

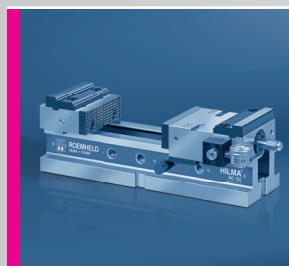
Program summary

ROEMHELD Group

Workholding elements
Hydraulic cylinders



Workholding systems
Machine vices



Zero point clamping systems



Clamping power units



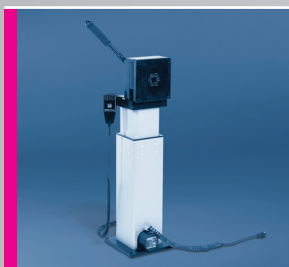
Hydraulic components



Pneumatic elements



Handling technology



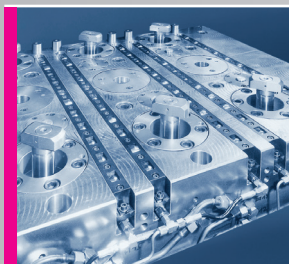
Press-in devices



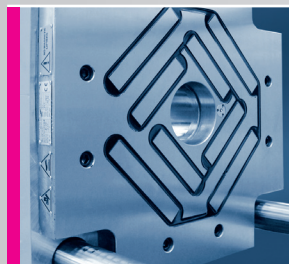
Drive technology



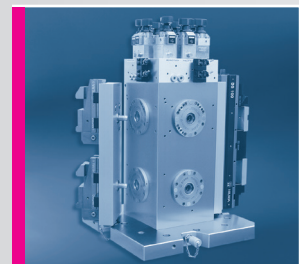
Die clamping systems



Magnetic clamping technology



System solutions





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Quality as an obligation

To take a leadership role in the national as well as international quality competition the ROEMHELD Group feels obliged to a continuous process of improvements. Thereby the high quality of the processes and products is always guaranteed even with continuously changing demands on the market.

Certification as per EN ISO 9001:2000 guarantees the compliance with standard guidelines.

In addition, it is a stated objective to make the products and services of the ROEMHELD Group an established idea of quality. This will be a long-term guarantee that the ROEMHELD Group will offer efficient and economic products and will contribute to a considerable extent to the success of its customers.

Solutions from the catalogue or as a customer-specific design

In addition to the most comprehensive range of catalogue elements and systems, available in clamping technology, the ROEMHELD Group permanently develops, designs, manufactures and supplies customer-specific solutions in cooperation with their customers.

This program summary of the product range of the ROEMHELD Group shows essentially the catalogue program.

Please contact for customer-specific designs the corresponding companies of the ROEMHELD Group.

International aimed at global presence

Beside national customers, which are well looked after by 17 sales partners in Germany, export is more and more important. Already today the ROEMHELD Group shows an export share of approx. 50 %, which increases to more than 65 % because of indirect exports.

Subsidiaries in Great Britain, France, USA, China, Japan, and South Korea as well as numerous sales partners guarantee worldwide an intensive consultation, an efficient sale and an extensive service for the customers of the ROEMHELD Group.

Environment The protection of the environment is important to us

The companies of the ROEMHELD Group have their own environmental management systems. These ensure that the impact of the production on the outside world is kept to a minimum, only the necessary extent of emissions occur and resources such as energy, water, air and raw materials are used as carefully as possible.

The environmental management system of ROEMHELD is certified according to EN ISO 14001.



ROEMHELD a strong Group

Römheld forms together with the specialists in clamping technology Hilma-Römheld and Stark Spannsysteme a group of companies, which offers an extensive product range in the field of clamping technology for production engineering. The product range is supplemented by numerous hydraulic elements for general industrial use, as well as components and systems of the assembly and drive technology.

The ROEMHELD Group comprises about 500 employees with an annual turnover of approx. 105 million Euro.

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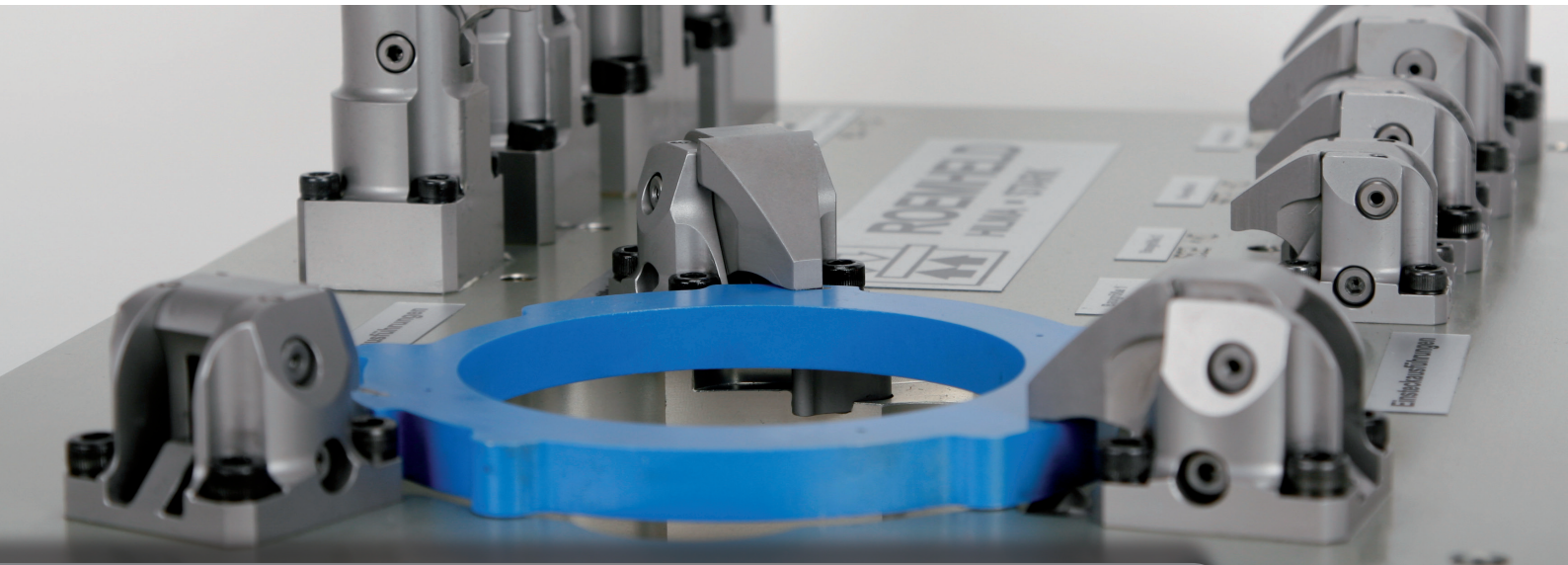


Stark Spannsysteme GmbH

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Austria

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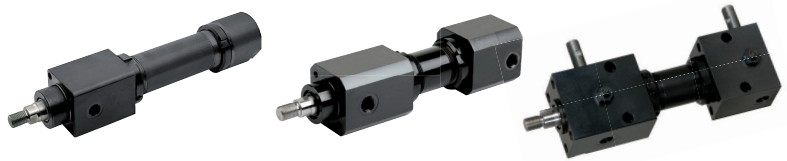
Hydraulic cylinders | Hydraulic workholding elements

Hydraulic cylinders for linear motions of every type
operating pressure: up to 500 bar

Hydraulic cylinders

Hydraulic cylinders, design with tube

with/without end position monitoring
piston diameter: 25 ... 80 mm
stroke: 60 ... 1200 mm



Universal cylinders

Hydraulic cylinders with round housing

for axial adjustability
piston diameter: 10 ... 63 mm
stroke: 8 ... 100 mm



Threaded-body cylinders

Compact hydraulic cylinders and built-in pistons for screwing in

piston diameter: 8 ... 50 mm
stroke: 4 ... 40 mm



Block cylinders

Hydraulic cylinders with block-type body made of steel, aluminium or bronze

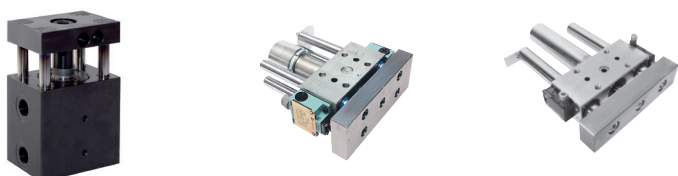
with/without end position monitoring
piston diameter: 16 ... 200 mm
stroke: 8 ... 200 mm



Hydraulic slides

Hydraulic cylinders with integrated guides

with/without end position monitoring
piston diameter: 25 ... 100 mm
stroke: 20 ... 200 mm





Hydraulic elements for positioning and clamping of workpieces operating pressure: up to 500 bar

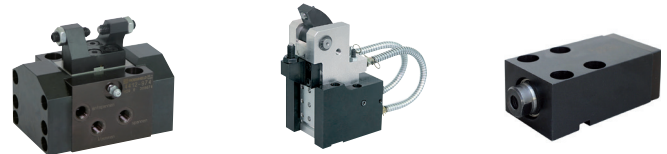
Bore clamps

Clamping elements for clamping in bore holes
with/without centring function / with pull-down clamping
with/without seat check
bore hole diameter: 6.6 ... 46 mm
max. low-clamping force 0.6 ... 24.5 kN



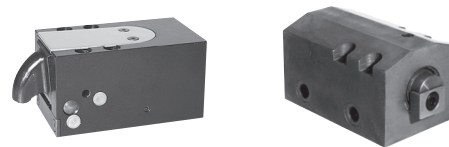
Position flexible clamping elements

Clamping elements for "floating" clamping
for exterior and interior clamping
with/without position monitoring
max. clamping force: 7.5 kN



Clamps / clamping cylinders

Clamping elements for clamping in small recesses
with/without position monitoring
with/without self-locking
max. clamping force: 2.5 ... 50 kN



Hinge clamps

Clamping elements with operation of a clamping lever
with/without position monitoring
max. clamping force: 1.3 ... 21.5 kN
clamping stroke/clamping range: 2.0 ... 9.0 mm



Swing clamps

Clamping elements with swing piston
with/without position monitoring
max. clamping force: 0.6 ... 41 kN
clamping stroke: 6 ... 50 mm



Work supports

Elements to support workpieces
single or double acting
max. load force: 4 ... 102 kN
plunger diameter: 16 ... 50 mm
plunger stroke: 6 ... 20 mm



Concentric clamping elements

Clamping elements for concentric positioning and clamping
for exterior and interior clamping
max. clamping force: 5 ... 44 kN
repetitive clamping accuracy : ± 0.005 mm



Fixture clamps

Compact standard clamping systems for use on fixtures
with fixed jaw, concentric or position flexible
max. clamping force: 6.5 ... 15 kN
jaw width: 40 ... 65 mm



Hollow-piston cylinders

Clamping cylinders with through hole in the piston
piston diameter: 20 ... 80 mm
max. push force: 10 ... 153 kN
clamping stroke: 6 ... 40 mm





Workholding systems | Machine vices

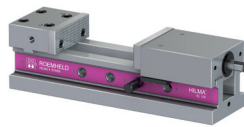
Mechanically, mechanically-hydraulically or hydraulically operated standard fixtures for workpieces

Machine vices

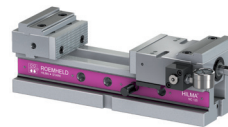
mechanically-hydraulically or hydraulically operated clamping against the fixed jaw

- with hydraulic power transmission
- completely encapsulated lead screw area
- sizes: 100 ... 160 mm
- max. clamping force: 25 ... 50 kN

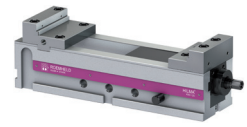
Series EL



Series NC



Series KNC



5-axis workholding systems

mechanically or hydraulically operated clamping against the fixed jaw or concentric clamping

- compact design
- collision-free tool paths
- sizes: 40 ... 125 mm
- max. clamping force: 8 ... 35 kN

Series MC-P



Series SCS



Series PC

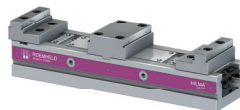


Double workholding systems

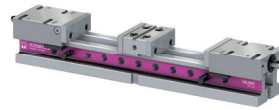
mechanically, mechanically-hydraulically or hydraulically-operated clamping against the fixed jaw

- safe loading and unloading by 3rd-hand function
- sizes: 80 ... 160 mm
- max. clamping force: 25 ... 63 kN

Series DS



Series DF



Series DUO

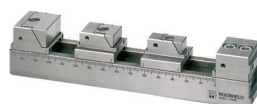


Multiple workholding systems

mechanically operated clamping against the fixed jaw

- compact design
- modular design
- sizes: 24 ... 120 mm
- max. clamping force: 15 ... 40 kN

Series MSH



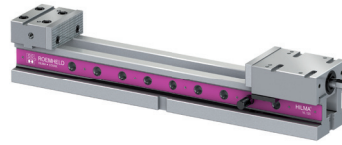


VariLine

Series VL

mechanically-hydraulically or hydraulically operated clamping against the fixed jaw

- option: clamping force display
- system with variants for customised machine vices
- sizes: 100 ... 160 mm
- max. clamping force: 25 ... 60 kN
- length of base: up to 750 mm



Concentric workholding systems

Series ZH

hydraulically operated, double acting concentric clamping

- high repetitive clamping repeatability ± 0.01 mm
- fixing and mounting possibilities for customer-specific clamping jaws
- sizes: 100 ... 160 mm
- max. clamping force: 16 ... 64 kN



Automation

Series ASH

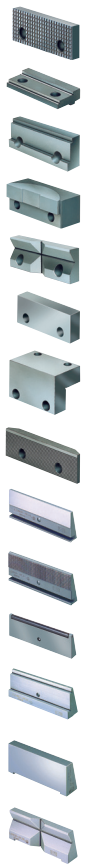
hydraulically operated, double acting clamping against the fixed jaw

- also available with position measuring system (electrically or via flow rate)
- setups can be automated
- sizes: 100 ... 125 mm
- hydraulic stroke: up to 250 mm
- max. clamping force: 32 kN



Clamping jaws

- top jaws with grip
- spacer jaws
- precision step reversible jaws
- precise step bars
- formed jaws
- central jaws
- pendulum jaws
- precision step jaws
- Vee jaws
- QIS base jaws
- with permanent magnets
- QIS interchangeable jaws, smooth
- QIS interchangeable jaws, serrated
- QIS interchangeable jaws, crowned
- QIS interchangeable jaws, stepped
- QIS interchangeable jaws, prismatic
- QIS interchangeable jaws, soft
- floating central jaws
- SlimFlex jaws
- clamping jaws, soft
- clamping jaws, extra high
- clamping jaws, extra large
- clamping jaws with grip bar
- special grip jaws
- reversible step jaws
- interchangeable inserts, round, with grip
- interchangeable inserts with grip / smooth
- interchangeable inserts
- with hard-metal coating / smooth
- reversible jaws



Tower workholding systems

Series TS

arrangement of the clamping points:

TS: 4 x 90° | TS TriStar: 3 x 120°

mechanically operated clamping against the fixed jaw

- version with 3rd-hand function
- version Vector
- sizes: 80 ... 125 mm
- max. clamping force: 20 ... 40 kN



Series TS TriStar



Series TS Vector



Milling and turning machining

Series KK

Box jaws

mechanically operated

- lead screw and nut completely encapsulated
- easy pre-adjustment using a scale
- track: 150 and 180 mm
- max. clamping force: 30 ... 63 kN





Zero point clamping systems

Clamping systems for exact zero point positioning and clamping of the workpieces and fixtures

STARK.metec

easy, compact and sturdy

clamping: mechanically
unclamping: mechanically
max. retention force: 12... 50 kN



STARK.classic

clamping force monitoring, seat check, blast cleaning, flow power

clamping: mechanically
unclamping: hydraulically or pneumatically
max. insertion force: 30 kN
max. retention force: 55 kN



STARK.airtec

quick and precise

clamping: mechanically
unclamping: pneumatically
max. clamping force: 20 kN
max. retention force: 55 kN



STARK.easy click

clamping by pressing

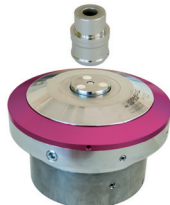
clamping: mechanically
unclamping: pneumatically
max. clamping force: 5 kN
max. retention force: 10 kN



STARK.hydratec

quick and flexible

clamping: hydraulically
unclamping: hydraulically
max. clamping force: 20 kN
max. retention force: 38 kN



STARK.sweeper

for the automation

clamping: mechanically
unclamping: hydraulically or pneumatically
max. insertion force: 20 kN
max. retention force: 38 kN



STARK.plaintec

strong and unique

clamping: hydraulically
unclamping: hydraulically
max. clamping force: 50 kN

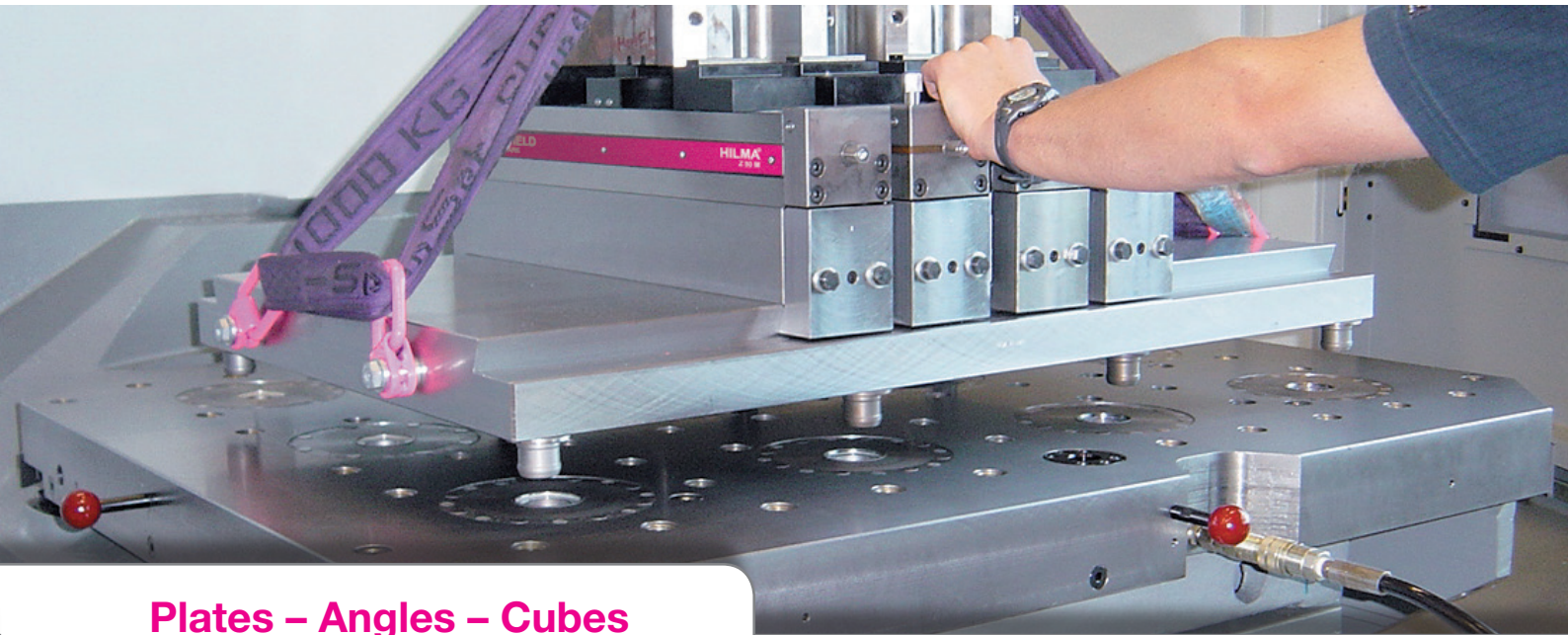


Couplings

universal and compact for hydraulics, pneumatics, vacuum and electrics

nominal diameters: 3... 8 mm





Plates – Angles – Cubes

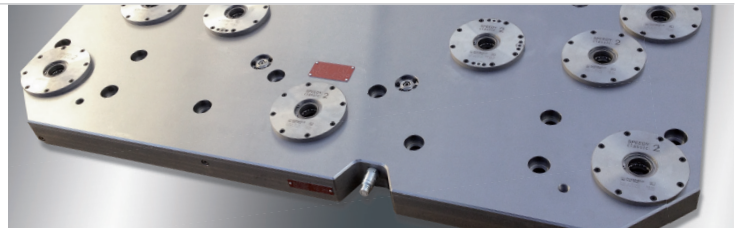
From standard elements to systems for flexible use - with minimum set-up time
– mechanical – hydraulic – pneumatic – electrical – single acting – double acting –

Quick-locking plates

for milling machining

from standard components, adapted to the machine and machining task

- fully assembled with 3D dimensional and functional test

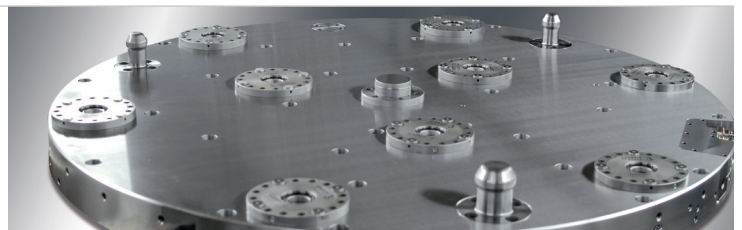


Quick-locking plates

for turning machining

from standard components, adapted to the machine and the machining task

- standard clamping monitoring
- applicator for pre-centring

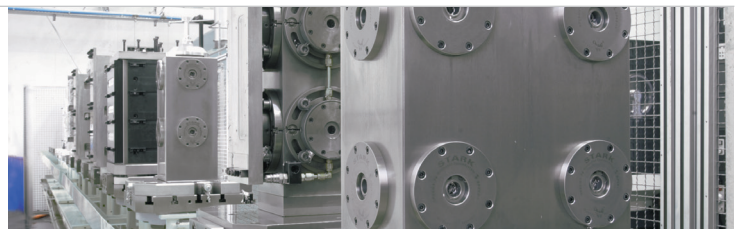


Quick-locking cubes

for milling machining

from standard components, adapted to the machine and the machining task

- 3rd-hand-function (DHF) prevents the dropping of the parts



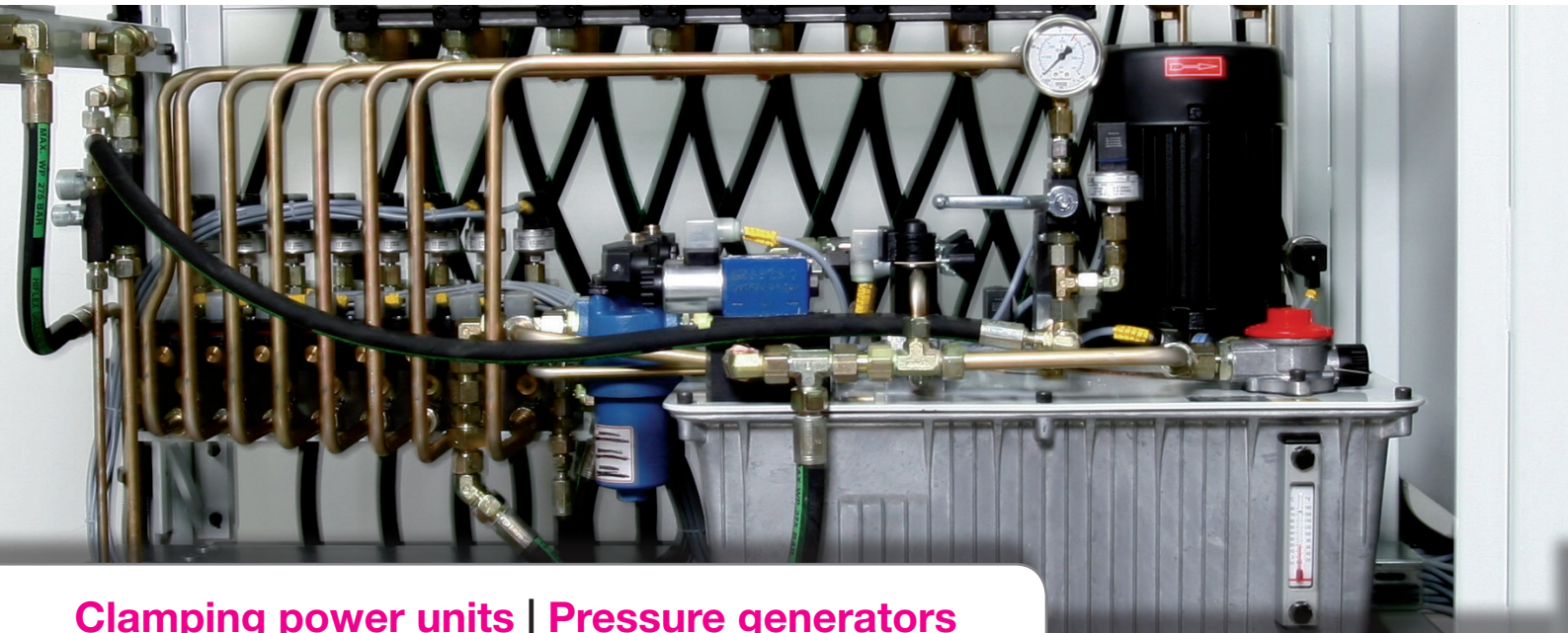
Quick-locking plates

for the automation

from standard components, adapted to the machine and machining task

- flow power as interface for pneumatic or hydraulic clamping fixtures and signal queries





Clamping power units | Pressure generators

Clamping power units, hydraulic power units, hydro-pneumatic pump units and manually-operated pumps to generate and control hydraulic pressure

Power units D 8.013

with two-hand operator console

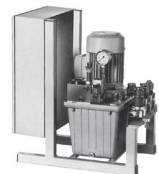
flow rate: 0.9 ... 4.5 l/min
max. operating pressure: 50 ... 500 bar
reservoir volume: approx. 11 l
voltage: 400 VAC



Power units D8.015

with proportional pressure adjustment

flow rate: 0.9 l/min
max. operating pressure: 500 bar
reservoir volume: approx. 11 l
voltage: 400 VAC



Power units D8.031

basic versions

flow rate: 0.9 ... 24 l/min
max. operating pressure: 50 ... 500 bar
reservoir volume: 11, 27, 40 and 63 l
voltage: 400 VAC



Power units D 8.026

modular design

flow rate: 0.9 ... 24 l/min
max. operating pressure: 120 ... 500 bar
reservoir volume: 11, 27, 40 and 63 l
voltage: 400 VAC



Power units D 8.0115

ready for connection

energy-saving intermittent cycling

flow rate: 0.8 ... 3.5 l/min
max. operating pressure: 160 ... 500 bar
reservoir volume: approx. 5 l
voltage: 400 VAC



Manually-operated pumps

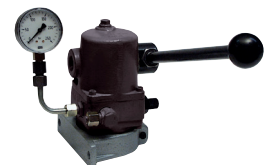
Hydraulic pumps

for single-acting cylinders

operation by hand or foot lever
displacement per stroke: 2 ... 12 cm³

Screw pumps

displacement: 21 cm³

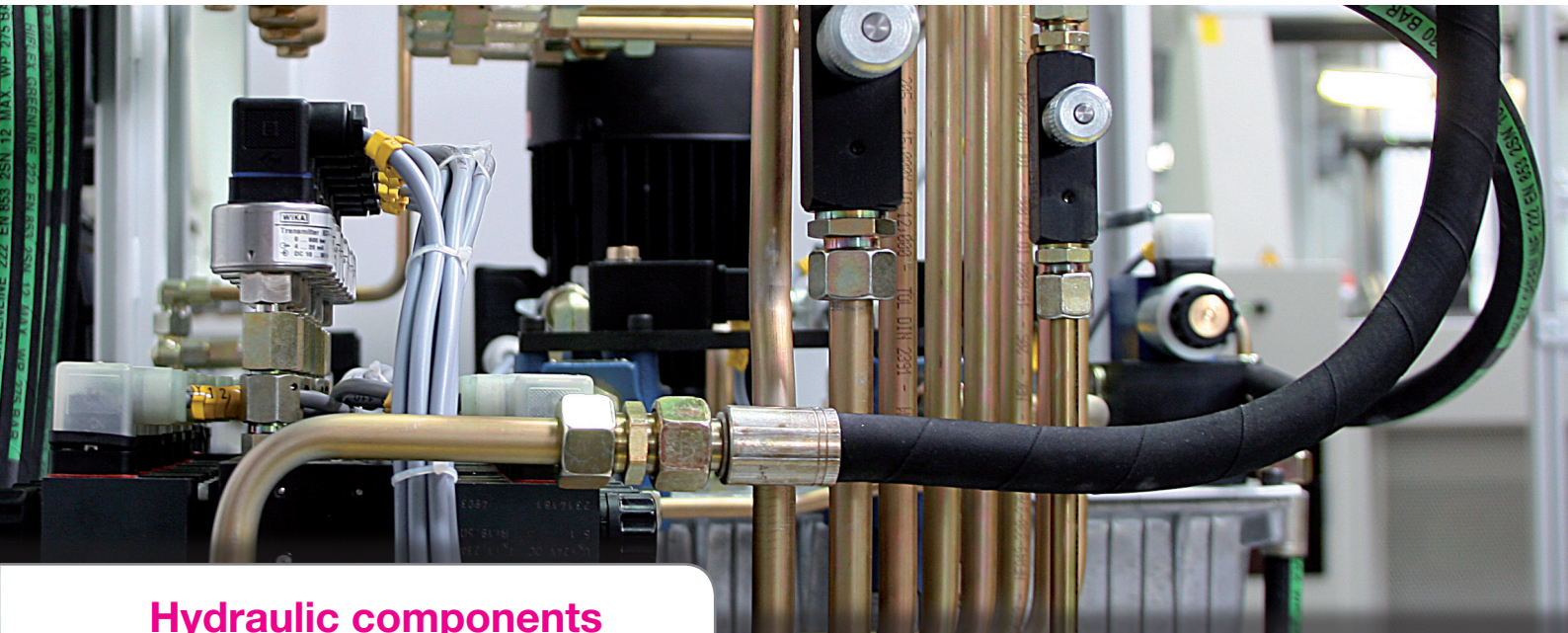


Hydro-pneumatic pump units

for single and double acting cylinders

flow rate: 0.85 ... 1.5 l/min
air pressure: 0.85 ... 5.0 bar
max. operating pressure: 500 bar





Hydraulic components

Elements for oil supply and control to hydraulic elements

Hydraulic valves

Directional control and shut-off valves
Throttle and pressure control valves
Pressure relief valves
Check valves
Sequence valves
Valve combinations



Coupling elements

for hydraulic oil,
compressed air and vacuum
nominal diameter: ND 3...8
max. flow rate: 8...35 l/min
max. operating pressure: 300...500 bar



Hydraulic accumulator

Diaphragm accumulator for hydraulic oil
with nitrogen gas filling
nominal volume: 13...750 cm³
ports: G $\frac{1}{4}$...G $\frac{1}{2}$
max. operating pressure: 250...500 bar



Multi-couplings

2 to 12 passages
nominal diameter: ND 5...8
depressurised coupling
or coupling against pressure
max. operating pressure: 300 bar



Rotary couplings

Rotary couplings and rotary valve couplings
for oil supply to rotating
and swivelling installations
max. operating pressure: 500 bar



High-pressure filters

In-line filters, plug-in filters
and rectifier filter
filter fineness: 10 and 100 μ m
material: stainless steel and steel
max. operating pressure: 350 and 500 bar



Intensifiers

hydraulic-hydraulic or
pneumatic-hydraulic
single and double acting
max. output pressure: 500 bar



Coupling units and systems

manually or automatically operated
for single or double acting elements
max. operating pressure: 400 and 500 bar



Pressure transducer

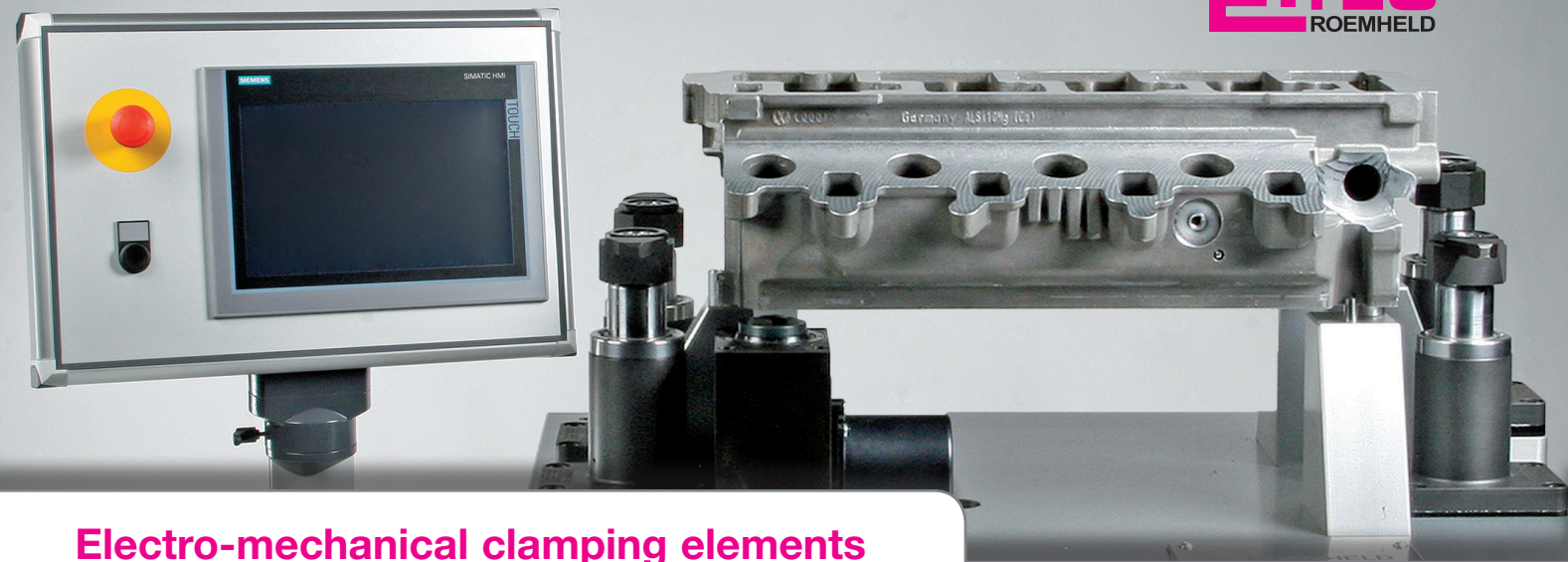
piston pressure switch
with continuously adjustable switching point
manifold mounting or G $\frac{1}{4}$
pressure sensors with radio transmission
receiver units with data interfaces



Piping elements

Fittings
Hydraulic hoses / Hydraulic oil
Precision steel pipes
Plug-in connectors
Pressure gauges / pipe clamps





Electro-mechanical clamping elements

Electric swing clamps

max. clamping force: 7 kN
clamping stroke: 23 mm
swing angle: max. 180°
voltage: 24 VDC



Electric block cylinders

max. clamping force: 10 ... 20 kN
stroke: 100 mm
voltage: 24 / 48 VDC



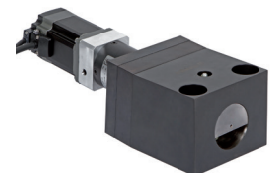
Electric work supports

max. load force: 20 kN
plunger stroke: 20 mm
voltage: 24 VDC



Electric wedge clamps

max. retention force: 130 ... 320 kN
clamping stroke: 20 mm
voltage: 24 VDC



FSS clamping systems

Flexible clamping and support elements for clamping of thin-walled workpieces with free-form surfaces

Clamping and supporting elements

elements with their own linear actuator and vacuum clamping technology

piston rod Ø: up to 70 mm
strokes: 100 to 1000 mm
max. axial support force: 1.2 ... 12.0 kN



The core elements of a FSS clamping system are the clamping and support elements that can be used in unlimited quantity and that together form the contact surface of the workpiece. Since each element can be positioned individually on the relevant workpiece geometry, FSS clamping systems allow for a flexible configuration of individual surfaces to clamp and support workpieces. Depending on the workpiece surface and geometry, clamping forces of 300 N per element and more can be obtained.



Drive technology

Electrically and manually operated linear actuators for adjusting procedures under demanding conditions in industry, automotive engineering and medicine technology

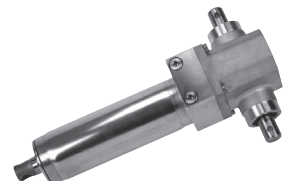
Electrically-operated linear actuators

version with limit switches or stroke measuring system
max. lifting force: 0.3 ... 6.0 kN
stroke: 100 ... 600 mm
voltage: 12 or 24 VDC



Manually-operated linear actuators

manual-hydraulic version
max. lifting force: 4.5 ... 12.5 kN
stroke: 140 ... 600 mm



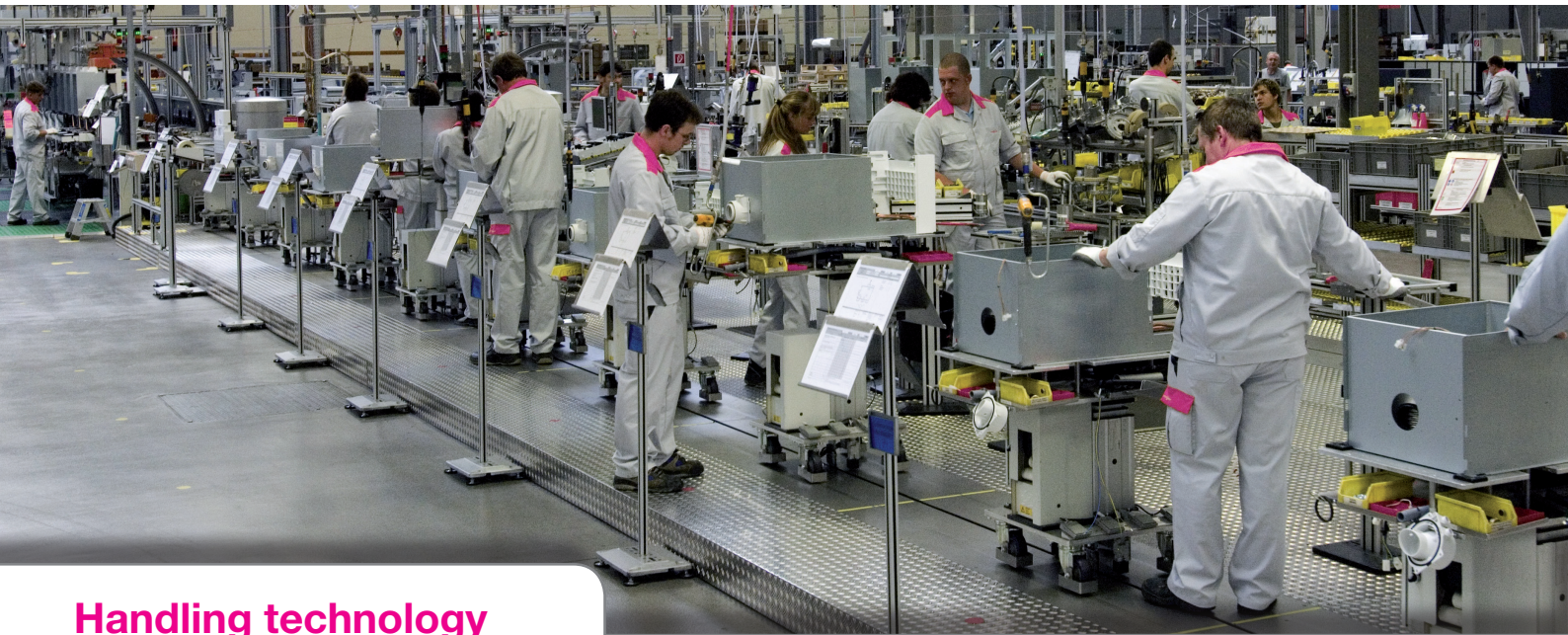
Pneumatic elements

Pneumatically operated swing clamps

Pneumatic swing clamps

with adjustable magnetic sensors
double acting
max. clamping force: 140 ... 1400 N
max. operating pressure: 7 bar





Handling technology

moduhub module programme – modules for rotating, lifting, tilting and moving of heavy workpieces
Individual modules can be easily combined to built multi-functional units

Rotating modules – horizontal axis

for rotation of the workpiece around the horizontal axis
manually or electrically operated
option: indexing
option: flow power
workpiece weight: up to 200 kg



Rotating modules – vertical axis

for rotation of the workpiece around the vertical axis
manually or electrically operated
option: indexing
option: flow power
workpiece weight: up to 1000 kg



Lifting modules

for guided lifting and lowering of the workpiece
operated by a hydraulic or electrical actuator
workpiece weight: up to 600 kg
max. strokes: 200 ... 1000 mm



Tilting modules

for tilting or swivelling of the workpiece around an axis between the final positions 0° and 90°
manually or electrically operated
option: indexing
workpiece weight: up to 100 kg



Cart modules

to displace manually individual modules or module combinations
with parking brake
max. load: 2000 and 6000 N



Floor modules

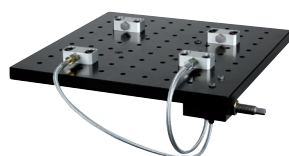
base frame for 1 or 2 modules
to compensate unevenness of the floor space and good stability
max. load: 6000 and 8000 N



Clamping jaws

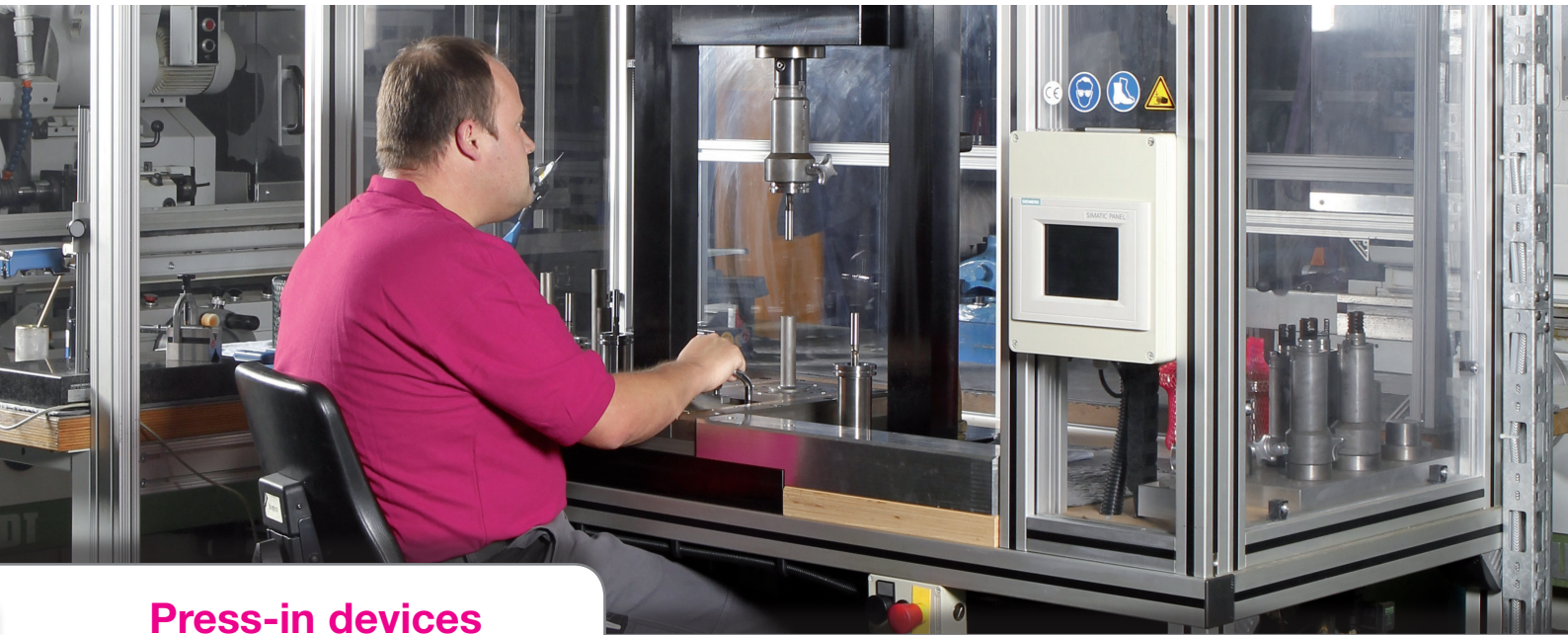
to clamp workpieces on moduhub modules

- hydraulic and mechanical clamping elements with universal clamping plate
- quick-change mounting plate with STARK zero point clamping system



Accessories

Base plates, Adaptor plates, Flange plate, Table plates, Supply units, Hand panel, Foot switch, Operating panels
Power supply for mobile systems, Command modules



Press-in devices

modupress module programme – hydraulically or electrically-operated press in devices for power-operated processes such as jointing, pressing-in, jolting, deforming and riveting

Press-in devices P 1.100

portal design
hydraulic drive
creep/rapid speed control with optional force/stroke monitoring
max. press-in force: 40 ... 100 kN



Press-in devices P 1.200

C-frame design
hydraulic drive
creep/rapid speed control with optional force/stroke monitoring
max. press-in force: 40 ... 100 kN



Press-in devices P 1.101

portal design
electrical drive
creep/rapid speed control with optional force/stroke monitoring
max. press-in force: 7 and 25 kN



Press-in devices P 1.201

C-frame design
electrical drive
creep/rapid speed control with optional force/stroke monitoring
max. press-in force: 7 and 25 kN



Press-in devices P 1.102

portal design
hydraulic drive
creep/rapid speed control with programming of the operating time
max. press-in force: 40 ... 100 kN



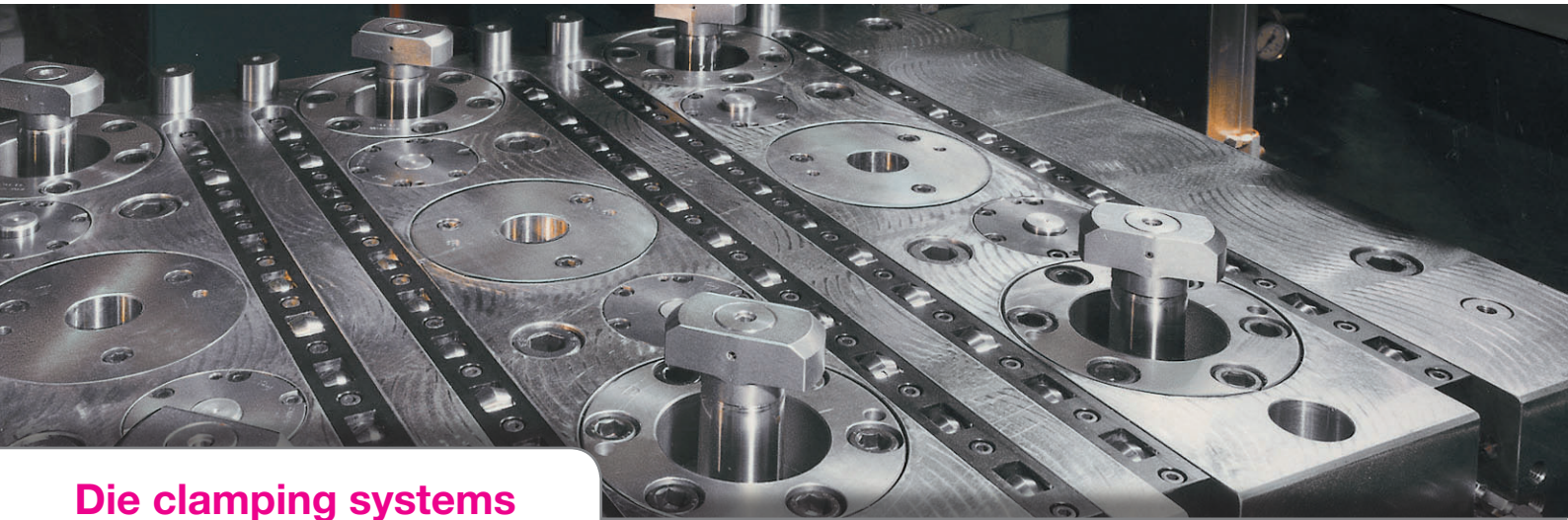
Press-in devices P 1.202

C-frame design
hydraulic drive
creep/rapid speed control with programming of the operating time
max. press-in force: 40 ... 100 kN



Accessories

Protection cabins, Light grids, Sliding tables, Sensor technology, Quick-disconnect couplings



Die clamping systems

Die clamping and changing systems for press automation
Quick changing systems for machines, presses and equipments

Hydraulic clamping elements

Hollow-piston cylinders

for retrofitting on press bed and ram

Spring clamping cylinders

for spring-loaded long-term clamping

Angular clamps

for clamping on small clamping edges



Clamping bars

flat clamping element for bed and ram

max. clamping force: 30 ... 116 kN, piston stroke: up to 8 mm

Double-T clamping bars

to use the complete bed or ram surface

max. clamping force: 16 ... 320 kN

Sliding clamps

for insertion in T-slots

max. clamping force: 19 ... 78 kN, piston stroke: up to 12 mm



Swivel and pull clamps

clamping cylinders with tie rods

Wedge clamps

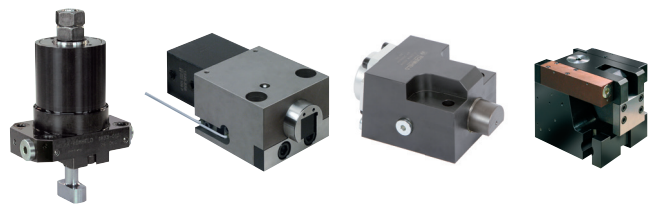
sturdy clamping elements for straight or inclined clamping edge

max. clamping force: 1250 kN

Block clamps

with self-locking mechanical lock

max. clamping force: 200 kN



Pivot and pull clamps

max. clamping force: 104 ... 160 kN

Swing / swing sink clamps

without interfering edges when inserting the die

max. clamping force: 60 ... 164 kN

Rapid clamping systems

automatic travelling units with clamping element



Pull clamps

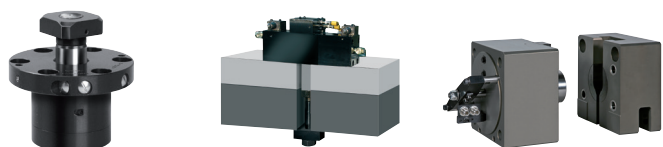
pull-type cylinder with tie rod for inaccessible points

Wedge swing clamps

with mechanical lock

Grip rail couplings

Rapid clamping systems for grip rails





Electro-mechanical clamping elements

Tenon-type clamps

clamping by grip and pull movement

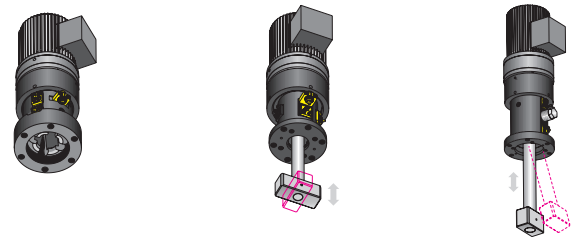
Swivel and pull clamps

clamping by swivel and lifting movement

Swing clamps

clamping by swing and lifting movement

max. clamping force: 70... 160 kN



Wedge clamps

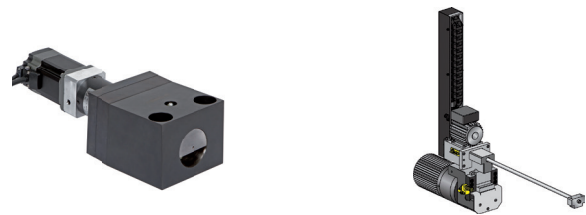
compact electro-mechanical power package

max. clamping force: 160 kN, retention force: 300 kN

Angular clamps

clamping in any position of the travelling path

max. clamping force: 50 kN, retention force: 320 kN



Mechanical clamping elements

Sliding clamps

max. clamping force: 40... 80 kN

High-pressure spindles

max. clamping force: 40... 140 kN

Clamping nuts, mechanical

max. clamping force: 60... 200 kN

Clamping nuts, hydro-mechanical

max. clamping force: 60... 150 kN



Die changing technology

Roller and ball bars

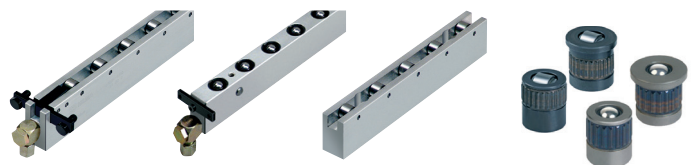
hydraulic or spring-loaded

Roller conveyors

without lifting

Roller and ball inserts

spring-loaded



Carrying consoles, hanging

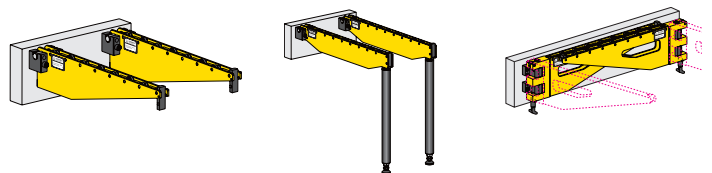
max. load per pair: 5... 30 kN

Carrying consoles, supported

max. load per pair: 20... 250 kN

Carrying consoles, swivelling

max. load per pair: 10... 60 kN



Changing carts

for handling of dies up to 500 kg
with ball table, hydraulic height adjustment
and safety docking station

Die changing consoles

with drive system for die weights up to 250 kN



Locking cylinders

To fix rotors of on- and offshore wind power plants
for maintenance works

Rotorlock

hydraulic, mechanical
or electro-mechanical

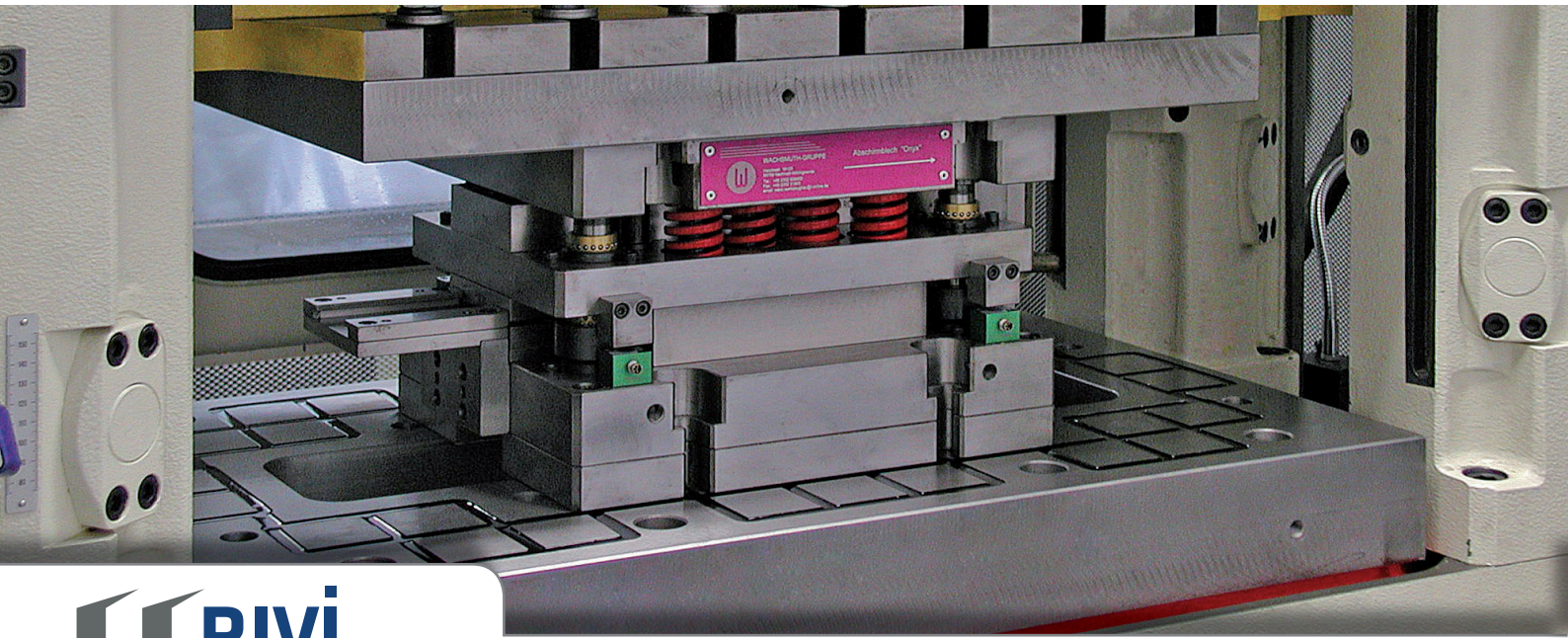
sizes: up to 7500 kN side load

with position monitoring

corrosion protection as per DIN ISO 12944

max. temperature range: -40... +70 °C



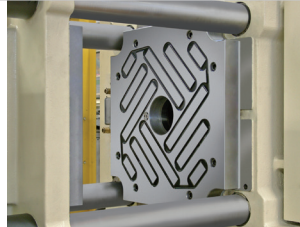


Magnetic clamping technology

Rivi Magnetics® M-TECS magnetic clamping plates and systems for injection moulding machines, forming presses, rubber presses, mould carriers, milling machines and machining centres

M-TECS P

for the plastics industry
max. temperature range: 120 °C
plate thickness: 47 mm



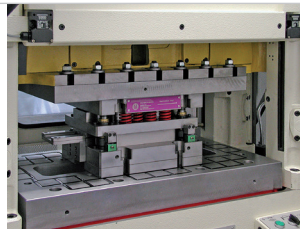
M-TECS R

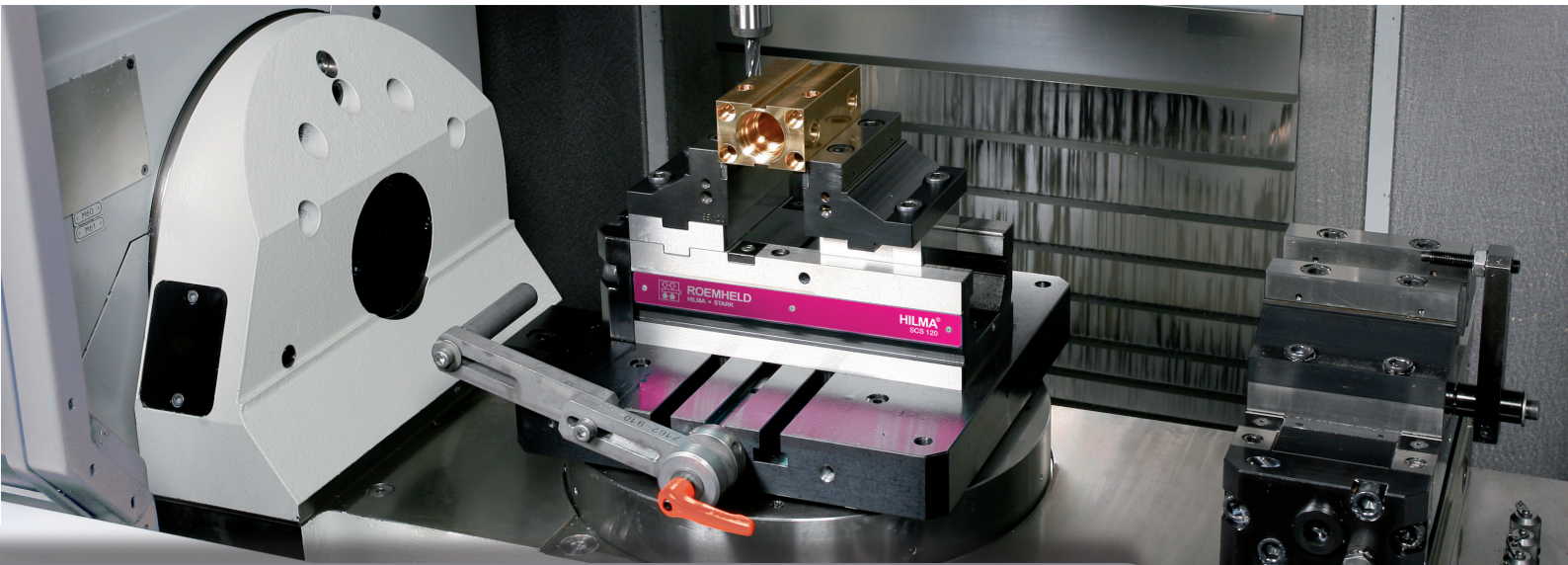
for the rubber and Duroplast industry
max. temperature range: 240 °C
plate thickness: 55 ... 85 mm



M-TECS M

for sheet metal forming
max. temperature range: 80 °C
plate thickness: 55 mm





System solutions for production engineering

Consulting, design, planning, engineering, construction design, production, delivery, commissioning and maintenance of clamping and positioning systems.

All from a single source

From the idea to the engineering up to start up and maintenance

If it is the matter of planning of clamping systems for a new machine tool or of optimising and transition to flexible of already existing clamping processes, we give you our advice and support.

Based on your demands, we develop for you ideas and support you in engineering, start up and maintenance.



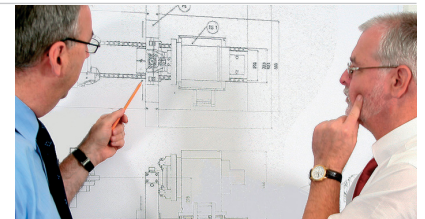
Expert know-how on call

Individual consultation and services

From the first consultation free of cost up to order-related services, our activities for all tasks are adapted to your requests and objectives.

If it is a matter of preparation of concepts or constructional sketches for partial or complete solutions or calculations of amortisations or detailed designs:

You decide yourself which services you would like to use.



Approved and reliable solutions

Clamping and fixture systems made of standard modules

With the experience in realising versatile individual projects in the individual companies of the ROEMHELD Group, we are now in the position to offer an unique, modular product range of clamping and fixture systems.

The use of approved and reliable standard modules is the key for optimised production and engineering costs and guarantees the realisation of individual system solutions without risks.

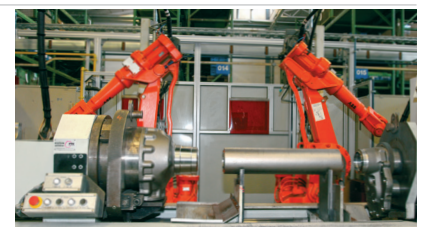


System solutions – directly from the manufacturer of power workholding

Customer-specific clamping and positioning systems

Our engineering know-how and the huge number of fully-developed clamping and positioning technologies in the ROEMHELD Group allows us to produce and to deliver customer-specific systems.

Due to design and production of the relevant components within the ROEMHELD Group we have access to extended know-how and well-proven production engineering, which together with our engineering know-how guarantees a fully-developed and reliable function of the complete system.





ROEMHELD
HILMA ■ STARK

Are you interested in an individual consultation or do you have any questions about our products?

We are pleased to support you.

**Elements and systems
for production engineering**

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**Workholding systems and standard fixtures
for metal cutting and non-cutting manufacturing**

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Intelligent zero point clamping systems

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