

RKD

clamping
force presetting

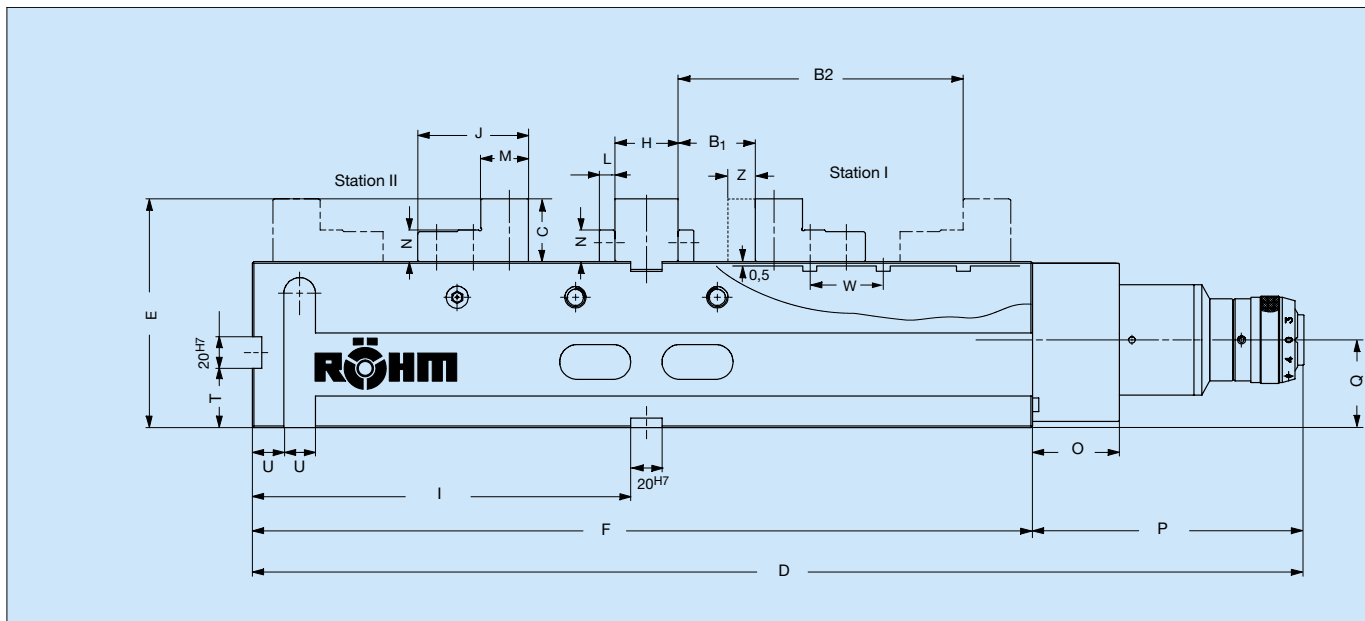
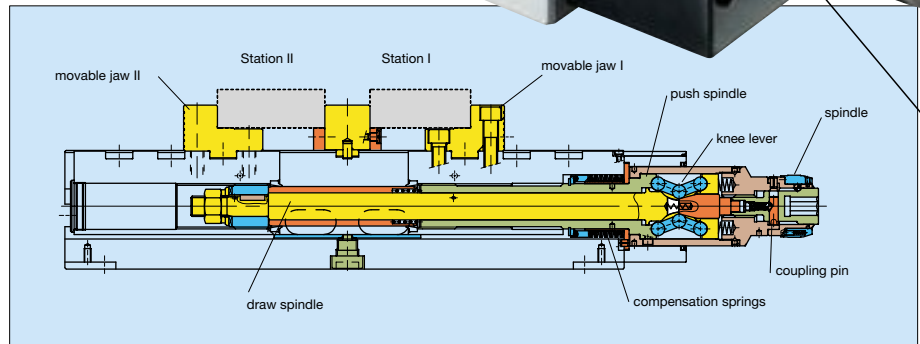


With unilateral drive and mechanical transmission via knee lever

For flexible clamping on machining centers and other production systems. Increased versatility combined with excellent exploitation of the available space.

Advantages:

- Clamping system: mechanical/mechanical
- High and safe clamping force
- Approx. 1.5 rotations only for maximum clamping force
- Constant clamping force for increased repeating accuracy
- No overload of the vise, even when applying maximum clamping force
- Pre-adjustment of clamping force by means of locking system
- Self-locking transmission



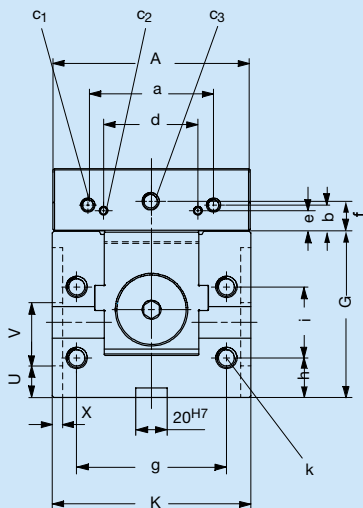
4 NC-compact vises

Tool group 32

Jaw width	A	92	125
Id.-No.		161830	162655
Clamping capacity	Groove 1	0 - 48	0 - 48
	B ₁ Groove 2	48 - 96	46 - 94
	Groove 3	-	92 - 140
	Groove 1	42 - 79	51 - 88
	B ₂ Groove 2	79 - 127	86 - 134
	Groove 3	-	132 - 180
Jaw height	C	32	4
Total length	D _{max.}	500 ⁺⁵	667 ⁺⁵
	E	117	145
	F	356	495
	G _{-0,02}	85	105
	H _{-0,02}	30	40
	J	56	70
	K	94	126
	L	10	10
	M	25	30
	N _{-0,01}	16	20
	O	55	55
	P	144	172
	Q	45	55,5
	T _{-0,02}	30	37,5
	U	20	20
	V	28	40
Shifting range	W	1 x 48	2 x 46
	X	4,5	6,5
Clamping slide travel	Z	50	50
	a	63	80
	b	13,6	15,6
	c ₁	M6 x 14	M8 x 14
	c ₂	M5 x 9	M5 x 10
	c ₃	M10 x 16	M10 x 18
	d	48	60
	e	8	12
	f	14	18
	g	70	95
	h	20	25
	i	50	45
	k	M10 x 18	M12 x 22
	l _{-0,02}	170	240
Clamping force	kN	25	40
Weight approx.	kg	24	53



Thread for fastening V-drive, see accessories



Specifications:

- Double-clamping via two mobile claws (left-right hand thread) and one immobile center jaw
- Three clamping positions: horizontal, vertical and lateral, 50 mm stroke per jaw
- The complete clamping thread of the spindle is protected to prevent the penetration of dirt and chips
- All sides of the steel body are hardened and ground
- Standard equipment includes stepped, interchangeable jaws and center jaw with work support
- The grease nipples available on both sides ensure lubrication for the spindle thread and all guides that are subject to wear
- Fastening of the vise by means of clamping claws only
- **Repeating accuracy: 0.01**

Function:

To adjust mobile jaw I with regard to the workpiece of station I turn the spindle to the right by means of the handle (left-right handed thread).

About 1 kN are applied to keep the jaw in the adjusted position (third-hand function). By further turning the lever, mobile jaw II is adjusted with regard to workpiece in station II and then locked. By further turning the lever clockwise until stop, the mechanical transmission of the toggle lever is activated.

The force acts equally on both jaws via pressing screw and feed screw. By means of compensating springs, variations between workpiece I and II of up to ± 3 mm are compensated.

Both stations must always be equipped with identical workpieces for clamping!

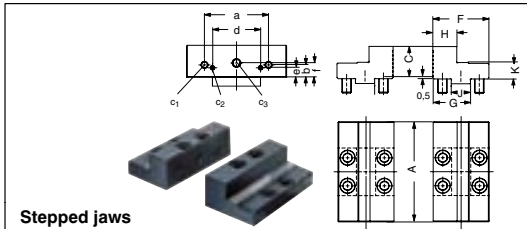


QUATRO clamping tower with four RKD NC Compact Twin Vises, face mounting in the shape of a cross.

Accessories

Clamping jaws for RKD and RKD-M

Further clamping jaws for self-centrical clamping and accessories suitable only for RKD-M
The components will always be clamped centric, independent of outside tolerances.



Stepped jaws

suitable for set	Id.-No.	92	125
	161831	162631	
Jaw width	A	92	125
Jaw height	C	32	40
	F	56	70
	G	38	47
	H	25	30
	J _{g6}	20	24
	K	16	20
	a	63	80
	b	13,6	15,6
	c ₁	M6 x 14	M8 x 14
	c ₂	M5 x 9	M5 x 10
	c ₃	M10 x 16	M10 x 18
	d	48	60
	e	8	12
	f	14	18

Work supports for stepped jaws

suitable for set	Id.-No.	92	125
	159636	158602	
Jaw width	A	92	125
Jaw height	B	6	6
	C _{-0,01}	16	20
	d	48	60
	e	8	12

Center jaws

suitable for piece	Id.-No.	92	125
	161833	162632	
Jaw width	A	92	125
Jaw height	B _{-0,02}	30	40
	C	32	40
	D	50	62
	E _{h6}	16	20
	F	5	5
	a	63	80
	b	13,6	15,6
	c ₁	M6 x 10	M8 x 14
	c ₂	M5 x 9	M5 x 10
	c ₃	M10 x 15	M10 x 18
	d	48	60
	e	8	8
	f	14	18

Fixed stepped jaw for single clamping, reversible

Jaw width A	Id.-No. piece	B	C	D	E _{h7}	H	K	a	b	c ₁	c ₂	c ₃	d	e	f
92	162633	64	32	42	20	25	16	63	13,6	M6x14	M5x9	M10x16	48	8	14
125	160344	94	40	60	24	40	20	80	15,6	M8x14	M5x10	M10x18	60	12	18

Work supports for center jaws

suitable for set	Id.-No.	92	125
	159613	158599	
jaw width	A	92	125
jaw height	B	10	10
	C _{-0,01}	16	20
	d	48	60
	e	8	12

SGN normal jaw

Jaw width	Id.-No. set	C	y	Clamping capacity		
				Groove 1	Groove 3	Groove 3
92	162363	32	15,6	0-100	94-196	
125	158897	39,7	15,6	8-111	100-203	192-295

V-jaw, horizontal and vertical

	Jaw width A	Id.-No. set	C	E	J	Clamping capacity		
						Groove 1	Groove 3	Groove 3
horizontal D ₁	92	162365	32	19,5	16	12-36	-	-
vertical D ₂						12-36	-	-
horizontal D ₁	125	158641	40	24	20	15-40	-	-
vertical D ₂						18-60	-	-

V-jaw, horizontal

Jaw width	Id.-No. set	C	E	F	G	J _{g6}	Clamping capacity		
							Groove 1	Groove 3	Groove 3
92	162367	84,5	54	79,5	51,5	20	32-105	-	-
125	158643	84,5	54	85,5	58,5	24	42-105	-	-

V-jaw, vertical

	Jaw width A	Id.-No. set	C	F	G	J _{g6}	Clamping capacity		
							Groove 1	Groove 3	Groove 3
D ₄	92	162369	32	81,4	53,4	20	34-118	-	-
	125	158645	40	87,9	60,9	24	42-118	-	-
D ₅	92	162371	40	86	58	20	42-120	115-154	-
	125	158647	50	99,3	72,3	24	55-130	122-198	-

Hand crank, with octagon socket

suitable for	Id.-No. piece	octagon socket x L
92	009153	17 x 160
125	009154	19 x 200

Drive adapter for torque wrench

suitable for	Id.-No. piece	SW
92	162192	17-1/2"
125	161730	19-1/2"

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NC-compact vises