

# Orange Line

Success with standard products

## Orange Line - Success with standard products



→ Drill Chucks



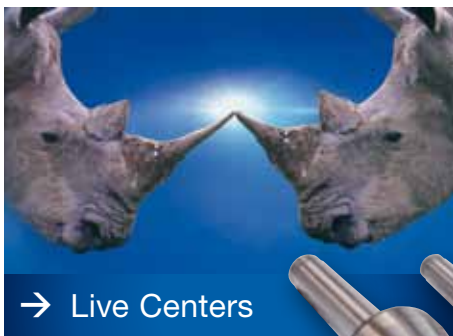
**As a specialist in clamping technology RÖHM has been developing and producing all the chucking tools needed by its customers for more than 100 years.**

With the new „Orange Line“ RÖHM now offers favourable products at proven RÖHM quality. In future the customer will benefit from faster processes in ordering and service.

The Orange Line includes the product groups drill chucks, live centers, lathe chucks and vices. It offers one product per product group in the most common sizes. Variants and special functions have been excluded.

The Orange Line offers many valuable advantages:

- Standard products with proven characteristics
  - Long life
  - Heavy duty
  - Various fields of application
- Fast delivery
- Fast repair and service performance
- Very good price performance ratio



→ Live Centers



→ Geared Scroll Chucks



Our wide product range with clamping tools for each application area can be found in our main catalogue or at [www.roehm.biz](http://www.roehm.biz).



→ Vices



# Drill Chucks

With our keyless drill chucks **EXTRA RV-E** and the key-type drill chucks **PRIMA-L** you are perfectly prepared for any kind of application.



- Keyless clamping by turning the sleeve
- Suitable for
  - Percussion drilling
  - Drilling in steel and wood
  - Screwing
- Metal and plastic sleeve design
- With through-hole for clockwise and anti-clockwise rotation
- With retaining ring for machines without spindle stop

## Extra-RV-E with radial locking



Item no.	Size	Clamping capacity	Mount	Retaining ring	External Ø	Length opened	Length closed	Through-hole	Sleeve
1261215 ●	10	1-10	1/2"-20		42,7	50,2	60	•	plastic
1261216 ●	10	1-10	1/2"-20	•	42,7	50,2	60	•	plastic
1261217 ●	10	1-10	3/8"-24	•	42,7	50,2	60	•	plastic
1261211 ●	13	1,5-13	1/2"-20		42,7	57	67,5	•	metal
1261212 ●	13	1,5-13	1/2"-20	•	42,7	57	67,5	•	metal
1261213 ●	13	1,5-13	1/2"-20		42,7	57	67,5	•	plastic
1261214 ●	13	1,5-13	1/2"-20	•	42,7	57	67,5	•	plastic

● from stock



keyless



metal sleeve



plastic sleeve



percussion drilling



- Suitable for
  - Percussion drilling
  - Drilling in steel and wood
  - Screwing
- With through-hole for clockwise and anti-clockwise rotation
- Tothing according to DIN 6349

## Prima-L



Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Key size	Through-hole
1261225 ●	10	1-10	1/2"-20	33,5	49,5	61,5	S2 A	•
1261226 ●	10	1-10	3/8"-24	33,5	49,5	61,5	S2 A	•
1261227 ●	13	1,5-13	1/2"-20	42,5	59	74,5	S2 A	•
1261228 ●	13	1,5-13	3/8"-24	42,5	59	74,5	S2 A	•

● from stock



with key



metal sleeve



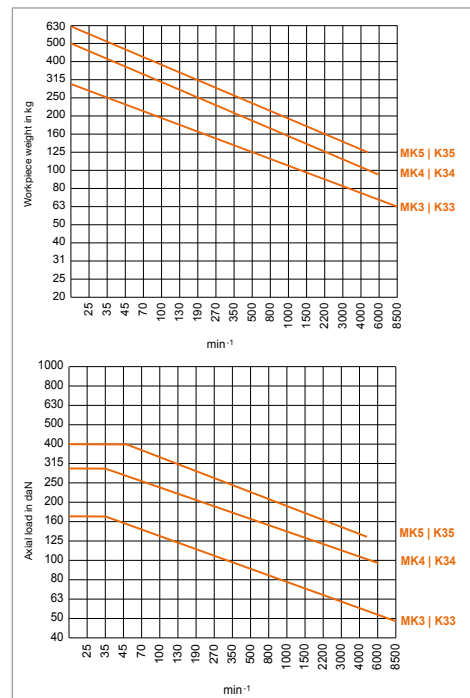
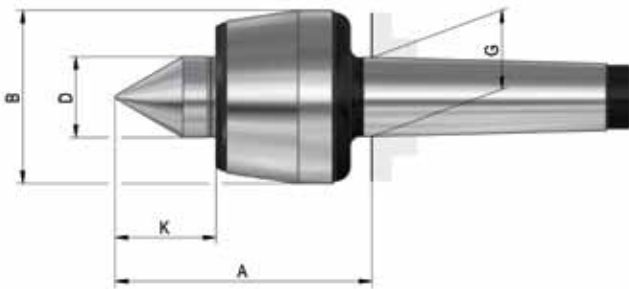
percussion drilling

# Revolving Tailstock Centers

The revolving tailstock centers of the Orange Line meet all basic requirements of turning machining at best price performance ratio. Available in the versions MT 3, MT 4 und MT 5. Further tailstock centers for different applications can be found in our main catalogue.



- High runout accuracy
- Triple bearing method
- Center hardened, repeated regrinding at will
- Long life due to:
  - Splash water groove
  - Improved life-time lubrication
  - Close toleranced bearing seat
- Lower interference shape due to slim housing



**Revolving tailstock center**  
Body hardened and ground -  
tip angle 60°

Item no.	1267217 ●	1267218 ●	1267219 ●
Mount MT	3	4	5
Size	K33	K34	K35
A	82,5	101,5	128
B	55	68,5	88,5
D	25	32	40
G	23,825	31,267	44,399
K	30,3	39,8	49,3
Weight approx. g	1000	1800	4300
Workpiece weight max. kg	300	500	630
Concentricity deviation	0,005	0,005	0,005
Speed max. min <sup>-1</sup>	8500	6000	4500
<b>Spare live centers</b>	<b>1243613</b>	<b>1241722</b>	<b>1241721</b>

● from stock

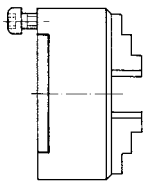
# Geared Scroll Chuck ZG

In the area of manual lathe chucks the Orange Line offers the geared scroll chuck ZG as favourable alternative to the proven steel version ZS. The ZG is available with high value cast iron body and one-piece jaws in 5 sizes as a 3-jaw version and in 5 sizes as a 4-jaw version. Suitable adapter flanges and additional lathe chucks can be found in the main catalogue.



- Self-centering
- Jaws can be moved across the entire clamping range. Due to this, workpieces with different diameters can be clamped without changing or shifting the jaws.
- Vibration isolation body made of iron cast
- Scroll drop-forged, balanced, hardened
- With one set of outward stepped jaws and one set of inward stepped jaws

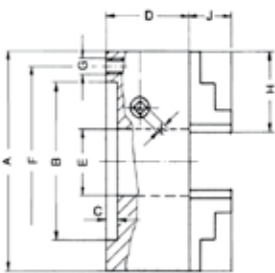
Lathe chuck with scroll ZG  
DIN 6350 - Cylindrical centre mount, form A



Size	ZA	Through-hole	3-jaw chuck with outward and inward stepped jaws	4-jaw chuck with outward and inward stepped jaws	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
100	70	20	101781 ●	102129 ●	4500	60	27
125	95	32	101628 ●	106074 ●	4000	80	31
160	125	42	100300 ●	100325 ●	3600	110	47
200	160	55	100000 ●	100465 ●	3000	140	55
250	200	76	100200 ●	100834 ●	2500	150	63
315	260	103	101248 ●	101567 ●	2000	180	69

● from stock

Cylindrical center mount DIN 6350



Size A	100	125	160	200	250	315
B <sup>H6</sup>	70	95	125	160	200	260
C	3	4	4	4	5	5
D	50	56	65	73,5	82	95
E	20	32	42	55	76	103
F	83	108	140	176	224	286
G	3xM8	3xM8	3xM10	3xM10	3xM12	3xM16
H	48	52	61	69	90	130
J	18	22,5	26	32,5	40	46
K	8	9	10	11	12	14
approx. kg	2,9	4,5	8,2	14,6	25,7	44,2

Suitable clamping jaws can be found in our clamping jaw catalogue as well as our clamping jaw finder at [www.spannbacken.biz](http://www.spannbacken.biz).



3-jaw chuck



inside jaw/outside jaw



side machining



pipe



disc



rotating



4-jaw chuck



selfcentering



length machining



bar



flange



stationary



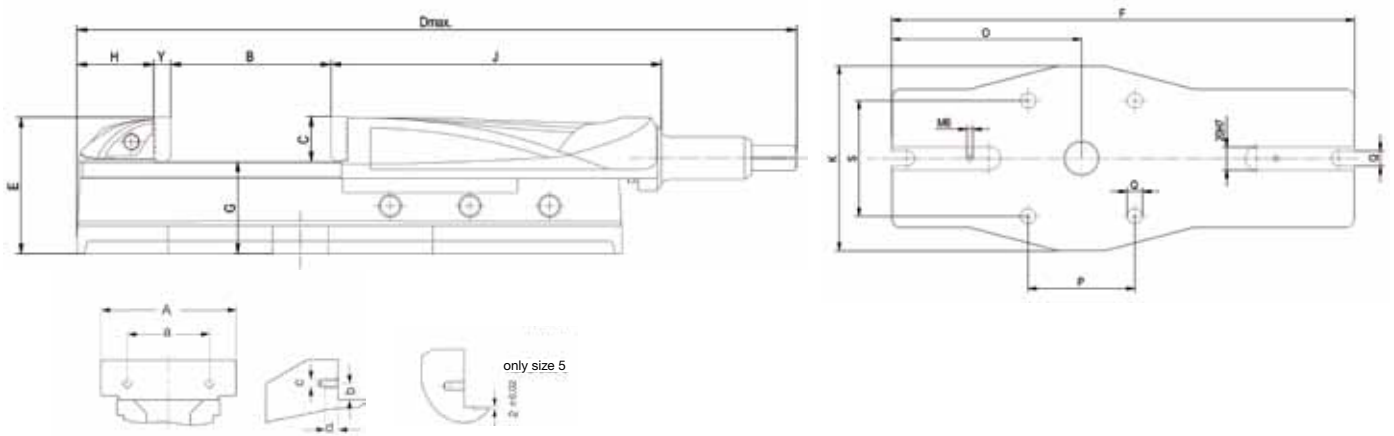
[www.jawfinder.biz](http://www.jawfinder.biz)

## Vices RB-M

The vices RB-M are operated completely mechanically via a threaded spindle. Defined clamping force initiation is possible by the means of a torque wrench and the suitable adapter. The new machine vices RB-M are being released in a new design especially for the Orange Line.



- Mechanically operated via threaded spindle
- High precision due to precise jaw guides
- Rapid clamping range adjustment via locking pin
- The new design enables a better coolant and chip flow
- High wear resistance due to hardened jaw guides
- Can be used on a rotation plate with angular spacing
- Ground area with longitudinal groove for accurate fixing on machine table
- Clamping option with clamps
- Enclosed spindle



Item no.	179080	179081	179082	179083	179084
<b>RB-M (mechanical)</b>					
Size	1	2	3	4	5
Jaw width A	92	113	135	160	200
Clamping capacity B	0-100	0-185	0-240	0-330	0-370
C	31,6	31,6	39,6	49,6	66,6
D <sub>max</sub>	420	586	686	860	1015
E	91	97	112	133	171
F	310	390	468	574	685
G±0,02	59	65,5	72,5	83,5	104,5
H	50	55	70	80	90
J	218	236,5	262	298	375
K	160	160	200	240	280
O	115	160	180	220	230
P	90	90	90	90	160
Q	13	13	13	17	21
S	100	100	135	180	180
Y	12	12	16	16	20
a	63	63	80	100	140
b	13,6	13,6	15,6	19,6	23
c	M6	M6	M8	M8	M10
d	12	12	13	13	16
Clamping force kN	20	25	35	45	55
Weight kg	15,5	24	39	60	112
Adapter for 1/2" torque wrench	168721	161103	162192	161730	161730

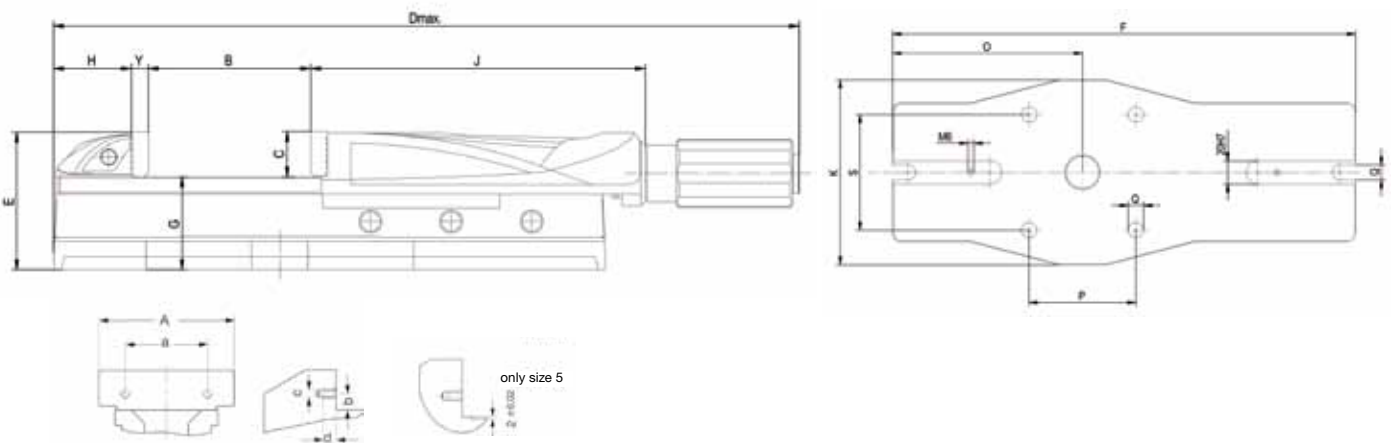
● from stock

# Vices RB-K (power intensification)

The vices RB-K are operated mechanically with power intensification. The new machine vices are being released in a new design especially for the Orange Line.



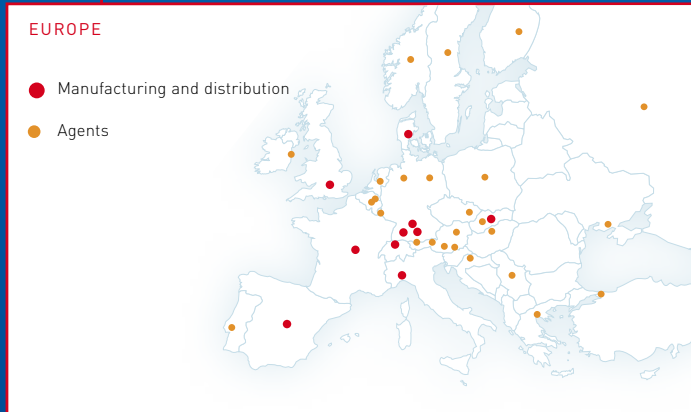
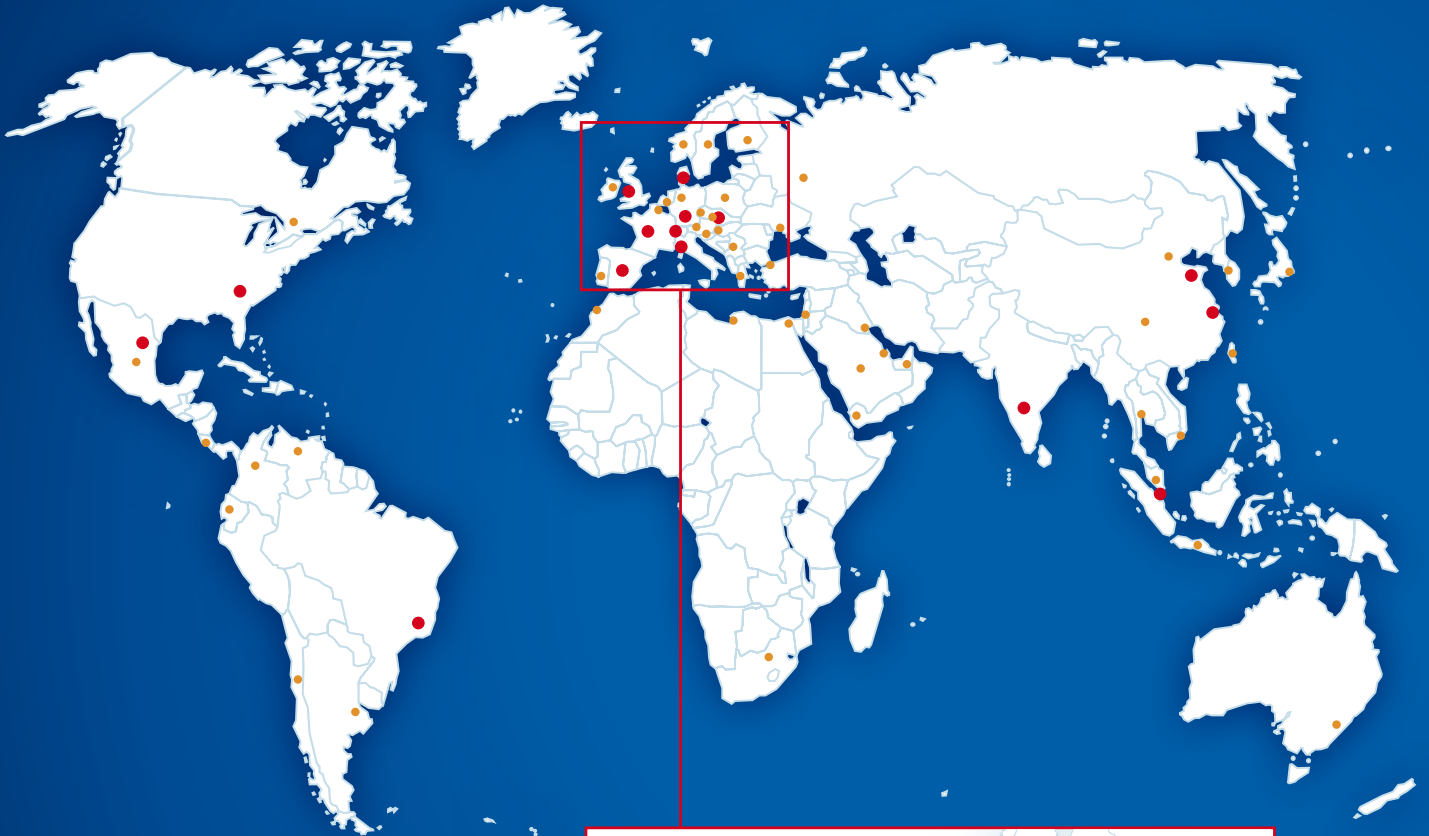
- Stepwise clamping force presetting
- Clamping without power intensification for deformation-sensitive workpieces possible
- High precision due to precise jaw guides
- Rapid clamping range adjustment via locking pin
- The new design enables a better coolant and chip flow
- High wear resistance due to hardened jaw guides
- Can be used on a rotation plate with angular spacing
- Ground area with longitudinal groove for accurate fixing on machine table
- Clamping option with clamps
- Enclosed spindle



**RB-K**  
With SGN normal jaws and hand crank

Item no. RB-K (power intensification)	179075 ●	179076 ●	179077 ●	179078 ●	179079 ●
Size	1	2	3	4	5
Jaw width A	92	113	135	160	200
Clamping capacity B	0-100	0-170	0-220	0-310	0-350
C	31,6	31,6	39,6	49,6	66,6
D <sub>max</sub>	490	583	679	817	1022
E	91	97	112	133	171
F	310	390	468	574	685
G±0,02	59	65,5	72,5	83,5	104,5
H	50	55	70	80	90
J	218	236,5	262	298	375
K	160	160	200	240	280
O	115	160	180	220	230
P	90	90	90	90	160
Q	13	13	13	17	21
S	100	100	135	180	180
Y	12	12	16	16	20
a	63	63	80	100	140
b	13,6	13,6	15,6	19,6	23
c	M6	M6	M8	M8	M10
d	12	12	13	13	16
Clamping force kN	25	30	40	50	100
Weight kg	15,5	24	39	60	112

● from stock



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