

# Operation guide



TYPE	RKE				RKE-M				RKE-LV		RKK		
NC-Compact vices													
<b>Features</b>	- Highest clamping precision - Clamping force presetting - Precise, wear-resistant body				- Highest clamping precision - Without clamping force presetting - Precise, wear-resistant body				- Very good accessibility for 5-axis machining - Clamping force presetting - Large clamping range		- Designed to resist deformation for the highest clamping precision - Greatest repeatability - Clamping force presetting		
<b>Clamping system</b>	mechanical-mechanical size 92: mechanical-hydraulic				mechanical				mechanical-mechanical		mechanical-mechanical		
<b>Force amplification</b>	✓								✓		✓		
<b>Set-up options</b>	3-Side, Duo-Tower Quattro-Tower				3-Side, Duo-Tower Quattro-Tower				Base		3-Side, Duo-Tower Quattro-Tower		
Machining centers with high working accuracy	✓✓				✓✓				✓✓		✓✓		
Universal milling machines with high working accuracy	✓✓				✓✓				✓✓		✓✓		
Universal milling machines standard version	✓				✓				✓		✓		
Jig boring machines	✓✓				✓✓				✓✓		✓✓		
5-axis machining	✓				✓				✓✓		✓		
Grinding machines	✓				✓				✓		✓		
Series production	✓				✓				✓		✓		
For limited space	✓				✓				✓✓		✓		
<b>Jaw width mm</b>	92 <sup>1)</sup>	125 <sup>1)</sup>	160 <sup>1)</sup>	200 <sup>1)</sup>	92 <sup>1)</sup>	125 <sup>1)</sup>	160 <sup>1)</sup>	200 <sup>1)</sup>	125 <sup>1)</sup>	125 <sup>3)</sup>	135 <sup>2)</sup>	160 <sup>2)</sup>	200 <sup>2)</sup>
Clamping range (max.)	208	312	451	451	208	312	451	451	192	225	215	340	340
Length (opened) mm	345	478	633	633	315	442	607	607	372	372	483	618	618
Width mm	94	126	162	162	94	126	162	162	126	126	150	205	205
Height mm	112	140	165	175	112	140	165	175	140	130	148	179	189
Clamping force (max.) kN	25	40	60	60	25	40	60	60	40	40	40	60	60
Weight kg	15	41	79	85	15	41	79	85	29	29	50	107	108
<b>Page</b>	4012				4020				4032		4038		



yes



suitable



very suitable

<sup>1)</sup> with stepped jaws  
<sup>2)</sup> with standard jaws  
<sup>3)</sup> with carrier jaws

<sup>4)</sup> with claw-type jaws  
<sup>5)</sup> with heightend stepped jaws

# Operation guide



TYPE	RKD-M		RZM				RKZ-M				
	NC-Compact twin vices		NC-Compact self centering vices								
<b>Features</b>	<ul style="list-style-type: none"> <li>- Double, centric and compact wrench (removable middle jaw)</li> <li>- Greatest repeatability</li> <li>- Low rapid traverse</li> </ul>		<ul style="list-style-type: none"> <li>- Very large clamping stroke due to patented guide system</li> <li>- Open design for optimal chip flow</li> <li>- Overhead spindle for optimal power transmission</li> </ul>				<ul style="list-style-type: none"> <li>- Highest average precision and repeatability</li> <li>- Minimum collision contour</li> </ul>				
<b>Clamping system</b>	mechanical		mechanical				mechanical				
<b>Force amplification</b>	*		*				*				
<b>Set-up options</b>	3-Side Duo-Tower, Quattro-Tower		Base				Base				
Machining centers with high working accuracy	✓✓		✓				✓				
Universal milling machines with high working accuracy	✓✓		✓				✓				
Universal milling machines standard version	✓✓		✓				✓				
Jig boring machines	✓✓		✓				✓				
5-axis machining			✓✓				✓				
Grinding machines	✓		✓				✓				
Series production	✓		✓				✓				
For limited space	✓		✓✓				✓				
<b>Jaw width mm</b>	<b>92<sup>1)</sup></b>	<b>125<sup>1)</sup></b>	<b>92<sup>4)</sup></b>	<b>92<sup>4)</sup></b>	<b>125<sup>4)</sup></b>	<b>125<sup>4)</sup></b>	<b>50<sup>1)</sup></b>	<b>70<sup>1)</sup></b>	<b>92<sup>1)</sup></b>	<b>125<sup>1)</sup></b>	<b>125<sup>5)</sup></b>
Clamping range (max.)	127	180	160	100	142	222	111	153	208	269	269
Length (opened) mm	480	617	230	170	298	218	157	209	283	353	353
Width mm	94	126	94	94	125	125	52	72	94	126	126
Height mm	117	145	174	174	196,5	196,5	75	95	117	145	165
Clamping force (max.) kN	25	40	20	20	25	25	10	15	20	25	25
Weight kg	24	52	11,7	11,5	17,4	20,3	3,5	7	18	32,5	35
<b>Page</b>	4050		4058				4062				

\* Constant clamping force for each clamping process and high repeatability in combination with a torque wrench

# Operation guide



ORANGE LINE



TYPE	RB-K Orange Line					RBAW		
	Machine vices					NC-power vices		
<b>Features</b>	- Great accuracy due to precise jaw guidance - Fast clamping range adjustment using the pin system					- Integrated angular drive - Clamping width presetting		
<b>Clamping system</b>	mechanical-hydraulic					mechanical-hydraulic		
<b>Force amplification</b>	✓					✓		
<b>Set-up options</b>	Base					3-Side		
Machining centers with high working accuracy	✓✓					✓✓		
Universal milling machines with high working accuracy	✓✓					✓✓		
Universal milling machines standard version	✓					✓		
Jig boring machines	✓✓					✓✓		
5-axis machining								
Grinding machines	✓					✓		
Series production	✓					✓		
For limited space	✓					✓		
<b>Jaw width mm</b>	<b>92</b>	<b>113</b>	<b>135</b>	<b>160</b>	<b>200</b>	<b>113</b>	<b>135</b>	<b>160</b>
Clamping range (max.)	100	170	220	310	350	175	225	310
Length (opened) mm	490	583	679	817	1022	500	578	702
Width mm	160	160	200	240	280	115	137	162
Height mm	91	97	112	133	171	96	111	132
Clamping force (max.) kN	25	30	40	50	100	30	40	50
Weight kg	15,5	24	39	60	112	22	36	62
<b>Page</b>	4074					4080		



yes



suitable



very suitable

# Operation guide



TYPE	MSR					RS					UZ				
	Machine vices														
<b>Features</b>	- Fast clamping range adjustment using the pin system					- Made of special steel casting for flexible application - Entire clamping range can be reached by turning the crank					- Centric clamping - Spindle covered in the working area				
<b>Clamping system</b>	mechanical					mechanical					mechanical				
<b>Force amplification</b>	*					*					*				
<b>Set-up options</b>	Base					Base					Base				
Machining centers with high working accuracy	✓					✓					✓				
Universal milling machines with high working accuracy	✓					✓					✓				
Universal milling machines standard version	✓					✓					✓				
Jig boring machines															
5-axis machining															
Grinding machines	✓					✓					✓				
Series production	✓					✓					✓				
For limited space	✓					✓					✓				
<b>Jaw width mm</b>	<b>125</b>	<b>150</b>	<b>150</b>	<b>175</b>	<b>175</b>	<b>92</b>	<b>113</b>	<b>135</b>	<b>160</b>	<b>200</b>	<b>113</b>	<b>135</b>	<b>160</b>	<b>200</b>	<b>250</b>
Clamping range (max.)	150	200	300	400	400	85	105	125	145	185	110	140	180	300	400
Length (opened) mm	401	487	587	701	701	362	423	510	575	675	358	408	495	655	767
Width mm	95	125	125	145	145	160	160	200	240	280	132	152	180	200	220
Height mm	80	100	100	118	118	79,6	89,6	103,6	119,6	144,6	92,6	105,1	123,6	141,6	147,6
Clamping force (max.) kN	30	50	50	60	60	18	25	35	45	55	15	22	24	25	28
Weight kg	12,7	25,6	29,5	51,2	51,2	12	13,5	25	40	65	12,4	19	31	52	71
<b>Page</b>	4086					4088					4092				

\*Constant clamping force for each clamping process and high repeatability in combination with a torque wrench

# Operation guide



TYPE	BSS		BOF				BSH							DPV				DPV 3-W	
Drilling machine vices																			
<b>Features</b>	- Compact and stable construction - Entire clamping range can be reached by turning the crank		- Compact and stable construction - Entire clamping range can be reached by turning the crank - Long guidance of the movable jaws also in the outer clamping range				- Do-it-yourself version			- Robust and stable version				- Covering of the threaded spindle by cover sleeve - Constructional length remains the same - Entire clamping range can be reached by turning the crank					
<b>Clamping system</b>	mechanical manually operated		mechanical manually operated				mechanical manually operated							mechanical manually operated					
<b>Force amplification</b>																			
<b>Set-up options</b>	Base		Base				Base							Base				3-Side	
Machining centers with high working accuracy																			
Universal milling machines with high working accuracy																			
Universal milling machines standard version																			
Jig boring machines																			
5-axis machining																			
Grinding machines																			
Series production	✓		✓				✓							✓					
For limited space																			
<b>Jaw width mm</b>	<b>110</b>	<b>135</b>	<b>90</b>	<b>110</b>	<b>135</b>	<b>160</b>	<b>65</b>	<b>80</b>	<b>100</b>	<b>80</b>	<b>100</b>	<b>120</b>	<b>140</b>	<b>80</b>	<b>100</b>	<b>120</b>	<b>150</b>	<b>100</b>	
Clamping range (max.) mm	100	160	90	130	160	220	65	85	80	80	95	110	150	70	92	110	125	93	
Length (opened) mm	510	587	195	315	365	445	125	150	170	200	215	260	300	154	175	225	238	189	
Width mm	175	205	145	175	205	245	105	130	175	140	175	215	220	142	152	180	198	159	
Height mm	72,5	80,5	60	72,5	80,5	95,5	43	46	47	70	75	85	85	58	63,5	63,5	65	65	
Clamping force (max.) kN	10	10	8	10	12	15													
Weight kg	9,5	13,5	5,5	9,5	13,5	25	1,2	1,7	4,2	5	7	11	12,5	3,6	4,3	6,3	8,1	5,1	
<b>Page</b>	4098		4098				4099							4100				4100	



yes



suitable



very suitable

# Operation guide



TYPE	PL-S micro		PL-S			PLF			PL-G			PS-SV		PS-ZD	
<b>Grinding and inspection vice</b>															
<b>Features</b>	<ul style="list-style-type: none"> <li>- Draw-down effect</li> <li>- Simple clamping and releasing with allen key</li> <li>- Clamping jaw adjustable in steps; engages automatically</li> <li>- No spindle</li> </ul>					<ul style="list-style-type: none"> <li>- Draw-down effect</li> <li>- Made of alloyed tool steel, hardened and finely ground</li> <li>- Horizontal and vertical ground prism</li> <li>- No spindle which could, become dirty during erosion</li> </ul>			<ul style="list-style-type: none"> <li>- Clamping and releasing with threaded spindle</li> <li>- Made of alloyed tool steel, hardened and finely ground</li> </ul>			<ul style="list-style-type: none"> <li>- Made of alloyed tool steel, hardened and finely ground</li> <li>- Bearing and location pins hardened and ground with a precision of 0.001 mm</li> <li>- The clamping device can be positively locked in any angular position</li> </ul>		<ul style="list-style-type: none"> <li>- Positive locking in any desired angular position by locking screws</li> <li>- Made of alloyed tool steel, hardened and finely ground</li> <li>- Can be rotated 360°</li> </ul>	
<b>Clamping system</b>	mechanical, manually operated					mechanical, manually operated			mechanical, manually operated			mechanical, manually operated		mechanical, manually operated	
<b>Force amplification</b>															
<b>Set-up options</b>	Base					Base			Base			Base		Base	
Machining centers with high working accuracy															
Universal milling machines with high working accuracy															
Universal milling machines standard version															
Jig boring machines															
5-axis machining															
Grinding machines	✓✓					✓✓			✓✓			✓✓		✓✓	
Series production															
For limited space															
<b>Jaw width mm</b>	<b>34</b>	<b>45</b>	<b>70</b>	<b>90</b>	<b>120</b>	<b>50</b>	<b>73</b>	<b>100</b>	<b>60</b>	<b>73</b>	<b>88</b>	<b>70</b>	<b>90</b>	<b>70</b>	<b>120</b>
Clamping range (max.)	25	50	80	120	150	65	100	125	55	100	125	80	120	80	150
Length (opened) mm	75	110	160	210	280	140	190	245	110	210	250	160	210	180	270
Width mm	34	45	70	90	120	50	73	100	60	73	88	70	90	110	160
Height mm	35	45	62	80	90	50	67	90	50	67	88	93	113	137	210
Clamping force (max.) kN	2	2	2,5	3	4	1,6	2	5	2	4	4	6	7	-	-
Weight kg	0,35	1	3	5,8	13,5	1,4	4,1	7,3	1,6	4	7,6	5,3	11	11,1	43
<b>Page</b>	4104					4105			4105			4106		4106	

\* Constant clamping force for each clamping process and high repeatability in combination with a torque wrench