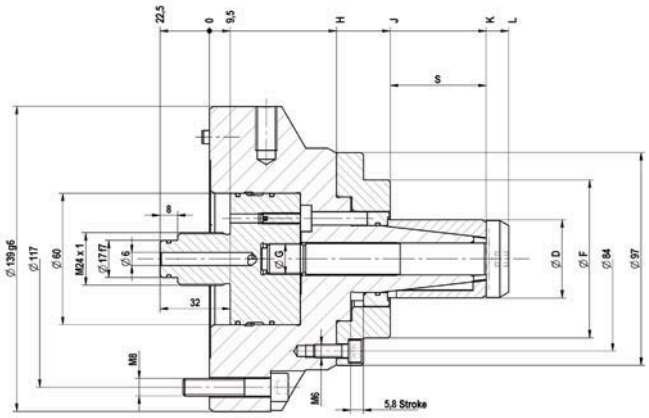
CUSTOMER BENEFITS

- Short setup and non-productive times thanks to great expansion of the segment sleeves
- Vibration damping due to high vulcanized rubber component of the clamping sleeves
- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- Fast change of segment sleeves thanks to central clamping screw
- High concentricity, axial run-out and repeatability

TECHNICAL FEATURES

- Manual lubrication
- Air sensing prepared

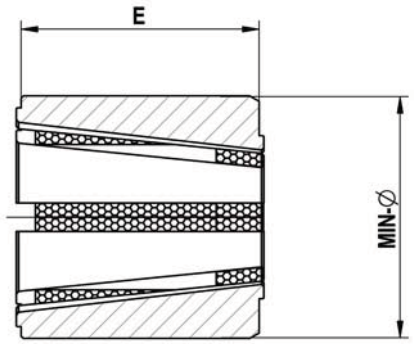
ABSIS = in Latin: segment



C 18
ABSIS segment clamping mandrel, **power-operated with flanged seat,** for internal clamping
Consisting of basic mandrel, adapter, ejector ring, locking belt

	ABSIS 00	ABSIS 01	ABSIS 02	ABSIS 03	ABSIS 04
Segment clamping mandrel	**1110000**	**1110001**	**1110002**	**1110003**	**1110004**
Basic mandrel	**1110100**	**1110101**	**1110102**	**1110103**	**1110104**
Adapter power-operated	**1110040**	**1110041**	**1110042**	**1110043**	**1110044**
Ejector ring	**1110020**	**1110021**	**1110022**	**1110023**	**1110024**
Locking bolt	**1110060**	**1110061**	**1110062**	**1110063**	**1110064**
F max, in kN	7	10	20	25	30
Max, total clamping force approx, kN	32	46	92	115	138
D Min-Ø unclamped from mm	19,7	25,7	35,7	50,7	72,7
D Min-Ø unclamped to mm	27,7	38,7	54,7	81,7	105,7
Clamping-Ø max, mm	29	40	56	83	107
S mm	23	27	44	50	60
Ø F mm	58	58	72	90	120
Ø G	M6x0,75	M10x1	M14x1	M18x1	M20x1
H mm	55	55	58	58,5	60
J mm	75	75	82,5	84,5	86
K mm	98	102	126,3	134,5	146
L mm	103,5	108,5	136,5	146,5	160

Accessories ABSIS



C 18

Segment clamping sleeve - standard design

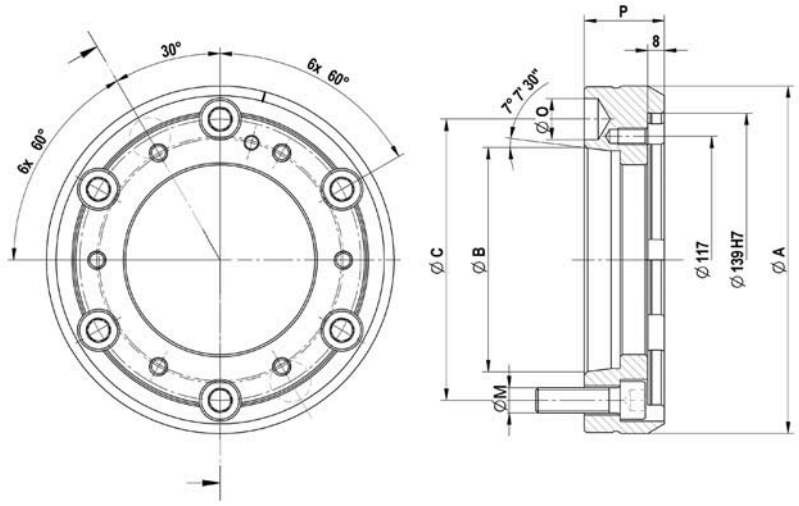
	ABSIS 00	ABSIS 01	ABSIS 02	ABSIS 03	ABSIS 04
Expansion in Ø mm	1,2	1,2	1,2	1,2	1,2
Total length E mm	23	27	44	50	60
Min-Ø mm	19,7	25,7	35,7	50,7	72,7
Segment sleeve	**1111400**	**1111409**	**1111423**	**1111443**	**1111475**
Work stop	1110070	1110071	1110072	1110073	1110074
Min-Ø mm	20,7	26,7	36,7	51,7	73,7
Segment sleeve	**1111401**	**1111410**	**1111424**	**1111444**	**1111476**
Work stop	1110070	1110071	1110072	1110073	1110074
Min-Ø mm	21,7	27,7	37,7	52,7	74,7
Segment sleeve	**1111402**	**1111411**	**1111425**	**1111445**	**1111477** ▲
Work stop	1110070	1110071	1110072	1123341	1123372
Min-Ø mm	22,7	28,7	38,7	53,7	75,7
Segment sleeve	**1111403**	**1111412**	**1111426**	**1111446**	**1111478** ▲
Work stop	1110070	1110071	1110072	1123342	1123373
Min-Ø mm	23,7	29,7	39,7	54,7	76,7
Segment sleeve	**1111404**	**1111413**	**1111427**	**1111447**	**1111479** ▲
Work stop	1110070	1110071	1110072	1123343	1123374
Min-Ø mm	24,7	30,7	40,7	55,7	77,7
Segment sleeve	**1111405**	**1111414**	**1111428**	**1111448**	**1111480** ▲
Work stop	1110070	1110071	1110072	1123344	1123375
Min-Ø mm	25,7	31,7	41,7	56,7	78,7
Segment sleeve	**1111406**	**1111415**	**1111429**	**1111449**	**1111481**
Work stop	1110070	1110071	1110072	1123345	1123376
Min-Ø mm	26,7	32,7	42,7	57,7	79,7
Segment sleeve	**1111407**	**1111416**	**1111430**	**1111450**	**1111482** ▲
Work stop	1123305	1110071	1123327	1123346	1123377
Min-Ø mm	27,7	33,7	43,7	58,7	80,7
Segment sleeve	**1111408**	**1111417**	**1111431**	**1111451**	**1111483** ▲
Work stop	1123306	1123315	1123328	1123347	1123378
Min-Ø mm		34,7	44,7	59,7	81,7
Segment sleeve		**1111418**	**1111432**	**1111452**	**1111484** ▲
Work stop		1123316	1123329	1123348	1123379
Min-Ø mm		35,7	45,7	60,7	82,7
Segment sleeve		**1111419**	**1111433**	**1111453**	**1111485** ▲
Work stop		1123317	1123330	1123349	1123380
Min-Ø mm		36,7	46,7	61,7	83,7
Segment sleeve		**1111420**	**1111434**	**1111454**	**1111486**
Work stop		1123318	1123331	1123350	1123381
Min-Ø mm		37,7	47,7	62,7	84,7
Segment sleeve		**1111421**	**1111435**	**1111455**	**1111487** ▲
Work stop		1123319	1123332	1123351	1123382
Min-Ø mm		38,7	48,7	63,7	85,7
Segment sleeve		**1111422**	**1111436**	**1111456**	**1111488**
Work stop		1123320	1123333	1123352	1123383
Min-Ø mm			49,7	64,7	86,7
Segment sleeve			**1111437**	**1111457**	**1111489** ▲
Work stop			1123334	1123353	1123384
Min-Ø mm			50,7	65,7	87,7
Segment sleeve			**1111438**	**1111458**	**1111490** ▲
Work stop			1123335	1123354	1123385
Min-Ø mm			51,7	66,7	88,7
Segment sleeve			**1111439**	**1111459**	**1111491**
Work stop			1123336	1123355	1123386

Accessories ABSIS

C 18
Segment clamping sleeve - standard design

	ABSIS 00	ABSIS 01	ABSIS 02	ABSIS 03	ABSIS 04
Expansion in Ø mm	1,2	1,2	1,2	1,2	1,2
Total length E mm	23	27	44	50	60
Min-Ø mm			52,7	67,7	89,7
Segment sleeve			**1111440**	**1111460**	**1111492**
Work stop			1123337	1123356	1123387
Min-Ø mm			53,7	68,7	90,7
Segment sleeve			**1111441**	**1111461**	**1111493**
Work stop			1123338	1123357	1123388
Min-Ø mm			54,7	69,7	91,7
Segment sleeve			**1111442**	**1111462**	**1111494**
Work stop			1123339	1123358	1123389
Min-Ø mm				70,7	92,7
Segment sleeve				**1111463**	**1111495**
Work stop				1123359	1123390
Min-Ø mm				71,7	93,7
Segment sleeve				**1111464**	**1111496**
Work stop				1123360	1123391
Min-Ø mm				72,7	94,7
Segment sleeve				**1111465**	**1111497**
Work stop				1123361	1123392
Min-Ø mm				73,7	95,7
Segment sleeve				**1111466**	**1111498** ▲
Work stop				1123362	1123393
Min-Ø mm				74,7	96,7
Segment sleeve				**1111467**	**1111499**
Work stop				1123363	1123394
Min-Ø mm				75,7	97,7
Segment sleeve				**1111468**	**1111500**
Work stop				1123364	1123395
Min-Ø mm				76,7	98,7
Segment sleeve				**1111469**	**1111501**
Work stop				1123365	1123396
Min-Ø mm				77,7	99,7
Segment sleeve				**1111470**	**1111502**
Work stop				1123366	1123397
Min-Ø mm				78,7	100,7
Segment sleeve				**1111471**	**1111503**
Work stop				1123367	1123398
Min-Ø mm				79,7	101,7
Segment sleeve				**1111472**	**1111504** ▲
Work stop				1123368	1123399
Min-Ø mm				80,7	102,7
Segment sleeve				**1111473**	**1111505** ▲
Work stop				1123369	1123400
Min-Ø mm				81,7	103,7
Segment sleeve				**1111474**	**1111506** ▲
Work stop				1123370	1123401
Min-Ø mm					104,7
Segment sleeve					**1111507** ▲
Work stop					1123402
Min-Ø mm					105,7
Segment sleeve					**1111508** ▲
Work stop					1123403

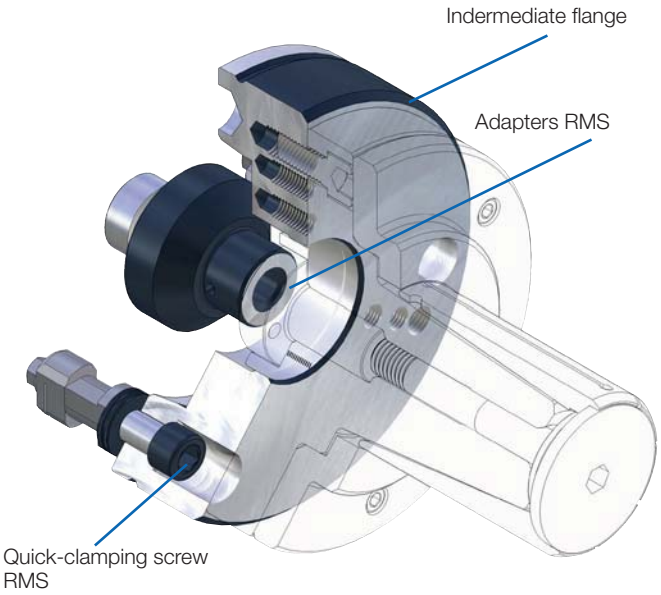
Accessories ABSIS



C 18
Intermediate flange ISO 702-1 (DIN 55028), for size 00-04

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	**1110005**	**1110006**	**1110008**	**1110011 ▲**
Ø A mm	165	170	220	282
Ø B mm	82,563	106,375	139,719	196,869
Ø C mm	104,8	133,4	171,4	235
Thread-Ø M	M10	M12	M16	M20
Ø O mm	16,3	19,45	24,2	29,4
P mm	36	38	45	45

Accessories ABSIS



APPLICATION

For manual clamping device exchange in a minimum of time.

TYPE

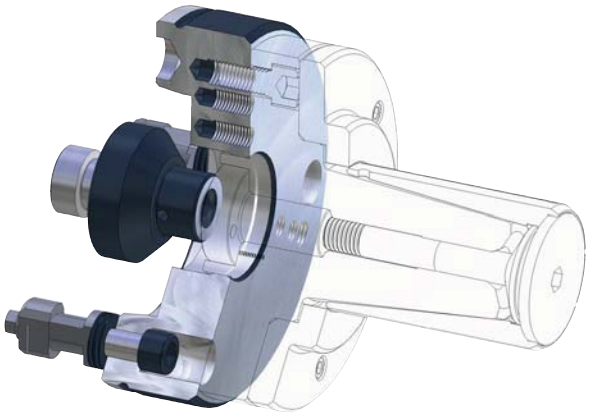
Manual quick-change system for clamping devices.
Fits for ABSIS (269-00) and AGILIS (296-00).
Central lubrication and/or air sensing control possible.

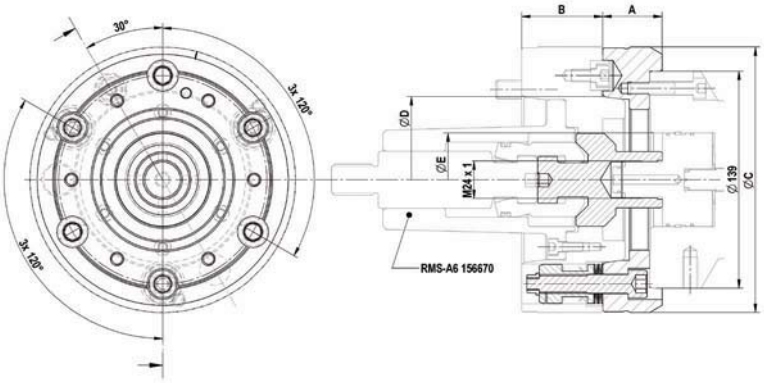
CUSTOMER BENEFITS

- Manual clamping devices change in about 30 seconds
- High change precision within 0.005 mm
- Quick change of different clamping devices with short time, similar to the automatic or semiautometic clamping devices changing systems

TECHNICAL FEATURES

- Quick-change system suitable due to recording RMS see quick-change system RMS (Product Group 6)
- Corresponds to the guidelines of the Employer's Liability Insurance Association in combination with ROHM safety clamping cylinder OVS and LVS

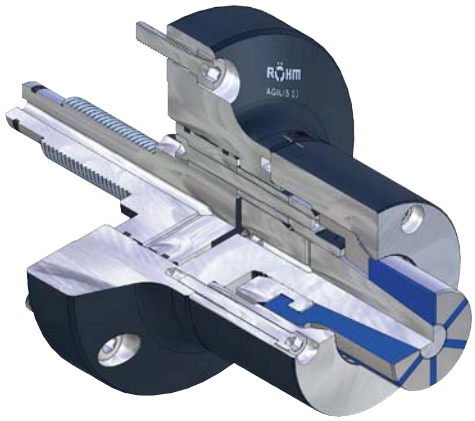




C18
RMS quick-change system, hand-operated for clamping devices

	KK 06	KK 08
RMS - complete (flange incl. quick-clamping screw)	**1160028 ▲**	**1160029 ▲**
Adapters RMS	**1183312 ▲**	**1183313 ▲**
A	38	45
Ø B	170	220
Ø C	133,4	171,4
Ø D	106,375	139,719
Ø E mm	M8	M8
Ø F mm	139 H7	139 H7

AGILIS - for short clamping lengths, with axial tightening



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring.
Suitable for short clamping lengths and very small clamping diameters starting from 10 mm.

TYPE

Force-actuated.

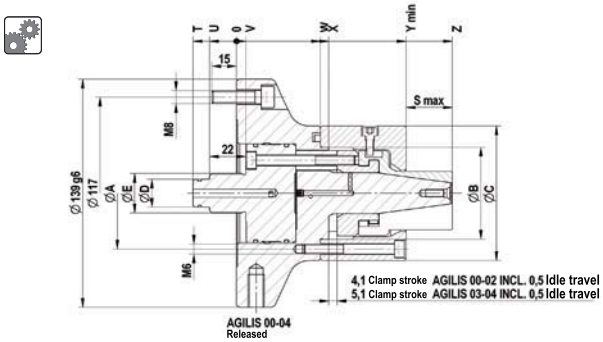
CUSTOMER BENEFITS

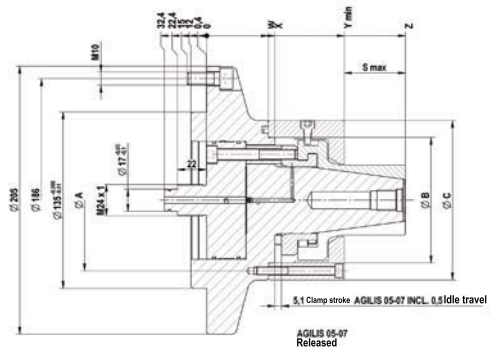
- Short setup and non-productive times thanks to great expansion of the segment sleeves
- Vibration damping due to high vulcanized rubber component of the clamping sleeves
- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- Fast change thanks to bayonet catch
- High concentricity, axial run-out and repeatability

TECHNICAL FEATURES

- Manual lubrication
- Air sensing prepared

AGILIS = in Latin: movable

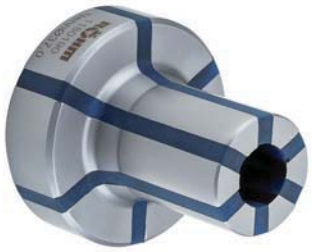


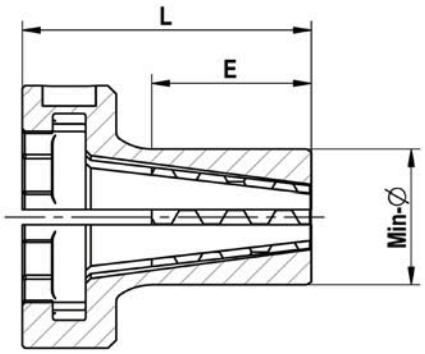


C 18
AGILIS segment clamping mandrel, **power-operated with flanged seat,** for internal clamping

	AGILIS 00	AGILIS 01	AGILIS 02	AGILIS 03	AGILIS 04	AGILIS 05	AGILIS 06	AGILIS 07
Segment clamping mandrel	**1180000**	**1180001**	**1180002**	**1180003**	**1180004**	**1180005**	**1180006 ▲**	**1180007 ▲**
Basic mandrel	**1180010**	**1180011**	**1180012**	**1180013**	**1180014**	**1180015**	**1180016 ▲**	**1180017 ▲**
Adapter power-operated	**1180030**	**1180030**	**1180032**	**1180032**	**1180034**	**1180035**	**1180036 ▲**	**1180037 ▲**
Bolt spacer	**1180060**	**1180060**	**1180062**	**1180063**	**1180064**	**1180065**	**1180066 ▲**	**1180066 ▲**
Retaining ring	**1180050**	**1180050**	**1180052**	**1180052**	**1180054**	**1180055**	**1180056 ▲**	**1180057 ▲**
F max, in kN	5	7,5	15	20	25	30	35	35
Max, total clamping force approx, kN	26	39	79	85	106	127	149	149
Min-Ø unclamped from mm	9,7	13,7	18,7	26,7	36,7	53,7	71,7	94,7
Min-Ø unclamped to mm	15,7	24,7	34,7	44,7	64,7	84,7	104,7	129,7
Pitch diameter A mm	54	54	69	69	88	108	127	152
Guide diameter B mm	42	42	56	56	75	96	114	135
Ø C mm	68	68	82	82	101	122	140	169
Ø D mm	12	12	17	17	17			
Ø E mm	M 16	M 16	M 24x1	M 24x1	M 24x1			
S max, mm	16,8	18,8	23,8	28,1	42,1	46,1	57,1	67,1
T mm	27,7	27,7	25,4	26,4	26,4			
U mm	17,7	17,7	15,4	16,4	16,4			
V mm	4,3	4,3	6,6	5,6	5,6			
W mm	41,5	41,5	52	51	52	47	49	49
X mm	46,5	46,5	57,2	56	57	52	54	54
Y min, mm	80	80	103	103	108	105	109	109
Z mm	96,8	98,8	126,8	131,1	150,1	151,1	166,1	176,1

Accessories AGILIS





C18
Segment clamping sleeves AGILIS

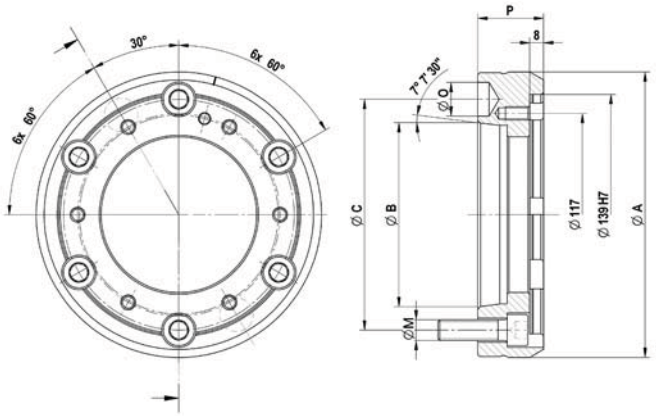
	AGILIS 00	AGILIS 01	AGILIS 02	AGILIS 03	AGILIS 04	AGILIS 05	AGILIS 06	AGILIS 07
Expansion in Ø mm	0,6	0,6	0,6	1,2	1,2	1,2	1,2	1,2
Total length L	38	40	52,5	57	76	82	95	105
Min-Ø mm	9,7	13,7	18,7	26,7	36,7	53,7	71,7	94,7
Segment sleeve	**1180100**	**1180120**	**1180140**	**1180170**	**1180190**	**1180220**	**1180250** ▲	**1180290** ▲
Work stop	1180400 ▲	1180420 ▲	1180440 ▲	1180470 ▲	1180490 ▲	1180520 ▲	1180550 ▲	1180590 ▲
Min-Ø mm	10,2	14,2	19,2	27,7	37,7	54,7	72,7	95,7
Segment sleeve	**1180101**	**1180121**	**1180141**	**1180171**	**1180191**	**1180221**	**1180251** ▲	**1180291** ▲
Work stop	1180401 ▲	1180421 ▲	1180441 ▲	1180471 ▲	1180491 ▲	1180521 ▲	1180551 ▲	1180591 ▲
Min-Ø mm	10,7	14,7	19,7	28,7	38,7	55,7	73,7	96,7
Segment sleeve	**1180102**	**1180122**	**1180142**	**1180172**	**1180192**	**1180222**	**1180252** ▲	**1180292** ▲
Work stop	1180402 ▲	1180422 ▲	1180442 ▲	1180472 ▲	1180492 ▲	1180522 ▲	1180552 ▲	1180592 ▲
Min-Ø mm	11,2	15,2	20,2	29,7	39,7	56,7	74,7	97,7
Segment sleeve	**1180103**	**1180123**	**1180143**	**1180173**	**1180193**	**1180223**	**1180253** ▲	**1180293** ▲
Work stop	1180403 ▲	1180423 ▲	1180443 ▲	1180473 ▲	1180493 ▲	1180523 ▲	1180553 ▲	1180593 ▲
Min-Ø mm	11,7	15,7	20,7	30,7	40,7	57,7	75,7	98,7
Segment sleeve	**1180104**	**1180124**	**1180144**	**1180174**	**1180194**	**1180224**	**1180254** ▲	**1180294** ▲
Work stop	1180404 ▲	1180424 ▲	1180444 ▲	1180474 ▲	1180494 ▲	1180524 ▲	1180554 ▲	1180594 ▲
Min-Ø mm	12,2	16,2	21,2	31,7	41,7	58,7	76,7	99,7
Segment sleeve	**1180105**	**1180125**	**1180145**	**1180175**	**1180195**	**1180225**	**1180255** ▲	**1180295**
Work stop	1180405 ▲	1180425 ▲	1180445 ▲	1180475 ▲	1180495 ▲	1180525 ▲	1180555 ▲	1180595 ▲
Min-Ø mm	12,7	16,7	21,7	32,7	42,7	59,7	77,7	100,7
Segment sleeve	**1180106**	**1180126**	**1180146**	**1180176**	**1180196**	**1180226**	**1180256** ▲	**1180296** ▲
Work stop	1180406 ▲	1180426 ▲	1180446 ▲	1180476 ▲	1180496 ▲	1180526 ▲	1180556 ▲	1180596 ▲
Min-Ø mm	13,2	17,2	22,2	33,7	43,7	60,7	78,7	101,7
Segment sleeve	**1180107**	**1180127**	**1180147**	**1180177**	**1180197**	**1180227**	**1180257** ▲	**1180297** ▲
Work stop	1180407 ▲	1180427 ▲	1180447 ▲	1180477 ▲	1180497 ▲	1180527 ▲	1180557 ▲	1180597 ▲
Min-Ø mm	13,7	17,7	22,7	34,7	44,7	61,7	79,7	102,7
Segment sleeve	**1180108**	**1180128**	**1180148**	**1180178**	**1180198**	**1180228**	**1180258** ▲	**1180298** ▲
Work stop	1180408 ▲	1180428 ▲	1180448 ▲	1180478 ▲	1180498 ▲	1180528 ▲	1180558 ▲	1180598 ▲
Min-Ø mm	14,2	18,2	23,2	35,7	45,7	62,7	80,7	103,7
Segment sleeve	**1180109**	**1180129**	**1180149**	**1180179**	**1180199**	**1180229**	**1180259** ▲	**1180299** ▲
Work stop	1180409 ▲	1180429 ▲	1180449 ▲	1180479 ▲	1180499 ▲	1180529 ▲	1180559 ▲	1180599 ▲
Min-Ø mm	14,7	18,7	23,7	36,7	46,7	63,7	81,7	104,7
Segment sleeve	**1180110**	**1180130**	**1180150**	**1180180**	**1180200**	**1180230**	**1180260** ▲	**1180300** ▲
Work stop	1180410 ▲	1180430 ▲	1180450 ▲	1180480 ▲	1180500 ▲	1180530 ▲	1180560 ▲	1180600 ▲
Min-Ø mm	15,2	19,2	24,2	37,7	47,7	64,7	82,7	105,7
Segment sleeve	**1180111**	**1180131**	**1180151**	**1180181**	**1180201**	**1180231**	**1180261** ▲	**1180301** ▲
Work stop	1180411 ▲	1180431 ▲	1180451 ▲	1180481 ▲	1180501 ▲	1180531 ▲	1180561 ▲	1180601 ▲
Min-Ø mm	15,7	19,7	24,7	38,7	48,7	65,7	83,7	106,7
Segment sleeve	**1180112**	**1180132**	**1180152**	**1180182**	**1180202**	**1180232**	**1180262** ▲	**1180302** ▲
Work stop	1180412 ▲	1180432 ▲	1180452 ▲	1180482 ▲	1180502 ▲	1180532 ▲	1180562 ▲	1180602 ▲
Min-Ø mm		20,2	25,2	39,7	49,7	66,7	84,7	107,7
Segment sleeve		**1180133**	**1180153**	**1180183**	**1180203**	**1180233**	**1180263** ▲	**1180303** ▲
Work stop		1180433 ▲	1180453 ▲	1180483 ▲	1180503 ▲	1180533 ▲	1180563 ▲	1180603 ▲
Min-Ø mm		20,7	25,7	40,7	50,7	67,7	85,7	108,7
Segment sleeve		**1180134**	**1180154**	**1180184**	**1180204**	**1180234**	**1180264** ▲	**1180304** ▲
Work stop		1180434 ▲	1180454 ▲	1180484 ▲	1180504 ▲	1180534 ▲	1180564 ▲	1180604 ▲
Min-Ø mm		21,2	26,2	41,7	51,7	68,7	86,7	109,7
Segment sleeve		**1180135**	**1180155**	**1180185**	**1180205**	**1180235**	**1180265** ▲	**1180305** ▲
Work stop		1180435 ▲	1180455 ▲	1180485 ▲	1180505 ▲	1180535 ▲	1180565 ▲	1180605 ▲

Accessories AGILIS

C18
Segment clamping sleeves AGILIS

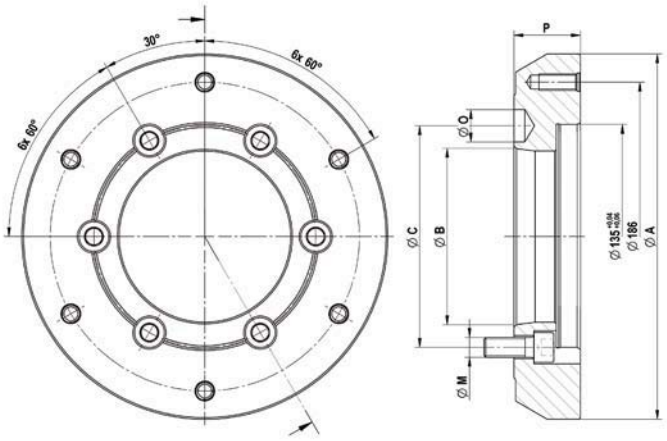
	AGILIS 00	AGILIS 01	AGILIS 02	AGILIS 03	AGILIS 04	AGILIS 05	AGILIS 06	AGILIS 07
Expansion in Ø mm	0,6	0,6	0,6	1,2	1,2	1,2	1,2	1,2
Total length L	38	40	52,5	57	76	82	95	105
Min-Ø mm		21,7	26,7	42,7	52,7	69,7	87,7	110,7
Segment sleeve		**1180136**	**1180156**	**1180186**	**1180206**	**1180236**	**1180266** ▲	**1180306** ▲
Work stop		1180436 ▲	1180456 ▲	1180486 ▲	1180506 ▲	1180536 ▲	1180566 ▲	1180606 ▲
Min-Ø mm		22,2	27,2	43,7	53,7	70,7	88,7	111,7
Segment sleeve		**1180137**	**1180157**	**1180187**	**1180207**	**1180237**	**1180267** ▲	**1180307** ▲
Work stop		1180437 ▲	1180457 ▲	1180487 ▲	1180507 ▲	1180537 ▲	1180567 ▲	1180607 ▲
Min-Ø mm		22,7	27,7	44,7	54,7	71,7	89,7	112,7
Segment sleeve		**1180138**	**1180158**	**1180188**	**1180208**	**1180238**	**1180268** ▲	**1180308** ▲
Work stop		1180438 ▲	1180458 ▲	1180488 ▲	1180508 ▲	1180538 ▲	1180568 ▲	1180608 ▲
Min-Ø mm		23,2	28,2		55,7	72,7	90,7	113,7
Segment sleeve		**1180139**	**1180159**		**1180209**	**1180239**	**1180269** ▲	**1180309** ▲
Work stop		1180439 ▲	1180459 ▲		1180509 ▲	1180539 ▲	1180569 ▲	1180609 ▲
Min-Ø mm		23,7	28,7		56,7	73,7	91,7	114,7
Segment sleeve		**1180350**	**1180160**		**1180210**	**1180240**	**1180270** ▲	**1180310** ▲
Work stop		1180630 ▲	1180460 ▲		1180510 ▲	1180540 ▲	1180570 ▲	1180610 ▲
Min-Ø mm		24,2	29,2		57,7	74,7	92,7	115,7
Segment sleeve		**1180351**	**1180161**		**1180211**	**1180241**	**1180271** ▲	**1180311** ▲
Work stop		1180631 ▲	1180461 ▲		1180511 ▲	1180541 ▲	1180571 ▲	1180611 ▲
Min-Ø mm		24,7	29,7		58,7	75,7	93,7	116,7
Segment sleeve		**1180352**	**1180162**		**1180212**	**1180242**	**1180272** ▲	**1180312** ▲
Work stop		1180632 ▲	1180462 ▲		1180512 ▲	1180542 ▲	1180572 ▲	1180612 ▲
Min-Ø mm			30,2		59,7	76,7	94,7	117,7
Segment sleeve			**1180163**		**1180213**	**1180243**	**1180273** ▲	**1180313** ▲
Work stop			1180463 ▲		1180513 ▲	1180543 ▲	1180573 ▲	1180613 ▲
Min-Ø mm			30,7		60,7	77,7	95,7	118,7
Segment sleeve			**1180164**		**1180214**	**1180244**	**1180274** ▲	**1180314** ▲
Work stop			1180464 ▲		1180514 ▲	1180544 ▲	1180574 ▲	1180614 ▲
Min-Ø mm			31,2		61,7	78,7	96,7	119,7
Segment sleeve			**1180165**		**1180215**	**1180245**	**1180275** ▲	**1180315**
Work stop			1180465 ▲		1180515 ▲	1180545 ▲	1180575 ▲	1180615 ▲
Min-Ø mm			31,7		62,7	79,7	97,7	120,7
Segment sleeve			**1180166**		**1180216**	**1180246**	**1180276** ▲	**1180316** ▲
Work stop			1180466 ▲		1180516 ▲	1180546 ▲	1180576 ▲	1180616 ▲
Min-Ø mm			32,2		63,7	80,7	98,7	121,7
Segment sleeve			**1180167**		**1180217**	**1180247**	**1180277** ▲	**1180317** ▲
Work stop			1180467 ▲		1180517 ▲	1180547 ▲	1180577 ▲	1180617 ▲
Min-Ø mm			32,7		64,7	81,7	99,7	122,7
Segment sleeve			**1180168**		**1180218**	**1180248**	**1180278** ▲	**1180318** ▲
Work stop			1180468 ▲		1180518 ▲	1180548 ▲	1180578 ▲	1180618 ▲
Min-Ø mm			33,2			82,7	100,7	123,7
Segment sleeve			**1180169**			**1180249**	**1180279** ▲	**1180319** ▲
Work stop			1180469 ▲			1180549 ▲	1180579 ▲	1180619 ▲
Min-Ø mm			33,7			83,7	101,7	124,7
Segment sleeve			**1180360**			**1180370**	**1180280** ▲	**1180320** ▲
Work stop			1180640 ▲			1180650 ▲	1180580 ▲	1180620 ▲
Min-Ø mm			34,2			84,7	102,7	125,7
Segment sleeve			**1180361**			**1180371**	**1180281** ▲	**1180321** ▲
Work stop			1180641 ▲			1180651 ▲	1180581 ▲	1180621 ▲
Min-Ø mm			34,7				103,7	126,7
Segment sleeve			**1180362**				**1180282** ▲	**1180322** ▲
Work stop			1180642 ▲				1180582 ▲	1180622 ▲
Min-Ø mm							104,7	127,7
Segment sleeve							**1180283** ▲	**1180323** ▲
Work stop							1180583 ▲	1180623 ▲
Min-Ø mm								128,7
Segment sleeve								**1180324** ▲
Work stop								1180624 ▲
Min-Ø mm								129,7
Segment sleeve								**1180325** ▲
Work stop								1180625 ▲

Accessories AGILIS



C 18
Intermediate flange ISO 702-1 (DIN 55028), for size 00-04

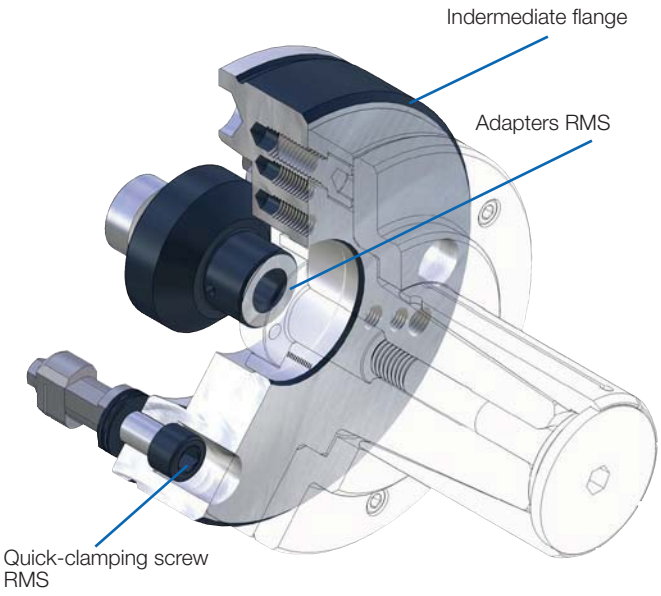
	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	**1110005**	**1110006**	**1110008**	**1110011 ▲**
Ø A mm	165	170	220	282
Ø B	82,563	106,375	139,719	196,869
Ø C mm	104,8	133,4	171,4	235
Thread-Ø M	M10	M12	M16	M20
Ø O mm	16,3	19,45	24,2	29,4
P mm	36	38	45	45



C 18
Intermediate flange ISO 702-1 (DIN 55028)

	Nr. 5 (A5)	Nr. 6 (A6)	Nr. 8 (A8)
Intermediate flange	**1072115 ▲**	**1072117**	**1072119**
For	KZF-S 80/AGILIS 05-07	KZF-S 120/AGILIS 05-07	KZF-S 120/AGILIS 05-07
Short-taper-Ø B	82,563	106,375	139,719
Short-taper pitch circle Ø C	104,8	133,4	171,4
Flange outer-Ø A	220	220	220
Ø D	135	135	135
Ø F mm	186	186	186
Ø O mm	16,3	19,45	24,2
Thread-Ø M	M10	M12	M16
Total length flange P	40	40	40

Accessories AGILIS



APPLICATION

For manual clamping device exchange in a minimum of time.

TYPE

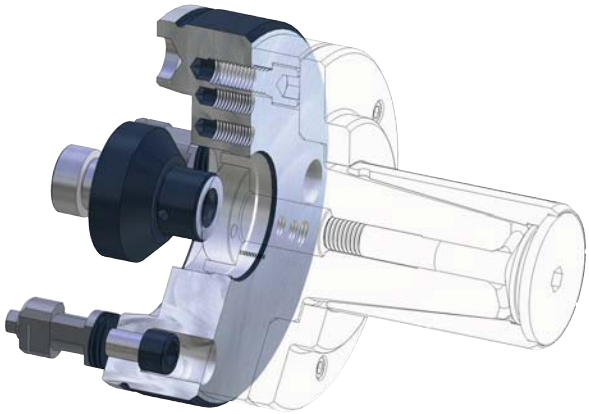
Manual quick-change system for clamping devices.
Fits for ABSIS (269-00) and AGILIS (296-00).
Central lubrication and/or air sensing control possible.

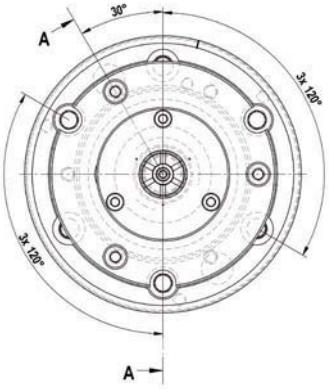
CUSTOMER BENEFITS

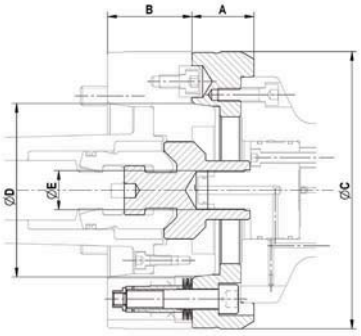
- Manual clamping devices change in about 30 seconds
- High change precision within 0.005 mm
- Quick change of different clamping devices with short time, similar to the automatic or semiautomatic clamping devices changing systems

TECHNICAL FEATURES

- Quick-change system suitable due to recording RMS see quick-change system RMS (Product Group 6)
- Corresponds to the guidelines of the Employer's Liability Insurance Association in combination with ROHM safety clamping cylinder OVS and LVS





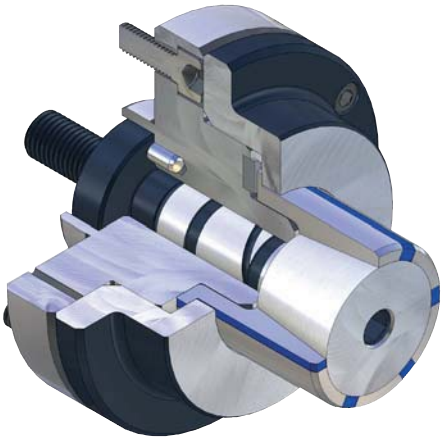


C18
RMS quick-change system, hand-operated for clamping devices

	A 06	A 08
For	AGILIS 00-04 296-00	AGILIS 00-04 296-00
RMS - complete (flange incl. quick-clamping screw)	**1180340 ▲**	**1180342 ▲**
Adapters RMS	**1183314 ▲**	**1183314 ▲**
A	38	45
Ø B	170	215
Ø C	133,4	171,4
Ø D	106,375	139,719
Ø E mm	M12	M16
Ø F mm	139 H7	139 H7

Matching intermediate pieces RMS KK6 and RMS KK8 can be found directly in the product table of the segment clamping mandrel AGILIS

KFR-SE - without axial tightening, force-actuated



APPLICATION

Internal clamping of round workpieces. Turning, grinding and toothing operations, as well as for balancing and measuring.

TYPE

Force-actuated. Ideal for short clamping lengths / workpieces.

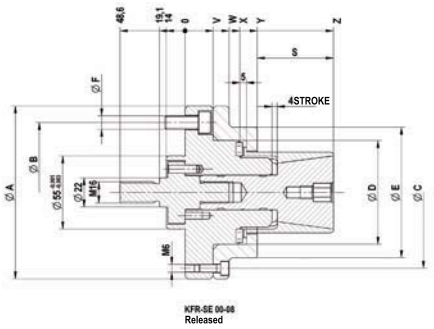
CUSTOMER BENEFITS

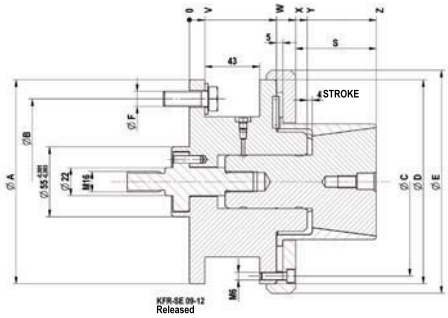
- Short setup and non-productive times thanks to great expansion of the segment sleeves
- Vibration damping due to high vulcanized rubber component of the clamping sleeves
- No workpiece tension thanks to def. axial tension against the workpiece stop
- High concentricity, axial run-out and repeatability

TECHNICAL FEATURES

- Integrated lubrication
- Air sensing prepared

KFR-SE = force-actuated, flange, R-type, segment sleeve





C18
KFR-SE segment clamping mandrel, **power-operated with flanged seat,** for internal clamping
Consisting of basic body, clamping taper, intermediate piece, nut

	KFR 00	KFR 01	KFR 02	KFR 03	KFR 04	KFR 05	KFR 06	KFR 07	KFR 08	KFR 09	KFR 10	KFR 11	KFR 12
Segment clamping mandrel	**1171410**	**1171411**	**1171412**	**1171413**	**1171414**	**1171415**	**893966**	**893967**	**893968**	**893969**	**893970**	**893971 ▲**	**893972 ▲**
Base bolt	**893800**	**893801**	**893802**	**893803**	**893804**	**893805**	**893806**	**893807**	**893807**	**893809**	**893809**	**893809**	**893809**
Clamping taper	**1171436**	**1171437**	**1171438**	**1171439**	**1171440**	**1171441**	**650346**	**650347**	**650348**	**650349**	**650350**	**650351 ▲**	**650352 ▲**
Adapter power-operated	**1199848**	**1199849**	**1199850**	**893819**	**893820**	**893820**	**893821**	**893822**	**893822**	**893822**	**893822**	**893822**	**893822**
Nut	**893814**	**893814**	**893814**										
F max, in kN	4,65	13,1	19,5	24,4	26,8	33	33	33	33	33	33	33	33
Max, total clamping force approx, kN	20	56	83	104	114	140	140	140	140	140	140	140	140
Min-Ø unclamped from mm	14,2	19,7	24,7	35,7	40,7	50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7
Min-Ø unclamped to mm	19,7	24,7	35,7	40,7	50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7	130,7
Clamping-Ø max, mm	20,7	25,7	36,7	41,7	51,7	61,7	71,7	81,7	91,7	101,7	111,7	121,7	131,7
External-Ø A mm	100	100	100	100	130	130	130	160	160	160	160	160	160
Pitch diameter B mm	75	75	75	75	105	105	105	130	130	130	130	130	130
Guide diameter B mm							78	100	100	160	160	160	160
Pitch diameter C mm	85	85	85	85	114	114	114	145	145	148	148	148	148
Ø D mm	50	50	50	50	78	78	78	100	100	160	160	160	160
Ø E mm	70	70	70	70	98	98	98	130	130	175	175	175	175
Ø F mm	M10	M10	M10	M10	M10	M10	M10	M12	M12	M12	M12	M12	M12
Ø F mm							98	130	130	175	175	175	175
S mm	21	27	27	27	42	42	57	55	55	63	63	63	63
V mm	21	21	21	21	21	21	21	32	32	12	12	12	12
W mm	33	33	33	33	33	33	33	50	50	68	68	68	68
X mm	39	39	39	39	41	41	41	58	58	83	83	83	83
Y mm	50	52	52	52	54	54	54	73	73	92	92	92	92
Z mm	71	79	79	79	96	96	111	128	128	146	146	146	146

MFR-SE - without axial tightening, manually actuated

APPLICATION

Internal clamping of round workpieces. Turning, grinding and toothing operations, as well as for balancing and measuring.
Ideal for short clamping lengths / workpieces.

TYPE

Manually actuated.
With vulcanized claming sleeves / segment sleeves.

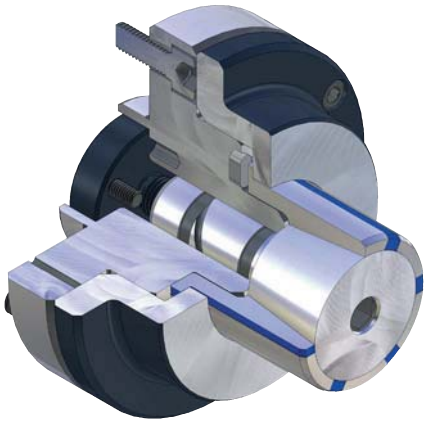
CUSTOMER BENEFITS

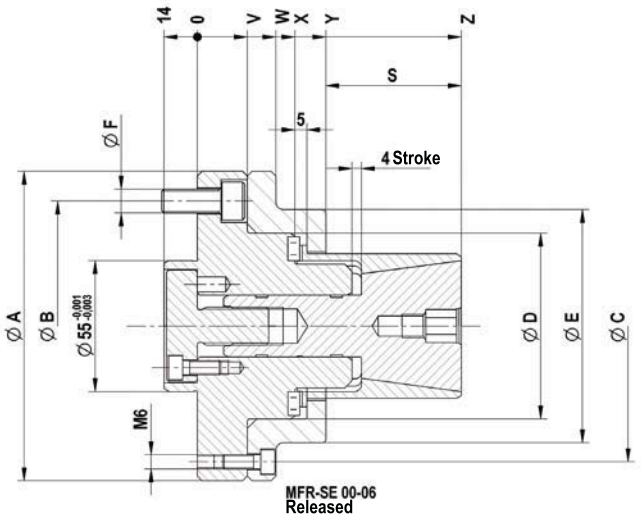
- No workpiece tension thanks to def. axial tension against the workpiece stop
- High concentricity, axial run-out and repeatability
- Low-maintenance

TECHNICAL FEATURES

- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared

MFR-SE = manually actuated, flange, R-type, segment sleeve

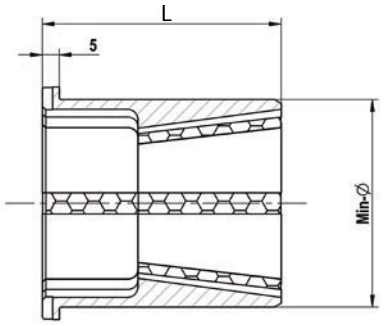




C18
MFR-SE segment clamping mandrel, **hand-operated with flanged seat,** for internal clamping
Consisting of basic body, clamping taper, intermediate piece

	MFR 00	MFR 01	MFR 02	MFR 03	MFR 04	MFR 05	MFR 06
Segment clamping mandrel	**1171423**	**1171424**	**1171425**	**1171426**	**1171427**	**1171428**	**1077706**
Base bolt	**893800**	**893801**	**893802**	**893803**	**893804**	**893805**	**893806**
Clamping taper	**1171436**	**1171437**	**1171438**	**1171439**	**1171440**	**1171441**	**650346**
Adapter hand-operated	**893823**	**893824**	**893825**	**893826**	**893827**	**893827**	**893828**
Md max, kN	4	5	20	40	55	60	85
Min-Ø unclamped from mm	14,7	19,7	24,7	35,7	40,7	50,7	60,7
Min-Ø unclamped to mm	19,7	24,7	35,7	40,7	50,7	60,7	70,7
Clamping-Ø max, mm	20,7	25,7	36,7	41,7	51,7	61,7	71,7
External-Ø A mm	100	100	100	100	130	130	130
Pitch diameter B mm	75	75	75	75	105	105	105
Guide diameter B mm							78
Pitch diameter C mm	85	85	85	85	114	114	114
Ø D mm	50	50	50	50	78	78	78
Ø E mm	70	70	70	70	98	98	98
Ø F mm	M10	M10	M10	M10	M10	M10	M10
Ø F mm							98
S mm	21	27	27	27	42	42	57
V mm	21	21	21	21	21	21	21
W mm	33	33	33	33	33	33	33
X mm	39	39	39	39	41	41	41
Y mm	50	52	52	52	54	54	54
Z mm	71	79	79	79	96	96	111

Accessories KFR-SE / MFR-SE



C18
Segment sleeve KFR-SE / MFR-SE

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1	1
Total length	32	40	40	40	55	55	70	70	70	78	78	78	78
Min-Ø mm	14,7	19,7	24,7	35,7	40,7	50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7
Segment sleeve	**1171000** ▲	**1171006** ▲	**1171012** ▲	**1171024** ▲	**1171030** ▲	**1171041** ▲	**1171052** ▲	**1171063** ▲	**1171074** ▲	**1171085** ▲	**1171096** ▲	**1171107** ▲	**1171118** ▲
Work stop	893830	893836	893842	893852	893857	893867	893878	893888	893897	893907	893917	893927	893937
Min-Ø mm	15,7	20,7	25,7	36,7	41,7	51,7	61,7	71,7	81,7	91,7	101,7	111,7	121,7
Segment sleeve	**1171001** ▲	**1171007** ▲	**1171013** ▲	**1171025** ▲	**1171031** ▲	**1171042** ▲	**1171053** ▲	**1171064** ▲	**1171075** ▲	**1171086** ▲	**1171097** ▲	**1171108** ▲	**1171119** ▲
Work stop	893831	893837	893842	893853	893858	893868	893879	893889	893898	893908	893918	893928	893938
Min-Ø mm	16,7	21,7	26,7	37,7	42,7	52,7	62,7	72,7	82,7	92,7	102,7	112,7	122,7
Segment sleeve	**1171002** ▲	**1171008** ▲	**1171014** ▲	**1171026** ▲	**1171032** ▲	**1171043** ▲	**1171054** ▲	**1171065** ▲	**1171076** ▲	**1171087** ▲	**1171098** ▲	**1171109** ▲	**1171120** ▲
Work stop	893832	893838	893843	893854	893859	893869	893880	893890	893899	893909	893919	893929	893939
Min-Ø mm	17,7	22,7	27,7	38,7	43,7	53,7	63,7	73,7	83,7	93,7	103,7	113,7	123,7
Segment sleeve	**1171003** ▲	**1171009** ▲	**1171015** ▲	**1171027** ▲	**1171033** ▲	**1171044** ▲	**1171055** ▲	**1171066** ▲	**1171077** ▲	**1171088** ▲	**1171099** ▲	**1171110** ▲	**1171121** ▲
Work stop	893833	893839	893844	893855	893860	893870	893881	893891	893900	893910	893920	893930	893940
Min-Ø mm	18,7	23,7	28,7	39,7	44,7	54,7	64,7	74,7	84,7	94,7	104,7	114,7	124,7
Segment sleeve	**1171004** ▲	**1171010** ▲	**1171016** ▲	**1171028** ▲	**1171034** ▲	**1171045** ▲	**1171056** ▲	**1171067** ▲	**1171078** ▲	**1171089** ▲	**1171100** ▲	**1171111** ▲	**1171122** ▲
Work stop	893834	893840	893845 ▲	893856	893861	893871	893882	893892	893901	893911	893921	893931	893941
Min-Ø mm	19,7	24,7	29,7	40,7	45,7	55,7	65,7	75,7	85,7	95,7	105,7	115,7	125,7
Segment sleeve	**1171005** ▲	**1171011** ▲	**1171017** ▲	**1171029** ▲	**1171035** ▲	**1171046** ▲	**1171057** ▲	**1171068** ▲	**1171079** ▲	**1171090** ▲	**1171101** ▲	**1171112** ▲	**1171123** ▲
Work stop	893835	893841	893846	893856	893862	893872	893883	893893	893902	893912	893922	893932	893942
Min-Ø mm			30,7		46,7	56,7	66,7	76,7	86,7	96,7	106,7	116,7	126,7
Segment sleeve			**1171018** ▲		**1171036** ▲	**1171047** ▲	**1171058** ▲	**1171069** ▲	**1171080** ▲	**1171091** ▲	**1171102** ▲	**1171113** ▲	**1171124** ▲
Work stop			893847		893863	893873	893884	893894	893903	893913	893923	893933	893943
Min-Ø mm			31,7		47,7	57,7	67,7	77,7	87,7	97,7	107,7	117,7	127,7
Segment sleeve			**1171019** ▲		**1171037** ▲	**1171048** ▲	**1171059** ▲	**1171070** ▲	**1171081** ▲	**1171092** ▲	**1171103** ▲	**1171114** ▲	**1171125** ▲
Work stop			893848		893864	893874	893885	893895	893904	893914	893924	893934	893944
Min-Ø mm			32,7		48,7	58,7	68,7	78,7	88,7	98,7	108,7	118,7	128,7
Segment sleeve			**1171020** ▲		**1171038** ▲	**1171049** ▲	**1171060** ▲	**1171071** ▲	**1171082** ▲	**1171093** ▲	**1171104** ▲	**1171115** ▲	**1171126** ▲
Work stop			893849		893865	893875	893886	893947	893905	893915	893925	893935	893945
Min-Ø mm			33,7		49,7	59,7	69,7	79,7	89,7	99,7	109,7	119,7	129,7
Segment sleeve			**1171021** ▲		**1171039** ▲	**1171050** ▲	**1171061** ▲	**1171072** ▲	**1171083** ▲	**1171094** ▲	**1171105** ▲	**1171116** ▲	**1171127** ▲
Work stop			893850		893866	893876	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm			34,7		50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7	130,7
Segment sleeve			**1171022** ▲		**1171040** ▲	**1171051** ▲	**1171062** ▲	**1171073** ▲	**1171084** ▲	**1171095** ▲	**1171106** ▲	**1171117** ▲	**1171128** ▲
Work stop			893851		893867	893877	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm			35,7										
Segment sleeve			**1171023** ▲										
Work stop			893852										

Intermediate flange KFR-SE / MFR-SE

APPLICATION

For adaption of cartridge mandrel KFR/MFR/KFR-SE/MFR-SE or KFS/MFS - on spindle head ISO 702-1 / ISO 702-3 (DIN 55021/55022/55026 and 55027).

TYPE

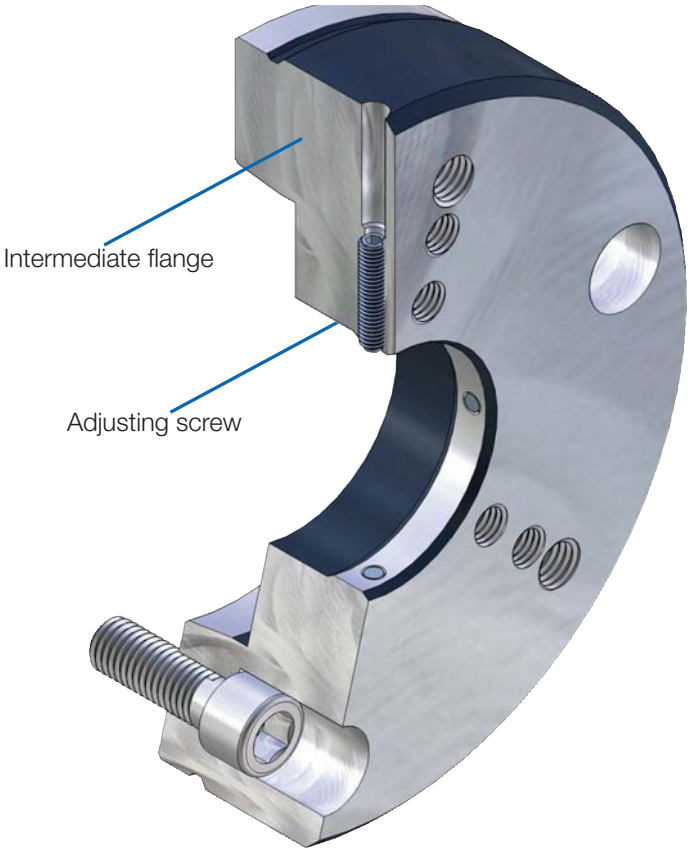
For KFR/MFR/KFR-SE/MFR-SE or KFS/MFS.

CUSTOMER BENEFITS

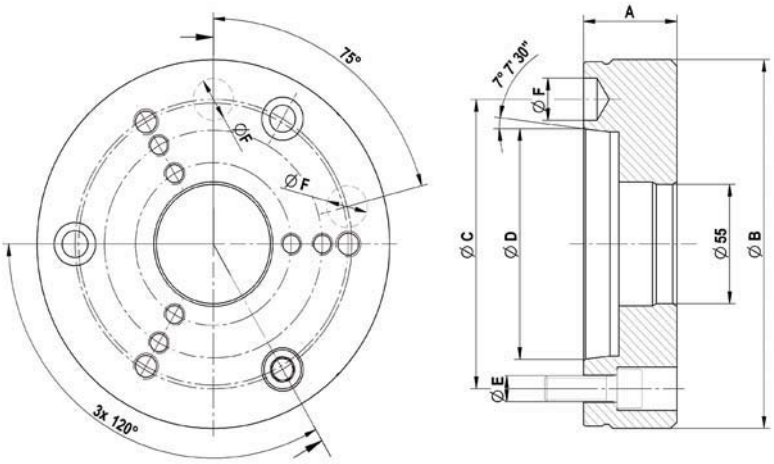
- By replacement of the Intermediate flange, one cartridge mandrel can be used on different machines

TECHNICAL FEATURES

Adaptation of mandrel KFR / MFR / KFR-SE / MFR SE or KFS / MFS on spindle head, with or without adjustment, with or without operation of air-conditioning control. Execution according to ISO 702-1 (DIN 55028-A) or ISO 702-3 (DIN 55028-C), in size no. 5, no. 6, no. 8, no. 11 or no. 5, no. 6, Nr. 8 (A5, A6, A8, A11 or C5, C6, C8).



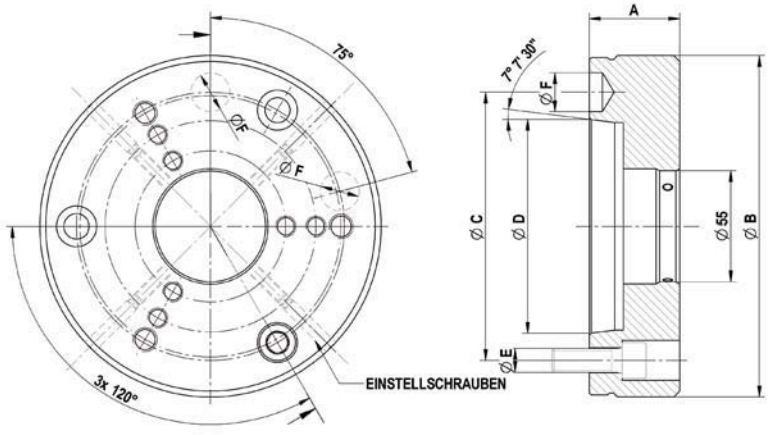
Accessories KFR-SE / MFR-SE



C 18

Intermediate flange ISO 702-1 (DIN 55026/55021) **without adjusting screws**

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	**893975**	**893976**	**893977**	**893978 ▲**
Design	without air-sensing	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50	50
Ø B	165	170	220	282
Ø C mm	104,8	133,4	171,4	235
Ø D mm	82,563	106,375	139,719	196,869
Ø E	M10	M12	M16	M20
Ø F mm	16,3	19,45	24,2	29,4

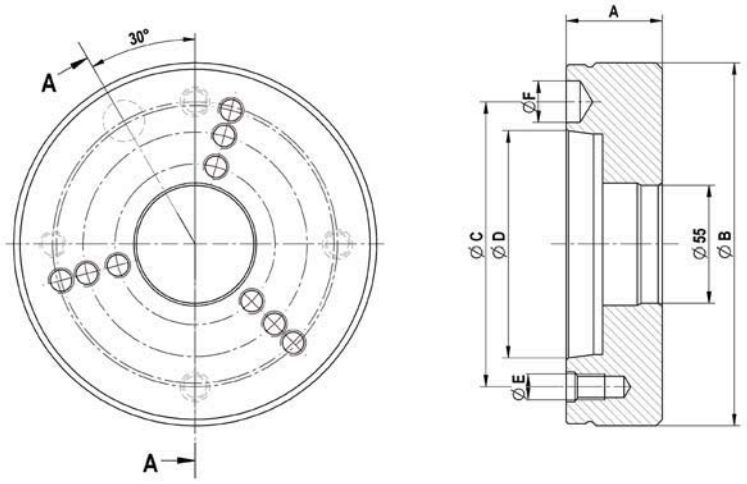


C 18

Intermediate flange ISO 702-1 (DIN 55028) **with adjusting screw**

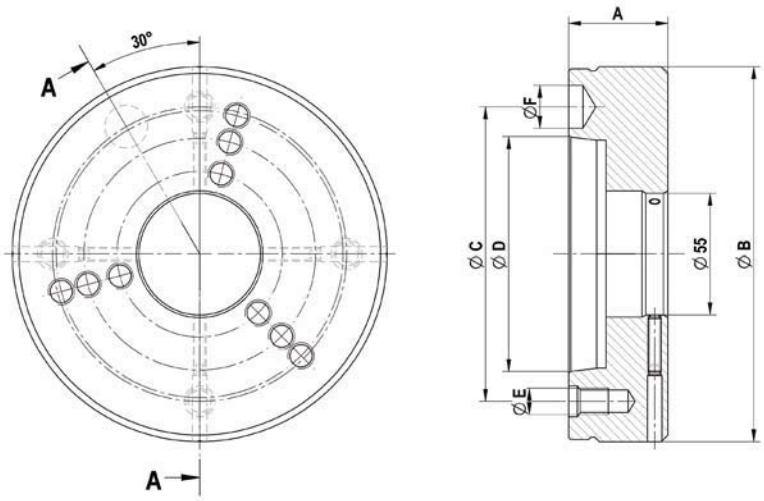
	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)
Intermediate flange	**893979**	**893980**	**893981**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M10	M12	M16
Ø F mm	16,3	19,45	24,2

Accessories KFR-SE / MFR-SE



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) **without adjusting screws**

	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	**893982**	**893983**	**893984 ▲**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) **with adjusting screws**

	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	**893985 ▲**	**893986 ▲**	**893987**
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2

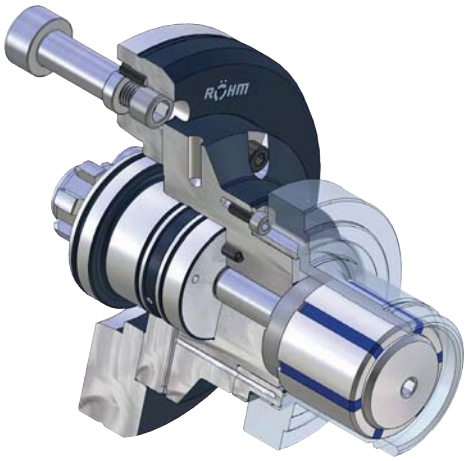
Special solutions ABSIS

ABSIS Segment clamping mandrel - nominal 38.43 mm

APPLICATION
Cutting, Turning

ABSIS clamping mandrel for clamping on a toothing machine. The centering is done by the segment clamping sleeve; the clamping by the pendulum bell. Clamping mandrel with quick change system on the basic take-up.

CUSTOMER BENEFITS
- Stable clamping using axial pull
- Concentricity of 0.01 mm
- A lot of freedom of the tool (milling coasting)
- Designed for wet machining



ABSIS Segment clamping mandrel - nominal 60.5 mm

APPLICATION
Turning

ABSIS clamping mandrel for clamping on a lathe. Clamping mandrel with quick change system on the basic take-up. Fixed workpiece stop with air sensing. Clamping screw sunk in the segment clamping sleeve to ensure the freedom of the tool. Different clamping mandrel sizes of clamping diameters 25 mm to diameter 105 mm (ABSIS size 00 to size 04).

CUSTOMER BENEFITS
- Stable clamping using axial pull
- Concentricity of 0.01 mm
- Simple changing of the workpiece stop as well as the clamping sleeves
- A lot of freedom of the tool

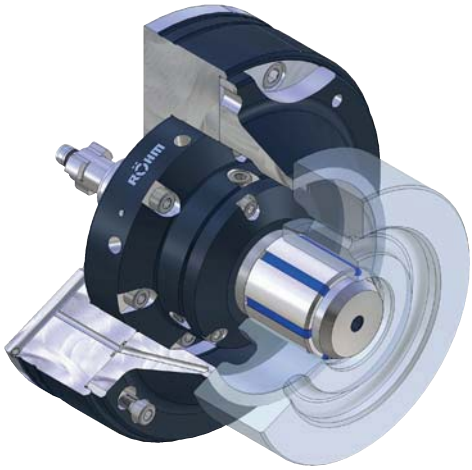
Special solutions ABSIS

ABSIS Segment clamping mandrel TK-Ø 88 mm

APPLICATION
Turning

ABSIS clamping mandrel for clamp in the toothing. The toothed segment clamping sleeve clamps the workpiece exactly in the tooth flanks. The centering disc helps during loading of the workpiece. Workpiece stop can be pulled back using draw bar with air sensing.

CUSTOMER BENEFITS
- Freedom of tool by stop that can be pulled back
- Concentricity of 0.01 mm



ABSIS Segment clamping mandrel Ø 55.33 mm

APPLICATION
Turning of a gear wheel blank

Force-actuated ABSIS standard clamping mandrel with quick change system. The stop diameter is far beyond the clamping diameter. Workpiece stop with air sensing attached on the intermediate flange.

CUSTOMER BENEFITS
- Stable clamping using axial pull
- Concentricity of 0.01 mm
- Low-cost thanks to standard components