

24110 - 24115

Fixed punch tips DIN 806

Design

- Tip angle 60°
- Fully hardened and ground

24110

RÖHM
Design

- Full tip

Quality

Tool steel.



24110

24113

RÖHM
Design

- Full tip

Quality

Cemented-carbide insert.



24113

24115

Design

- Half tip

Quality

Cemented-carbide insert.



24115

MK	Total length mm	No. 24115 b mm	No. 24115 c mm	RÖHM 24110	...	RÖHM 24113	...	24115	...
1	80	7	22	102					102
2	100	7	30	103					103
3	125	11	38	104			104		104
4	160	14	50	105			105		105
5	200	18	63	106			106		106

24200

Synchronously running punch tips

HHW

Design

- Tip angle 60°
- Mounted in ball bearings, fully hardened and ground
- Moving point made from high-quality tool steel
- High concentricity
- Smooth running



24200

Size	MK	Workpiece weight max. kg	Punch tip Ø mm	Housing Ø mm	24200	...
1	1	30	15	36		101
2	2	50	20	45		102
3	3	120	25	60		103
4	4	220	32	70		104

24202

Synchronously running punch tips, lightweight, slim

RÖHM

Design

- Tip angle 60°
- Lightweight design with slim housing
- Body and moving point are hardened
- Hardened moving point can be reground multiple times
- Precise rolling bearings for accurate true-running
- Maintenance-free due to permanent lubrication
- Special seal prevents the ingress of dirt and cooling lubricant

Applications

Mainly for machining small and very small parts on small and large lathes.



24202

MK	Length from spindle mm	Housing Ø mm	Largest rotating centre punch Ø mm	Concentricity deviation max. mm	Workpiece weight max. kg	24202	...
2	62.0	32	15	0.005	200		101
3	62.0	34	15	0.005	400		102
4	75.5	42	20	0.005	800		103
5	104.0	58	30	0.010	1600		104

24203

Synchronously running punch tips

ATORN®

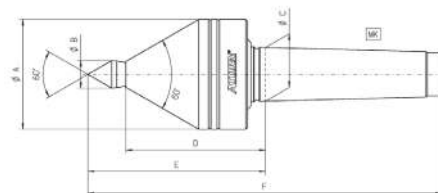
Design

- Tip angle 60°
- Extended moving point
- Max. concentricity deviation 0.005 mm
- Fully hardened and ground
- Bearings positioned for high axial forces
- Shaft seal prevents the ingress of dirt and cooling lubricant

Applications

Universal application on manual lathes.

24203



MK	A mm	B mm	C mm	D mm	E mm	F mm	rpm max.	Workpiece weight max. kg	24203	...
2	54	13	17.78	68.5	86.5	150.5	4200	170	201	
3	54	13	23.83	68.5	86.5	167.5	4200	170	202	
3	64	16	23.83	78.0	100.0	181.0	3800	330	203	
4	64	16	31.27	78.0	100.0	202.5	3800	330	204	
4	86	19	31.27	93.5	121.5	224.0	3200	550	205	
5	86	19	44.40	93.5	121.5	251.0	3200	550	206	

24204 - 24205

Synchronously running punch tips

RÖHM

Design

- Tip angle 60°
- Multiple ball bearings and needle bearings for moving point in shaft
- Body and moving point are die-forged, hardened and ground
- Fixed protective cover with special sealing against the ingress of dirt and coolant

Note:

Spare moving point deliverable on request.

24204

Design

- Normal moving point

Note:

Size 101–104 with single-row radial bearings.

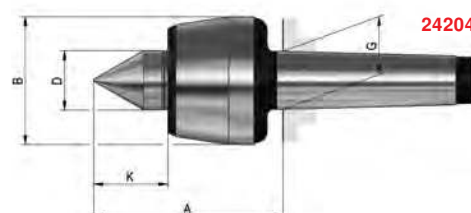
24205

Design

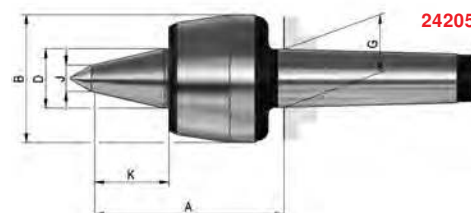
- Extended moving point permits unhindered access to the support

Applications

Ideal for copy turning.



24204



24205

Size	MK	Workpiece weight max. kg	A mm	B mm	D mm	G mm	K mm	J mm	Concentricity deviation max. mm	Rotation speed max. rpm	24204	...	24205	...
101 H	1	100	60.5	34.5	15	12.065	17.0	-	0.005	7000	101			
102 H	2	200	65.0	43.0	20	17.780	24.0	-	0.005	7000	102			
104 H	3	400	70.5	48.5	22	23.825	27.5	-	0.005	6300	103			
106 H	3	500	79.5	58.5	25	23.825	31.0	-	0.005	5000	104			
108 H	4	800	102.5	68.5	32	31.267	41.0	-	0.005	3800	105			
110 H	5	2000	129.0	88.5	40	44.399	50.5	-	0.005	3000	106			
114 H	6	3500	152.0	102.5	50	63.348	57.5	-	0.008	2600	107			
102 HVL	2	140	75.0	43.0	20	17.780	34.0	10	0.005	7000				101
106 HVL	3	400	95.5	58.5	25	23.825	47.0	12	0.005	5000				102
108 HVL	4	500	114.5	68.5	32	31.267	53.0	14	0.005	3800				103
110 HVL	5	1200	143.5	88.5	40	44.399	65.0	16	0.005	3000				104

24206

Synchronously running punch tip sets

RÖHM

Set contents

- 1 Body, hardened, maintenance-free
- 4 Inserts (60°/75°/90° and 60° extended)
- 1 Insert for hollow bodies
- 1 Small insert for workpieces without centres
- 1 Large insert for workpieces without centres
- 1 Lifter
- 1 Wooden box

Size	MK	Workpiece weight max. kg	Concentricity deviation max. mm	24206	...
102 H	2	40	0.01	101	
104 H	3	130	0.01	102	
108 H	4	250	0.01	104	
110 H	5	650	0.01	105	



24206

24207 - 24208

Synchronously running punch tips



Design

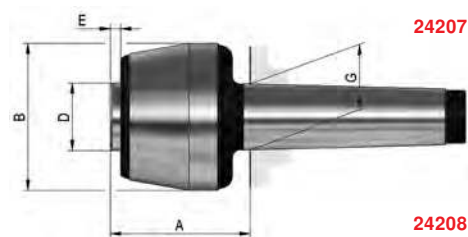
- Body hardened, maintenance-free
- Without insert and lifter

24208

Lifters

Applications

For releasing inserts.



24207

Applications

For replaceable inserts and various centring tasks, especially for single-part production.

Note:

For inserts, see art. no. 24209–24213.



24208

Size	MK	Workpiece weight max. kg	A mm	B mm	D mm	E mm	G mm	Concentricity deviation max. mm	24207	...	24208	...
102 A	2	40	45	43.0	20	4.0	17.780	0.01		101		201
104 A	3	130	48	48.5	22	4.5	23.825	0.01		102		202
108 A	4	250	67	68.5	32	5.0	31.267	0.01		104		202
110 A	5	650	85	88.5	40	6.0	44.399	0.01		105		203

24209 - 24213

Interchangeable inserts



24209

Extension use

Design

Type VL, tip angle 60°.

Applications

For synchronously running punch tips art. no. 24207.

24210

Use

Design

60°.

Applications

For synchronously running punch tips art. no. 24207.

24213

Use

Design

For hollow body 60°.

Applications

For synchronously running punch tips art. no. 24207.



24210



24213

For size	d mm	I mm	24209	...
102A	6	25		101
104A	8	30		102
108A	12	43		104
110A	13	55		105

For size	Centre Ø mm	24210	...
102A	16		101
104A	20		102
108A	28		104
110A	38		105

For size	D mm	d mm	24213	...
102A	25	10		101
104A	35	15		102
108A	55	30		104
110A	70	40		105

24231 - 24232

Synchronously running punch tips 400 NC



Design

- Tip angle 60°

- With shock absorption and high-precision bearings supported by spring assembly
- Body and moving point hardened and ground, maintenance-free

Applications

For damping impact loads, such as rapid start-up of the barrel on the workpiece and for high speeds with low axial loads.

24231

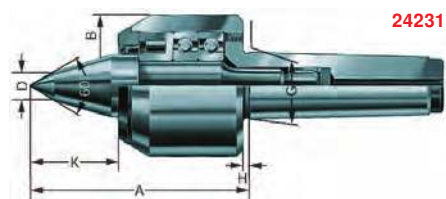
Applications

For heavy loads at high rotation speeds.

24232

Design

- With draw-off nut



24231



24232

Size art. no. 24231/24232	MK	Workpiece weight max. kg	Concentricity deviation max. mm	Rotation speed max. rpm	A mm	B mm	D mm	H mm	K mm	M mm	24231	...	24232	...
424/484	4	1000	0.005	7000	122	70	16	6.5	44	100		101		101
425/485	5	2000	0.005	6000	150	95	20	6.5	59	125		102		102

24260

Automatic synchronously running punch tips



Design

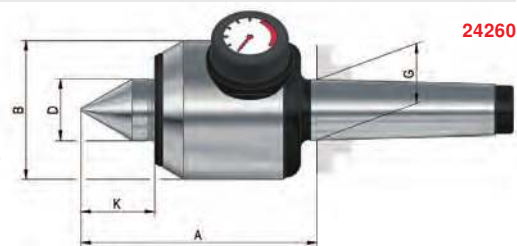
- Tip angle 60°
- Moving point preloaded
- Body and moving point hardened and ground
- Pressure display for an exact reading of the axial clamping force in daN

Applications

Also for normal clamping tasks.

Note:

Ideal as a counter centre for face drivers art. no. 25230–25239, to maintain constant axial clamping force between the tips (constant reclamping). Extended moving point deliverable on request.



Size	MK	Axial clamping force max. daN	D mm	E mm	B mm	F mm	Concentricity deviation max. mm	24260	...
503	3	550	25	31.5	64	67	0.01	101	
504	4	900	32	39.0	72	76	0.01	102	
505	5	1500	40	49.0	95	103	0.01	103	

24300

Synchronously running self-centring tapers

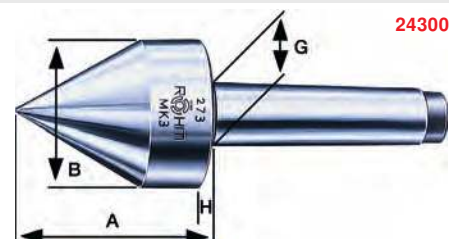


Design

- Taper point tapers to 60°
- Robust bearing
- Drive arbor, body and taper point hardened

Applications

As a self-centring taper for hollow bodies and as a centring tip for machining normal workpieces.



Size	MK	A mm	B mm	H mm	G mm	Workpiece weight max. kg	Concentricity deviation max. mm	24300	...
272	2	61	42	7.0	17.780	200	0.01	101	
273	3	79	56	7.0	23.825	400	0.008	102	
274	4	100	64	8.5	31.267	800	0.008	103	

24501 - 24502

Synchronously running self-centring tapers



Design

- Robust bearing
- High concentricity
- Body and housing hardened and ground, maintenance-free

Applications

For absorbing the highest axial and radial pressures. For machining tubes and other hollow bodies.

24501

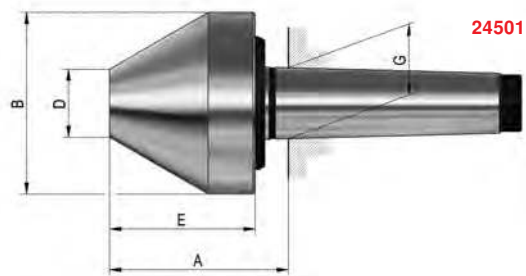
Design

- Tip angle 60°

24502

Design

- Tip angle 75°



Size	MK	A mm	B mm	D mm	E mm	G mm	Workpiece weight max. kg	Concentricity deviation max. mm	60° 24501	...	75° 24502	...
171A	2	65	50	20	52	17.78	200	0.008	102			
172	2	77	80	30	64	17.78	300	0.008	103			
172A	3	77	80	30	64	23.825	400	0.008	104			
172B	4	78.5	80	30	64	31.267	400	0.008	105			
172	2	80	80	20	67	17.78	300	0.008			101	
172A	3	80	80	20	67	23.825	400	0.008			102	
172B	4	81.5	80	20	67	31.267	400	0.008			103	
173	3	85.5	120	30	72	23.825	600	0.008			104	
173A	4	87	120	30	72	31.267	800	0.008			105	
173B	5	88	120	30	72	44.399	800	0.008			106	
174	4	107	170	50	90	31.267	1200	0.01			107	
174A	5	106	170	50	90	44.399	1600	0.01			108	

**Design**

- Basic body with Morse taper shank
- Long, guided, spring-loaded centring point, axially adjustable
- Attachable driving plates with hydraulic compensation for even clamping forces
- Rapid changeover of different driving plates
- Clamping diameter 12–32 mm
- Turning range 13–64 mm

Contents:

- 1 basic body
- Two driving plates
Clamping diameter 12 and 32 mm
- 2 centring point diameters = 6 and 16 mm
- In box

Applications

For turning between points for series and single-part production. Small and medium-sized workpieces can be machined without repositioning, along their entire lengths and with a high degree of accuracy.

For clockwise rotation.**Note:**

Also deliverable on request for anti-clockwise rotation and for larger face drivers.



25230

Morse taper	25230	...
3		101
4		102
5		103

**Design**

Basic body.

Does not include centring point or driving plate.

Applications

For clockwise and anti-clockwise rotation.



25233

Size	Morse taper	25233	...
1	3		101
2	4		102
3	5		103

**25235**

Driving plate, directly toothed.

Applications

For clockwise rotation.

25236

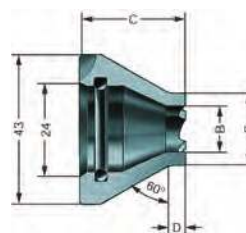
Driving plate, directly toothed.

Applications

For anti-clockwise rotation.

25239

Centring point



25235

25239



Clamping Ø S mm	For turning range mm	B mm	C mm	D mm	Suitable centring point diameter A mm	Clockwise rotation	Anti-clockwise rotation		Centring point	
						25235	...	25236	...	25239
8	9–16	4.5	38	4	4	101		101		101
10	11–20	4.5	38	4	4	102		102		101
12	13–24	7.0	36	4	6	103		103		102
16	17–32	11.0	33	4	10	104		104		103
20	21–40	13.0	30	4	12	105		105		104
25	26–50	17.0	30	8	16	106		106		105
32	33–64	22.0	30	10	16	107		107		105

25240 - 25241

Driving plates for sets, type CoA



Design

With replaceable cemented-carbide driving plates
6 x 3.2 mm.

25240

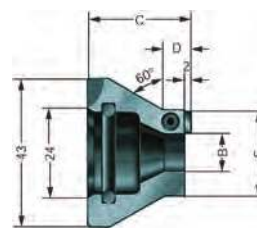
Applications

For clockwise rotation.

25241

Applications

For anti-clockwise rotation.



25240



Clockwise rotation

Anti-clockwise rotation

Clamping Ø S mm	For turning range mm	B mm	C mm	D mm	Suitable centring point diameter A mm	25240	...	25241	...
20 H	21-40	7	30	5	6			101	101
25 H	26-50	11	30	8	10			102	102
32 H	33-64	17.5	30	10	16			103	103

25243

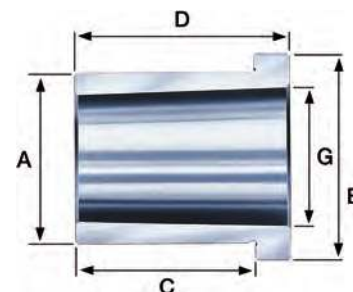
Sleeves



Applications

For clamping face drivers in lathe chucks.

25243



MK Inside	A mm	B mm	C mm	D mm	G mm	25243	...
3	31	39	32	40	23.825		101
4	39	47	42	50	31.267		102
5	54	62	52	60	44.399		103
6	75	83	62	70	63.448		104