

27656

NC compact clamp, type RKE



Design

With mechanical power transmission; can be clamped horizontally, vertically or laterally. Steel basic body with all sides hardened and ground. Stepped jaws, fixed, reversible; stepped jaws, movable, reversible. Long sliding clamp with transverse grooves. Drive spindle with default clamping force setting. Mounting thread M12 for workpiece stop. Clamping surfaces for adjustable clamps; reliable chip protection prevents the penetration of chips into the interior of the body.

Note:

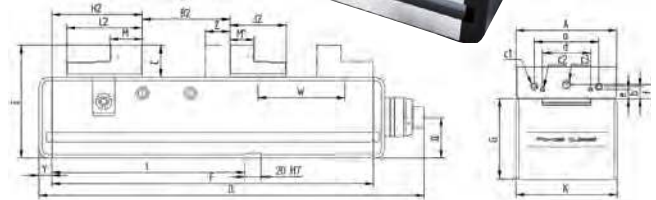
For accessories, see art. no. 27657–27663 and 27682–27684.

Standard interchangeable jaw grips on request.

Clamping width for reversible stepped jaws: Jaw width 125 = 97–312 mm, 160 = 131–451 mm.



27656



Jaw width A	B2	E	F	G	H2	K	W	Clamping force	Weight	27656	...
mm	mm	mm	mm	mm	mm	mm	mm	kN	approx. kg		
125	0-216	140	400	100	112.5	126	1 x 108.0	40	41		201
160	0-320	165	530	115	130.0	162	2 x 102.5	60	79		202

27649

NC compact clamp, type MM-G 125/160



Design

Standard version, can be clamped on the base. Clamping system mechanical/mechanical. Basic body made of GGG. Stepped jaws reversible, hardened and ground. Long sliding clamp with transverse grooves, drive spindle with default clamping force setting. Mounting thread M 12 for workpiece stop. Clamping surface for adjustable clamps. Reliable chip protection prevents chips from penetrating into the interior of the body.

Applications

Locating holes compatible with ATORN zero-point clamping system. Depth gauge 200 mm.

Note:

For accessories, see art. no. 27657–27663 and 27682–27684.



27649 101

Jaw width	Jaw offset	Travel of	Total length	Total height	Jaw height	Clamping range	Clamping range	Clamping	Weight	27649	...
mm	range mm	slide mm	mm	mm	mm	(high side) mm	(step side) mm	force kN	kg		
125	1 x 108.0	109	463	140	40	0-216	97-312	40	41		101
160	2 x 102.5	117	618	165	50	0-320	131-451	60	79		102

27657 - 27663

Accessories for NC compact clamp, type RKE + MMG

27657

Set of stepped jaws

27663 101

Dimensions: A = 133 mm, B = 106 mm, C = 98 mm.

27657



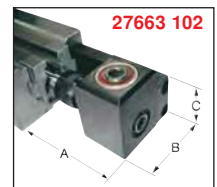
27658

Set of support jaws

27663 102

Dimensions: A = 166 mm, B = 111 mm, C = 98 mm.

27658



27659

Claw insert, single with fastening screw suitable for support jaws.

27663

Angle drive, 90°

Applications

Ideal for side-mounted clamping or for large machine tables.

27659 201-202



For jaw width	27657	...	27658	...	27659	...	27663	...
mm								
92-125		101		101		201		101
160		102		102		202		102

**Design**

- ALLMATIC compatible jaw interface
- Small dimensions
- Optimum ratio between the clamping width and overall length
- Rigid basic body made of GJS 600
- Inductively hardened
- Upper and lower side ground
- Pairing accuracy 0.02 mm

Advantages:

- Fully enclosed spindle
- Increased functional safety
- Optimised chip protection
- Minimal cleaning effort
- Mechanical power booster
- Quick-change system for spindle unit

Scope of delivery:

- Basic body with stepped jaws
- 1 hand crank
- 4 adjustable clamps

Note:

The overall length remains unchanged even when clamping large workpieces.

- ① Clamping with hand crank; highest clamping forces are achieved with max. 2 spindle revolutions
- ② Maintenance-free high-pressure spindle with constant pressure. Wear-resistant, purely mechanical power booster. No decrease in clamping force
- ③ Guideways inductively hardened and ground
- ④ Precise cross-directional aligning grooves on the underside
- ⑤ Thread for workpiece stop
- ⑥ Quick-change click system, Kesel
- ⑦ Thread for holding Kesel/ALLMATIC interchangeable jaws (except for ALLMATIC step strips)
- ⑧ Outlet for chips and coolant



Type	Jaw width mm	Clamping width (high side) mm	Clamping width (step side) mm	Clamping force max. kN	Clamping force steps	Basic body (L x W x H) mm	Total length mm	Bed height mm	Weight kg	27651	...
NCA 90	90	0-126	91-217	28	11	305 x 90 x 80	340	80	15		101
NCA 125	125	0-182	131-313	40	4	424 x 126 x 100	483	100	35		102
NCA 160	160	17-263	187-433	60	4	560 x 164 x 115	616	115	65		103

27724

High-pressure machine vices

Design

- Basic body and upper slide made of spheroidal graphite iron GGG60
- Guideways hardened and ground
- Ground camber to compensate for tilting
- Maintenance-free and fully enclosed high-pressure spindle with integrated mechanical power amplifier
- Lower section with longitudinal and transverse grooves for exact alignment
- Quick adjustment via stud bolts

Scope of delivery:

- 4 adjustable clamps
- 1 pair of hardened clamping jaws
- 1 hand crank

Applications

For vibration-free, absolutely safe clamping with extremely high cutting and feed forces.



27724

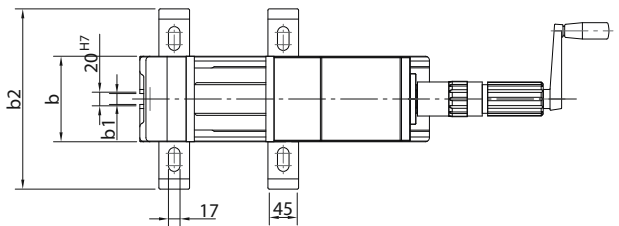
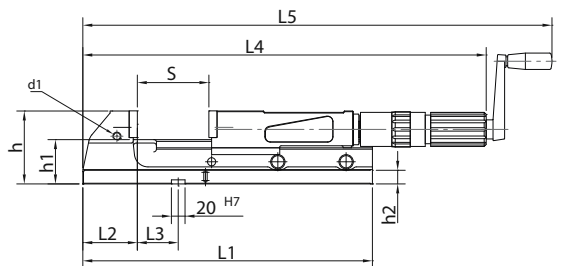
Note:

Narrow production tolerances allow subsequent assembly of several vices next to one another.

Technical data:		
Art. no.	27724 101	27724 102
Jaw width mm:	125	160
Clamping range S, step 1/2 mm:	0-105/100-205	0-155/150-305
Clamping range, extended mm*:	255	365
Clamping force, max. kN:	40	50
L1 mm:	425	570
L2 mm:	80	90
L3 mm:	60	95
L4 min./max. mm:	489/694	575/880
L5 min./max. mm:	613/818	712/1007
h mm:	107	130
h1 (+0.002) mm:	65	80
d1:	M 12	M 16

* Clamping range extended by fixing the bolt in the transverse groove of the spindle nut

Jaw width mm	Vices	
	27724	...
125	101	
160	102	



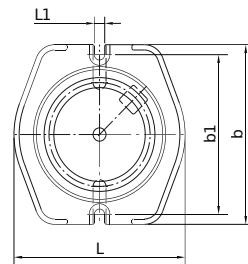
27725 201-202

Turntables

Design

- Turntable with 360 easily readable graduation lines (4 x 90°)
- Clamping slots for easy fastening on the machine table

For jaw width mm	L mm	L1 mm	Height mm	b mm	b1 mm	Weight kg	Turntables	
							27725	...
125	264	16	28	270	240	10.8	201	
160	325	16	32	325	295	18.4	202	



27725 201-202

27725 301-305

Clamping jaws

Clamping jaws For jaw width mm	With longitudinal groove		With step	
	27725	...	27725	...
125			301	304
160			302	305



27725 301-302

27725 304-305

High-pressure machine vices

27708

High-pressure machine vices

ATORN®

27708 101-102

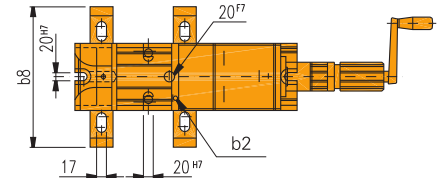
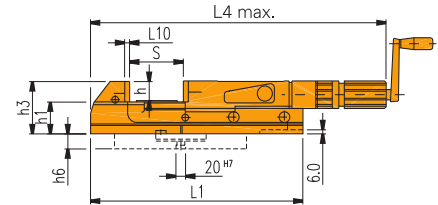
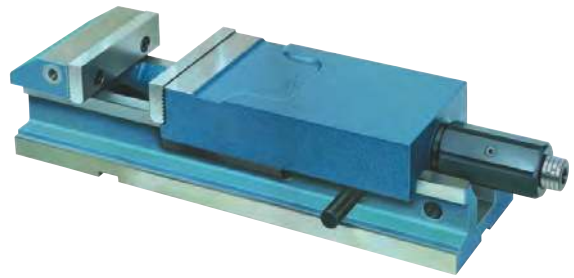
Design

- Mechanical/hydraulic
- Steel **body, guideways hardened and ground**
- Alignment on the machine table: longitudinal and transverse via groove and sliding blocks
- Rough adjustment of the clamping range via rigging pin
- **Clamping repeat accuracy** with a constant clamping force: **0.01 mm**
- **Clamping force adjustment** for fast pre-selection of the clamping force, precise repeatability
- Pre-clamping facility for elastic parts
- Package clamping
- Compensation jaws

Scope of delivery:

- 1 set of jaws (1 side smooth, 1 side serrated)
- 4 adjustable clamps
- Hand crank

27708 101-102



Technical data:		
Item no.	27708 101	27708 102
Jaw width b2 mm:	90	125
Clamping width S mm:	0-150	0-220
Jaw height h mm:	39.6	39.6
Jaw thickness L10 mm:	15.6	15.6
h3 x h1 x b8 mm:	99 x 53 x 230	120 x 70 x 265
L1 x l4 mm:	370 x 553	470 x 681
Clamping force kN:	25	40

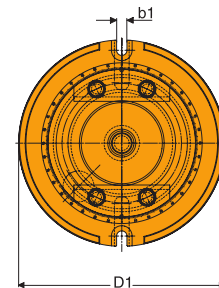
Jaw width mm	Vices	
	27708	...
90		101
125		102

27708 201-202

Turntables

27708 201-202

For jaw width mm	Slot width b1 mm	d x h6 mm	b5 x L8 x h6 mm	Turntables	
				27708	...
90	14	242 x 30	230 x 220 x 25		201
125	16	280 x 30	270 x 264 x 28		202



Info

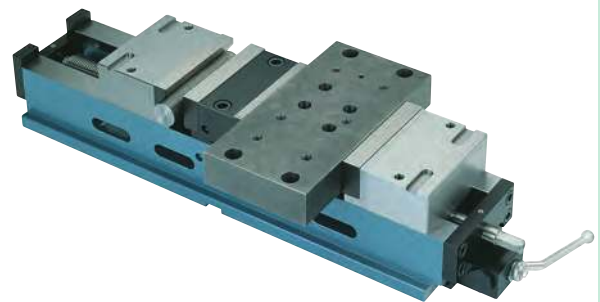
Single, double and multiple vices

MULTI 2000 – versatile, economical, compact –

A sophisticated enhancement to the standard double vice and single vice ranges.

- Multifunctional use possible
- Mechanical or fully hydraulic operation
- Change to other workpiece sizes in seconds
- High clamping and repeat accuracy
- Same clamping pressure at both clamping points
- Basic body made of case-hardening steel, guides inductively hardened
- Two independent spindles (only one operating side)
- Can be equipped with workpieces of different sizes
- Side slots on the underside of the vice divert chips and cooling water
- Small dimensions
- Ideal for use on vertical machining centres

Please contact us!



Clamping technology



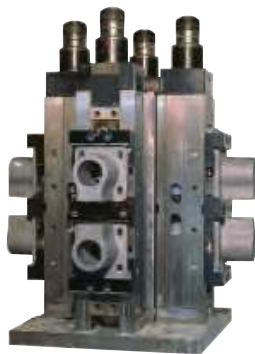
Precise workpiece clamping



Finely serrated clamping jaws for a high retention force.

Flexibility with RöhM clamping jaws

Can be used on NC compact clamps and machine vices



QUATRO clamping tower
With four NC compact clamps RKD mounted in a star shape



5-sided machining:
Multiple clamping (blank) in RKD 125 with pull-down claw inserts



Clamping jaws with 4 pendulum supports, serrated, compensation $\pm 9^\circ$, pendular movable jaw, without pull-down for clamping forged parts

High-pressure machine vices

27710 - 27715

High-pressure machine vices, RB



27710

High-pressure machine vices, RB

Design

- **Mechanical/hydraulic**
- With mechanical pre-clamping via hand crank
- Clamping force can be preset via stop
- Alignment on the machine table via longitudinal grooves
- Rough adjustment of the clamping range via rigging pin
- **Clamping repeat accuracy** with a constant clamping force: **0.01 mm**

Scope of delivery:

- 1 set of standard jaws (1 side smooth, 1 side grooved)
- Hand crank

Applications

For individual and series production on drills and milling machines.

Quality

Steel body, forged (jaws made from nodular cast iron, jaw width 200 mm). Guideways hardened and ground.

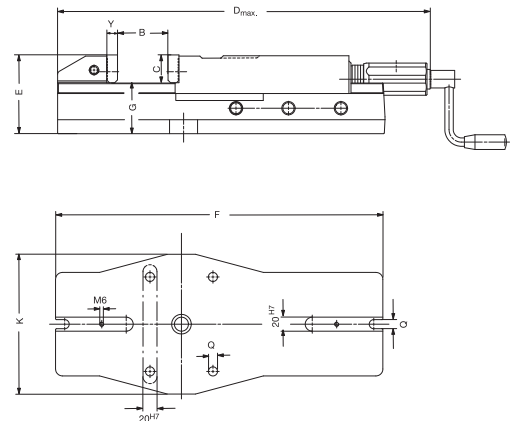
Note:

For workpiece stop see art. no. 27684. Vices with jaw width 250 and 315 mm and additional angle drive deliverable on request.

27710



Technical data:				
Art. no.	27710 101	27710 102	27710 103	27710 104
Jaw width mm:	113	135	160	200
Clamping width B mm:	170	220	310	350
Jaw height C mm:	31.6	39.6	49.6	66.6
Length D mm:	583	681	817	1022
Height E mm:	97	112	133	171
Length F mm:	390	468	574	685
Height G +/- 0.02 mm:	65.5	72.5	83.5	104.5
Width K mm:	160	200	240	280
Slot width Q mm:	13	13	17	21
Jaw thickness y mm:	12	16	16	20
Clamping force, max. kN:	30	40	50	100
Weight kg:	24	39	60	112



Jaw width mm	Vices	
	27710	...
113		101
135		102
160		103
200		104

27711

Turntables

Design

- With ground support edge to support the vice

- Graduation, fastening screws and sliding blocks for fixing the vice on the turntable

For jaw width mm	Turntables	
	27711	...
113		101
135		102
160		103
200		104

27711 101-103

27711 104



27715

Prism and normal jaw

Design

- With workpiece support
- Soft and bronzed
- Pairs

Applications

Screw-on.

For jaw width mm	27715	

113		101
135		102
160		103

27715



ATORN®**Design**

- Basic body and jaws made of case-hardening steel, nitrided on all sides
- Repeat accuracy ≤ 0.01 mm
- Clamping force up to 40 kN
- Mechanical/hydraulic spindle made of high-strength special steel
- Transverse grooves for fast positioning on tool table
- Basic body clampable and ground on 3 sides (for bed length 470 mm, otherwise optional)
- Ground internal guideway 58 HRC
- Positioning holes $\varnothing 12H7$ on underside in 40 and 50 mm pitch for grid plate clamping
- Use of pull-down quick-change jaws and interchangeable stepped jaw grips
- Spindle nut with double trapezoidal thread for quick adjustment
- Thread for workpiece stop

Scope of delivery:

- Delivery includes reversible screw-in jaws (serrated and smooth side)
- Hand crank
- Crank extension
- For bed length greater than 662 mm, crank extension deliverable on request

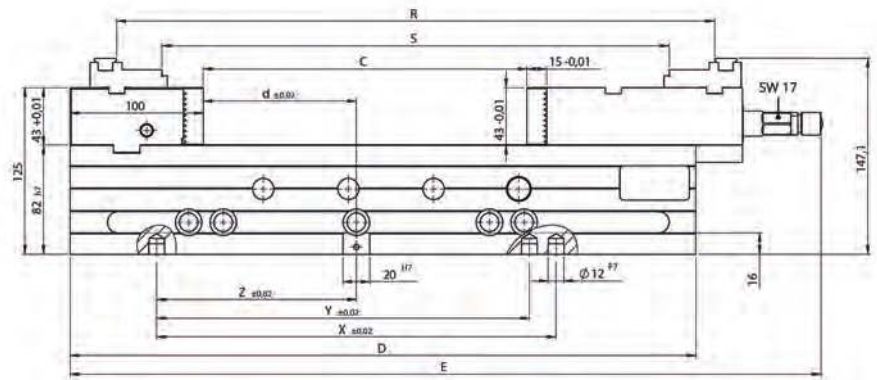
Applications

For precise clamping of workpieces.

Note:

Can also be used for tower clamping.
For workpiece stops see art. no. 27410.

Bed length up to 1200 mm and hydraulically operated versions deliverable on request.

NEW

Multiple clamping optionally possible with interchangeable slide (art. no. 27716 232)



Fast retooling even with pull-down quick-change jaws

27716 101-108

Groove and thread for interchangeable jaw grips

Flexible clamping

Optimum positioning

Fast presetting through 64 mm grid hole

Clamping force: hydraulic up to 40 kN/ mechanical up to 10 kN

Mounting hole for optional angle drive

Ground internal guideway 58 HRC

Clamping technology

Jaw width mm	Bed length D mm	Total length E mm	Clamping width C mm	Clamping width R mm	Clamping width S mm	Bed height mm H7	Groove width mm H7	Jaw height +/- mm	27716	...
125	470	564	0-239	131-445	63-377	82	20	43		101
125	534	628	0-303	131-509	63-441	82	20	43		102
125	598	692	0-367	131-573	63-505	82	20	43		103
125	662	756	0-431	131-637	63-569	82	20	43		104
125	726	820	0-495	131-701	63-633	82	20	43		105
125	790	884	0-559	131-765	63-697	82	20	43		106
125	854	948	0-623	131-829	63-761	82	20	43		107
125	918	1012	0-687	131-893	63-825	82	20	43		108

See next page for accessories ▶

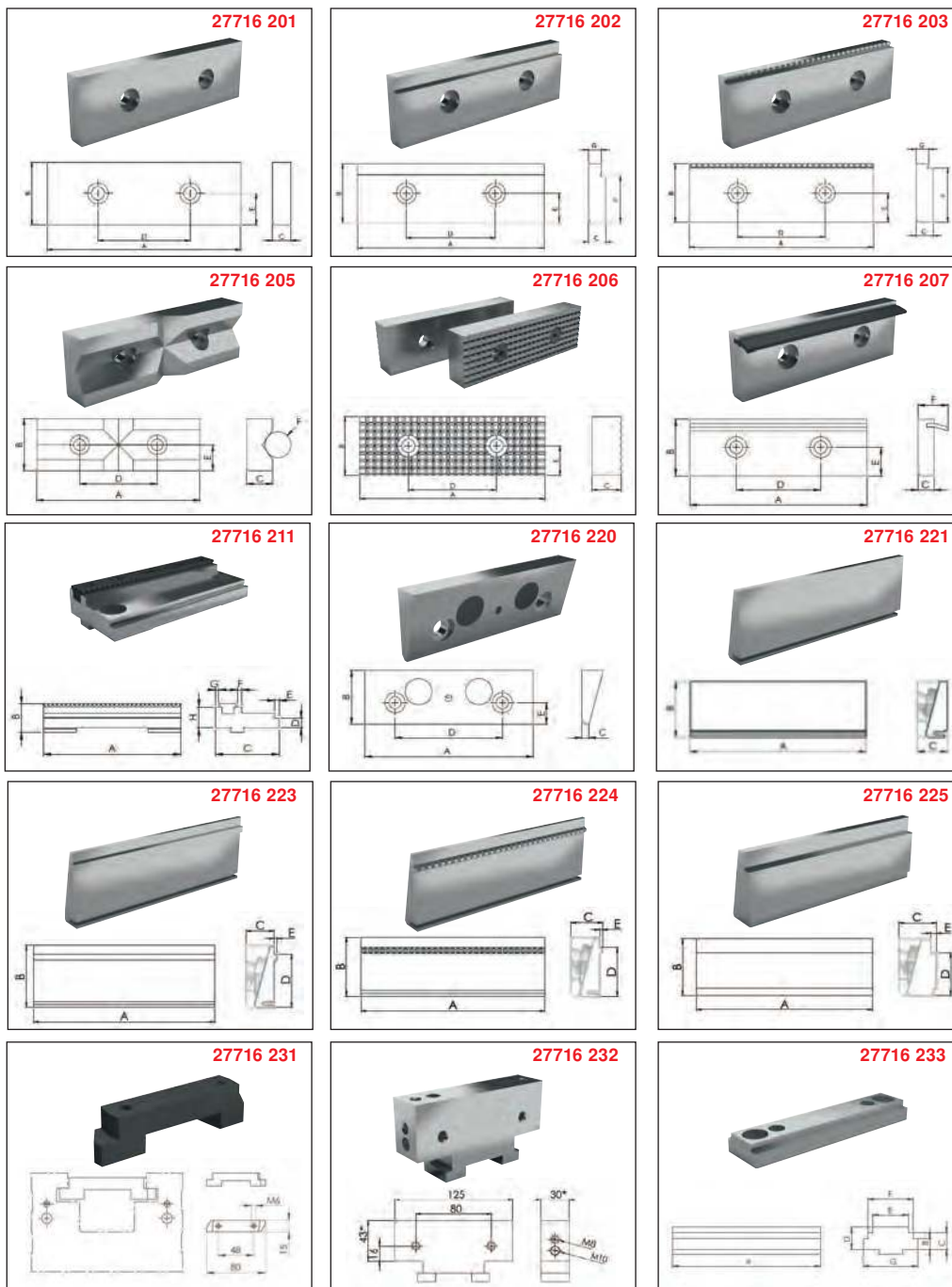
27716

Accessories for machine vice MH-S 125

Continued ▶

Scope of delivery:
All jaws 1 piece each.

NEW



Type	A	B	C	D	E	F	G	H	27716	...
	mm	mm	mm	mm	mm	mm	mm	mm		
Soft jaw	125	43.4	15.4	80	16	-	-	-		201
Stepped jaw	125	43	11.5	80	16	35	8.5	-		202
Grip stepped jaw	125	43	11.5	80	16	40	8.5	-		203
Prism jaw, vertical	125	43	20	80	16	8-38	-	-		204
Prism jaw, horizontal and vertical	125	43	20	80	16	8-38	-	-		205
Reversible screw-in jaw	125	43	15	80	16	-	-	-		206
Pull-down jaw with spring plate	125	43	11.5	80	16	21.5	-	-		207
Interchangeable stepped jaw	125	19	58	9	14	4	-	-		210
Interchangeable stepped jaw with grip insert	125	26.1	58	9	4	4	3	19		211
Plain jaw with two permanent magnets	125	43	6	80	16	-	-	-		220
Interchangeable jaw, smooth	125	43	21.5	-	-	-	-	-		221
Interchangeable jaw, serrated	125	43	21.5	-	-	-	-	-		222
Line interchangeable jaw	125	43	21.5	37	2	-	-	-		223
Serrated line interchangeable jaw	125	43	21.5	37	2	-	-	-		224
Stepped interchangeable jaw	125	43	26.9	33	4	-	-	-		225
Angle drive	-	-	-	-	-	-	-	-		230
Rhombic T-sliding block	-	-	-	-	-	-	-	-		231
Interchangeable slide	-	-	-	-	-	-	-	-		232
Interchangeable stepped jaw for interchangeable slide	124.9	-	-	105	-	-	-	-		233

27695

Hydro machine vices, EuroLine

ROEMHELD
HILMA • STARK

Design

Mechanical/hydraulic. The redesigned power transmission requires a minimum crank force. An angle drive (see art. no. 27703) facilitates operation, e.g. for longitudinal clamping on the machine table. An optional clamping force pre-selector (see art. no. 27705) enables 6-stage limitation of the maximum clamping force to partial values.

Function:

When the hand crank is turned, the mechanical/hydraulic clamping jaw is quickly brought to the workpiece via a steep threaded hollow spindle. After contact with the workpiece: Automatic disengagement of the inner pressure spindle. When the hand crank is turned further: Infinitely variable increase in the clamping force up to the maximum. To release the clamping force, the hand crank is turned in the opposite direction.

Scope of delivery:

Standard reversible jaws, smooth/serrated, hand crank and operating instructions.

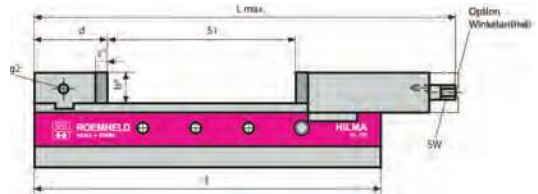
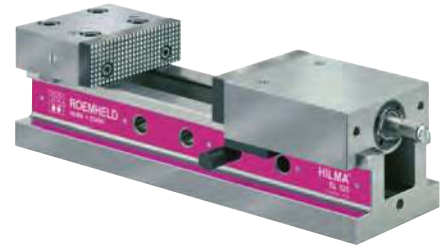
Applications

For tool and mould making, jig manufacturing and production.

Note:

Cannot be used with turntable.
For adjustable clamp sets, see art. no. 27805.

27695 302



Type	Jaw width mm	Clamping width S1 mm	Clamping force approx. kN	Jaw height b mm	Total length L max. mm	Lower section f mm	Crank force N	Crank radius mm	Weight approx. kg	27695	...
EL 100	100	205	25	34	464	380	50	80	18.5		301
EL 125	125	225	40	45	526	430	75	100	31.5		302
EL 160	160	309	50	54	684	550	95	125	58.5		303
EL 160 L	160	509	50	54	884	750	95	125	75.0		304

27800

Hydro machine vices, type NC

ROEMHELD
HILMA • STARK

Design

Mechanical/hydraulic. Manual clamping with hydraulic power transmission. Precise alignment on the machine table using longitudinal and transverse grooves. Extension of the clamping range with interchangeable stepped jaws or customer-specific special jaws via grooves and threaded holes on slides and fixed jaws. Threaded holes for holding extra-high clamping jaws as standard.

Function:

When the hand crank is turned, the mechanical/hydraulic clamping jaw is quickly brought to the workpiece via a steep threaded hollow spindle. After contact with the workpiece: Automatic disengagement of the inner pressure spindle. When the hand crank is turned further: Infinitely variable increase in the clamping force up to the maximum. To release the clamping force, the hand crank is turned in the opposite direction.

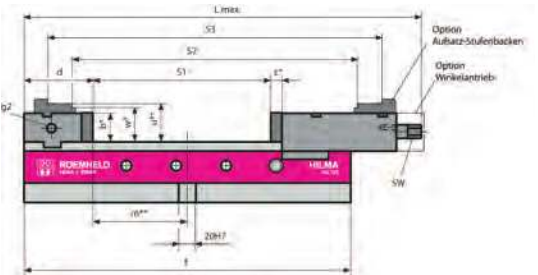
Applications

For tool and mould making, jig manufacturing and production.

Note:

1 = Interchangeable stepped jaws option
2 = Angle drive option
3 = Clamping force display in kN option
For adjustable clamp sets, see art. no. 27805.
Hydraulically operated version on request.

27800 102



Type	Jaw width mm	Clamping width S1/S2/S3 max. mm	Clamping force kN	Jaw height b mm	Total length L max. mm	Lower section f mm	Crank force N	Crank radius mm	Weight approx. kg	27800	...
NC 100	100	205/330/386	25	34	464	380	50	80	18.5		101
NC 125	125	225/363/431	40	45	526	430	75	100	31.5		102
NC 160	160	309/503/573	50	54	684	550	95	125	58.5		103

27702

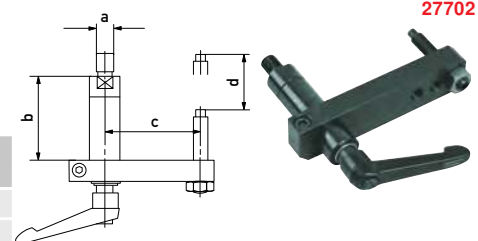
Workpiece stops for type EL, NC

ROEMHELD
HILMA • STARK

Applications

Coordinate workpiece stops, for self-assembly on all HILMA machine vices; can be swivelled away for 3-sided machining.

Type	For jaw width mm	a mm	b mm	c mm	d mm	27702	...
9.3291.0201	100/125	M 12	61	95	46		101
9.3291.0401	160	M 20	81	124	66		102



27702

27703

Angle drives for type EL, NC-M

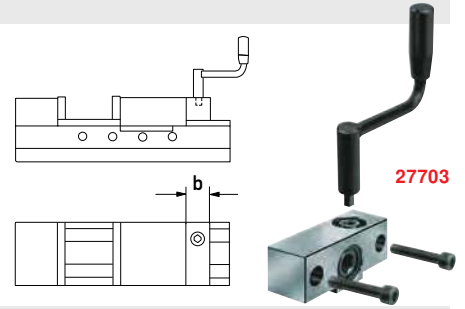


Design

Fast assembly with just 2 screws (overall length L max. of the machine vice does not change).
Supplied without hand crank.

Applications

Important accessory for longitudinal clamping on the machine table or when normal crank operation is difficult.



Type	For jaw width mm	b mm	27703	...
9.3294.0605	125	43	102	
9.3294.0705	160	46	103	

27705

Clamping force pre-selector, 6-stage



Design

The clamping force pre-selector limits the travel of the pressure spindle and thus enables gradual adjustment of the clamping force. The maximum clamping force is reached in stage 6.

Safety instructions:

The set clamping force must be high enough to ensure that the machining forces cannot move the workpiece.

Scope of delivery:

6-stage clamping force pre-selector, including fastening screw and two shims for tolerance compensation.

Applications

The 6-stage clamping force pre-selector is used to clamp thin-walled parts, sensitive materials and workpieces for fine machining with an adapted clamping force. For mechanical/hydraulic machine vices, type EL, NC-M.



Type	For jaw width mm	Thread of pressure spindle	Spacing X mm	27705	...
9.3762.0100	100	M 6 x 12	0.7-1.0	101	
9.3762.0125	125	M 8 x 14	1.0-1.5	102	
9.3762.0160	160	M 8 x 14	1.0-1.5	103	

27729

Standard clamping jaws

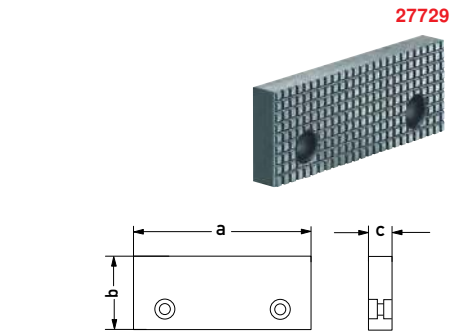


Design

Can be used on both sides.
1. Serrated side.
2. Smooth side.

Applications

For hydro machine vices, type EL, NC.



Type	a mm	b mm	c mm	Pieces 27729	...
5.2058.1003	100	34	13	101	
5.2058.1004	125	45	15	102	
5.2058.1005	160	54	18	103	

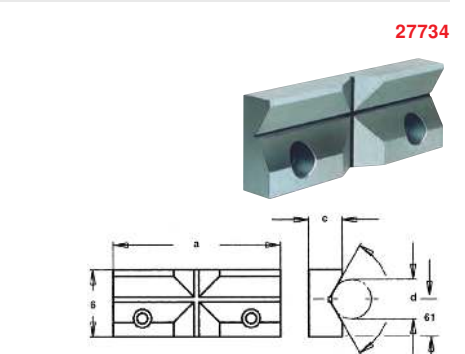
27734

Vee block jaw



Applications

For clamping round workpieces horizontally and vertically.
For hydro machine vices, type EL, NC.



Type	a mm	b mm	b1 mm	c mm	d mm	Pieces 27734	...
5.3030.0002	100	34	19	17	8-35	101	
5.3030.0003	125	45	27	19	10-50	102	
5.3030.0004	160	54	32	21	12-60	103	

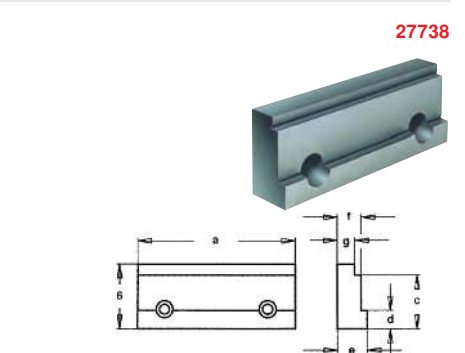
27738

Precision stepped jaws



Applications

For use in pairs. For clamping rectangular workpieces without parallel pieces. For producing bores close to the edge. For hydro machine vices, type EL, NC.



Type	a mm	b mm	c mm	d mm	e mm	f mm	g mm	Pieces 27738	...
5.2082.0001	100	34	29	10	19	15	11	201	
5.2082.0002	125	45	39	13	25	20	16	202	
5.2082.0003	160	54	45	15	25	20	16	203	

27739

Pendulum jaws

ROEMHELD
HILMA • STARK

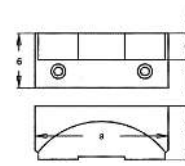
Applications

For clamping workpieces with non-parallel clamping

surfaces or 2 workpieces with different tolerances.
For hydro machine vices, type EL, NC.

27739

Type	a mm	b mm	c mm	d mm	Pieces	
					27739	...
8.3711.0208	100	34	35	16		101
8.3711.0308	125	45	50	22		102
8.3711.0408	160	54	55	26		103



27741

Clamping jaws, extra-wide

ROEMHELD
HILMA • STARK

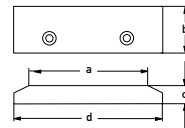
Applications

For safe clamping of workpieces that exceed the normal jaw widths.

For use in pairs.
For hydro machine vices, type EL, NC.

27741

Type	a mm	b mm	c mm	d mm	Pieces	
					27741	...
5.2058.1025	100	34	13	125		201
5.2058.1026	125	45	15	160		202
5.2058.1027	160	54	18	200		203



27803 - 27804

Interchangeable stepped jaws

ROEMHELD
HILMA • STARK

Design

For achieving very large clamping widths. Includes fastening screws.

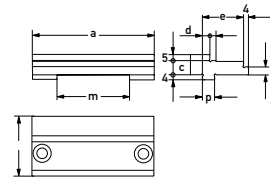
Applications

For machine vices art. no. 27800.

27803
For fixed jaws.

27804
For slides.

Note:
Recess dimension m for art. no. 27804 only.



27803



Type	a mm	c mm	d mm	e mm	h mm	m mm	p mm	27803		27804	
							
9.3284.0201	100	11.5	6	34	6.5	60	10h6		101		
9.3284.0301	125	14.0	6	40	9.0	58	12h6		102		
9.3284.0401	160	17.0	8	43	12.0	64	18h6		103		
9.3284.1201	100	11.5	6	34	6.5	60	10h6				201
9.3284.1301	125	14.0	6	40	9.0	58	12h6				202
9.3284.1401	160	17.0	8	43	12.0	64	18h6				203

27805

Adjustable clamp sets for type EL/NC/DS

ROEMHELD
HILMA • STARK

Design

4 pieces, with screws.

Applications
For machine vices art. no. 27695, 27800.

27805

Type	For type	Clamping edge mm	Groove mm	Cheese head	27805	...
9.3777.2011	EL/NC 100, DS 100	24	14	M 12		101
9.3777.3011	EL/NC 125/160, DS 125	27	14	M 12		102
9.3777.3021	EL/NC 125/160, DS 125	27	18	M 16		103



Info

Double clamping system, DS

The ideal component for efficient multiple clamping. One-sided spindle action and 3rd manual function enables successive loading and unloading of the clamping points with workpieces of the same size or different sizes. The spindle chamber is completely enclosed, providing optimum protection against chips and coolant. A zero-backlash linear guide ensures maximum precision. Pre-selectable clamping force via torque wrench.

Please enquire as necessary.





Design

- Fast and precise clamping of a wide variety of workpieces
- Changeover in seconds for different machining operations
- Loose surfaces become superfluous, as does time-consuming cleaning
- Stable and robust construction, also suitable for high clamping forces
- Compressed air supply via valves on both front ends
- Enclosed on all sides when installed, thus low maintenance
- Recommended air pressure: 5.5 bar
- Contents: 1 piece

Applications

Clamping jaw system with positioning pins eliminates the need for complex and time-consuming clamping devices; practical, fast and uncomplicated position fixing of workpieces in seconds.

Quality

High-quality tool steel, hardened, ground and treated with a special oxidation process.



Advantage: Actuate once with the blow-out gun and all pins are driven out



27895 201



27895 202



27895 203



27895 204

Jaw width mm	For vice brand	For vice type	Pitches of mounting hole (w x h)	27895	...
125	Hilma:	NC 125, NC 125 H, EL 125, KNC 125	2 x M 8		201
125	ATORN:	MM-G 125			202
	Gressel:	Gripos GPS 125, Gripos GPS 125-VS, Gripos2, Grepos-5X, Grepos-5X-S, Grefors, S2, Duogrip, C2, Ecopos	2 x M 8/1 x M 10		
	Kesel:	CNC 125, Bull pneumatic 125, Bull 125 mechanical, ARNO 125			
	Röhm:	RKE 125, RKE-L 125, RKE-U 125, RKG-L 125, RKE-LV 125			
160	Hilma:	NC 160, NC 160 H, EL 160, KNC 160	2 x M10		203
160	ATORN:	MM-G 160			204
	Gressel:	Gripos GPS 160, Gripos GPS 160-VS, Gripos2, Grepos-5X, Grefors, S2, Duogrip, C2, Ecopos	3 x M 10		
	Kesel:	CNC 160, Bull pneumatic 160, Bull 160 mechanical, ARNO 160			
	Röhm:	RKE 160, RKE-L 160, RKE-U 160, RKG-L 160, RKE-LV 160			



27890

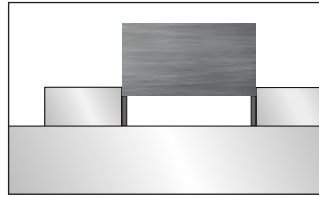
Magnetic parallel rest sets

ATORN®**Design**

- Made from hardened, bronzed and distortion-free tool steel
- High retention force of the magnets

Advantage:

Strip width 2.5 mm, enabling machining close to the edge.



Height tolerance +/- mm	Length mm	Width mm	Contents, pairs	Contents, height mm	27890	...
0.01	100	2.5	5	20/27/29/31/32	101	
0.01	125	2.5	5	15/30/35/37/39	102	
0.01	160	2.5	5	22/30/37/42/47	103	

36600

Precision parallel rest sets

AMF®**Design****- Pairs**

- Plane parallel, finely ground
- Size specifications on the face
- Sets cover a wide range with 1 mm increment
- Case-hardened.
- **Nominal dimension tolerance +/- 0.01 mm**
- Remaining dimensions in accordance with **DIN ISO 2768 m**
- In wooden holder

Applications

For clamping and positioning a wide range of workpieces, e.g. when grinding, milling, eroding, measuring and marking off.

In connection with corresponding clamping tools such as the precision grinding and eroding vice, ideal for exact-angle or exact-parallel processing of a wide range of workpieces.

Note:

Designs of special dimensions, in high precision or as individual pairs available on request.

36600 101**Design****Length 100 mm.**

Box contents one pair each:

2 x 5 / 2 x 10 / 2 x 15 / 2 x 20 / 3 x 6 / 3 x 11 /
3 x 16 / 3 x 21 / 4 x 7 / 4 x 12 / 4 x 17 / 4 x 22 /
5 x 8 / 5 x 13 / 5 x 18 / 5 x 23 / 6 x 9 / 6 x 14 /
6 x 19 / 6 x 24 mm.

36600 103**Design****Length 125 mm.**

Box contents one pair each:

8 x 11 / 8 x 16 / 8 x 21 / 8 x 26 / 8 x 31 / 8 x 36 /
10 x 13 / 10 x 18 / 10 x 23 / 10 x 28 / 10 x 33 /
10 x 38 / 12 x 15 / 12 x 20 / 12 x 25 / 12 x 30 /
12 x 35 / 12 x 40 / 14 x 17 / 14 x 22 / 14 x 27 /
14 x 32 / 14 x 37 / 14 x 42 mm.

36600 102**Design****Length 150 mm.**

Box contents one pair each:

8 x 11 / 8 x 16 / 8 x 21 / 8 x 26 / 8 x 31 / 8 x 36 /
10 x 13 / 10 x 18 / 10 x 23 / 10 x 28 / 10 x 33 /
10 x 38 / 12 x 15 / 12 x 20 / 12 x 25 / 12 x 30 /
12 x 35 / 12 x 40 / 14 x 17 / 14 x 22 / 14 x 27 /
14 x 32 / 14 x 37 / 14 x 42 mm.

Pair tolerance in height mm	Length mm	Contents pairs	36600	...
IT 5	100	20	101	
IT 5	125	24	103	
IT 5	150	24	102	



36602

Parallel rest sets

Design

- Case-hardened and ground
- Contact surfaces finely ground
- **Nominal dimension tolerance** up to height 30 mm = +/- 0.2 mm, from height 35 mm = +/- 0.3 mm.
- Nominal dimensions in accordance with **ISO 2768 m**
- In wooden case with removable hinged lid

Contents:

1 pair each (= 14 pairs).

Height of the measuring surfaces mm:

14/16/18/20/22/ 24/26/28/30/32/35/40/45/50.

Pair tolerance, height mm	Length mm	Width mm	Contents, pairs	36602	...
0.01	150	10	14	101	



36615

Parallel rest sets

AMF®**Design**

- Case-hardened and ground
- Contact surfaces finely ground
- **Nominal dimension tolerance, height +/- 0.004 mm**
- Nominal length and width in accordance with **ISO 2768 m**
- In wooden case with removable hinged lid

Applications

As spacers for workpieces in a wide variety of machining operations.

The constant width means that the parallel rests can be built up in height.

The removable hinged lid allows the set to be stored open in the tool cabinet.

Contents:

1 pair each (= 14 pairs).

Height of the measuring surfaces mm:

14/16/18/20/22/24/26/28/30/32/35/40/45/50.

Pair tolerance, height mm	Length mm	Width mm	Contents, pairs	36615	...
0.004	150	10	14	101	

