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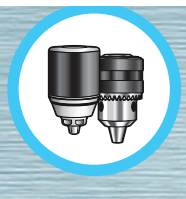

enduring.

Drill Chucks NC-Tooling

2013/2014

www.roehm.biz

RÖHM

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DRILL CHUCKS - NC-TOOLING

Keyless drill chucks
EXTRA ____ 1004
EXTRA-RV ____ 1005
SUPRA ____ 1006
SUPRA-SK ____ 1008
SUPRA-SK E ____ 1008
SPIRO - SPIRO-SK ____ 1009

Key-type drill chucks
PRIMA ____ 1010

Drill chuck keys
BFS ____ 1012

Two-jaw drill chucks
WILLIAM-GEMA ____ 1013

Two-jaw tapping chucks
GSF ____ 1014

Taper shank arbors for drill chucks
KD ____ 1015

Reducing sleeves
RH ____ 1016

Extension sleeves
VLH ____ 1018

Drill- and reamer extensions
BV ____ 1019

Spindle sleeves
SPH ____ 1020

Adjustable adapters
SH ____ 1021

Precision short drill chucks
KBF ____ 1024

Quick change tapping chucks
GS ____ 1027
GSP ____ 1029
GSA ____ 1030
GS/C ____ 1032
GS/NC ____ 1033

Quick change adaptors
SE ____ 1034
SES ____ 1036

Quick change reduction adaptors
SRE ____ 1038

Quick change adaptors
SEA ____ 1039

Floating chucks
SMP / SMP compact ____ 1042

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Drill chucks - NC-Tooling

Drill chucks	1004
Drill chuck accessories	1015
Adjustable adapters	1021
Precision short drill chucks	1024
Quick change tapping chucks	1028
Floating chucks	1042

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ROHM Keyless drill chucks

Operation guide

	EXTRA		SUPRA					SPIRO	
Type	**EXTRA**	**EXTRA -RV**	**SUPRA**	**SUPRA -S**	**SUPRA -F**	**SUPRA -SK**	**SUPRA -SKE**	**SPIRO**	**SPIRO -SK**
Clamping capacity	1-10 1,5-13	1-10 1,5-13	0-16	0-16	0-16	0,5-13	1,5-13	0-16	0-13
Mount	1/2“-20 3/8“-24	1/2“-20 3/8“-24	B10/12/ 16/18 J0/2/6/33 1/2“-20 3/8“-24 5/8“-16	B10/12/ 16/18 J0/2/6/33 1/2“-20 3/8“-24 5/8“-16	B 16/18	B 12/16	1/2“x20	B 10/12/ 16/18 J 1/2/6	B 12/16
Through-hole	O	O	✗	✗	✗	✗	✗	✗	✗
Retaining ring	O	O	✓	✓	✓	✓	✓	✓	✓
Max. mach. capacity (W)	1000	1100	-	-	-	-	-	-	-
Actuation									
Socket	K	K S	S	S	S	S	S	S	S
Radial locking	✗	✓	✗	✗	✗	✓	✓	✗	✓
Impact resistant	✗	✓	✗	✗	✗	✓	✓	✗	✗
Clockwise rotation	O Through hole	O Through hole	✗	✗	✗	O up to 15Nm	O up to 50Nm	✗	O up to 15Nm
Automatic retightening	✗	✗	✓	✓	✓	✓	✓	✓	✓
Design									
For									
Page	1004	1005	1006	1007	1007	1008	1008	1009	1009

✓	yes		keyless	S	steel		heavy version
O	optional		with key	M	metal		corded drills
✗	no	K	plastic		light version		cordless screw drivers

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Operation guide

	PRIMA				WILLIAM / GEMA			
Type	**PRIMA**	**PRIMA S**	**PRIMA M**	**PRIMA Mat**	**WILLIAM** with protecting sleeve	**WILLIAM**	**GEMA** with protecting sleeve	**GEMA**
Clamping capacity	0,5-26	0,8-13	0,5-16	1,5-16	1-20	1-26	1-20	1-26
Mount	B 10/12/16/18/22/24 J 1/2/6/33/3 1/2“-20 3/8“-24 5/8“-16	B 10/16 1/2“-20 3/8“-24	B 10/12/16 1/2“-20 5/8“-16	1/2“-20; 5/8“-16	B 16/18/22	B 16/18/22/24	B 16/18/22	B 16/18/22/24
Through-hole	O	O	O	O	✗	✗	✗	✗
Retaining ring	✗	✗	✗	✗	✗	✗	✗	✗
Max. mach. capacity (W)	-	-	-	-	-	-	-	-
Actuation								
Socket	M	M	M	M	M	M	M	M
Radial locking	✗	✗	✗	✗	✗	✗	✗	✗
Impact resistant	✗	✗	✗	✓	✗	✗	✗	✗
Clockwise rotation	O Through hole	O Through hole	O Through hole	O Through hole	✓	✓	✓	✓
Automatic retightening	✗	✗	✗	✗	✗	✗	✗	✗
Design					with offset drive spindle		with additional driving jaws for tapping	
For					especially suitable for wood working machines		especially suitable for wood working machines	
Page	1010	1011	1011	1011	1013	1013	1013	1013

stationary drilling machines

machining centers

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ROHM

Keyless drill chucks

EXTRA

Keyless drill chucks for cordless screw-drivers, cordless and corded drills with hexagon for assembling and disassembling on the machine spindle.

This drill chuck series is specially designed for use with cordless screwdrivers, cordless and corded drills.
The ideal chuck for professionals and D.I.Y. users.
One-piece design without retaining ring for machines with spindle stop.

Technical features:

- very ergonomical, easy to handle, equipped with collision protector
- high concentricity
- with through-hole for clockwise and anti-clockwise rotation (security screw M 5 or M 6)

Tool group A01
Type 102-60 **Extra**

Item no.	Size	Clamping capacity	Mount	Retaining ring	External Ø	Length opened	Length closed	Max. mach. capacity	Through-hole
767686 ■	10	1-10	1/2”-20		42,7	55	60,9	550	
767688 ●	10	1-10	1/2”-20		42,7	55	60,9	550	•
767633 ●	10	1-10	1/2”-20	•	42,7	55	60,9	550	
767634 ●	10	1-10	1/2”-20	•	42,7	55	60,9	550	•
766871 ●	10	1-10	3/8”-24		42,7	55	60,9	550	•
767687 ■	10	1-10	3/8”-24		42,7	55	60,9	550	
664465 ●	10	1-10	3/8”-24	•	42,7	55	60,9	550	•
767632 ●	10	1-10	3/8”-24	•	42,7	55	60,9	550	
766872 ●	13	1,5-13	1/2”-20		42,7	64,5	72,4	1000	•
767689 ■	13	1,5-13	1/2”-20		42,7	64,5	72,4	1000	
767554 ●	13	1,5-13	1/2”-20	•	42,7	64,5	72,4	1000	•
767636 ●	13	1,5-13	1/2”-20	•	42,7	64,5	72,4	1000	
767690 ■	13	1,5-13	3/8”-24		42,7	64,5	72,4	1000	
767691 ●	13	1,5-13	3/8”-24		42,7	64,5	72,4	1000	•
664466 ●	13	1,5-13	3/8”-24	•	42,7	64,5	72,4	1000	•
767635 ■	13	1,5-13	3/8”-24	•	42,7	64,5	72,4	1000	

● from stock ■ 4 - 6 weeks ▲ on request

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EXTRA-RV

Keyless drill chucks in plastic or metal design with radial locking, for corded and cordless drills, for percussion drilling, with hexagon for assembling and disassembling on the machine spindle.

One-piece design without retaining ring for machines with spindle stop.

Technical features:

- no further locking when drilling and screwing, especially percussion drilling
- very ergonomical, easy to handle, equipped with collision protector
- with carbide inserts in the clamping jaws (size 13)
- for all drills up to 1100 W
- with through-hole for clockwise and anti-clockwise rotation (security screw M 5 or M 6)

Customer advantage:

- with carbide inserts in the clamping jaws (size 13)
- additional locking no longer necessary (1 movement = 2 functions)

Tool group A01
Type 104-61 **Extra-RV**
with radial locking
metal design

Item no.	Size	Clamping capacity	Mount	Retaining ring	External Ø	Length opened	Length closed	Max. mach. capacity	Through-hole
893350 ●	10	1-10	1/2"-20		42,7	55	60,9	550	•
1033052 ■	10	1-10	1/2"-20	•	42,7	55	60,9	550	
1033053 ●	10	1-10	1/2"-20	•	42,7	55	60,9	550	•
893351 ●	10	1-10	3/8"-24		42,7	55	60,9	550	•
893352 ●	13	1,5-13	1/2"-20		42,7	64,5	72,4	1100	•
802490 ●	13	1,5-13	1/2"-20	•	42,7	64,5	72,4	1100	•
802492 ●	13	1,5-13	1/2"-20	•	42,7	64,5	72,4	1100	
1033051 ●	13	1,5-13	3/8"-24	•	42,7	64,5	72,4	1100	•

Tool group A01
Type 104-61 **Extra-RV**
with radial locking
plastic design

Item no.	Size	Clamping capacity	Mount	Retaining ring	External Ø	Length opened	Length closed	Max. mach. capacity	Through-hole
767650 ■	10	1-10	1/2"-20		42,7	55	60,9	550	
767651 ●	10	1-10	1/2"-20		42,7	55	60,9	550	•
767638 ■	10	1-10	1/2"-20	•	42,7	55	60,9	550	
767639 ●	10	1-10	1/2"-20	•	42,7	55	60,9	550	•
767573 ●	10	1-10	3/8"-24		42,7	55	60,9	550	•
767649 ■	10	1-10	3/8"-24		42,7	55	60,9	550	
664467 ●	10	1-10	3/8"-24	•	42,7	55	60,9	550	•
767637 ●	10	1-10	3/8"-24	•	42,7	55	60,9	550	
753530 ■	13	1,5-13	1/2"-20		42,7	64,5	72,4	1000	
767580 ●	13	1,5-13	1/2"-20		42,7	64,5	72,4	1000	•
767648 ●	13	1,5-13	1/2"-20	•	42,7	64,5	72,4	1000	
767692 ●	13	1,5-13	1/2"-20	•	42,7	64,5	72,4	1000	•
767640 ■	13	1,5-13	3/8"-24		42,7	64,5	72,4	1000	
767641 ●	13	1,5-13	3/8"-24		42,7	64,5	72,4	1000	•
767647 ●	13	1,5-13	3/8"-24	•	42,7	64,5	72,4	1000	
767657 ●	13	1,5-13	3/8"-24	•	42,7	64,5	72,4	1000	•

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ROHM Keyless drill chucks

SUPRA

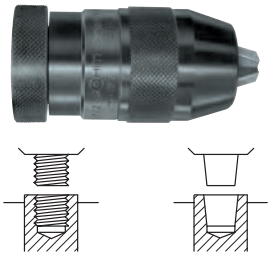
User-friendly version
Rapid clamping and releasing of the drilling tools, without key

Keyless rapid drill chucks for hand-operated drilling machines and heavy industrial version with thread mount and conical mount.
The drill can be clamped by hand simply and quickly.

Technical features:

- automatic retightening in proportion to cutting force; therefore retention of the clamping force even when used under difficult conditions
- strong retaining ring

Tool group A02
Type 136 **Supra**
heavy industrial version for stationary and hand-operated percussion drilling machines



Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Weight
871019 ●	4	0-4	B10	26	45,5	50,8	137
871020 ●	4	0-4	J0	26	46,5	51,5	130
871025 ●	6	0-6,5	3/8”-24	32	59,5	65,6	301
871022 ●	6	0-6,5	B10	32	59,5	65,6	280
871023 ●	6	0-6,5	B12	32	59,5	65,6	250
871024 ●	6	0-6,5	J1	32	59,5	65,6	275
871031 ●	8	0-8	B10	35	67	73,5	380
871034 ●	8	0-8	3/8”-24	35,8	67	73,4	390
871032 ●	8	0-8	B12	35,8	67	73,4	345
871033 ●	8	0-8	J1	35,8	67	73,4	390
871045 ●	10	0-10	1/2”-20	40,2	79,5	86,1	618
871044 ●	10	0-10	3/8”-24	40,2	79,5	86,1	625
871040 ●	10	0-10	B12	40,2	79,5	86,1	578
871041 ●	10	0-10	B16	40,2	82,5	89,1	624
871042 ●	10	0-10	J2	40,2	80,5	87,1	636
871043 ●	10	0-10	J33	40,2	84	90,6	560
871055 ●	13	1-13	1/2”-20	46	93	101,5	932
871056 ■	13	1-13	5/8”-16	46	93	101,5	830
871051 ●	13	1-13	B16	46	93	101,5	915
871052 ●	13	1-13	J2	46	91	99,5	900
871053 ●	13	1-13	J33	46	94	102,5	948
871054 ●	13	1-13	J6	46	94	102,5	870
871067 ●	16	3-16	5/8”-16	51	96,5	106,8	1115
871064 ●	16	3-16	B16	51	96,5	106,8	1161
871065[1] ●	16	3-16	B18	51	96,5	106,8	1115
871066 ●	16	3-16	J6	51	96,5	106,8	1120

[1] shortened: B18 by 7 mm

● from stock ■ 4 - 6 weeks ▲ on request

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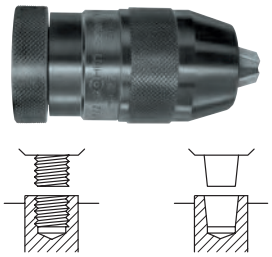
SUPRA

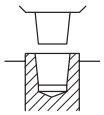
Tool group A02
Type 136 **Supra S and M light version** mainly for hand-operated drilling machines



Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Weight
871030 ●	8S	0-8	1/2"-20	32	61,5	67,6	285
871029 ●	8S	0-8	3/8"-24	32	61,5	67,6	285
871026 ●	8S	0-8	B10	32	62,5	68,6	290
871027 ●	8S	0-8	B12	32	62,5	68,6	285
871028 ●	8S	0-8	J1	32	61,5	67,5	265
871039 ●	10S	0,5-10	1/2"-20	35,8	66	73,7	377
871038 ●	10S	0,5-10	3/8"-24	35,8	66	73,7	370
871036 ●	10S	0,5-10	B 12	35,8	68	75,7	382
871037 ●	10S	0,5-10	J1	35,8	66	73,7	385
871050 ●	13S	1-13	1/2"-20	40,2	76,3	83,6	548
871049 ●	13S	1-13	3/8"-24	40,2	76,3	83,6	610
871046 ●	13S	1-13	B12	40,2	78,8	86,1	593
871047[1] ●	13S	1-13	B16	40,2	82,3	89,6	581
871048 ●	13S	1-13	J2	40,2	82,3	89,5	605
871062 ●	16S	3-16	1/2"-20	46	87,5	97,5	880
871063 ●	16S	3-16	5/8"-16	46	87,5	97,5	865
871057[1] ●	16S	3-16	B16	46	88,5	98,5	858
871058[2] ●	16S	3-16	B18	46	92	102	875
871059 ●	16S	3-16	J2	46	89,5	99,5	875
871060 ●	16S	3-16	J33	46	92	102	885
871061 ●	16S	3-16	J6	46	92	102	850

[1] shortened: B16 by 2,5 mm
[2] shortened: B18 by 7 mm

Tool group A02
Type 144 **Supra F with extended sockets** for workpieces whose surface might not be damaged



Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Weight
1017418 ●	F13	1-13	B16	46	102,5	102,5	915
1017422[1] ●	F16	3-16	B18	51	108	108	1180

[1] shortened: B18 by 7 mm

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ROHM Keyless drill chucks

SUPRA-SK

Quick-action keyless drill chuck for percussion drilling machines of all brands.

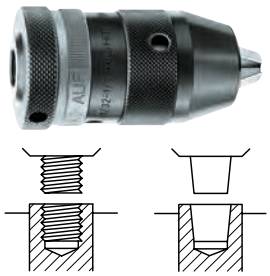
Technical features:

- the chuck is sealed against swarf and dirt
- design SK: for anti-clockwise rotation up to a turning moment of 15 Nm
- automatic retightening in proportion to cutting force
- robust design: stressed components made from steel
- no throughhole: chucks must be tightened onto the spindle with high torque

Customer advantage:

- a safety device reduces the risk of accidents
- the drill can be clamped by hand simply and quickly
- preventing the chuck from opening of its own even when subjected to heavy vibration and high impact frequencies
- when drilling the swarf is ejected through holes in the conical sleeve

Tool group A02
Type 141 **Supra-SK**



Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Weight
249925 ●	SK 10S	0,5-10	1/2"-20	40	66	73,7	399
249910 ●	SK 10S	0,5-10	3/8"-24	40	66	73,7	428
305188 ●	SK 10S	0,5-10	B 12	40	68	75,7	416
249804 ●	SK 13S	1-13	1/2"-20	42,8	74,2	83,3	537
863921[2] ●	SK 13S	1-13	1/2"-20	42,8	74,2	83,3	548
305221 ●	SK 13S	1-13	B 12	42,8	77	86,1	575
305203[1] ●	SK 13S	1-13	B 16	42,8	80,2	89,3	585

[1] shortened: B16 by 2,5 mm
[2] with additional thread-lock for thread mount

SUPRA-SK E

Keyless self-tightening drill chucks suitable for percussion drilling on hand-operated power tools.

Technical features:

- automatic retightening during drilling in proportion to cutting force; therefore retention of the clamping force even when used under difficult conditions
- robust design: stressed components made from steel
- no throughhole: chucks must be tightened onto the spindle with high torque
- lightweight design for powerful cordless- and corded power tools (cordless percussion drills up to 36 volt)
- torque in left-hand rotation up to 50 Nm

Customer advantage:

- Clamping and radial locking possible in one single movement
- Available in two and single sleeve design

Tool group A02
Type 141 **Supra SK E**

Item no.	Size	Clamping capacity	Mount	Retaining ring	External Ø	Length opened	Length closed	Weight
1193005 ■	SK 13E	1,5-13	1/2"-20	•	42,5	72,0	79,3	375

● from stock ■ 4 - 6 weeks ▲ on request

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SPIRO - SPIRO-SK

Due to permanent self-tightening action perfectly suitable for use with high speeds on drilling machines, machining centers and special drilling heads.

Technical features:

- pointed shape of sleeve
- high concentricity
- wear parts are hardened and ground
- high precision design
- design SK: for anti-clockwise rotation up to a turning moment of 15 Nm

Tool group A03
Type 134 **Spiro**
run-out accuracy **0,05 mm**

Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Weight
871000 ●	4	0-4	B 10	28	48	53,3	140
871002 ■	4	0-4	J 1	28	48	53,3	140
871003 ●	6	0-6,5	B 10	35	62,5	68,6	315
871004 ●	6	0-6,5	B 12	35	62,5	68,6	310
871005 ■	6	0-6,5	J 1	35	62,5	68,6	310
871006 ●	8	0-8	B 12	38	70,5	76,9	405
871007 ●	8	0-8	J 1	38	70,5	76,9	420
871008 ●	10	0-10	B 12	43	82,5	90,1	665
871009 ●	10	0-10	B 16	43	82,5	90,1	650
871010 ■	10	0-10	J 2	43	82,5	90,1	670
871011 ■	10	0-10	J 33	43	83	90,6	655
871012 ●	13	1-13	B 16	50	94	102,5	995
871013 ■	13	1-13	J 2	50	91,5	100	995
871015 ■	13	1-13	J 6	50	94	102,5	980
871016 ●	16	3-16	B 16	55	96,5	106,8	1260
871017[1] ●	16	3-16	B 18	55	96,5	106,8	1250
871018 ■	16	3-16	J 6	55	96,5	106,8	1255

[1] shortened: B18 by 7 mm

Tool group A03
Type 133 **Spiro-SK**
run-out accuracy **0,07 mm**

Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Weight
871068 ■	SK 8	0-8	B 12	38	70	76,5	460
871069 ■	SK 10	0-10	B 12	43	76	83,6	670
871070 ●	SK 10	0-10	B 16	43	81	88,5	670
871071 ●	SK 13 S	1-13	B 16	43	92	100,3	1050

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ROHM

Key-type drill chucks

PRIMA

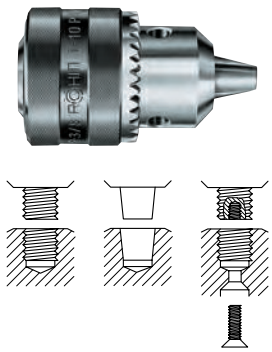
Key-type drill chucks with key, DIN ISO 10887

With taper mounting respectively thread mounting impact resistant.
For drills with a high frequency we recommend key-type drill chuck Prima-Mat.

Technical features:

- the versatile applicable model has proven itself for decades, especially on hand-operated drilling machines and impact drilling machines
- if required, we deliver the heavy industrial chucks with DIN-taper in the sizes 6-10 with draw-off thread, in the sizes 13-20 with driver

Tool group A01
Type 111 **Prima**
heavy industrial version for stationary and hand-operated percussion drilling machines



Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Key size
072810 ●	6	0,5-6,5	J1	29,5	42,5	52,5	S1
245548 ●	6	0,5-6,5	B12	29,5	47,5	57,5	S1
1033093 ●	7	0,5-7	B10	23,7	39	48,3	S1
072628 ●	8	0,5-8	3/8”-24	34,5	49,5	61	S2 A
072631 ●	8	0,5-8	1/2”-20	34,5	49,5	61	S2 A
072656 ●	8	0,5-8	J1	34,5	48	58,5	S2 A
245549 ●	8	0,5-8	B12	34,5	50	60,5	S2 A
064524 ●	10	1-10	1/2”-20	42,8	59	74	S2 A
072687 ●	10	1-10	B16	42,8	63	77	S2 A
072693 ●	10	1-10	J2	42,8	59	75,5	S2 A
072815 ●	13	1-13	B16	52	67,5	86	S3
072818 ●	13	1-13	J6	52	67,5	86	S3
072819 ●	13	1-13	J33	52	67,5	86	S3
072820 ●	13	1-13	5/8”-16	52	68,5	87,5	S3
072821 ●	13	1-13	M18x2,5	52	74,5	93,5	S3
072825 ●	16	1-16	B18	56,5	79	98	S3
072827 ●	16	1-16	J3	56,5	79	98	S3
072828 ●	16	1-16	J6	56,5	79	98	S3
072829 ●	16	1-16	5/8”-16	56,5	80	100,5	S3
072831 ●	20	5-20	B22	65	92,5	113,5	S4
072833 ●	20	5-20	J3	65	82,5	103,5	S4
072834[1] ●	26	5-26	B24	80	120	147	S4

[1] with driver

● from stock ■ 4 - 6 weeks ▲ on request

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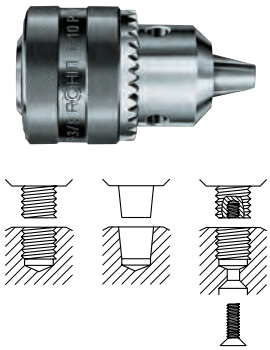
PRIMA

Tool group A01
Type 111 **Prima S and M slight intermediate sizes** primarily for hand-operated percussion drilling machines



Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Key size
072811 ●	6M	0,5-6,5	3/8”-24	29,5	42,5	53	S1
245586 ●	6M	0,5-6,5	B10	29,5	43	53	S1
245485 ●	8M	0,5-8	B10	29,5	43	53	S1
245550 ●	8M	0,5-8	B12	29,5	47,5	57,5	S1
245552 ●	8M	0,5-8	3/8”-24	29,5	42,5	53	S1
245553 ●	8M	0,5-8	1/2”-20	29,5	45	55,5	S1
070679 ●	10S	0,8-10	3/8”-24	34,5	49,5	61	S2 A
072614 ●	10S	0,8-10	1/2”-20	34,5	49,5	61	S2 A
072653 ●	10S	0,8-10	B12	34,5	50	60,5	S2 A
317255[1] ●	10S	0,8-10	3/8”-24	34,5	49,5	61	S2 A
317256[1] ●	10S	0,8-10	1/2”-20	34,5	49,5	61	S2 A
208881 ●	10M	1-10	3/8”-24	37	49,5	61	S2 A
218555 ●	10M	1-10	B12	37	50	60,5	S2 A
232521 ●	10M	1-10	1/2”-20	37	49,5	61	S2 A
064527 ●	13S	1,5-13	3/8”-24	42,8	59	74	S2 A
064530 ●	13S	1,5-13	1/2”-20	42,8	59	74	S2 A
072800 ●	13S	1,5-13	B16	42,8	63	77	S2 A
072897 ●	13S	1,5-13	B12	42,8	58	72	S2 A
317257[1] ●	13S	1,5-13	1/2”-20	42,8	59	74	S2 A
091492 ●	13M	1,5-13	1/2”-20	45,5	63	78	S2 A
072866 ●	16M	3-16	1/2”-20	50	68,5	87,5	S3
227152 ●	16M	3-16	B16	50	67,5	86,5	S3

[1] Drilled-through for clockwise and anti-clockwise rotating drilling and percussion drilling machines M5 or M6

Tool group A01
Type 105 **Prima-Mat** (LT-MT) **toothed ring drill chuck** with excentric clamping force safety device

Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Key size
245558 ●	13LT	1,5-13	1/2”-20	42,5	59	74	S2AT
1196033[1] ●	16MT	3-16	M18x2,5	50	68,5	87,5	S3T
329718 ●	16LT	3-16	5/8”-16	50	68,5	87,5	S3T

For percussion drilling machines with a high impact frequency
[1] Drilled-through for clockwise and anti-clockwise rotating drilling and percussion drilling machines M5 or M6

Tool group A01
Type 109-06 **Prima 6L** for hand-operated drilling and percussion drilling machines, in particular for screwdrivers with 1/4” hexagonal take-up

Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Key size
368292 ●	6L	0,5-6,5	E6,3	29,3	42,5	53	S14

For clockwise and anti-clockwise rotation

Tool group A01
Type 129-00 HBF **hammer drill chuck** with SDS-Plus adaptor take-up

Item no.	Size	Clamping capacity	Mount	External Ø	Length opened	Length closed	Key size
600581 ●	HBF13	2,5-13	SDSØ10	42,9	68	81,5	S2A

with carbide inserts in the clamping jaws
Chuck end play for transmitting the entire impact onto the drill
For clockwise and anti-clockwise rotation

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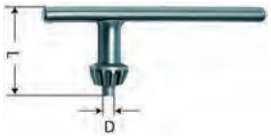
ROHM Drill chuck keys

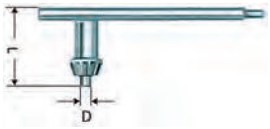
BFS

Tool group A01
Type 120
Keys with **DIN toothing 6349** for key-type drill chucks



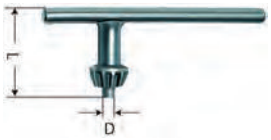
Item no.	Size	Packaging	D	L	Weight
026411 ●	S1	loose	4	30	25
205989 ●	S2 A	loose	6	41	50
025835 ●	S3	loose	8	50	100
025839 ●	S4	loose	9	55	115

Tool group A01
Type 105-00
Keys with **DIN toothing 6349** for key-type drill chucks



Item no.	Size	Packaging	D	L	Weight
309380 ●	S2 AT	loose	6	42	50
309382 ●	S 3T	loose	8	51	90

Tool group A01
Type 109-08
Key with **Jacobs-toothing**



Item no.	Size	Packaging	D	L	Weight
307319 ●	S14	loose	6,1	30	50

● from stock ■ 4 - 6 weeks ▲ on request

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WILLIAM-GEMA

Especially suitable for wood working machines.
Appropriate for high speeds.

No automatic slackening by vibrations due to the offset drive spindle.
the thread spindle is covered by a protecting sleeve

Tool group A03
Type 125 SH **William with protecting sleeve**
with offset drive spindle

Item no.	Size	Clamping capacity	Mount	Total length	Head length	Head Ø	Neck-Ø	Weight approx. g
019577 ■	10	1-10	B16	61,5	39	58	33	555
019592 ■	13	1-13	B16	63,5	41	66	38	765
019605 ■	16	1-16	B18	76,5	45	75	42	1070
019620 ■	20	1-20	B22	90,5	55	87,5	50	1890

Tool group A03
Type 125 **William**
with offset drive spindle

Item no.	Size	Clamping capacity	Mount	Total length	Head length	Head Ø	Neck-Ø	Weight approx. g
019566 ■	10	1-10	B16	61,5	39	43	33	505
019581 ■	13	1-13	B16	63,5	41	50	38	705
019596 ■	16	1-16	B18	76,5	45	55	42	995
019609 ■	20	1-20	B22	90,5	55	68	50	1785
019624 ■	26	3-26	B24	107,5	65	85	60	3120

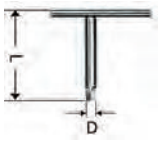
Tool group A03
Type 126 SH **Gema with protecting sleeve**
with additional driving jaws for tapping

Item no.	Size	Clamping capacity	Mount	Total length	Head length	Head Ø	Neck-Ø	Weight approx. g	Machine tap		
									mm DIN 371	mm DIN 376	Inch DIN 356
023261 ■	10	1-10	B16	75,6	53	58	33	690	M 3-M 12	1/8-1/2	M 3-M 10
023264 ■	13	1-13	B16	79,6	57	66	38	960	M 4-M 16	5/32-5/8	M 4-M 10
023267 ■	16	1-16	B18	91	59,6	75	42	1290	M 4-M 20	5/32-13/16	M 4-M 10
023270 ■	20	1-20	B22	109,6	74	87,5	50	2305	M 5-M 27	7/32-1	M 5-M 10

Tool group A03
Type 126 **Gema**
with additional driving jaws for tapping

Item no.	Size	Clamping capacity	Mount	Total length	Head length	Head Ø	Neck-Ø	Weight approx. g	Machine tap		
									mm DIN 371	mm DIN 376	Inch DIN 356
020209 ■	10	1-10	B16	75,6	53	43	33	630	M 3-M 12	1/8-1/2	M 3-M 10
020217 ■	13	1-13	B16	79,6	57	50	38	895	M 4-M 16	5/32-5/8	M 4-M 10
020225 ■	16	1-16	B18	91	59,6	55	42	1190	M 4-M 20	5/32-13/16	M 4-M 10
020233 ■	20	1-20	B22	109,6	74	68	50	2185	M 5-M 27	7/32-1	M 5-M 10
020241 ■	26	3-26	B24	134	91,6	85	60	4000	M 6-M 33	1/4-11/4	M 6-M 10

Tool group A03
Type 125 **Keys** for two-jaw drill chucks



Item no.	Size	D	L
026416 ●	10	5	50
026417 ●	13/16	6	
026418 ●	20	7	
026419 ●	26	8	

● from stock ■ 4 - 6 weeks ▲ on request

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ROHM Two-jaw tapping chucks

GSF

Tool group A03
Type 127-00 **GSF**
without locking pin

Item no.	Size	Mount	Square clamping width	For taps	External Ø	Key	Set of jaws
319605 ●	9	B10	3-9	M 3,5-14	28	**026416**	**309341**
303081 ●	9	B12	3-9	M 3,5-14	28	**026416**	**309341**

Tool group A03
Type 127-01 **GSF**
with locking pin

Item no.	Size	Mount	Square clamping width	For taps	External Ø	Key	Set of jaws
307158 ●	9	B12	3-9	M 3,5-14	28	**026416**	**309341**

● from stock ■ 4 - 6 weeks ▲ on request

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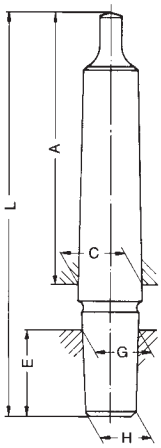
KD

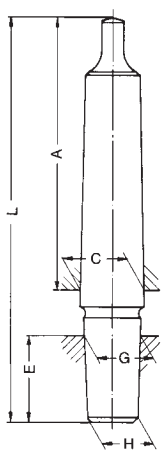
Tool group A04
Type 236 **Taper shank arbors with drill chuck taper DIN 238**
completely hardened and ground



Item no.	Morse taper DIN 228 B	Hole for alignment pin	L	A	C	E	G	H	Weight
014893 ●	0	B10	79	56,5	9,045	14,5	10,095	9,4	35
014894 ●	0	B12	85	56,5	9,045	18,5	12,065	11,1	40
014897 ●	1	B10	86	62	12,065	14,5	10,095	9,4	55
014898 ●	1	B12	89	62	12,065	18,5	12,065	11,1	65
014899 ●	1	B16	97	62	12,065	24	15,733	14,5	90
014900 ●	1	B18	106	62	12,065	32	17,78	16,2	110
018755[1] ●	1	B18	97	62	12,065	25	17,431	16,2	95
014904 ●	2	B10	103,5	75	17,78	14,5	10,095	9,4	130
014905 ●	2	B12	106,5	75	17,78	18,5	12,065	11,1	135
014906 ●	2	B16	110,5	75	17,78	24	15,733	14,5	160
014907 ●	2	B18	117,5	75	17,78	32	17,78	16,2	180
018756[1] ●	2	B18	108,5	75	17,78	25	17,431	16,2	165
014908 ●	2	B22	128,5	75	17,78	40,5	21,793	19,8	245
014911 ●	3	B12	125	94	23,825	18,5	12,065	11,1	280
014912 ●	3	B16	134	94	23,825	24	15,733	14,5	310
014913 ●	3	B18	141	94	23,825	32	17,78	16,2	320
018757[1] ●	3	B18	132	94	23,825	25	17,431	16,2	320
014914 ●	3	B22	147	94	23,825	40,5	21,793	19,8	390
014915 ●	3	B24	158	94	23,825	50,5	23,825	21,3	440
014916 ●	4	B16	159	117,5	31,267	24	15,733	14,5	625
014917 ●	4	B18	168	117,5	31,267	32	17,78	16,2	660
018758[1] ●	4	B18	159	117,5	31,267	25	17,431	16,2	640
014918 ●	4	B22	176	117,5	31,267	40,5	21,793	19,8	715
014919 ●	4	B24	185	117,5	31,267	50,5	23,825	21,3	770
014920 ●	5	B16	196	149,5	44,399	24	15,733	14,5	1600
014921 ●	5	B18	204,5	149,5	44,399	32	17,78	16,2	1600
018759[1] ●	5	B18	195,5	149,5	44,399	25	17,431	16,2	1560
014922 ●	5	B22	213,5	149,5	44,399	40,5	21,793	19,8	1650
014923 ●	5	B24	224,5	149,5	44,399	50,5	23,825	21,3	1700

[1] for Supra and Spiro with shortened pick up taper
Taper shank arbors with tapped shank (type 238) or cylindrical shank type (type 237) on request

Tool group A04
Type 236 **Taper shank arbors with Jacobs drill chuck taper**
completely hardened and ground



Item no.	Morse taper DIN 228 B	Hole for alignment pin	L	A	C	E	G	H	Weight
014970 ●	1	J1	86,5	62	12,065	16,7	9,754	8,5	50
014971 ●	1	J2	92	62	12,065	22,2	14,199	12,4	70
014972 ●	1	J3	101	62	12,065	31	20,599	19	50
014974 ●	1	J6	95	62	12,065	25,4	17,17	15,9	50
014976 ●	2	J1	101	75	17,78	16,7	9,754	8,5	130
014977 ●	2	J2	106,5	75	17,78	22,2	14,199	12,4	160
014978 ●	2	J3	115,5	75	17,78	31	20,599	19	200
014980 ●	2	J33	109,5	75	17,78	25,4	15,85	14,2	160
014981 ●	2	J6	109,5	75	17,78	25,4	17,17	15,9	165
014983 ●	3	J2	126	94	23,825	22,2	14,199	12,4	310
014984 ●	3	J3	135	94	23,825	31	20,599	19	350
014987 ●	3	J33	129	94	23,825	25,4	15,85	14,2	310
014988 ●	3	J6	129	94	23,825	25,4	17,17	15,9	310
014991 ●	4	J3	161	117,5	31,267	31	20,599	19	475
014995 ●	4	J6	155	117,5	31,267	25,4	17,17	15,9	620

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Reducing sleeves

RH

Tool group A05
Type 261 **Standard version**
similar to DIN 2185
ground external taper

Item no.	External taper MT	Internal taper MT	L	Weight approx. g
017002 ●	1	0	80	30
017003 ●	2	1	92	95
017001 ●	3	1	99	250
017004 ●	3	2	112	190
017005 ●	4	1	124	550
017006 ●	4	2	124	480
017007 ●	4	3	140	360
017008 ●	5	1	156	1700
017009 ●	5	2	156	1520
017010 ●	5	3	156	1360
017011 ●	5	4	171	950
017013 ●	6	2	218	4300
017014 ●	6	3	218	4100
017015 ●	6	4	218	3600
017016 ●	6	5	218	2550

Tool group A05
Type 262 **Precision version**
DIN 2185
completely hardened, ground
internal and external

Item no.	External taper MT	Internal taper MT	L	Weight approx. g
017017 ●	1	0	80	30
017018 ●	2	1	92	95
017019 ●	3	1	99	250
017020 ●	3	2	112	190
017021 ●	4	1	124	550
017022 ●	4	2	124	480
017023 ●	4	3	140	360
017024 ●	5	1	156	1700
017025 ●	5	2	156	1520
017026 ●	5	3	156	1360
017027 ●	5	4	171	950
017028 ●	6	2	218	4300
017029 ●	6	3	218	4100
017030 ●	6	4	218	3600
017031 ●	6	5	218	2550

Tool group A05
Type 263 **with internal cones**
reduced by the length of the tang
ground external taper

Item no.	External taper MT	Internal taper MT	L	Weight approx. g
017032 ●	1	0	80	30
017033 ●	2	1	92	95
017034 ●	3	2	112	190
017035 ●	4	3	140	360
017036 ●	5	4	171	950
017037 ■	6	5	218	2550

For use with spiral drills with broken off flat tang. The broken off shaft is provided with a new flat tang. The drill shortened in this way can then be reinserted and later ejected.

● from stock ■ 4 - 6 weeks ▲ on request

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Reducing sleeves

RH

Tool group A05
Type 274 with **forcing nuts**
completely hardened, ground
internal and external

Item no.	External taper MT	Internal taper MT	L	Weight approx. g
032112 ■	2	1	95	140
032113 ■	3	1	115	360
032114 ■	3	2	115	270
032115 ■	4	1	137	670
032116 ■	4	2	137	590
032117 ■	4	3	137	470
032119 ■	5	2	173	1750
032120 ■	5	3	173	1590
032121 ■	5	4	173	1270
032124 ■	6	3	240	4630
032125 ■	6	4	240	4110
032126 ■	6	5	240	3020

Tool group A05
Type 266-00 **Taper drift**

Item no.	for MT	Length	Weight
017075 ●	0	90	14
017076 ●	1+2	140	70
017077 ●	3	190	150
017078 ●	4	225	310
017079 ●	5+6	265	650

Tool group A05
Type 266-50 **Taper drift**
for one-hand-operation

Item no.	for MT	Length	Weight
317236 ●	1-3	320	320
317258 ●	4-6	380	520

● from stock ■ 4 - 6 weeks ▲ on request

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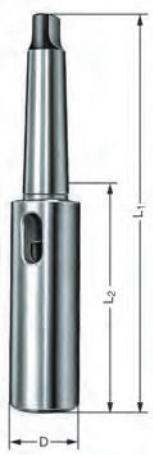
Extension sleeves

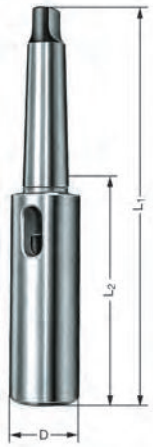
VLH

Tool group A05
Type 265 **Standard version**
similar to DIN 2187
ground external taper



Item no.	External taper MT	Internal taper MT	D	L1	L2	Weight
017054 ●	1	1	20	145	83	190
017055 ●	1	2	30	160	98	340
017056 ●	2	1	20	160	85	250
017057 ●	2	2	30	175	100	400
017058 ●	2	3	36	196	121	840
017059 ●	3	1	20	175	81	400
017060 ●	3	2	30	194	100	550
017061 ●	3	3	36	215	121	1000
017062 ●	3	4	48	240	146	1500
017063 ●	4	1	20	200	82,5	800
017064 ●	4	2	30	215	97,5	850
017065 ●	4	3	36	240	122,5	1300
017066 ●	4	4	48	265	147,5	1900
017067 ●	4	5	63	300	182,5	3310
017068 ●	5	1	20	232	82,5	1800
017069 ●	5	2	30	247	97,5	1900
017070 ●	5	3	36	268	118,5	2150
017071 ●	5	4	48	300	150,5	2750
017072 ●	5	5	63	335	185,5	4200
017073 ●	6	4	48	355	145	5420
017074 ●	6	5	63	390	180	6750

Tool group A05
Type 275 **Precision version**
DIN 2187
completely hardened, ground
internal and external



Item no.	External taper MT	Internal taper MT	D	L1	L2	Weight
029122 ●	1	1	20	145	83	190
029123 ●	1	2	30	160	98	340
029124 ●	2	1	20	160	85	250
029125 ●	2	2	30	175	100	400
029126 ●	2	3	36	196	121	840
029127 ●	3	1	20	175	81	400
029128 ●	3	2	30	194	100	550
029129 ●	3	3	36	215	121	1000
029130 ●	3	4	48	240	146	1500
029131 ●	4	1	20	200	82,5	800
029132 ●	4	2	30	215	97,5	850
029133 ●	4	3	36	240	122,5	1300
029134 ●	4	4	48	265	147,5	1900
029135 ●	4	5	63	300	182,5	3310
029136 ■	5	1	20	232	82,5	1800
029137 ●	5	2	30	247	97,5	1900
029138 ●	5	3	36	268	118,5	2150
029139 ●	5	4	48	300	150,5	2750
029140 ●	5	5	63	335	185,5	4200
029141 ■	6	4	48	355	145	5420
029142 ●	6	5	63	390	180	6750

● from stock ■ 4 - 6 weeks ▲ on request

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BV

Tool group A05
Type 268 **Standard version**
ground external taper

Item no.	External taper MT	Internal taper MT	D	L1	L2	Weight approx. g
017082 ●	1	1	20	200	138	250
017083 ●	1	1	20	250	188	375
017084 ●	1	1	20	300	238	500
017085 ●	1	1	20	350	288	625
017086 ●	1	1	20	400	338	750
017087 ●	1	1	20	450	388	875
017088 ●	1	1	20	500	438	1000
017000 ●	2	2	25	300	225	820
017090 ●	2	2	25	200	125	430
017091 ●	2	2	25	250	175	625
017092 ●	2	2	25	350	275	1015
017093 ●	2	2	25	400	325	1200
017094 ●	2	2	25	450	375	1400
017095 ●	2	2	25	500	425	1600
017096 ●	2	2	25	600	525	1800
017098 ●	3	3	32	250	156	1000
017099 ●	3	3	32	300	206	1300
017100 ●	3	3	32	350	256	1550
017101 ●	3	3	32	400	306	1850
017102 ●	3	3	32	450	356	2100
017103 ●	3	3	32	500	406	2400
017104 ●	3	3	32	600	506	2700
017107 ●	4	4	40	300	182,5	1650
017108 ●	4	4	40	350	232,5	2150
017109 ●	4	4	40	400	282,5	2650
017110 ●	4	4	40	450	332,5	3100
017111 ●	4	4	40	500	382,5	3600
017112 ●	4	4	40	600	482,5	4200

Tool group A05
Type 278 **Precision version**
completely hardened, ground
internal and external

Item no.	External taper MT	Internal taper MT	D	L1	L2	Weight approx. g
029143 ■	1	1	20	200	138	250
029144 ■	1	1	20	250	188	375
029145 ■	1	1	20	300	238	500
029146 ■	1	1	20	350	288	625
029147 ■	1	1	20	400	338	750
029148 ■	1	1	20	450	388	875
029149 ■	1	1	20	500	438	1000
029150 ■	2	2	25	200	125	430
029151 ■	2	2	25	250	175	625
029152 ■	2	2	25	300	225	820
029153 ■	2	2	25	350	275	1015
029154 ■	2	2	25	400	325	1200
029155 ■	2	2	25	450	375	1400
029156 ■	2	2	25	500	425	1600
029157 ■	2	2	25	600	525	1800
029158 ■	3	3	32	250	156	1000
029159 ■	3	3	32	300	206	1300
029160 ■	3	3	32	350	256	1550
029161 ■	3	3	32	400	306	1850
029162 ■	3	3	32	450	356	2100
029163 ■	3	3	32	500	406	2400
029164 ■	3	3	32	600	506	2700
029165 ■	4	4	40	300	182,5	1650
029166 ■	4	4	40	350	232,5	2150
029167 ■	4	4	40	400	282,5	2650
029168 ■	4	4	40	450	332,5	3100
029169 ■	4	4	40	500	382,5	3600
029170 ■	4	4	40	600	482,5	4200

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ROHM Spindle sleeves

SPH

Tool group A05
Type 273 **Open**, for lathes completely hardened, ground internal and external

Item no.	External taper MT	External taper metric D[1]	Internal taper MT	L	Weight
220101 ■	-	40	3	70	420
220102 ■	-	40	4	70	250
042554 ■	-	50	3	86	940
032031 ■	-	50	4	86	740
058264 ■	-	50	5	86	260
042644 ■	-	60	4	100	1480
220103 ■	-	60	5	100	950
098667 ■	-	70	4	110	2480
077140 ■	-	70	5	110	1850
220104 ■	-	80	4	110	3450
042551 ■	-	80	5	110	2850
042552 ■	-	80	6	110	1560
058313 ■	-	90	5	120	4300
058314 ■	-	90	6	120	2110
031931 ■	2	-	1	60	50
031932 ■	3	-	1	70	160
031933 ■	3	-	2	70	100
031935 ■	4	-	2	70	270
031936 ■	4	-	3	70	170
031938 ■	5	-	2	77	700
031939 ■	5	-	3	77	650
031940 ■	5	-	4	77	460
031942 ■	6	-	3	110	2160
031943 ■	6	-	4	110	1900
031944 ■	6	-	5	110	1350

[1] taper ratio 1:20

Collets

Type 8210-E, DIN 6328
for mounting screw taps with cylindrical shank and DIN square

Tool group 16
Type 8210-E, DIN 6328

External taper DIN 228 MK	0		1			2			3		4	
Bore diameter A Standard-model	2,5	2,8	2,5	2,8	3,15	4,5	5,0	5,5	8,0	9,0	12,0	12,5
	3,15	3,5	3,5	3,55	4,0	5,6	6,0	6,3	9,5	10,0	14,0	16,0
	3,55	4,0	4,5	5,0	5,5	7,0	7,0	8,0	11,0	11,2	18,0	20,0
	4,5		5,6	6,0	6,3	9,0	9,5	10,0	12,0	12,5	22,0	22,4
			7,0	7,1	8,0	11,0	11,2	12,0	14,0	16,0	25,0	

Collets be available in intermediate dimensions, short drill 1-2,9 and intermediate dimensions and short drill 1-2,9.
Please contact us.

Typ 8211-E, DIN 6329
for mounting twist drills and other tools with cylindrical shank and driver

Tool group 16
Type 8211-E, DIN 6329

External taper DIN 228 MK	0	1	2	3	4
Bore diameter A	1,5-5,5	3,0-8,0	5,0-13,0	8,0-18,0	12,0-20,0
Standard-model	rising by 0,1 mm			rising by 0,5 mm	rising by 1,0 mm

Collets be available in intermediate dimensions, short drill 1-2,9 and intermediate dimensions and short drill 1-2,9.
Please contact us.

● from stock ■ 4 - 6 weeks ▲ on request

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SH

Tool group A16
Type 250 **Short model**
Form D without counterbore for tools with flat tang
Form E with counterbore for tools with draw-in thread

Item no.	Design	Size Ø A	MT	Thread Tr	Weight
336093 ■	D	16	0	16 x 1,5	100
336076 ●	D	16	1	16 x 1,5	75
331344 ●	D	20	1	20 x 2	155
222802 ■	D	25	1	25 x 2	280
331347 ●	D	28	1	28 x 2	360
222803 ●	D	25	2	25 x 2	210
331165 ●	D	28	2	28 x 2	300
222804 ■	D	32	2	32 x 2	595
336183 ■	D	36	2	36 x 2	755
222805 ■	D	32	3	32 x 2	390
336211 ●	D	36	3	36 x 2	605
336224 ■	D	48	3	48 x 2	1645
336220 ●	D	48	4	48 x 2	1315
222800 ■	D	10	6	10 x 1,5	
222801 ■	D	12	6	12 x 1,5	
222806 ●	E	16	1	16 x 1,5	75
603203 ■	E	20	1	20 x 2	155
222808 ■	E	25	1	25 x 2	280
353515 ■	E	28	1	28 x 2	360
222809 ■	E	25	2	25 x 2	210
339117 ●	E	28	2	28 x 2	300
222812 ■	E	32	2	32 x 2	595
336603 ■	E	36	2	36 x 2	755
222813 ■	E	32	3	32 x 2	390
339038 ■	E	36	3	36 x 2	605
222816 ■	E	48	3	48 x 2	1645
379867 ●	E	48	4	48 x 2	1315

Locknuts must be ordered separately

Tool group A16
Type 252 **Offset model**
Form H offset model, for tools with flat tang

Item no.	Design	Size Ø A	MT	Thread Tr	Weight
222897 ■	H	10	0	10 x 1,5	150
222898 ■	H	12	0	12 x 1,5	155
222899 ■	H	16	1	16 x 1,5	365
336626 ■	H	16	2	16 x 1,5	325
082953 ●	H	20	2	20 x 2	495
222901 ■	H	25	3	25 x 2	600
082954 ●	H	28	3	28 x 2	1040
222902 ■	H	32	4	32 x 2	1100
082955 ■	H	36	4	36 x 2	1255
222896 ■	H	8	metr. 6	8 x 1	

Locknuts must be ordered separately

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Adjustable adapters

SH

Tool group A16
Type 251 **Long model**
Form F long model, without counterbore for tools with flat tang
Form G long model, with counterbore for tools with draw-in thread

Item no.	Design	Size Ø A	MT	L	Thread Tr	D	Weight
082924 ■	F	16	0	50	16 x 1,5	135	160
082925 ■	F	16	0	75	16 x 1,5	160	190
082926 ■	F	16	0	100	16 x 1,5	185	210
336644 ■	F	16	0	25	16 x 1,5	110	130
082930 ■	F	16	1	100	16 x 1,5	185	235
336633 ●	F	16	1	25	16 x 1,5	110	115
336637 ●	F	16	1	50	16 x 1,5	135	155
336641 ■	F	16	1	75	16 x 1,5	160	195
331351 ■	F	20	1	75	20 x 2	163	275
331544 ●	F	20	1	25	20 x 2	113	195
336648 ●	F	20	1	50	20 x 2	138	235
336652 ■	F	20	1	100	20 x 2	188	315
222832 ■	F	25	1	25	25 x 2	120	365
222833 ■	F	25	1	50	25 x 2	145	425
222834 ■	F	25	1	75	25 x 2	170	485
222835 ■	F	25	1	100	25 x 2	195	545
336471 ●	F	28	1	25	28 x 2	120	460
336672 ■	F	28	1	100	28 x 2	195	760
336683 ●	F	28	1	50	28 x 2	145	560
336687 ●	F	28	1	75	28 x 2	170	660
222836 ■	F	25	2	25	25 x 2	120	285
222837 ■	F	25	2	50	25 x 2	145	375
222838 ■	F	25	2	75	25 x 2	170	465
222839 ■	F	25	2	100	25 x 2	195	555
336656 ●	F	28	2	25	28 x 2	120	390
336660 ●	F	28	2	50	28 x 2	145	490
336664 ●	F	28	2	75	28 x 2	170	590
336668 ●	F	28	2	100	28 x 2	195	690
222840 ■	F	32	2	30	32 x 2	148	725
222841 ■	F	32	2	60	32 x 2	178	855
222842 ■	F	32	2	90	32 x 2	208	985
222843 ■	F	32	2	120	32 x 2	238	1115
082939 ■	F	36	2	90	36 x 2	208	1355
082940 ■	F	36	2	120	36 x 2	238	1555
339182 ■	F	36	2	30	36 x 2	148	955
379985 ■	F	36	2	60	36 x 2	178	1155
222844 ■	F	32	3	30	32 x 2	148	540
222845 ■	F	32	3	60	32 x 2	178	740
222846 ■	F	32	3	90	32 x 2	208	940
222847 ■	F	32	3	120	32 x 2	238	1140
082943 ●	F	36	3	90	36 x 2	208	1205
082944 ■	F	36	3	120	36 x 2	238	1405
364941 ●	F	36	3	60	36 x 2	178	1005
364945 ●	F	36	3	30	36 x 2	148	805
082945 ■	F	48	3	40	48 x 2	184	2155
082946 ■	F	48	3	80	48 x 2	224	2660
082947 ■	F	48	3	120	48 x 2	264	3165
082948 ■	F	48	3	160	48 x 2	304	3675
082949 ■	F	48	4	40	48 x 2	184	1815
082950 ■	F	48	4	80	48 x 2	224	2315
082951 ■	F	48	4	120	48 x 2	264	2815
082952 ■	F	48	4	160	48 x 2	304	3315
222824 ▲	F	10	6	10	10 x 1,5	72	
222825 ▲	F	10	6	20	10 x 1,5	82	
222826 ▲	F	10	6	30	10 x 1,5	92	
222827 ▲	F	12	6	10	12 x 1,5	72	
222828 ▲	F	12	6	20	12 x 1,5	82	
222829 ▲	F	12	6	30	12 x 1,5	92	
222830 ▲	F	12	6	40	12 x 1,5	102	
222848 ■	G	16	1	25	16 x 1,5	110	115
222849 ■	G	16	1	50	16 x 1,5	135	155
222850 ■	G	16	1	75	16 x 1,5	160	195
222851 ■	G	16	1	100	16 x 1,5	185	235
222852 ■	G	20	1	25	20 x 2	113	195
222853 ■	G	20	1	50	20 x 2	138	235
222854 ■	G	20	1	75	20 x 2	163	275
222855 ■	G	20	1	100	20 x 2	188	315
222856 ■	G	25	1	25	25 x 2	120	365

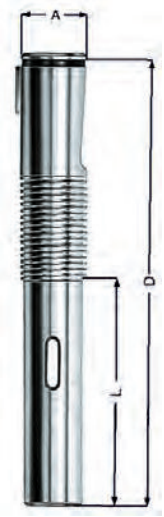
Locknuts must be ordered separately

● from stock ■ 4 - 6 weeks ▲ on request

To Order Contact: Exact Tooling / www.exacttooling.com / sales@exacttooling.com / 888-988-8820

SH

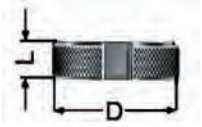
Tool group A16
Type 251 **Long model**
Form F long model, without counterbore for tools with flat tang
Form G long model, with counterbore for tools with draw-in thread



Item no.	Design	Size Ø A	MT	L	Thread Tr	D	Weight
222857	G	25	1	50	25 x 2	145	425
222858	G	25	1	75	25 x 2	170	485
222859	G	25	1	100	25 x 2	195	545
222864	G	28	1	25	28 x 2	120	460
222865	G	28	1	50	28 x 2	145	560
222866	G	28	1	75	28 x 2	170	660
222867	G	28	1	100	28 x 2	195	760
222860	G	25	2	25	25 x 2	120	285
222861	G	25	2	50	25 x 2	145	375
222862	G	25	2	75	25 x 2	170	465
222863	G	25	2	100	25 x 2	195	555
222868	G	28	2	25	28 x 2	120	390
222869	G	28	2	50	28 x 2	145	490
222870	G	28	2	75	28 x 2	170	590
222871	G	28	2	100	28 x 2	195	690
222872	G	32	2	30	32 x 2	148	725
222873	G	32	2	60	32 x 2	178	855
222874	G	32	2	90	32 x 2	208	985
222875	G	32	2	120	32 x 2	238	1115
222880	G	36	2	30	36 x 2	148	955
222881	G	36	2	60	36 x 2	178	1155
222882	G	36	2	90	36 x 2	208	1355
222883	G	36	2	120	36 x 2	238	1555
222876	G	32	3	30	32 x 2	148	540
222877	G	32	3	60	32 x 2	178	740
222878	G	32	3	90	32 x 2	208	940
222879	G	32	3	120	32 x 2	238	1140
222884	G	36	3	30	36 x 2	148	805
222885	G	36	3	60	36 x 2	178	1005
222886	G	36	3	90	36 x 2	208	1205
222887	G	36	3	120	36 x 2	238	1405
222888	G	48	3	40	48 x 2	184	2155
222889	G	48	3	80	48 x 2	224	2660
222890	G	48	3	120	48 x 2	264	3165
222891	G	48	3	160	48 x 2	304	3675
222892	G	48	4	40	48 x 2	184	1815
222893	G	48	4	80	48 x 2	224	2315
222894	G	48	4	120	48 x 2	264	2815
222895	G	48	4	160	48 x 2	304	3315

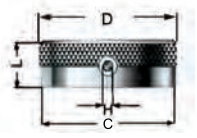
Locknuts must be ordered separately

Tool group A16
Type 0483-Y **Grooved nuts** to DIN 6327



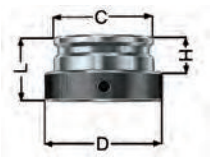
Item no.	Size	Ø D	L	Weight
200115	TR 10 x 1,5	17,8-0,2	6	10
200116	TR 12 x 1,5	19,7-0,2	6	10
200114	TR 8 x 1	14,8-0,2	5	10

Tool group A16
Type 250 **Locknuts** to DIN 6327



Item no.	Size	Ø D	Ø C	H	L	Threaded pin AM DIN 9131	Weight
069913	TR 16 x 1,5	24,6-0,4	24	M 5	12	5 x 3	25
072723	TR 20 x 2	31,6-0,4	31	M 5	12	5 x 4	40
222821	TR 25 x 2	36,6-0,4	36	M 6	12	6 x 4	45
069914	TR 28 x 2	39,6-0,4	39	M 6	12	6 x 4	50
222822	TR 32 x 2	44,6-0,4	44	M 6	14	6 x 4	75
074575	TR 36 x 2	49,6-0,4	49	M 6	14	6 x 4	90
021385	TR 48 x 2	66,6-0,4	66	M 8	18	8 x 8	220
082673	TR 55 x 2	74,6-0,4	74	M 8	18	8 x 8	

Tool group A16
Type 375-91 **Quick-change locating nuts** with guide on both sides - highest accuracy



Item no.	Size	Ø D	Ø C	H	L	Weight
368694	TR 12 x 1,5	21,5	16,4	9	18	20
601490	TR 16 x 1,5	26	19,9	9,5	18,5	30
601493	TR 20 x 2	33	25,4	11	20	50
601496	TR 25 x 2	40	31,9	12	22	80
601499	TR 28 x 2	42	33,9	12	22	80
341200	TR 32 x 2	47	37,9	13,4	23,5	100
608205	TR 36 x 2	54	43,4	16	26	140
341202	TR 48 x 2	72	57,9	19,9	34	350
341203	TR 55 x 2	79	66,9	25	41	

● from stock ■ 4 - 6 weeks ▲ on request

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ROHM Precision short drill chucks

KBF

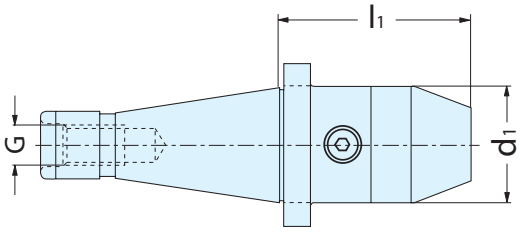
For clockwise and anti-clockwise rotation.
For clamping cylindrical shafted tools.

high axial- and radial accuracy
Secure gripping of the tool through mechanical amplification of the clamping force.
No automatic slackening of the clamping force while machining with either clockwise or anticlockwise rotation or on spindle stop.

Technical features:

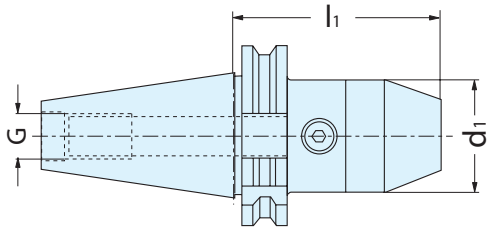
- for quick and easy tool change
- short clamping and tool changing times due to continuously adjustable clamping
- high clamping forces due to angular gears
- low expenditure of clamping energy due to the use of a hexagon wrench
- coolant supply with 50 bar due to the sealed design

Tool group A38
Type 142-20 **Steep taper DIN 2080 form AD**



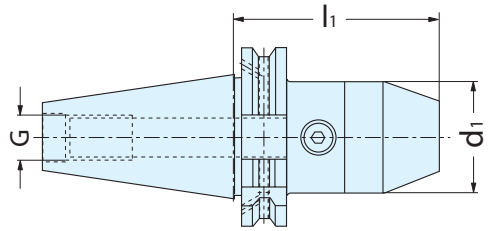
Item no.	Mount SA	Clamping range	d1	l1	G	Weight
893315 ●	40	1-13	50	80	M 16	1500
893316 ●	40	2,5-16	50	85,5	M 16	1700
893317 ■	50	1-13	50	83,5	M 24	3300
893318 ■	50	2,5-16	50	89	M 24	3600

Tool group A38
Type 142-10 **Steep taper DIN 69871 form AD**



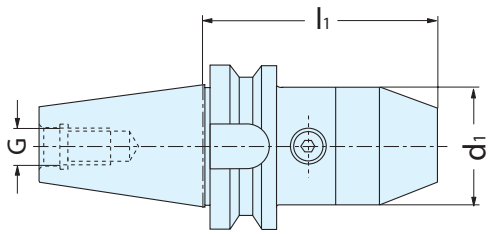
Item no.	Mount SA	Clamping range	d1	l1	G	Weight
893302 ■	30	1-13	50	103	M 12	900
893303 ●	40	1-13	50	87,5	M 16	1500
893304 ●	40	2,5-16	50	93	M 16	1700
893305 ■	50	1-13	50	87,5	M 24	3300
893306 ■	50	2,5-16	50	93	M 24	3600

Tool group A38
Type 142-12 **Steep taper DIN 69871 form AD/B** - with coolant feed



Item no.	Mount SA	Clamping range	d1	l1	G	Weight
893307 ■	40	1-13	50	88,5	M 16	1500
893308 ■	40	2,5-16	50	93	M 16	1700
893309 ■	50	1-13	50	103	M 24	3300
893310 ■	50	2,5-16	50	108,5	M 24	3600

Tool group A38
Type 142-30 **MAS BT 403**



Item no.	Mount MAS BT	Clamping range	d1	l1	G	Weight
893311 ■	40	1-13	50	95,5	M 16	1500
893312 ■	40	2,5-16	50	101	M 16	1700
893313 ■	50	1-13	50	106,5	M 24	3300
893314 ■	50	2,5-16	50	112	M 24	3600

● from stock ■ 4 - 6 weeks ▲ on request

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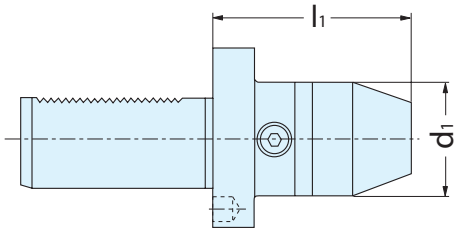
KBF

Tool group A38
Type 142-50 **VDI 3425 DIN 69880**
with coolant feed



Item no.	Mount VDI	Clamping range	d1	l1	Weight
893319 ■	40	1-13	50	75	1300
893320 ■	40	2,5-16	50	92	1500

Tool group C15
Type 7023
Hexagon key

Item no.	Length l_1	Key-width SW
202893 ■	100	6

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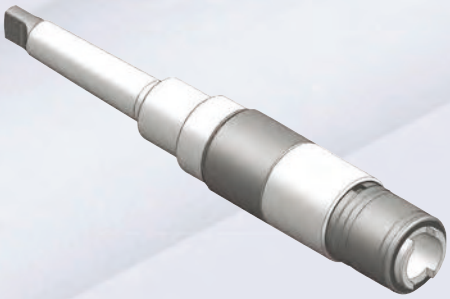
Overview

GS - slim design

For thread-cutting and- forming on transfer lines and special machines. Due to their small outside diameter the tapping chucks **GS - slim design**, are used mostly on multi spindle machines with narrow spindle distances.



GS/NC - rigid design

The tapping chucks **GS/NC - rigid design** are intended for mechanical or numerical controlled single spindle machines (milling- and drilling machines, boring mills, machining centres, etc.) as well as for machines with an automatic tool-change unit.

Available on request:

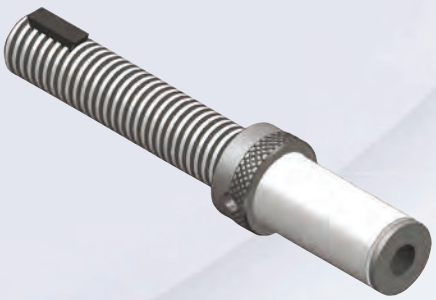
Synchro tapping chucks

For thread-cutting without compensation chucks; enabled by the synchronisation between rotational speed and advance.

The RÖHM Synchro chuck with its high quality technique compensates the small axial difference between the pitch of the tap and the feed motion of the machine spindle. RÖHM Synchro chucks are maintenance free and their perfected technique are offering a high process security as well as an extended life time of the thread work. Applicable for clockwise and anticlockwise tapping works.

WF - change chucks

Tapping change chucks for transfer lines and special machines. These change chucks will be used especially for the multi spindle purpose with short spindle distances. The direct reception of the taps in the chuck via a quick change device allows smallest outside diameters.



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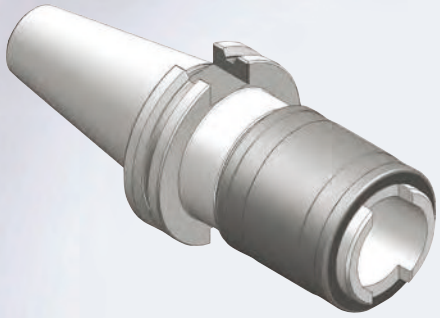
GS – slim design

For the machining of clockwise and anticlockwise threads. The small outside diameter allows narrow spindle distances.
Mainly used on multi-spindle machines. Small design and short overhang length. Depending on the application threads may be produced in between the allowance using chucks with or without length compensation or radial-parallel floating action.
The compensation movement is just axis parallel. If the feed motion of the spindle is different from the pitch of the tap chucks with length compensation acting on compression and expansion.

Type GS

Simple design without length compensation.
Due to the missing length compensation the tapping cycle must be synchronised i. e. via the leading spindle and leading cartridge or adequate adjustable machine control.

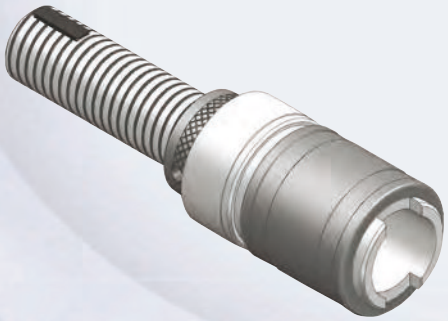
Steep Taper acc. DIN 69871,
Adjustable Adapter Shaft acc. DIN 6327,
Morse taper acc. DIN 228-B,
Drilling chuck taper acc. DIN 238 with wedge groove.



Type GSP

Simple design without length compensation.
Tapping cycle like type GS. Additionally with radial-parallel floating action for the compensation of run-out errors of the machine spindle, or offset errors between spindle and workpiece bore.

Adjustable Adapter Shaft acc. DIN 6327,
Morse Taper acc. DIN 228-B,
Drilling chuck taper shaft acc. DIN 238 with wedge groove.

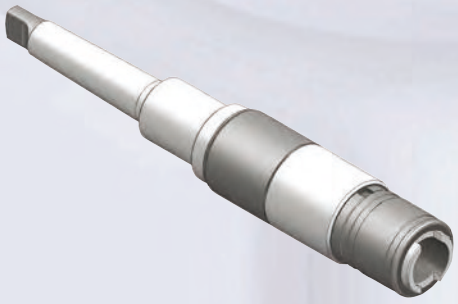


Available on request:

Type GSL

With length compensation acting on compression and expansion.

Adjustable Adapter Shaft acc. DIN 6327,
Morse Taper acc. DIN 228-B.

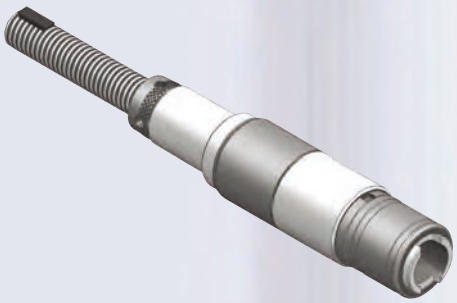


Type GSLP

With length compensation acting on compression and expansion and radial-parallel floating action.

The radial-parallel floating action of the chuck type GSLP compensates the offset between machine spindle axis and the core bore axis.

Adjustable Adapter Shaft acc. DIN 6327,
Morse Taper acc. DIN 228-B



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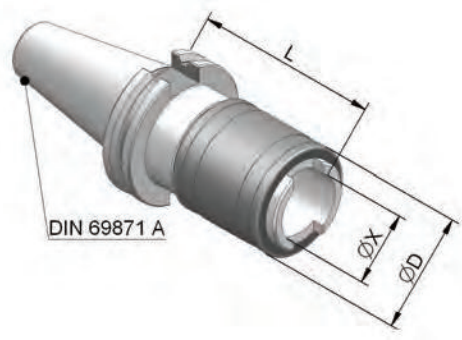
Quick change tapping chucks

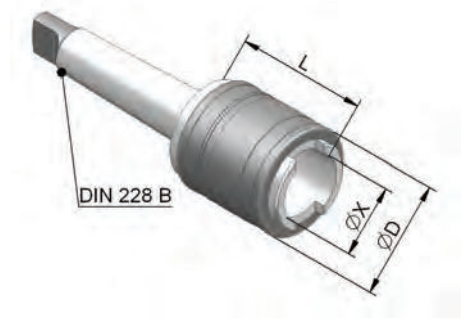
GS

Tool group A19
Type 350-72 **GS**
with steep taper shank DIN 69871 - form A



Item no.	Size	For taps	Mount	Ø D	Ø X	L
715266 ■	1	M3 - M12	SK 40	32	19	72
715268 ■	1	M3 - M12	SK 50	32	19	72
715270 ■	2	M8 - M20	SK 40	50	31	91
715272 ■	2	M8 - M20	SK 50	50	31	91
715273 ■	3	M14 - M33	SK 40	72	48	118
715275 ■	3	M14 - M33	SK 50	72	48	118
715278 ■	4	M22 - M48	SK 50	95	60	141

Tool group A19
Type 350-60 **GS**
with morse taper DIN 228 B



Item no.	Size	For taps	Mount	Ø D	Ø X	L
332113 ■	0	M1 - M10	MK 1	23	13	39
358898 ■	0	M1 - M10	MK 2	23	13	40
329138 ■	1	M3 - M12	MK 1	35	19	43
329139 ■	1	M3 - M12	MK 2	35	19	44
329140 ●	1	M3 - M12	MK 3	35	19	44
329141 ■	2	M8 - M20	MK 2	50	31	61
329142 ■	2	M8 - M20	MK 3	50	31	61
329143 ■	2	M8 - M20	MK 4	50	31	62
329144 ●	3	M14 - M33	MK 3	72	48	90
329145 ■	3	M14 - M33	MK 4	72	48	91
329146 ■	4	M22 - M48	MK 4	95	60	114
329147 ■	4	M22 - M48	MK 5	95	60	114

Tool group A19
Type 350-70 **GS**
with mounting for drill chuck taper DIN 238, with keyway

Item no.	Size	For taps	Mount	Ø D	Ø X	L
358899 ■	0	M1 - M10	B 10	23	13	51
332114 ■	0	M1 - M10	B 12	23	13	55
329148 ■	1	M3 - M12	B 12	35	19	59
329150 ●	1	M3 - M12	B 16	35	19	65
329151 ■	1	M3 - M12	B 18	32	19	73
329152 ■	2	M8 - M20	B 16	50	31	84
329153 ■	2	M8 - M20	B 18	50	31	92
329154 ■	2	M8 - M20	B 22	50	31	101
329155 ■	3	M14 - M33	B 22	72	48	126
329156 ■	3	M14 - M33	B 24	72	48	136

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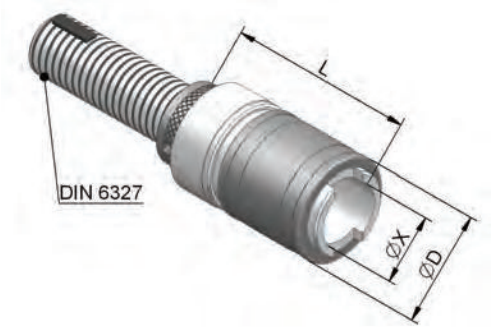
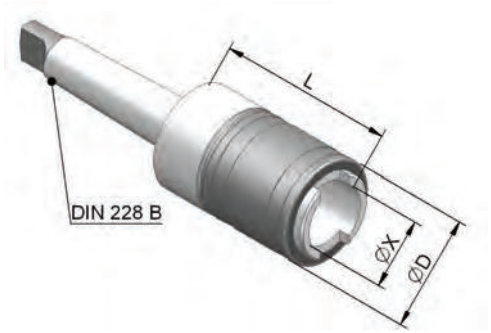
GSP

Tool group A19
Type 350-00 **GSP**
with trapezoidal thread shank DIN 6327



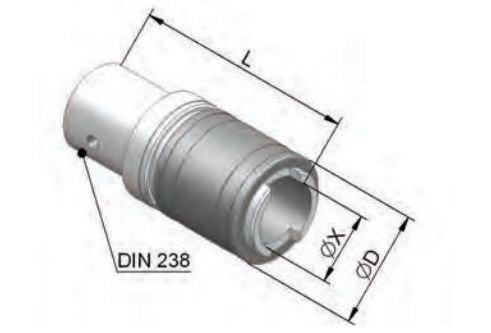
Item no.	Size	For taps	Mount	Ø D	Ø X	L	Radial float mm
332130 ■	0	M1 - M10	Tr 16x1,5	23	13	65	0,25
357490 ■	0	M1 - M10	Tr 20x2	23	13	65	0,25
329100 ■	1	M3 - M12	Tr 16x1,5	35	19	70	0,5
329101 ■	1	M3 - M12	Tr 20x2	35	19	70	0,5
329102 ■	1	M3 - M12	Tr 28x2	35	19	70	0,5
329103 ■	2	M8 - M20	Tr 20x2	50	31	96	1
329104 ■	2	M8 - M20	Tr 28x2	50	31	96	1
329105 ■	2	M8 - M20	Tr 36x2	50	31	98	1
329106 ■	3	M14 - M33	Tr 28x2	72	48	136	1,5
329107 ■	3	M14 - M33	Tr 36x2	72	48	138	1,5
329108 ■	4	M22 - M48	Tr 36x2	95	60	167	2
329109 ■	4	M22 - M48	Tr 48x2	95	60	171	2
358891 ■	7	M6 - M18	Tr 20x2	40	26	89	0,75
358892 ■	7	M6 - M18	Tr 28x2	40	26	89	0,75

Tool group A19
Type 350-10 **GSP**
with morse taper DIN 228 B



Item no.	Size	For taps	Mount	Ø D	Ø X	L	Radial float mm
332131 ■	0	M1 - M10	MK 1	23	13	59	0,25
358893 ■	0	M1 - M10	MK 2	23	13	60	0,25
329110 ■	1	M3 - M12	MK 1	35	19	64	0,5
329111 ■	1	M3 - M12	MK 2	35	19	65	0,5
329112 ■	1	M3 - M12	MK 3	35	19	65	0,5
329113 ■	2	M8 - M20	MK 2	50	31	91	1
329114 ■	2	M8 - M20	MK 3	50	31	91	1
329115 ■	2	M8 - M20	MK 4	50	31	92	1
329116 ■	3	M14 - M33	MK 3	72	48	131	1,5
329117 ■	3	M14 - M33	MK 4	72	48	132	1,5
329118 ■	4	M22 - M48	MK 4	95	60	161	2
329119 ■	4	M22 - M48	MK 5	95	60	162	2
358894 ■	7	M6 - M18	MK 2	40	26	84	0,75
358895 ■	7	M6 - M18	MK 3	40	26	84	0,75

Tool group A19
Type 350-20 **GSP**
with mounting for drill chuck taper DIN 238, with keyway



Item no.	Size	For taps	Mount	Ø D	Ø X	L	Radial float mm
358896 ■	0	M1 - M10	B 10	23	13	72	0,25
332132 ■	0	M1 - M10	B 12	23	13	76	0,25
329120 ■	1	M3 - M12	B 12	35	19	79	0,5
329121 ■	1	M3 - M12	B 16	35	19	85	0,5
329122 ■	1	M3 - M12	B 18	35	19	95	0,5
329123 ■	2	M8 - M20	B 16	50	31	112	1
329124 ■	2	M8 - M20	B 18	50	31	119	1
329125 ■	2	M8 - M20	B 22	50	31	129	1
329126 ■	3	M14 - M33	B 22	72	48	165	1,5
329127 ■	3	M14 - M33	B 24	72	48	175	1,5

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RÖHM Quick change tapping chucks

GS/NC – rigid design

For the machining of clockwise and anticlockwise threads – with taps – on mechanical and numeric controlled machines and CNC machines with tool magazine.

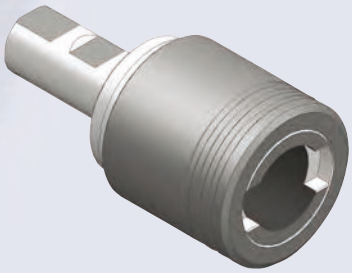
Type GSA

For automatic tool changing,
with length compensation acting on compression and expansion.

Positive Taper Lock acc. DIN 69893
Steep Taper acc. DIN 69871/A,
Steep Taper for MAS-BT (one-piece)
Steep Taper for MAS-BT (two-piece)

Type GS/C

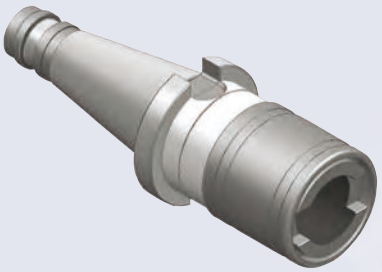
The newly developed push and length compensation acting on compression and expansion marks the RÖHM GS/C Chuck for tapping. The axial movement gives the chuck a rigid grip with a narrow axial play due the asymmetric arrangement of the balls and thus the ideal force distribution.
A tough lead force pressure and an easy going length compensation guarantees threads in between the allowance and production security even under hardest conditions.
The tapping chuck offers highest security during the tapping cycle.
Few maintenance required.



Adjustable Adapter Shaft acc. DIN 6327,
Morse Taper acc. DIN 228-A,
Morse Taper acc. DIN 228-B,
Module Shaft acc. DIN 1835 - form B+E
Cylindrical Shaft acc. VDI without toothing,
Reception type ABS.

Type GS/NC

Tapping Chuck with an extremely easy going and low friction compression and expansion length compensation due to the ball guiding sleeve.
This results in a very accurate compensation of the differences between machine feed movement and the pitch of the tap. The lead force mechanism provides that the tap immediately starts to cut the thread when the permissible axial forces – depending on the material strength and specific cutting force. Only if the effectively produced axial force exceeds the normal permissible lead force the lead force mechanism releases the length compensation ability. The ball pretension resp. the lead force may be raised or reduced by the threaded pin via the pressure spring.



Adjustable Adapter Shaft acc. DIN 6327,
Morse Taper acc. DIN 228-A,
Morse Taper acc. DIN 228-B,
Cylindrical Shaft similar to DIN 1835 - form B+E,
Cylindrical Shaft similar to DIN 1835 - with clamping surface,
Steep Taper acc. DIN 2080.

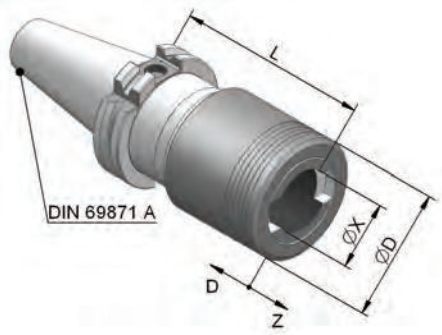
To Order Contact: Exact Tooling / www.exacttooling.com / sales@exacttooling.com / 888-988-8820

GSA

Tool group A19
Type 354-80 **GSA HSK**
hollow taper shank DIN 69893 A

Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
1132809 ■	1	M3 - M12	7,5	7,5	HSK-100	39	19	80
1132813 ■	1	M3 - M12	0	12,5	HSK-100	39	19	72,5
1132806 ■	1	M3 - M12	7,5	7,5	HSK-50	39	19	72
1132810 ■	1	M3 - M12	0	12,5	HSK-50	39	19	64,5
1132807 ■	1	M3 - M12	7,5	7,5	HSK-63	39	19	72
1132811 ■	1	M3 - M12	0	12,5	HSK-63	39	19	64,5
1132808 ■	1	M3 - M12	7,5	7,5	HSK-80	39	19	75
1132812 ■	1	M3 - M12	0	12,5	HSK-80	39	19	67,5
1132817 ■	2	M8 - M20	10	10	HSK-100	60	31	100
1132821 ■	2	M8 - M20	0	16,5	HSK-100	60	31	90
1132814 ■	2	M8 - M20	10	10	HSK-50	60	31	110
1132818 ■	2	M8 - M20	0	16,5	HSK-50	60	31	100
1132815 ■	2	M8 - M20	10	10	HSK-63	60	31	110
1132819 ■	2	M8 - M20	0	16,5	HSK-63	60	31	100
1132816 ■	2	M8 - M20	10	10	HSK-80	60	31	95
1132820 ■	2	M8 - M20	0	16,5	HSK-80	60	31	85
1132824 ■	3	M14 - M33	17,5	17,5	HSK-100	86	48	144
1132827 ■	3	M14 - M33	0	35	HSK-100	86	48	126,5
1132822 ■	3	M14 - M33	17,5	17,5	HSK-63	86	48	141
1132825 ■	3	M14 - M33	0	35	HSK-63	86	48	123,5
1132823 ■	3	M14 - M33	17,5	17,5	HSK-80	86	48	141
1132826 ■	3	M14 - M33	0	35	HSK-80	86	48	123,5

Tool group A19
Type 354-85 **GSA SK**
with steep taper shank DIN 69871 - form A



Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
1132768 ■	0	M1 - M10	6,5	6,5	SK 40	26	13	94
1132769 ■	0	M1 - M10	6,5	6,5	SK 50	26	13	104
1132828 ■	1	M3 - M12	7,5	7,5	SK 30	39	19	65
1132830 ■	1	M3 - M12	0	12,5	SK 30	39	19	57,5
1132829 ■	1	M3 - M12	7,5	7,5	SK 40	39	19	65
1132831 ■	1	M3 - M12	0	12,5	SK 40	39	19	57,5
1132832 ■	2	M8 - M20	10	10	SK 30	60	31	103
1132835 ■	2	M8 - M20	0	16,5	SK 30	60	31	93
1132833 ■	2	M8 - M20	10	10	SK 40	60	31	103
1132836 ■	2	M8 - M20	0	16,5	SK 40	60	31	93
1132834 ■	2	M8 - M20	10	10	SK 50	60	31	88
1132837 ■	2	M8 - M20	0	16,5	SK 50	60	31	78
1132838 ■	3	M14 - M33	17,5	17,5	SK 40	86	48	134
1132840 ■	3	M14 - M33	0	35	SK 40	86	48	116,5
1132839 ■	3	M14 - M33	17,5	17,5	SK 50	86	48	134
1132841 ■	3	M14 - M33	0	35	SK 50	86	48	116,5

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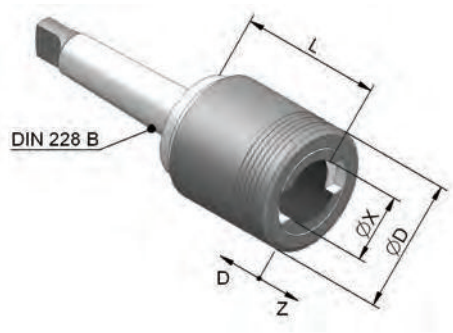
ROHM Quick change tapping chucks

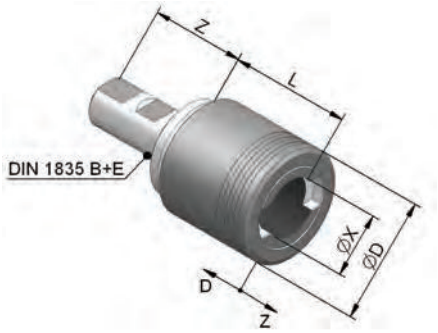
GS/C

Tool group A19
Type 353-65 **GS/C**
with morse taper DIN 228 B



Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
1132914 ■	1	M3 - M12	7,5	7,5	MK 2	39	19	52
1132916 ■	1	M3 - M12	0	12,5	MK 2	39	19	44,5
1132915 ■	1	M3 - M12	7,5	7,5	MK 3	39	19	52
1132917 ■	1	M3 - M12	0	12,5	MK 3	39	19	44,5
1132918 ■	2	M8 - M20	10	10	MK 3	60	31	75
1132920 ■	2	M8 - M20	0	16,5	MK 3	60	31	65
1132919 ■	2	M8 - M20	10	10	MK 4	60	31	76
1132921 ■	2	M8 - M20	0	16,5	MK 4	60	31	66
1132922 ■	3	M14 - M33	17,5	17,5	MK 4	86	48	107
1132924 ■	3	M14 - M33	0	35	MK 4	86	48	89,5
1132923 ■	3	M14 - M33	17,5	17,5	MK 5	86	48	107,5
1132925 ■	3	M14 - M33	0	35	MK 5	86	48	90

Tool group A19
Type 353-55 **GS/C**
with parallel shank DIN 1835 - form B + E



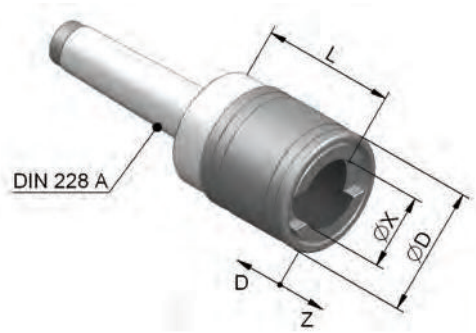
Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L	Z
1132858 ■	1	M3 - M12	7,5	7,5	25	39	19	45	53
1132859 ■	1	M3 - M12	0	12,5	25	39	19	37,5	53
1132860 ■	2	M8 - M20	10	10	25	60	31	68	53
1132861 ■	2	M8 - M20	0	16,5	25	60	31	58	53
1132862 ■	3	M14 - M33	17,5	17,5	32	86	48	99	60
1132863 ■	3	M14 - M33	0	35	32	86	48	81,5	60

Tool group A19
Type 344-01 **GS/NC** with trapezoidal thread DIN 6327
woodruff key DIN 6888

Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
637100 ■	0	M1 - M10	6,5	6,5	Tr 16x1,5	25,5	13	49
637101 ■	0	M1 - M10	6,5	6,5	Tr 20x2	25,5	13	49
637102 ■	1	M3 - M12	7,5	7,5	Tr 16x1,5	36	19	51
637103 ■	1	M3 - M12	7,5	7,5	Tr 20x2	36	19	51
637104 ●	1	M3 - M12	7,5	7,5	Tr 28x2	36	19	51
637105 ■	1	M3 - M12	7,5	7,5	Tr 36x2	36	19	53
652058 ■	2	M8 - M20	12,5	12,5	Tr 20x2	53	31	75
637106 ●	2	M8 - M20	12,5	12,5	Tr 28x2	53	31	75
637107 ●	2	M8 - M20	12,5	12,5	Tr 36x2	53	31	77
707994 ■	3	M14 - M33	20	20	Tr 28x2	78	48	108
637108 ■	3	M14 - M33	20	20	Tr 36x2	78	48	110
637109 ■	3	M14 - M33	20	20	Tr 48x2	78	48	114
691303[1] ■	4	M22 - M48	22,5	22,5	Tr 36x2	96	60	121
637110 ■	4	M22 - M48	22,5	22,5	Tr 48x2	96	60	125

[1] special design

Tool group A19
Type 344-12 **GS/NC**
with morse taper DIN 228 A



Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
637134 ■	0	M1 - M10	6,5	6,5	MK 2	25,5	13	44
637135 ■	1	M3 - M12	7,5	7,5	MK 2	36	19	46
637136 ■	1	M3 - M12	7,5	7,5	MK 3	36	19	46
637137 ■	2	M8 - M20	12,5	12,5	MK 3	53	31	70
637138 ■	2	M8 - M20	12,5	12,5	MK 4	53	31	71
1132762 ■	3	M14 - M33	20	20	MK 3	78	48	163
637139 ■	3	M14 - M33	20	20	MK 4	78	48	104
637140 ■	3	M14 - M33	20	20	MK 5	78	48	104
637141 ■	4	M22 - M48	22,5	22,5	MK 5	96	60	115
637142 ■	4	M22 - M48	22,5	22,5	MK 6	96	60	117

● from stock ■ 4 - 6 weeks ▲ on request

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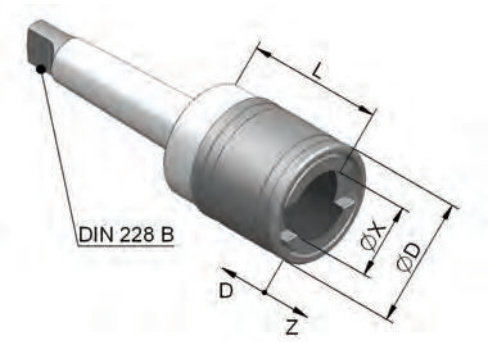
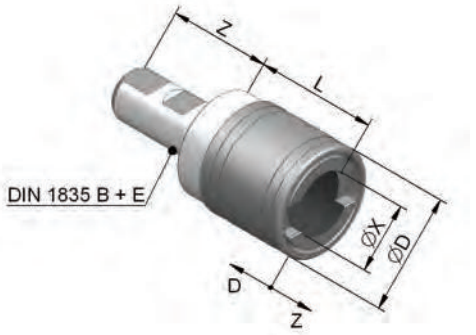
Tool group A19
Type 344-11 **GS/NC**
with morse taper DIN 228 B



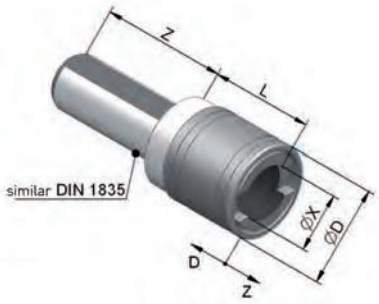
Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
637125 ■	0	M1 - M10	6,5	6,5	MK 2	25,5	13	44
637126 ●	1	M3 - M12	7,5	7,5	MK 2	36	19	46
637127 ●	1	M3 - M12	7,5	7,5	MK 3	36	19	46
637128 ●	2	M8 - M20	12,5	12,5	MK 3	53	31	70
637129 ●	2	M8 - M20	12,5	12,5	MK 4	53	31	71
637130 ●	3	M14 - M33	20	20	MK 4	78	48	104
637131 ■	3	M14 - M33	20	20	MK 5	78	48	104
637132 ■	4	M22 - M48	22,5	22,5	MK 5	96	60	115
637133 ■	4	M22 - M48	22,5	22,5	MK 6	96	60	117

Tool group A19
Type 344-64 **GS/NC**
with parallel shank DIN 1835 - form B + E



Item no.	Size	For taps	Com-pr.	Ex-pan.	Mount	Ø D	Ø X	L	Z
697807 ■	0	M1 - M10	6,5	6,5	16	25,5	13	37	49
1132755 ■	0	M1 - M10	6,5	6,5	20	25,5	13	37	51
672875 ●	1	M3 - M12	7,5	7,5	20	36	19	39	51
697808 ●	1	M3 - M12	7,5	7,5	25	36	19	39	53
672876 ■	2	M8 - M20	12,5	12,5	25	53	31	63	53
697809 ■	2	M8 - M20	12,5	12,5	32	53	31	63	60
1132756 ■	3	M14 - M33	20	20	25	78	48	170	53
672877 ■	3	M14 - M33	20	20	32	78	48	124	60
1132757 ■	4	M22 - M48	22,5	22,5	32	96	60	140	60

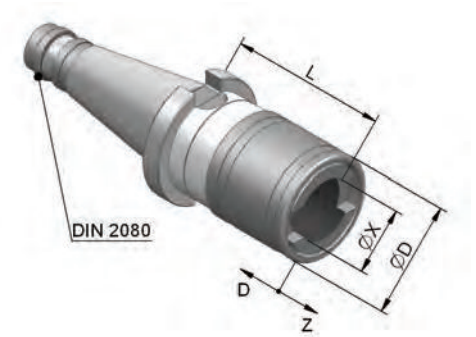
Tool group A19
Type 344-62 **GS/NC**
with cylindrical shank similar to DIN 1835, with clamping flat



Item no.	Size	For taps	Com-pr.	Ex-pan.	Mount	Ø D	Ø X	L	Z
637115 ■	0	M1 - M10	6,5	6,5	16	25,5	13	37	56
637116 ■	0	M1 - M10	6,5	6,5	20	25,5	13	37	56
637117 ●	1	M3 - M12	7,5	7,5	16	36	19	39	56
697798 ●	1	M3 - M12	7,5	7,5	20	36	19	39	58
637118 ●	1	M3 - M12	7,5	7,5	25	36	19	39	58
1132988 ■	1	M3 - M12	7,5	7,5	30	36	19	39	58
637119 ■	1	M3 - M12	7,5	7,5	32	36	19	39	58
637120 ■	1	M3 - M12	7,5	7,5	40	36	19	39	58
637121 ■	2	M8 - M20	12,5	12,5	30	53	31	63	77
637122 ■	2	M8 - M20	12,5	12,5	32	53	31	63	77
637123 ■	2	M8 - M20	12,5	12,5	35	53	31	63	77
637124 ■	2	M8 - M20	12,5	12,5	40	53	31	63	77
608540[1] ■	3	M14 - M33	20	20	25	78	48	98	100
697810 ■	3	M14 - M33	20	20	30	78	48	98	100
697811 ■	3	M14 - M33	20	20	32	78	48	98	100
697812 ■	3	M14 - M33	20	20	35	78	48	98	100
697813 ■	3	M14 - M33	20	20	40	78	48	98	100

[1] special design

Tool group A19
Type 344-21 **GS/NC**
with steep taper shank DIN 2080



Item no.	Size	For taps	Compr.	Expan.	Mount	Ø D	Ø X	L
637143 ■	1	M3 - M12	7,5	7,5	SK 30	36	19	58
637144[1] ■	1	M3 - M12	7,5	7,5	SK 40	36	19	71
733898 ■	1	M3 - M12	7,5	7,5	SK 50	36	19	59
637145[1] ■	2	M8 - M20	12,5	12,5	SK 40	53	31	85
1132946 ■	2	M8 - M20	12,5	12,5	SK 45	53	31	95
733899 ■	2	M8 - M20	12,5	12,5	SK 50	53	31	79
637147[1] ■	3	M14 - M33	20	20	SK 40	78	48	142
637148 ■	3	M14 - M33	20	20	SK 50	78	48	129
1132947 ■	4	M22 - M48	22,5	22,5	SK 40	96	60	157
637149 ■	4	M22 - M48	22,5	22,5	SK 50	96	60	143

[1] with ring groove for automatic tool clamping

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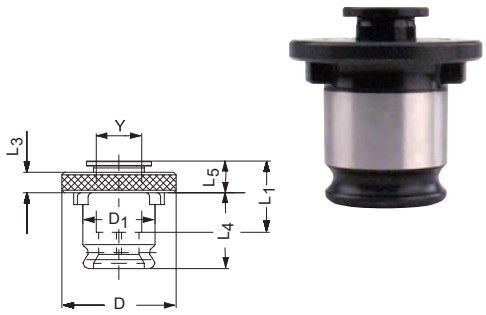
Quick change adaptors

SE



To mount taps.
Suitable for use in conjunction with every of the RÖHM quick-change tapping chucks.

Standard type, without safety clutch

Technical features:

- quick change adaptor without adjustable torque safety clutch
- adjustable in length for presetting outside the machine; adjustment by inner hexagon bolt inside the shank of the adaptor
- the selection of the taps results of shank diameter and square
- SE adaptors are mainly used for through-hole or when the depth of the thread is shorter than the core-hole

Tool group A19
Type 358-00 **size 0**

Item no.	Tap		D	D1	L1	L3	L4	L5	Weight
	Shank-ØY	Square							
389100 ●	2,5	2,1	22	13	15	4	19,5	7	30
389101 ●	2,8	2,1	22	13	15	4	19,5	7	30
389102 ■	3,15	2,5	22	13	15	4	19,5	7	30
389103 ●	3,5	2,7	22	13	15	4	19,5	7	30
389104 ●	3,55	2,8	22	13	15	4	19,5	7	30
389105 ●	4	3	22	13	15	4	19,5	7	30
389106 ●	4	3,15	22	13	15	4	19,5	7	30
389107 ●	4,5	3,4	22	13	15	4	19,5	7	30
389108 ■	5	4	22	13	15	4	19,5	7	30
389109 ●	6	4,9	22	13	15	4	19,5	7	30
389110 ■	6,3	5	22	13	15	4	19,5	7	30
389111 ■	7	5,5	22	13	15	4	19,5	7	30
607828 ●	8	6,2	22	13	15	4	19,5	7	30

Tool group A19
Type 358-01 **size 1**

Item no.	Tap		D	D1	L1	L3	L4	L5	Weight
	Shank-ØY	Square							
389112 ■	2,5	2,1	30	19	17	4	21,5	7	60
389113 ●	2,8	2,1	30	19	17	4	21,5	7	60
389114 ■	3,15	2,5	30	19	17	4	21,5	7	60
389115 ●	3,5	2,7	30	19	17	4	21,5	7	60
389116 ■	3,55	2,8	30	19	17	4	21,5	7	60
389117 ■	4	3	30	19	17	4	21,5	7	60
389118 ■	4	3,15	30	19	17	4	21,5	7	60
389119 ●	4,5	3,4	30	19	17	4	21,5	7	60
389120 ■	5	4	30	19	17	4	21,5	7	60
389121 ●	6	4,9	30	19	17	4	21,5	7	60
389122 ■	6,3	5	30	19	17	4	21,5	7	60
389123 ●	7	5,5	30	19	17	4	21,5	7	60
389124 ●	8	6,2	30	19	17	4	21,5	7	60
389125 ●	9	7	30	19	17	4	21,5	7	60
389126 ●	10	8	30	19	17	4	21,5	7	60
326616 ●	11	9	30	19	17	4	21,5	7	60
697653 ■	11,2	9	30	19	17	4	21,5	7	60

Tool group A19
Type 358-02 **size 2**

Item no.	Tap		D	D1	L1	L3	L4	L5	Weight
	Shank-ØY	Square							
389127 ●	6	4,9	48	31	30	5	35	11	250
389128 ■	6,3	5	48	31	30	5	35	11	250
389129 ●	7	5,5	48	31	30	5	35	11	250
389130 ●	8	6,2	48	31	30	5	35	11	250
389131 ●	9	7	48	31	30	5	35	11	250
389132 ●	10	8	48	31	30	5	35	11	250
389133 ●	11	9	48	31	30	5	35	11	250
389134 ■	11,2	9	48	31	30	5	35	11	250
389135 ●	12	9	48	31	30	5	35	11	250
389136 ■	12,5	10	48	31	30	5	35	11	250
389137 ■	14	11	48	31	30	5	35	11	250
389138 ■	14	11,2	48	31	30	5	35	11	250
389139 ●	16	12	48	31	30	5	35	11	250
389140 ■	16	12,5	48	31	30	5	35	11	250
697655 ■	18	14	48	31	30	5	35	11	250
389365 ●	18	14,5	48	31	30	5	35	11	250

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SE

Tool group A19
Type 358-03 **size 3**

Item no.	Tap		D	D1	L1	L3	L4	L5	Weight
	Shank-ØY	Square							
389141 ■	11	9	70	48	44	6	55,5	14	800
389142 ■	11,2	9	70	48	44	6	55,5	14	800
389143 ■	12	9	70	48	44	6	55,5	14	800
389144 ■	12,5	10	70	48	44	6	55,5	14	800
389145 ■	14	11	70	48	44	6	55,5	14	800
389146 ■	14	11,2	70	48	44	6	55,5	14	800
389147 ●	16	12	70	48	44	6	55,5	14	800
389148 ■	16	12,5	70	48	44	6	55,5	14	800
389149 ■	18	14	70	48	44	6	55,5	14	800
389150 ●	18	14,5	70	48	44	6	55,5	14	800
389151 ●	20	16	70	48	44	6	55,5	14	800
389152 ●	22	18	70	48	44	6	55,5	14	800
389153 ■	22,4	18	70	48	44	6	55,5	14	800
389154 ■	25	20	70	48	44	6	55,5	14	800
600282 ■	28	22	70	48	44	6	55,5	14	800

Tool group A19
Type 358-04 **size 4**

Item no.	Tap		D	D1	L1	L3	L4	L5	Weight
	Shank-ØY	Square							
389155 ■	18	14	90	60	71	13	63	42	1500
389156 ■	18	14,5	90	60	71	13	63	42	1500
389157 ■	20	16	90	60	71	13	63	42	1500
389158 ■	22	18	90	60	71	13	63	42	1500
389159 ■	22,4	18	90	60	71	13	63	42	1500
389160 ■	25	20	90	60	71	13	63	42	1500
389161 ■	28	22	90	60	71	13	63	42	1500
389162 ■	32	24	90	60	71	13	63	42	1500
389163 ■	36	29	90	60	71	13	63	42	1500

Tool group A19
Type 358-07 **size 7**

Item no.	Tap		D	D1	L1	L3	L4	L5	Weight
	Shank-ØY	Square							
389804 ■	4,5	3,4	40	26	30	5	32	13	120
389805 ■	5	4	40	26	30	5	32	13	120
389806 ■	6	4,9	40	26	30	5	32	13	120
389807 ■	6,3	5	40	26	30	5	32	13	120
389808 ■	7	5,5	40	26	30	5	32	13	120
389809 ■	8	6,2	40	26	30	5	32	13	120
389810 ■	9	7	40	26	30	5	32	13	120
389811 ■	10	8	40	26	30	5	32	13	120
389812 ■	11	9	40	26	30	5	32	13	120
389813 ■	11,2	9	40	26	30	5	32	13	120
389814 ■	12	9	40	26	30	5	32	13	120
389815 ■	12,5	10	40	26	30	5	32	13	120
389816 ■	14	11	40	26	30	5	32	13	120
697656 ■	14	11,2	40	26	30	5	32	13	120

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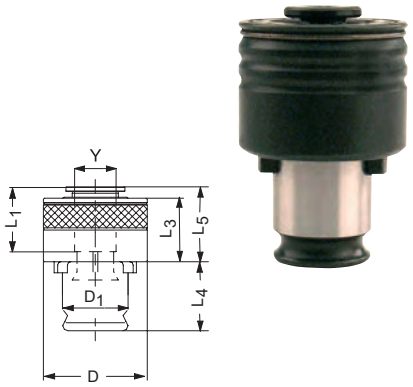
Quick change adaptors

SES



To mount taps.
Suitable for use in conjunction with every of the RÖHM quick-change tapping chucks.

With safety clutch for torque setting, torque adjustment for marked thread

Technical features:

- quick change adaptors with adjustable torque safety clutch
- adjustable in length for presetting outside the machine; adjustment by inner hexagon bolt inside the shank of the adaptor
- adaptors must be selected to suit the shank diameter and square of the tap, each adaptor can only be used for one shank diameter
- SES adaptors with safety clutch for limitation of the torque are mainly used for blind hole tapping or in material with high strengh
- all adaptors are factory set by us for a torque corresponding to a specific cutting force of K_c=2500 N/mm² which allows 100% for progressive dulling of the tool cutting edges

Tool group A19
Type 358-50 **size 0**

Item no.	Tap			D	D1	L1	L3	L4	L5	Weight
	Thread	Shank-ØY	Square							
389230 ■	M1,6	2,5	2,1	24	13	15	20	19,5	21	60
704380 ■	M3	2,5	2,1	24	13	15	20	19,5	21	60
389231 ■	M2,5	2,8	2,1	24	13	15	20	19,5	21	60
704381 ■	M4	2,8	2,1	24	13	15	20	19,5	21	60
389232 ■	M4	3,15	2,5	24	13	15	20	19,5	21	60
389233 ■	M3	3,5	2,7	24	13	15	20	19,5	21	60
704382 ■	M5	3,5	2,7	24	13	15	20	19,5	21	60
389234 ■	M4	3,55	2,8	24	13	15	20	19,5	21	60
389235 ■	M3,5	4	3	24	13	15	20	19,5	21	60
389236 ■	M5	4	3,15	24	13	15	20	19,5	21	60
389237 ■	M4	4,5	3,4	24	13	15	20	19,5	21	60
704383 ■	M6	4,5	3,4	24	13	15	20	19,5	21	60
389238 ■	M5	5	4	24	13	15	20	19,5	21	60
690595 ■	M5	6	4,9	24	13	15	20	19,5	21	60
389239 ●	M6	6	4,9	24	13	15	20	19,5	21	60
690596 ■	M8	6	4,9	24	13	15	20	19,5	21	60
389240 ■	M6	6,3	5	24	13	15	20	19,5	21	60
690597 ■	M8	6,3	5	24	13	15	20	19,5	21	60
389241 ●	M10	7	5,5	24	13	15	20	19,5	21	60
690598 ■	M8	8	6,2	24	13	15	20	19,5	21	60
389242 ■	M10	8	6,2	24	13	15	20	19,5	21	60

Tool group A19
Type 358-51 **size 1**

Item no.	Tap			D	D1	L1	L3	L4	L5	Weight
	Thread	Shank-ØY	Square							
389243 ■	M1,6	2,5	2,1	32,5	19	17	25	21,5	26	150
697639 ■	M3	2,5	2,1	32,5	19	17	25	21,5	26	150
389244 ■	M2,5	2,8	2,1	32,5	19	17	25	21,5	26	150
697640 ■	M4	2,8	2,1	32,5	19	17	25	21,5	26	150
389245 ■	M4	3,15	2,5	32,5	19	17	25	21,5	26	150
389246 ●	M3	3,5	2,7	32,5	19	17	25	21,5	26	150
697641 ■	M5	3,5	2,7	32,5	19	17	25	21,5	26	150
389247 ■	M4	3,55	2,8	32,5	19	17	25	21,5	26	150
389248 ■	M3,5	4	3	32,5	19	17	25	21,5	26	150
389249 ■	M5	4	3,15	32,5	19	17	25	21,5	26	150
389250 ●	M4	4,5	3,4	32,5	19	17	25	21,5	26	150
697642 ■	M6	4,5	3,4	32,5	19	17	25	21,5	26	150
389251 ●	M5	5	4	32,5	19	17	25	21,5	26	150
668272 ●	M5	6	4,9	32,5	19	17	25	21,5	26	150
668273 ●	M6	6	4,9	32,5	19	17	25	21,5	26	150
389252 ●	M8	6	4,9	32,5	19	17	25	21,5	26	150
668274 ■	M6	6,3	5	32,5	19	17	25	21,5	26	150
389253 ■	M8	6,3	5	32,5	19	17	25	21,5	26	150
389254 ●	M10	7	5,5	32,5	19	17	25	21,5	26	150
668275 ●	M8	8	6,2	32,5	19	17	25	21,5	26	150
389255 ●	M10	8	6,2	32,5	19	17	25	21,5	26	150
389256 ●	M12	9	7	32,5	19	17	25	21,5	26	150
389257 ●	M10	10	8	32,5	19	17	25	21,5	26	150
389258 ●	M14	11	9	32,5	19	17	25	21,5	26	150
697643 ■	M14	11,2	9	32,5	19	17	25	21,5	26	150

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SES

Tool group A19
Type 358-52 **size 2**

Item no.	Tap			D	D1	L1	L3	L4	L5	Weight
	Thread	Shank-ØY	Square							
1145240 ■	M3	3,5	2,7	50,5	31	30	31	35	34	550
389259 ■	M5	6	4,9	50,5	31	30	31	35	34	550
668277 ●	M6	6	4,9	50,5	31	30	31	35	34	550
668278 ■	M8	6	4,9	50,5	31	30	31	35	34	550
690599 ■	M6	6,3	5	50,5	31	30	31	35	34	550
389260 ■	M8	6,3	5	50,5	31	30	31	35	34	550
389261 ●	M10	7	5,5	50,5	31	30	31	35	34	550
690600 ●	M8	8	6,2	50,5	31	30	31	35	34	550
389262 ●	M10	8	6,2	50,5	31	30	31	35	34	550
389263 ●	M12	9	7	50,5	31	30	31	35	34	550
389264 ●	M10	10	8	50,5	31	30	31	35	34	550
389265 ●	M14	11	9	50,5	31	30	31	35	34	550
389266 ■	M14	11,2	9	50,5	31	30	31	35	34	550
389267 ●	M16	12	9	50,5	31	30	31	35	34	550
389268 ●	M16	12,5	10	50,5	31	30	31	35	34	550
389269 ●	M18	14	11	50,5	31	30	31	35	34	550
389270 ●	M18	14	11,2	50,5	31	30	31	35	34	550
704407 ■	M20	14	11,2	50,5	31	30	31	35	34	550
389271 ●	M20	16	12	50,5	31	30	31	35	34	550
389272 ■	M22	16	12,5	50,5	31	30	31	35	34	550
707942 ■	M24	18	14	50,5	31	30	31	35	34	550
389273 ●	M22	18	14,5	50,5	31	30	31	35	34	550

Tool group A19
Type 358-53 **size 3**

Item no.	Tap			D	D1	L1	L3	L4	L5	Weight
	Thread	Shank-ØY	Square							
389274 ■	M14	11	9	72	48	44	41	55,5	45	1700
389275 ■	M14	11,2	9	72	48	44	41	55,5	45	1700
389276 ■	M16	12	9	72	48	44	41	55,5	45	1700
389277 ■	M16	12,5	10	72	48	44	41	55,5	45	1700
389278 ■	M18	14	11	72	48	44	41	55,5	45	1700
389279 ■	M18	14	11,2	72	48	44	41	55,5	45	1700
704410 ■	M20	14	11,2	72	48	44	41	55,5	45	1700
389280 ●	M20	16	12	72	48	44	41	55,5	45	1700
389281 ■	M22	16	12,5	72	48	44	41	55,5	45	1700
389282 ■	M24	18	14	72	48	44	41	55,5	45	1700
389283 ■	M22	18	14,5	72	48	44	41	55,5	45	1700
704411 ●	M24	18	14,5	72	48	44	41	55,5	45	1700
704412 ■	M27	20	16	72	48	44	41	55,5	45	1700
389284 ■	M30	20	16	72	48	44	41	55,5	45	1700
389285 ●	M30	22	18	72	48	44	41	55,5	45	1700
389286 ■	M33	22,4	18	72	48	44	41	55,5	45	1700
389287 ●	M33	25	20	72	48	44	41	55,5	45	1700
704409 ■	M36	28	22	72	48	44	41	55,5	45	1700
389288 ■	M38	28	22	72	48	44	41	55,5	45	1700

Tool group A19
Type 358-54 **size 4**

Item no.	Tap			D	D1	L1	L3	L4	L5	Weight
	Thread	Shank-ØY	Square							
389289 ■	M24	18	14	95	60	71	61	63	68	3300
389290 ■	M22	18	14,5	95	60	71	61	63	68	3300
697645 ■	M24	18	14,5	95	60	71	61	63	68	3300
704390 ■	M27	20	16	95	60	71	61	63	68	3300
389291 ■	M30	20	16	95	60	71	61	63	68	3300
389292 ■	M30	22	18	95	60	71	61	63	68	3300
389293 ■	M33	22,4	18	95	60	71	61	63	68	3300
704391 ■	M33	25	20	95	60	71	61	63	68	3300
389294 ●	M36	28	22	95	60	71	61	63	68	3300
389295 ■	M38	28	22	95	60	71	61	63	68	3300
389296 ■	M39	32	24	95	60	71	61	63	68	3300
697646 ■	M42	32	24	95	60	71	61	63	68	3300
389297 ■	M45	36	29	95	60	71	61	63	68	3300
697647 ■	M48	36	29	95	60	71	61	63	68	3300

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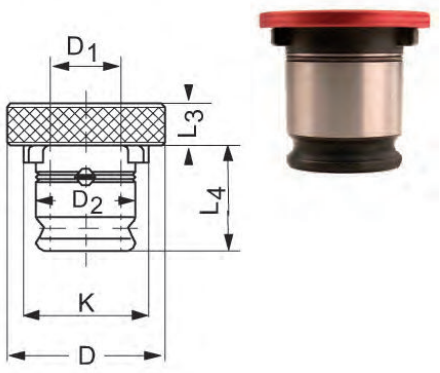
Quick change reduction adaptors

SRE



To mount taps.
Suitable for use in conjunction with every of the RÖHM quick-change tapping chucks.

To reduce the adaptor shank

Technical features:

- quick change adaptor without adjustable torque safety clutch
- adjustable in length for presetting outside the machine; adjustment by inner hexagon bolt inside the shank of the adaptor
- adaptors must be selected to suit the shank diameter and square of the tap, each adaptor can only be used for one shank diameter

Tool group A19
Type 358-99 Quick change reduction adaptors SRE
Size 1 - 4

Item no.	For chuck size	Adaptor size	D	D1	D2	L3	L4	K	For adaptor size
715203 ■	1	1/0	30	13	19	4	21,5	24,9	0
715204 ■	2	2/0	48	13	31	5	31	39,9	0
652859 ■	2	2/1	48	19	31	5	31	39,9	1
652860 ■	3	3/1	70	19	48	6	48	59,8	1
663861 ■	3	3/2	70	31	48	6	48	59,8	2
652861 ■	4	4/2	90	31	31	13	60	72,8	2
715205 ■	4	4/3	90	48	48	13	60	72,8	3

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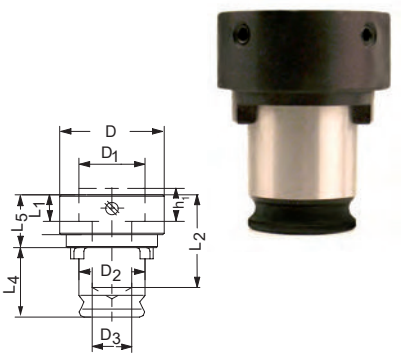
Quick change adaptors

SEA



For circular screwing dies attachment EN 22568 (DIN 223 + DIN 5158). Suitable for use in conjunction with every of the RÖHM quick-change tapping chucks.

To mount circular cutting tools

Technical features:

- quick change adaptor without adjustable torque safety clutch

Tool group A19
Type 357-01 **size 1**

Item no.	Cutting tool acc. to EN 22568		Draw-in thread	External Ø D	D2	D3	L1	L2	L4	L5
	D1	h_1								
658060 ■	16	5	M 1-M 2,5	25	19	12,5	4,8	28	21,5	14
658061 ■	20	5	M 3-M 4	30	19	12,5	4,8	28	21,5	14
658062 ■	20	7	M 4,5-M 6	30	19	12,5	6,5	30	21,5	16
658063 ■	25	9	M 7-M 9	35	19	12,5	8,5	33	21,5	19
658064 ■	30	11	M 10-M 11	40	19	12,5	10	35	21,5	21
658065[1] ■	38	10	M 12-M 15	48	19	14,2	9	34	21,5	20
658066 ■	38	14	M 12-M 14	48	19	14,2	13	38	21,5	24

[1] fine thread - not DIN

Tool group A19
Type 357-02 **size 2**

Item no.	Cutting tool acc. to EN 22568		Draw-in thread	External Ø D	D2	D3	L1	L2	L4	L5
	D1	h_1								
658067 ■	20	5	M 3-M 4	30	31	22	4,8	55	35	20
658068 ■	20	7	M 4,5-M 6	30	31	22	6,5	56	35	21,5
658069 ■	25	9	M 7-M 9	35	31	22	8,5	55	35	23,5
658070 ■	30	11	M 10-M 11	40	31	22	10	57	35	22
658071[1] ■	38	10	M 12-M 15	48	31	22	9	56	35	21
658072 ■	38	14	M 12-M 14	48	31	22	13	60	35	25
658073[1] ■	45	14	M 16-M 20	57	31	20	17	60	35	25
658074 ■	45	18	M 16-M 20	57	31	22	-	64	35	35

[1] fine thread - not DIN

Tool group A19
Type 357-03 **size 3**

Item no.	Cutting tool acc. to EN 22568		Draw-in thread	External Ø D	D2	D3	L1	L2	L4	L5
	D1	h_1								
658075 ■	30	11	M 10-M 11	60	60	25	10	85	55,5	30
658076 ■	38	10	M 12-M 15	60	60	32	9	83	55,5	28
658077 ■	38	14	M 12-M 14	60	60	32	13	87	55,5	32
658078[1] ■	45	14	M 16-M 20	60	60	37	-	87	55,5	32
658079 ■	45	18	M 16-M 20	60	60	37	17	91	55,5	36
658080[1] ■	55	16	M 22-M 26	72	60	37	15	85	55,5	30
658081 ■	55	22	M 22-M 24	72	60	37	20	90	55,5	35
658082[1] ■	65	18	M 27-M 36	82	60	37	17	87	55,5	32
658083 ■	65	25	M 27-M 36	82	60	37	23	93	55,5	38

[1] fine thread - not DIN

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ROHM Technical data

Torque specifications for setting the safety clutches

All adaptors are factory set by us for a torque corresponding to a specific cutting of Kc = 2500 N/mm2, which allows 100% for progressive dulling of the tool cutting edges. Torques for materials with other Kc values are specified below.

Workpiece/materials

Specific cutting force K_c	
Steel 1000 ... 1300 N/mm^2	= 3600 N/mm^2
Steel 850 ... 1000 N/mm^2	= 2600 N/mm^2
Steel 700 N/mm2	= 2500 N/mm2
Stahl 600 N/mm2	= 2400 N/mm2
Cast bronze	= 1900 N/mm^2
GG-22 (HB 170)	= 1600 N/mm^2
GTW heavy	= 1250 N/mm^2
Copper	= 1100 N/mm^2
GTW sofr	= 900 N/mm^2
Ms	= 720 N/mm^2
Al Si-alloy	= 680 N/mm^2
Zinc alloy	= 440 N/mm^2

For taps with metric thread DIN 13
Torque Nm for K_c in N/mm2

Thread	K_c = 3600	K_c = 2600	K_c = 2500	K_c = 1900	K_c = 1600	K_c = 1100	K_c = 720	K_c = 440
M 4 x 0,7	2	1,3	1,2	1	0,8	0,5	0,4	0,2
M 5 x 0,8	3	2	2	1,5	1,3	0,8	0,4	0,4
M 6 x 1	5	4	4	3	2,4	1,6	1	0,6
M 8 x 1,25	11	8	8	6	5	3,4	2,2	1,4
M 10 x 1,5	20	15	14	10	9	6	4	2,4
M 12 x 1,75	33	24	23	17	14	10	7	4
M 14 x 2	50	36	35	26	22	15	10	6
M 16 x 2	57	42	40	30	26	18	11	7
M 18 x 2,5	101	73	70	53	45	31	18	12
M 20 x 2,5	112	81	78	59	50	34	22	14
M 22 x 2,5	123	90	86	65	55	38	25	15
M 24 x 3	194	140	135	102	86	59	38	24
M 27 x 3	218	158	152	115	97	66	44	27
M 30 x 3,5	330	240	230	174	150	100	66	40
M 33 x 3,5	364	260	252	192	160	110	72	44
M 36 x 4	518	374	360	273	230	158	104	63
M 39 x 4	561	405	390	296	250	163	112	68
M 42 x 4,5	765	550	530	403	340	234	153	93
M 45 x 4,5	820	590	570	423	360	250	164	100
M 48 x 5	1080	780	750	570	480	330	216	132

For taps with metric thread DIN 13
Torque Nm for K_c in N/mm2

Thread	K_c = 3600	K_c = 2600	K_c = 2500	K_c = 1900	K_c = 1600	K_c = 1100	K_c = 720	K_c = 440
M 8 x 1	7,2	5,2	5	3,8	3,2	2,2	1,44	0,88
M 10 x 1	9	6,6	6,2	4,8	4	2,8	1,8	1,1
M 12 x 1	10,8	8	7,4	5,6	4,8	3,2	2	1,32
M 14 x 1	12,6	9,2	8,8	6,6	5,6	3,8	2,4	1,54
M 16 x 1	14,4	10,6	10	7,6	6,4	4,4	2,8	1,76
M 18 x 1	16,2	12	11,2	8,6	7,2	5	3,2	2
M 20 x 1	18	13,2	12,4	9,5	8	5,4	3,6	2,2
M 22 x 1	19,8	14,6	13,6	10,4	8,8	6	4	2,4
M 24 x 1	21,6	16	15	11,4	9,6	6,6	4,2	2,6
M 27 x 1	24	18	16,8	12,8	10,8	7,4	4,8	3
M 30 x 1	27	20	18,8	14,2	12	8,2	5,4	3,2
M 33 x 1	29,6	22	20,6	15,6	13,2	9	6	3,6
M 36 x 1	32,4	24	22,4	17,2	14,4	10	6,4	4
M 39 x 1	35	26	24,4	18,6	15,6	10,6	7	4,2
M 42 x 1	38	28	26	20	16,8	11,4	7,6	4,6
M 45 x 1	40	30	28	21,4	18	12,4	8	5
M 48 x 1	44	32	30	22,8	19,2	13,2	8,6	5,2
M 52 x 1	48	34	32,5	24,8	20,8	14,2	9,4	5,8

For taps with metric thread DIN 13
Torque Nm for K_c in N/mm2

Thread	K_c = 3600	K_c = 2600	K_c = 2500	K_c = 1900	K_c = 1600	K_c = 1100	K_c = 720	K_c = 440
M 12 x 1,5	24	17,4	16,8	12,8	10,8	7,4	4,8	3
M 14 x 1,5	28	20	19,6	15	12,6	8,6	5,6	3,4
M 16 x 1,5	32	24	22,4	17	14,4	9,8	6,4	4
M 18 x 1,5	36	26	25,2	19,2	16	11	7,2	4,4
M 20 x 1,5	40	29	28	21,2	18	12,4	8	5
M 22 x 1,5	44	32	30,8	23,4	19,6	13,4	8,8	5,4
M 24 x 1,5	48	34	34	25,6	21,6	14,8	9,6	6
M 27 x 1,5	54	40	38	28,8	24	16,6	10,8	6,6
M 30 x 1,5	60	44	42	32	27	18,4	12	7,4
M 33 x 1,5	66	48	46	35	29,6	20,2	13,2	8
M 36 x 1,5	72	52	50	38	32,2	22	14,4	8,8
M 39 x 1,5	78	56	54	41,4	35	24	15,6	9,6
M 42 x 1,5	84	60	58	44,6	37,6	26	17	102
M 45 x 1,5	90	66	63	48	40,4	27,8	18	11
M 48 x 1,5	96	70	67,2	51	43	29,6	19,4	11,8
M 52 x 1,5	104	76	72,8	55,4	46,6	32	21	12,8
M 18 x 2	65	47	45	34	29	20	13	8
M 20 x 2	72	52	50	38	32	22	14	9
M 22 x 2	79	57	55	42	35	24	15	10
M 24 x 2	86	62	60	46	38	26	17	11
M 27 x 2	97	70	68	51	43	30	19	12
M 30 x 2	108	78	75	57	48	33	22	13
M 33 x 2	119	86	82	63	53	36	24	15
M 36 x 2	130	94	90	68	58	40	26	16
M 39 x 2	140	102	98	74	62	43	28	17
M 42 x 2	151	109	105	80	67	46	30	18
M 45 x 2	162	117	112	85	72	49	32	20
M 48 x 2	173	125	120	91	77	53	35	21
M 52 x 2	187	135	130	99	83	57	37	23

For taps with thread measured in inches DIN 477
Torque Nm for K_c in N/mm2

Thread inches	Taper ratio mm	Gears at 1 inch	K_c = 3600	K_c = 2600	K_c = 2500	K_c = 1900	K_c = 1600	K_c = 1100	K_c = 720	K_c = 440
1/4	1,270	20	9	6,6	6,4	4,8	4	2,8	1,8	1,1
5/16	1,411	18	14	10,4	10	7,4	6	4,4	2,8	1,8
3/8	1,588	16	21,6	15,6	15	11,4	9,6	6,6	4,4	2,6
1/2	2,177	12	50	36	35	26	22	15,4	10	6
5/8	2,309	11	74	54	52	40	33	23	14,8	9
3/4	2,540	10	110	80	76	58	49	33,5	22	13,4
7/8	2,822	9	160	116	111	84	71	49	32	20
1	3,175	8	228	166	158	120	102	70	46	28
1 1/8	3,629	7	340	246	236	179	151	104	68	42
1 1/4	3,629	7	378	272	262	199	168	115	76	46
1 3/8	4,233	6	566	408	392	298	252	173	114	69
1 1/2	4,233	6	618	446	428	326	274	188	124	76
1 5/8	5,080	5	966	498	670	510	430	294	194	118
1 3/4	5,080	5	1040	752	722	550	462	318	208	127
2	5,645	4 1/2	1464	1056	1016	772	650	448	292	178
2 1/4	6,350	4	2058	1486	1428	1086	914	628	412	252
2 1/2	6,350	4	2286	1652	1588	1206	1016	698	458	280

For taps with whitworth pipe thread DIN ISO 228
Torque Nm for K_c in N/mm2

Thread inches	Taper ratio mm	Gears at 1 inch	K_c = 3600	K_c = 2600	K_c = 2500	K_c = 1900	K_c = 1600	K_c = 1100	K_c = 720	K_c = 440
G 1/8	0,907	28	7	5	4,8	3,6	3	2,2	1,4	0,8
G 1/4	1,337	19	21	15,4	14,8	11,2	9,4	6	4,2	2,6
G 3/8	1,337	19	27	19,4	18,8	14	12	8	5,4	3,2
G 1/2	1,814	14	62	45	43	32	27	19	12,4	7,6
G 5/8	1,814	14	68	49	47	38	30	21	13,6	8
G 3/4	1,814	14	78	56	54	41	35	24	15,6	10
G 7/8	1,814	14	89	64	62	47	40	27	18	11
G 1	2,309	11	160	115	110	84	70	49	32	20
G 1 1/8	2,309	11	182	182	131	126	96	80	56	22
G 1 1/4	2,309	11	200	145	140	106	89	61	40	25
G 1 3/8	2,309	11	212	154	148	112	94	65	42	26
G 1 1/2	2,309	11	228	166	159	121	102	70	46	28
G 1 3/4	2,309	11	258	186	178	136	114	79	51	31
G 2	2,309	11	286	206	198	151	127	87	57	35

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Tap shank dimensions

Top shank dimensions and recommanded core hole-Ø to DIN 336-1

Shank dimensions Ø x □	DIN 352	core hole-Ø mm	DIN 5157	core hole-Ø mm	DIN 371	core hole-Ø mm	DIN 374	core hole-Ø mm	DIN 376	core hole-Ø mm
Ø 2,5 x 2,1 □	M 1	0,75			M 1	0,75	M 3	2,5	M 3,5	2,9
Ø 2,5 x 2,1 □	M 1,1	0,85			M 1,1	0,85	M 3,5	2,9		
Ø 2,5 x 2,1 □	M 1,2	0,95			M 1,2	0,95				
Ø 2,5 x 2,1 □	M 1,4	1,1			M 1,4	1,1				
Ø 2,5 x 2,1 □	M 1,6	1,25			M 1,6	1,25				
Ø 2,5 x 2,1 □	M 1,8	1,45			M 1,8	1,45				
Ø 2,8 x 2,1 □	M 2	1,6			M 2	1,6	M 4	3,3	M 4	3,3
Ø 2,8 x 2,1 □	M 2,2	1,75			M 2,2	1,75				
Ø 2,8 x 2,1 □	M 2,5	2,05			M 2,5	2,05				
Ø 3,5 x 2,7 □	M 3	2,5			M 3	2,5	M 5	4,2	M 5	4,2
Ø 4 x 3 □	M 3,5	2,9			M 3,5	2,9				
Ø 4,5 x 3,4 □	M 4	3,3			M 4	3,3	M 6	5	M 6	5
Ø 6 x 4,9 □	M 5	4,2			M 5	4,2				
Ø 6 x 4,9 □	M 6	5			M 6	5				
Ø 6 x 4,9 □	M 8	6,8					M 8	6,8	M 8	6,8
Ø 7 x 5,5 □	M 10	8,5	G 1/8 "	8,8			M 10	8,5	M 10	8,5
Ø 8 x 6,2 □					M 8	6,8				
Ø 9 x 7 □	M 12	10,2					M 12	10,2	M 12	10,2
Ø 10 x 8 □					M 10	8,5				
Ø 11 x 9 □	M 14	12	G 1/4 "	11,8			M 14	12	M 14	12
Ø 12 x 9 □	M 16	14	G 3/8 "	15,25			M 16	14	M 16	14
Ø 14 x 11 □	M 18	15,5					M 18	15,5	M 18	15,5
Ø 16 x 12 □	M 20	17,5	G 1/2 "	19			M 20	17,5	M 20	17,5
Ø 18 x 14,5 □	M 22	19,5	G 5/8 "	21			M 22	19,5	M 22	19,5
Ø 18 x 14,5 □	M 24	21					M 24	21	M 24	21
Ø 20 x 16 □	M 27	24	G 3/4 "	24,5			M 27	24	M 27	24
Ø 22 x 18 □	M 30	26,5	G 7/8 "	28,25			M 30	26,5	M 30	26,5
Ø 25 x 20 □	M 33	29,5	G 1"	30,75			M 33	29,5	M 33	29,5
Ø 28 x 22 □	M 36	32	G 1 1/8 "	35,3			M 36	32	M 36	32
Ø 32 x 24 □	M 39	35	G 1 1/4 "	29,25			M 39	35	M 39	35
Ø 32 x 24 □	M 42	37,5					M 42	37,5	M 42	37,5
Ø 36 x 29 □	M 45	40,5	G 1 3/8 "	41,9			M 45	40,5	M 45	40,5
Ø 36 x 29 □	M 48	43	G 1 1/2 "	45,25			M 48	43	M 48	43
Ø 36 x 29 □			G 1 3/4 "	51,3						
Ø 36 x 29 □			G 2"	57						

Tap shank dimensions to ISO standards - to ISO 7451-7453

Shank dimensions Ø x □	metric	metric - shank enforced	UNC	UNC - shank enforced	UNF	UNF - shank enforced	BSW	BSW - shank enforced	BSF	BSF - shank enforced	BA	BA - shank enforced
Ø 2,24 x 1,8 □	M 3		Nr. 5-40		Nr. 5-44		1/8"-40				Nr. 5	
Ø 2,5 x 2,0 □	M 3,5	M 2	Nr. 6-32	Nr. 1-64	Nr. 6-40	Nr. 0-80						Nr. 11
Ø 2,5 x 2,0 □						Nr. 1-72						Nr. 10
Ø 2,5 x 2,0 □												Nr. 9
Ø 2,8 x 2,24 □		M 2,2		Nr. 2-56		Nr. 2-64						Nr. 8
Ø 2,8 x 2,24 □		M 2,5		Nr. 3-48		Nr. 3-56						Nr. 7
Ø 2,8 x 2,24 □												Nr. 6
Ø 3,15 x 2,5 □	M 4	M 3		Nr. 4-40		Nr. 4-48						Nr. 5
Ø 3,15 x 2,5 □			Nr. 8-32	Nr. 5-40	Nr. 8-36	Nr. 5-44					Nr. 3	
Ø 3,55 x 2,8 □	M 4,5	M 3,5	Nr. 10-24	Nr. 6-32	Nr. 10-32	Nr. 6-40	3/16"-24		3/16"-32		Nr. 2	Nr. 4
Ø 4 x 3,15 □	M 5	M 4	Nr. 12-24		Nr. 12-28				7/32"-28		Nr. 1	
Ø 4,5 x 3,55 □	M 6		1/4"-20	Nr. 8-36	1/4"-28	Nr. 8-36	1/4"-20		1/4"-26		Nr. 0	Nr. 3
Ø 5 x 4 □		M 5		Nr. 10-24		Nr. 10-32		3/16"-24		3/16"-32		Nr. 2
Ø 5,6 x 4,5 □				Nr. 12-24		Nr. 12-28			9/32"-26	7/32"-28		Nr. 1
Ø 6,3 x 5 □	M 8	M 6	5/16"-18	1/4"-20	5/16"-24	1/4"-28	5/16"-18	1/4"-20	5/16"-22	1/4"-26		Nr. 0
Ø 7,1 x 5,6 □			3/8"-16		3/8"-24		3/8"-16		3/8"-20	9/32"-26		
Ø 8 x 6,3 □	M 10	M 8	7/16"-24	5/16"-18	7/16"-20		7/16"-14	6/16"-18	7/16"-18	5/16"-22		
Ø 9 x 7,1 □	M 12		1/2"-13		1/2"-20		1/2"-12		1/2"-16			
Ø 10 x 8 □		M 10		3/8"-16		3/8"-24		3/8"-16		3/8"-20		
Ø 11,2 x 9 □	M 14		9/16"-12		9/16"-18		9/16"-24		9/16"-16			
Ø 12,5 x 10 □	M 16		5/8"-11		5/8"-18		5/8"-11		5/8"-14			
Ø 14 x 11,2 □	M 18		3/4"-10		3/4"-16		11/16"-11		11/16"-14			
Ø 14 x 11,2 □	M 20						3/4"-10		3/4"-12			
Ø 16 x 12,5 □	M 22		7/8"-9		7/8"-14		7/8"-9		7/8"-11			
Ø 18 x 14 □	M 24		1"-8		1"-12		1"-8		1"-10			
Ø 20 x 16 □	M 27		1 1/8"-7		1 1/8"-12		1 1/8"-7		1 1/8"-9			
Ø 20 x 16 □	M 30											
Ø 22,4 x 18 □	M 33		1 1/4"-7		1 1/4"-12		1 1/4"-7		1 1/4"-9			
Ø 25 x 20 □	M 36		1 3/8"-6		1 3/8"-12				1 3/8"-8			

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SMP / SMP Compact

Available on request: Floating chucks SMP / SMP Compact

Efficient production of bores accurate in dimensions and design on single-spindle and multi-spindle machines.
RÖHM designed special floating chucks for reamers with internal coolant supply.

The tool locating sleeve is moving on precision balls and coupled to the chuck body through an Oldham type clutch, driven by means of precision rollers. Therefore the tool retains all its mobility independent of the torque resulting of the cutting force.
A patent conception prevents any destruction of the bearing through the balls due to an incident (breaking of the tool, program error, shocks, very high cutting load, etc.).

Technical features:

- The floating chucks are suitable for vertical, horizontal, as well as for right- and left-hand rotation
- Radial and floating movement can be limited (SMP Compact radial movement only)
- A patented, not deformable intermediate piece with two Viton seals connects floating sleeve and body
- These floating chucks with internal coolant supply can be used with non-tight standard collets
- We offer three different capabilities of connecting:
  - coolant supply through the centre
  - lateral fixed
  - lateral rotating

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The headquarter: our parent plant in Sontheim/Brenz.

The RÖHM parent plant is located in Sontheim/Brenz. In this ultra-modern production facility comprising 41,000 m², optimum conditions have been achieved in order to solve the extensive range of discerning construction and production tasks making the company even better, faster and more efficient in the future.

Sontheim/Brenz

All national and international activities are planned and co-ordinated at the administrative headquarters in Sontheim. Thanks to the excellent infrastructure and transport routes available, this location is ideal for a company relying on perfect product quality as well as maximum flexibility. Furthermore, the region around Sontheim offers another key basis for the success of our company: it is rich in quality awareness and motivated employees with the result that we are ideally prepared for the challenges of the future. The parent plant uniquely unites mass production, serial production and customised individual production under a single roof.

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Key locations for the company: Dillingen and St. Georgen.

Such strong growth on the part of the RÖHM Group is also obviously associated with higher requirements on development and production capacities. The demands of today and tomorrow can be complied with the two facilities in Dillingen and St. Georgen.

Dillingen/Danube

St. Georgen

Plant: Dillingen/Danube | This branch plant in Dillingen was put into operation by the RÖHM Group as early as 1953. Thanks to extremely positive development, the plant is subject to constant expansion and modernisation. For this reason, new modern production facilities were built in 1982 and 1991. In 2007 RÖHM built a new production hall for two portal turning and milling machines. This enables machining of workpieces up to 4 metres in length which will secure a leading market position for the RÖHM brand in the future.
More than 300 employees are primarily involved in engineering and manufacturing lathe chucks, machine vices and special clamping equipment for turning and milling machinery as well as for machining centres.

Engineering and sales department St. Georgen | Apart from standard mandrels, tailor-made solutions for a wide variety of requirements are also manufactured here in this small but accomplished high-tech forge. RÖHM retains mechanical or power-operated mandrels, sliding jaw mandrels and hydraulic mandrels for its customers for tensioning workpieces in drill holes or interior contours.

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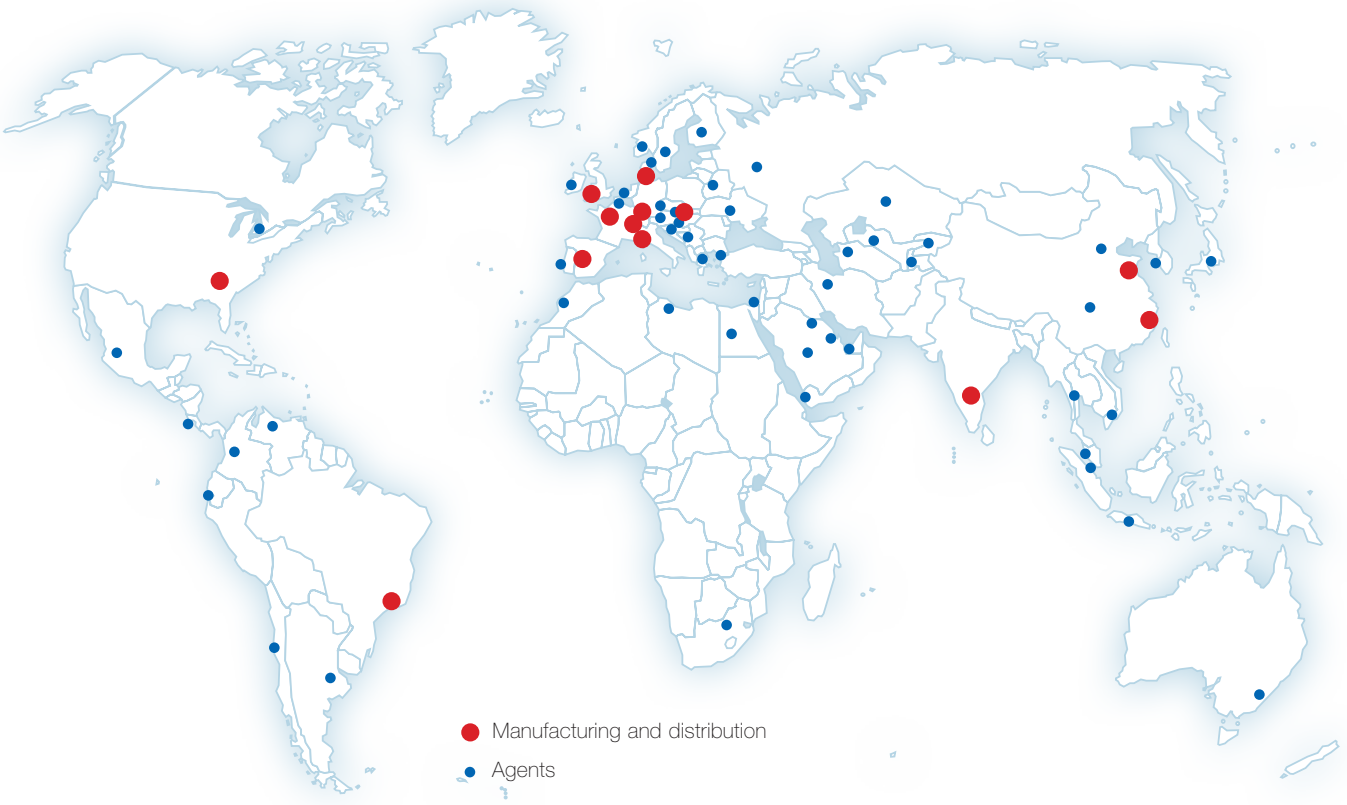

Always close to our customers. With locations all around the world.

Customer orientation at RÖHM has less to do with marketing than with attitude. We consider customer proximity as an intensive dialogue with our partners as well as direct presence on key international markets.
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China

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General conditions of sale and delivery

§ 1 Quotation, Formation of Contract and Content of Contract

1. The present General Terms of Sale and Delivery apply exclusively. We do not recognise any terms and conditions that are contradictory or different from our own, unless we have explicitly given our written agreement to do so. Our Terms of Sale and Delivery will also apply if we effect delivery to the Purchaser without any reservation in full awareness of the contradictory or different nature of the terms of the Purchaser, as compared to our own Terms.
2. Our quotations are always subject to change without notice unless they have been explicitly described as binding. The contract will only materialise upon our written confirmation and in line with the content thereof and by way of performance/delivery on our part. If delivery/service is immediately provided without any confirmation, the invoice will also be deemed to be the order confirmation.
3. Our General Terms of Sale and Delivery will only apply to a business entity as defined in Section 14 BGB [German Civil Code].
4. Costs for the compilation of drawings for specific constructions will be borne by the Orderer if, for reasons for which we are not responsible, the quotation does not lead to an order placement.
5. All particulars regarding weights, dimensions, services and technical data that feature in our printed matter, catalogues, price lists or in other contract documents are only approximate, unless they have been explicitly described as binding.
6. We retain the right to amend the construction and form of the subject of contract, providing this does not involve unreasonable alterations for the Orderer.
7. The documentation comprises an assembly layout, piece list with details of the wearing and spare parts, as well as operational and maintenance instructions; this is always in the German language. Documentation is only in paper form or in digital form. For digital forms, the texts are provided in the formats .TXT, .RTF or .DOC; drawings and piece lists are in the .TIF format (grid format). Any documentation in excess thereof will be billed and is subject to particular arrangement.
8. For testing, when specific temperatures, times and other measurements or control values are to apply, the appropriate measurement methods must be specified prior to delivery and acknowledged by both Parties. Unless such values are so defined, our own measurement methods will apply.
9. Samples will only be delivered subject to a fee.
10. Assurances given, ancillary agreements and changes to the contract will require the written form to be operative. It will not be possible to waive this requirement.
11. An order placement will be deemed irrevocable unless the Deliverer has agreed in writing to cancel it.
12. For export transactions, delivery will be subject to the conditions specified on the order confirmation; in addition, the respectively current version of the international trade definitions most commonly used in international sales contracts (incoterms 1953) will apply as devised by the International Chamber of Commerce.
13. In addition to the General Terms of Delivery and Sale, compliance with our “product information“ sheets, the technical data sheets as well as other product-specific publications will apply, each in their current version.

§ 2 Prices

1. Failing specific written agreement, prices apply as in the Federal Republic of Germany, free house plus the value added tax required by law. For export transactions, the item to be delivered is deemed sold “ex works”, unless the contract stipulates otherwise about the type of sale. For single orders for a value of goods less than 100.00 € net, a handling fee of 10.00 € plus the value added tax required by law will be charged throughout the country.
2. Please note that we only despatch the consignment at the request of the customer. Irrespective of this, the rulings laid down in Section 5 will apply.
3. We bill the prices that were valid when the contract was drawn up, based on the cost factors applicable at the time. Should these cost factors (particularly material, wages, energy etc.) alter during the period between the drawing up of contract and the agreed delivery time, we will be entitled to amend prices accordingly. For export transactions, the Deliverer will be entitled to cancel that part of the order that has not yet been completed or to adjust prices appropriately if the currency in which the contract was drawn up has devalued.
4. With an „ex works” contract, the goods will be transported at the expense and risk of the Orderer. For all consignments, the respectively current version of the provisions of incoterms 1953 will apply to the insurance and bearing of risk.
5. For parts/products that are produced in line with Purchaser requirements, we will notify the Purchaser of our production quantity. The Purchaser undertakes to take receipt of the quantity thus confirmed.
6. Over-deliveries and short-deliveries are admissible up to 5%; for special tooling up to 10% is admissible, at least, however, 2 (two) pieces. The respective delivery will be billed.

§ 3 Modalities of Payment

1. Failing specific arrangements, payment is due without deduction and without charges within 10 days of the date of invoice - even for delivery instalments.
2. We are not bound to accept cheques or bills. In the event cheques or bills are accepted subject to prior arrangement in individual circumstances, this will only be as conditional payment, taking due account of discount charges and collection fees that are to be paid immediately in cash by the Customer. The ultimate credit entry of bills of exchange and cheques will be after their redemption. The acceptance of cheques or bills will be without prejudice for subsequent commitments to payment. We will not be liable for the punctual presentation, protest, notification and return of a bill in the event it is not honoured.
3. Any overshooting of the payment deadline will incur interest to the amount of the banks’ borrowing costs, at least, however 8% in excess of the respective basic interest rate of the European Central Bank.
4. If a bill or a cheque is not honoured on time or if a deadline for payment is overreached, all receivables still outstanding, including those that are deferred and those for which bills or cheques have been given, will become due for immediate payment.
5. The Purchaser will only be entitled to offset if the counterclaims he asserts have been established by declaratory judgment, if they are undisputed or have been acknowledged by us. The Purchaser will be authorized to exercise a right of retention to the extent his counterclaim is derived from the same contractual relations.
6. For export transactions, payments will be paid subject to the modalities of payment contracted.
7. Costs of payment transactions, particularly bank charges of foreign payment transfers to us, are in principle for debits of the client.

§ 4 Delivery Period

1. The delivery period we specify begins to run providing all technical issues have been fully clarified. The delivery deadlines we give are in principle not binding and only constitute a probable delivery time.
2. The compliance with our commitment to deliver depends on the Purchaser having punctually and properly fulfilled his commitments, particularly his commitment to comply with the contracted terms of payment. The right to plea non-performance of contract will be retained.
This right will also be derived from commitments that have not been satisfied in full from previous deliveries.
3. The period of delivery commences upon the despatch of the order confirmation, yet not before the Orderer has provided the documents, permits, clearance papers etc. to be procured and not before the agreed deposit has been received.
4. If a fixed delivery date has been arranged, the Deliverer will effect delivery on time. Compliance with the delivery period will be deemed given if the item to be delivered has left the works or the readiness for despatch has been notified before the expiry of said delivery period, subject to timely and accurate delivery from our own suppliers. If the Orderer amends parts of the consignment to be delivered, the delivery period will run anew upon confirmation of said amendment.
5. Force majeure, war, uprising, strike, lock-out or measures enforced by the authorities for whatever reason that impede delivery, as well as a lack of raw materials, means of transport and theft – even with our own suppliers – will release the Deliverer from his commitment to deliver within the specified period of time. The Orderer will be notified immediately of the occurrence of the hindrance and of the likely repercussions.
6. It is admissible to effect delivery prior to the expiry of the specified delivery period and to deliver in appropriate instalments.
7. Compliance with the delivery period depends on the fulfilment of all contractual duties of the Orderer.
8. In the event of delivery delays or of the impossibility of delivery, the provisions of Section 10 will apply.

§ 5 Transfer of Risk and Taking Receipt

1. Risk will pass to the Orderer at the latest with the despatch of the consignment, even if delivery is to be in instalments or if we still have other services to provide, e.g. despatch costs or transport and delivery as well as installation.
2. At the request and at the expense of the Orderer, we will ensure insurance cover of the consignment to be delivered for theft, breakage and damages from transportation, fire and water and for other insurable risks.
3. If despatch is delayed for reasons for which the Orderer is responsible, the risk will pass to the Orderer as from the date of readiness for despatch; nevertheless, we undertake to ensure insurance cover at the request and expense of the Orderer as called for by the Orderer.
4. Even if the delivered items feature insignificant defects, the Orderer will take receipt thereof irrespective of the rights laid down in Section 8.

§ 6 Default of Acceptance, Call-off Orders

1. If the Orderer fails to take receipt of the items contracted on time, we will be entitled to set the Orderer a subsequent period of grace after which we will be entitled to dispose of the items otherwise and supply the Orderer subject to a subsequently lengthened delivery period. Irrespective of this, we will be entitled to withdraw from the contract as defined in Section 326 BGB [German Civil Code] and to call for compensation for damages owing to non-performance. In the event we call for compensation for non-performance, we will be able to claim compensation of 25% of the agreed price plus value added tax without having to provide evidence. We retain the right to assert actual damages of a greater dimension.
2. Orders, which we confirm for call-off must be accepted within one year of the date of order placement at the latest - unless otherwise arranged. The same will apply to fixed reservations or to permanent “call-off statuses. Section 6.1 will apply accordingly in the event the goods are not called off.

§ 7 Retention of Title

1. The items for delivery (the goods subject to the retention of title) will remain our property until all claims to which we are entitled from the Purchaser from the business relations have been satisfied in full. Where the value of all security interests to which we are entitled against the Purchaser exceeds all secured claims by more than 10%, we will release some of the security interests as appropriate at the request of the Purchaser.
2. During the period in which title to the goods is retained, the Purchaser is not allowed to pledge or assign the goods as security and is only permitted to resell to resellers in normal business transactions and only providing the reseller receives payment from its own customer or subjects the customer’s ownership of the item to the full satisfaction of the customer’s commitments to payment.
3. In the event of attachment, seizure or any other disposition or third-party intervention in respect of the goods, the Purchaser will notify us immediately so that we can file action subject to Section 771 ZPO [German Code of Civil Procedure]. If the third party is not able to reimburse us for the court and out-of-court costs of legal action pursuant to Section 771 ZPO, the Purchaser will be liable for the loss we thus incur.
4. The Purchaser undertakes to treat the item purchased with care. In particular, the Purchaser undertakes at his own expense to ensure it is adequately insured at reinstatement value against damages from fire, water and theft. Should maintenance and inspection work be required, the Purchaser will have this carried out in good time at his own expense.
5. In the event of breaches of duty on the part of the Purchaser, particularly with default in payment, we will be entitled to cancel the contract and to take back the goods; the Purchaser undertakes to surrender the goods. If we take back the goods and/or assert the retention of title, this does not mean we are cancelling the contract, unless we have explicitly declared as much.

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6. If the Purchaser has resold the item purchased in regular business transactions, the Purchaser herewith now assigns to us all claims to payment in the amount of the final invoice amount (including value added tax), such as due to the Purchaser from the resale to his customer or a third party, irrespective of whether the item purchased has been resold without or after further reworking. The Purchaser remains authorized to collect this payment, even after assignment. Our own authority to collect payment ourselves will not be affected hereby. However we undertake not to collect payment providing the Purchaser satisfies his own commitments to payment from the proceeds collected, does not default in payment and in particular providing the initiation of insolvency proceedings is not petitioned or payments cease to be made. Should this, however, be the case, we will be able to demand that the Purchaser provides us with details of the assigned payments and their debtors as well as all information necessary to collect payment, that he hands over the relevant documentation to us and notifies the debtors (third parties) of the assignment.
7. The processing or reworking of the item purchased by the Purchaser will always be carried out on our behalf. If the item purchased is processed with other items not belonging to us, we will acquire co-ownership to the new item to the value of the item purchased (final invoice amount including value added tax) in relation to the other processed items at the time of reworking. The same will apply to the thus newly created items as for the items delivered subject to retention of title.
8. If the item purchased is processed with other items not belonging to us, we will acquire co-ownership to the new item to the value of the item purchased (final invoice amount including value added tax) in relation to the other processed items at the time of reworking. If the intermixing is such that the Purchaser's item is to be deemed the main item, it is herewith agreed that the Purchaser will transfer co-ownership to us proportionately. The Purchaser will keep the property in which we hold exclusive ownership or co-ownership on our behalf.

§ 8 Quality Defects
We are liable for defects in quality as follows:
1. All parts or services will be remedied, at our discretion, free of charge or redelivered or provided again that are found to feature a quality defect during the statutory period of limitation - irrespective of service life - providing the origin thereof already existed at the time of the passing of risk.
2. Claims to quality defects will become statute-barred in 12 (twelve) months. The period of time commences with the passing of risk (Section 6).
3. The Purchaser will immediately file written objection to the quality defect with us.
4. In the event objections are filed, the Purchaser will be permitted to refrain from payment to an extent appropriate to the quality defects featured. The Purchaser will only be able to refrain from payment if an objection is asserted, the justification of which cannot be doubted. If the objection has been asserted unjustifiably, we will be entitled to call for the reimbursement of the expenses incurred by us.
5. Initially we will always be granted an opportunity to remedy a defect within an appropriate period of grace.
6. Should the remedy fail, the Purchaser – notwithstanding any claims to damages – will be able to cancel the contract or reduce remuneration. The Purchaser will only be able to call for the reimbursement of fruitless expenditure if the defect in question is attributable to our own wilful intent or gross carelessness for which we are responsible.
7. Claims to defects in quality are not given if the divergence from the agreed nature of the product is only minimal, if usability is only insignificantly impaired, in cases of natural depreciation or damages generated after passing of the risk as a result of faulty or negligent treatment, excessive exposure, unsuitable operating media or because of specific outer impact that was not to be expected given the contract, as well as in cases of non-reproducible software errors. If amendments or repair work is carried out improperly by the Purchaser or by third parties, there will be no claims to the defects resulting or the effects thereof. The same will apply to a lack of compliance with our instructions on handling and other instructions and if maintenance is not carried out properly
8. Claims of the Purchaser to a refund of the expenses incurred for the purpose of remedy, such as costs of transport, travel, labour and materials will be ruled out, when such expenses increase because the item delivered was brought to a destination other than the Purchaser's branch premises, unless said relocation is in accordance with the intended use of the item.
9. Legal claims to recourse against us on the part of the Purchaser will only be given if the Purchaser has entered into no agreement with his customer in excess of those claims to defects regulated by the law.
10. Claims to compensation for damages will be governed by Section 9. Any farther-reaching claims to quality defects or others than those governed in this Section or in Section 9 will be ruled out.

§ 9 Industrial Property Rights and Copyrights, Defects of Title
Unless otherwise agreed, we undertake to only effect delivery free from proprietary rights and third party copyrights (referred to in the following as industrial property rights) in the country of the delivery destination. In the event a third party files justified claims against the Purchaser for a breach of industrial property rights derived from deliveries we effected that are being used as contracted, we will be liable towards the Purchaser for the period of time specified in Section 8.2 as follows:
1. At our discretion and at our own expense, we will either procure a licence for the deliveries in question, alter them so that there is no breach of industrial property rights or we will provide a substitute. Should this not prove possible at appropriate conditions, the Purchaser will be entitled to the rights of cancellation or reduction as laid down by the law. The Purchaser will only be able to call for the reimbursement of fruitless expenditure if we are to blame for wilful intent or gross negligence. Our commitment to provide compensation for damages is governed by Section 10.
2. The above commitments will only be given if the Purchaser has given us immediate, written notification of the claims asserted by the third party, does not recognise any breach of rights and if we retain the right to initiate defence measures and negotiate a settlement. If the Purchaser ceases to use the item delivered in order to reduce damages or for other good cause, the Purchaser undertakes to inform the third party that this discontinuation of use does not embody any acknowledgement of a breach of industrial property rights.
3. Claims of the Purchaser will be ruled out if the Purchaser is responsible for the breach of industrial property rights.
4. Any claims of the Purchaser will also be ruled out if the breach of industrial property rights was derived from specific specifications of the Purchaser, from an application that we could not foresee or from the item delivered being altered by the Purchaser or used in combination with products that we have not delivered.
5. In the case of breaches of industrial property rights, the provisions of Sections 8.4, 8.5 and 8.9 will apply appropriately to the claims of the Purchaser governed by Section 13.
6. Any farther-reaching claims to defects of title of the Purchaser or claims other than those governed by the present Section 9 against us or our vicarious agents will be ruled out.

§ 10 Overall Liability
1. Claims of the Purchaser to compensation for damages – irrespective of the legal nature of the claim asserted – will be ruled out.
2. The exceptions are:
a) Damages due to the violation of major contractual duties (cardinal duties). However, in the case of simple negligence, liability for damages will be restricted to foreseeable, typically occurring damages.
b) Damages derived from injury to life and limb if we are responsibility for the breach of duty.
c) Damages attributable to wilfully intentional or negligent violations, said breach of duty on the part of our legal representatives or vicarious agents being of equal status to any breaches of duty on our part.
d) Claim to damages for impossibility or inability.
3. Any alteration of the onus of proof to the detriment of the Purchaser does not relate to the above provisions.
4. Liability subject to the Product Liability Act remains unaffected hereby.
5. Where liability for compensation is ruled out or restricted in our respect, this will also apply to the personal liability for damages of our employees, our trade representatives and our vicarious agents.

§ 11 Duties to Involvement of the Purchaser
1. The involvement of the Purchaser that has been agreed to explicitly or implicitly in the contract will be subject to no specific remuneration, unless otherwise explicitly agreed.
2. The Purchaser undertakes to inform us in good time of all facts, which indicate that stocks and products we have made available in the light of our notified production capacities cannot be used or not be used in full. Where stock remains, in the case of a premature change to his planning, the Purchaser will take over the remainder and any costs of destruction that might be incurred. This will also apply to products for which we have had to place orders for minimum quantities from our own suppliers, providing we previously advised the customer thereof.
3. The Purchaser guarantees that the products delivered by him for reworking are suitable for the purpose. We do not undertake to check the products delivered by the Purchaser for their quality and aptitude for reworking. In ongoing business relations and whenever an item for reworking has been initially checked, tested and released, the Purchaser undertakes to inform us in writing of each and every product amendment without actually being requested to do so. When items are being reworked, after every change in production conditions on his premises, in particularly when substituting tooling, machinery or introducing new production processes, the Purchaser also undertakes to examine the item to be processed by us for any divergence and alteration and to notify us in writing of any such divergence and alteration.
4. Instructions from our Purchaser, the selection of material or other specifications laid down by the Purchaser do not oblige us to check them for accuracy.
5. The Purchaser will hence check all instructions it issues as well as the quality of the material specified to us or made available to us for compliance with the law and technical regulations.
6. Should the Purchaser default in terms of its duties to provide or to become involved, we will be entitled to the rights stipulated by law.
7. In any case, goods may only be returned subject to the explicit consent of the Deliverer. Their return will be free-house and details of the order number and delivery date will be given as well as the original delivery packaging. The goods will be in their original condition, i.e. in an undamaged state. For the handling of a return, we charge 20% of the value of the goods, at least, however, 50.00 € plus value added tax. In individual circumstances, the Deliverer retains the right to charge the Orderer a higher sum based on evidence.

§ 12 Place of Performance and Jurisdiction/ Other
1. The place of performance and payment will be the registered office of our company in Sontheim/Brenz.
2. Exclusively the laws of the Federal Republic of Germany will govern the present contractual relations. The application of the United Nations Convention dated 11.04.80 on Contracts for the International Sale of Goods (CISG – "Wiener Kaufrecht") is ruled out.
3. For all disputes derived from contractual relations, if the Orderer is a registered businessperson, a legal entity under public law or a separate estate under public law, legal action will be filed with the court of law with jurisdiction for our registered office. We will also be entitled to file legal action at the location of the registered seat of the Orderer.
4. Should any one condition of our General Terms of Sale and Delivery be void for any reason whatsoever, the validity of the remaining provisions will not be affected hereby.
5. We will save your data in accordance with Section 23 BDSG [Federal Data Protection Act].

RÖHM GmbH

D–89565 Sontheim/Brenz

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driven by technology

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