

Компания "**ИНТЕРТУЛМАШ**" - поставщик оборудования

RÖHM в России.

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tough.

Live Centers Face Drivers

2013/2014

www.roehm.biz

RÖHM
driven by technology

LIVE CENTERS - FACE DRIVERS

Revolving tailstock centres

| | |
|---------------|------|
| Basic | 2005 |
| Heavy | 2009 |
| Speed | 2011 |
| Slim | 2012 |
| Control | 2014 |
| Flex | 2015 |

Revolving centering tapers

| | |
|-----------|------|
| MZK | 2018 |
|-----------|------|

Dead centres

| | |
|-----------|------|
| FKS | 2020 |
|-----------|------|

Constant Face Drivers

| | |
|-------------------------|------|
| CoE | 2024 |
| Accessories CoE | 2025 |
| CoE - Assortments | 2025 |
| CoA | 2026 |
| Accessories CoA | 2029 |
| CoA - Assortments | 2033 |
| CoM | 2034 |
| Driving head CoM | 2035 |
| Driving discs CoM | 2035 |
| Accessories CoM | 2036 |
| CoB | 2037 |
| Driving heads CoB | 2038 |
| Accessories CoB | 2042 |

Power-operated Face Drivers

| | |
|--|------|
| CoK 8-80 mm | 2044 |
| Accessories CoK | 2045 |
| CoK 50-250 mm | 2047 |
| Driving discs CoK | 2048 |
| Accessories CoK | 2049 |
| Power-operated Driving Heads CoK | 2050 |
| Accessories CoK | 2054 |



Live Centers - Face Drivers

| | |
|--|------|
| Revolving tailstock centres | 2002 |
| Revolving centering tapers | 2018 |
| Dead centres | 2020 |
| Constant Face Drivers CoE | 2023 |
| Constant Face Drivers CoA | 2026 |
| Constant Face Drivers CoM | 2034 |
| Constant Face Drivers CoB | 2037 |
| Power-operated Constant Face Drivers CoK | 2043 |



Operation Guide

| Basic - carbide insert | | | | | | | | | | | | |
|-----------------------------------|---|------|------|------|------|------|--|------|------|------|------|------|
| Type | Type 604 HM Basic - carbide insert Body hardened and ground | | | | | | Type 604 HMG Basic - with draw-off nut and carbide insert Body hardened and ground | | | | | |
| Size MT | 1 | 2 | 3 | 4 | 5 | 6 | 2 | 3 | 4 | 5 | 6 | |
| Workpiece weight max (kg) | 60 | 120 | 360 | 500 | 1000 | 1800 | 120 | 360 | 500 | 1000 | 1800 | |
| Concentricity deviation | 0,005 | | | | | 0,01 | 0,005 | | | | | 0,01 |
| Speed max min⁻¹ | 7000 | 7000 | 5000 | 3800 | 3000 | 2600 | 7000 | 5000 | 3800 | 3000 | 2600 | |
| Page | 2005 | | | | | | 2005 | | | | | |

| Basic | | | | | | | | | | |
|-----------------------------------|---|------|------|------|-------|---|------|------|------|------|
| Type | Type 604 HP Basic - precision design Body hardened and ground | | | | | Type 601 N Basic - economy design Body ground | | | | |
| Size MT | 2 | 3 | 4 | 5 | 0 | 1 | 2 | 3 | 4 | 5 |
| Workpiece weight max (kg) | 200 | 500 | 800 | 2000 | 10 | 80 | 180 | 300 | 750 | 1800 |
| Concentricity deviation | 0,003 | | | | 0,01 | 0,005 | | | | |
| Speed max min⁻¹ | 7000 | 5000 | 3800 | 3000 | 15000 | 7000 | 7000 | 6300 | 3800 | 3000 |
| Page | 2007 | | | | | 2007 | | | | |

| Heavy | | | | | | | | | | | | | | |
|-----------------------------------|--|------|------|--|------|------|---|------|----------|-----------|-----------|--------|---------|---------|
| Type | Type 640-20 Heavy - standard design Body hardened and ground | | | Type 640-80 Heavy - standard design with draw-off nut Body hardened and ground | | | Type 604 Heavy - heavy duty design Body hardened and ground | | | | | | | |
| Size MT | 4 | 5 | 6 | 4 | 5 | 6 | 6 | 7 | Metr. 80 | Metr. 100 | Metr. 120 | Nr. 80 | Nr. 100 | Nr. 120 |
| Workpiece weight max (kg) | 1000 | 2000 | 3000 | 1000 | 2000 | 3000 | 5000 | 9000 | 8500 | 13000 | 22000 | 8500 | 13000 | 22000 |
| Concentricity deviation | 0,005 | | | 0,005 | | | 0,01 | | 0,015 | 0,02 | 0,015 | 0,01 | 0,01 | 0,01 |
| Speed max min⁻¹ | 7000 | 6000 | 4800 | 7000 | 6000 | 4800 | 1500 | 1500 | 1500 | 1000 | 800 | 1500 | 1000 | 800 |
| Page | 2009 | | | 2009 | | | 2010 | | | | | | | |

| Slim | | | | | | | | | | | |
|-----------------------------------|--|------|------|------|------|--|------|------|------|------|------|
| Type | Type 600 Slim - standard design Body hardened and ground | | | | | Type 600-20 Slim - extended live centre with draw-off nut Body hardened and ground | | | | | |
| Size MT | 2 | 3 | 4 | 5 | 6 | 2 | 3 | 4 | 5 | 6 | |
| Workpiece weight max (kg) | 200 | 400 | 800 | 1600 | 3500 | 170 | 340 | 700 | 1400 | 3000 | |
| Concentricity deviation | 0,005 | | | 0,01 | 0,02 | 0,008 | | | | 0,01 | 0,02 |
| Speed max min⁻¹ | 7000 | 7000 | 6300 | 4300 | 3000 | 7000 | 7000 | 6300 | 4300 | 3000 | |
| Page | 2012 | | | | | 2012 | | | | | |

| Control | | | | | | | | |
|-----------------------------------|--|------|------|-------|--|------|------|-------|
| Type | Type 652 AC Control - standard design Body hardened and ground | | | | Type 652 AC-VL Control - extended live centre Body hardened and ground | | | |
| Size MT | 3 | 4 | 5 | 6 | 3 | 4 | 5 | 6 |
| Workpiece weight max (kg) | 400 | 800 | 1600 | 3200 | 260 | 550 | 1100 | 2500 |
| Concentricity deviation | 0,01 | | | 0,015 | 0,01 | | | 0,015 |
| Speed max min⁻¹ | 4000 | 3500 | 2500 | 1800 | 4000 | 3500 | 2500 | 1800 |
| Page | 2014 | | | | 2014 | | | |

Operation Guide

| | | Basic - standard design | | | | | | | | | | | |
|-----------------------------------|--|---|------|------|------|------|-------|----------|--|------|------|------|------|
| Type | | Type 604 H Basic - standard design Body hardened and ground | | | | | | | Type 604 HG Basic - standard design with draw-off nut Body hardened and ground | | | | |
| Size MT | | 1 | 2 | 3 | 4 | 5 | 6 | metr. 80 | 2 | 3 | 4 | 5 | 6 |
| Workpiece weight max (kg) | | 100 | 200 | 500 | 800 | 2000 | 5000 | 8500 | 200 | 500 | 800 | 2000 | 3500 |
| Concentricity deviation | | 0,005 | | | 0,01 | | 0,015 | | 0,005 | | | 0,01 | |
| Speed max min⁻¹ | | 7000 | 7000 | 5000 | 3800 | 3000 | 1500 | 1500 | 7000 | 5000 | 3800 | 3000 | 2600 |
| Page | | 2006 | | | | | | | 2006 | | | | |

| | | Basic - extended live centre | | | | | | | | | | |
|-----------------------------------|--|--|-------|------|------|------|------|--|------|------|------|--|
| Type | | Type 604 HVL Basic - extended live centre Body hardened and ground | | | | | | Type 604 HVLN Basic - extended live centre with profiled centre point Body hardened and ground | | | | |
| Size MT | | 1 | 2 | 3 | 4 | 5 | 6 | 2 | 3 | 4 | 5 | |
| Workpiece weight max (kg) | | 80 | 140 | 400 | 500 | 1200 | 2500 | 100 | 150 | 180 | 280 | |
| Concentricity deviation | | 0,01 | 0,005 | | | 0,01 | | 0,005 | | | | |
| Speed max min⁻¹ | | 7000 | 7000 | 5000 | 3800 | 3000 | 2600 | 7000 | 5000 | 3800 | 3000 | |
| Page | | 2008 | | | | | | 2008 | | | | |

| | | Speed | | | | | | | | | | | | | |
|-----------------------------------|--|--|--|-------|--|------|--|-------|--|-------|--|------|--|------|--|
| Type | | Type 663 Speed - with draw-off nut for especially high speeds - different head dia. at same shank Body hardened and ground | | | | | Type 664 Speed - extended NC-centre with carbide insert for especially high speed Body hardened and ground | | | | | | | | |
| Size MT | | 4 | | 5 | | 6 | | 2 | | 3 | | 4 | | 5 | |
| Workpiece weight max (kg) | | 800 | | 1250 | | 2500 | | 100 | | 100 | | 250 | | 250 | |
| Concentricity deviation | | 0,005 | | | | | | 0,01 | | | | | | | |
| Speed max min⁻¹ | | 10000 | | 10000 | | 7000 | | 12000 | | 12000 | | 9000 | | 9000 | |
| Page | | 2011 | | | | | | 2011 | | | | | | | |

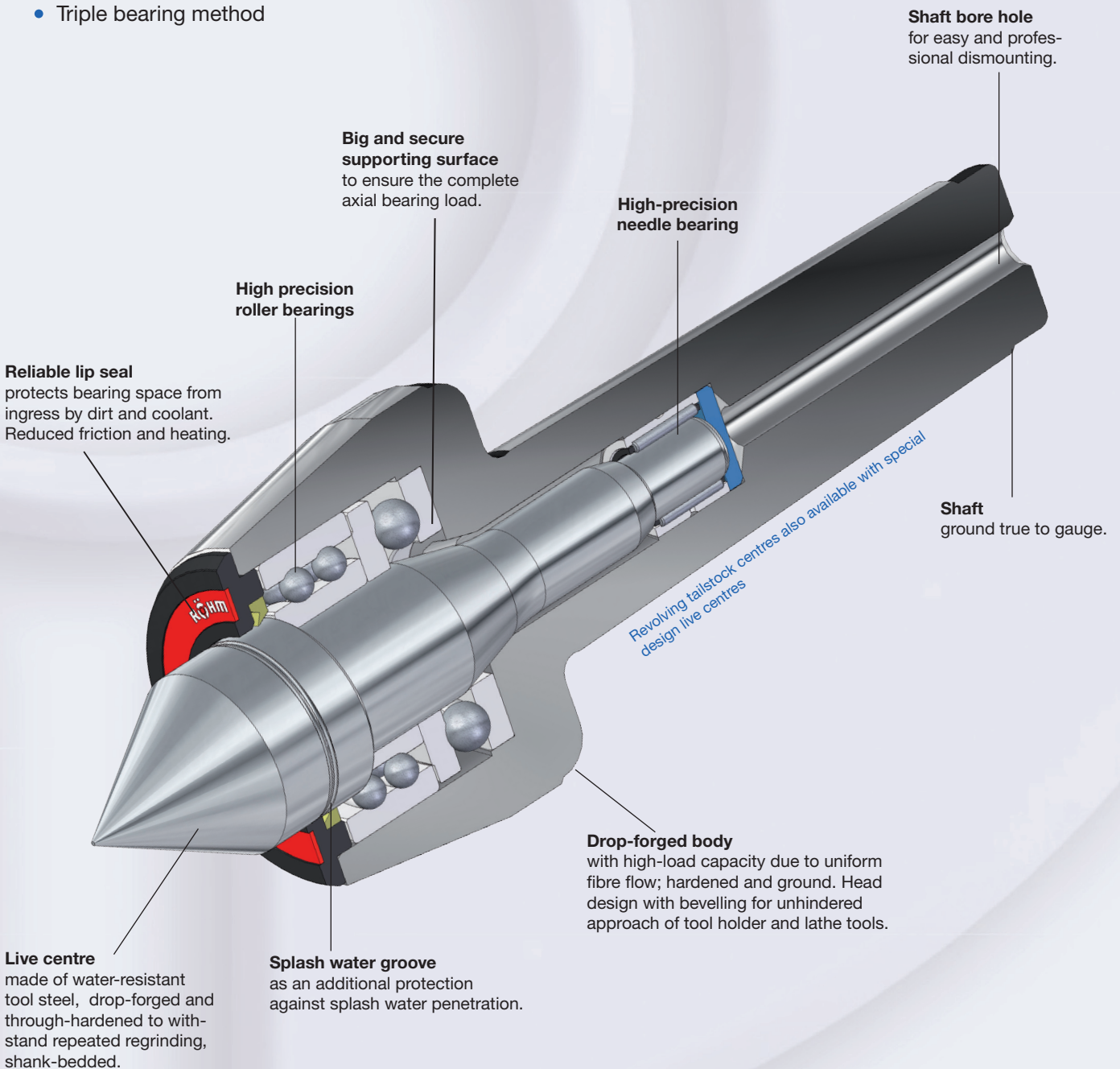
| | | Slim | | | | | | | |
|-----------------------------------|--|---|--|------|--|------|--|------|--|
| Type | | Type 600-20 Slim - extended live centre with profiled centre point Body hardened and ground | | | | | | | |
| Size MT | | 2 | | 3 | | 4 | | 5 | |
| Workpiece weight max (kg) | | 50 | | 100 | | 150 | | 180 | |
| Concentricity deviation | | 0,005 | | | | | | | |
| Speed max min⁻¹ | | 7000 | | 7000 | | 6300 | | 4300 | |
| Page | | 2013 | | | | | | | |

Technical features

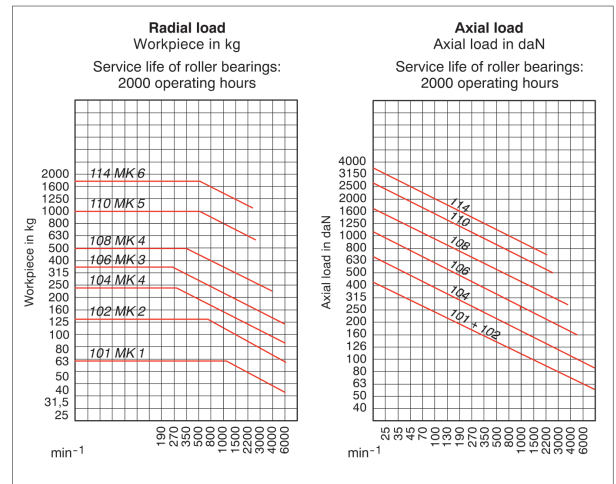
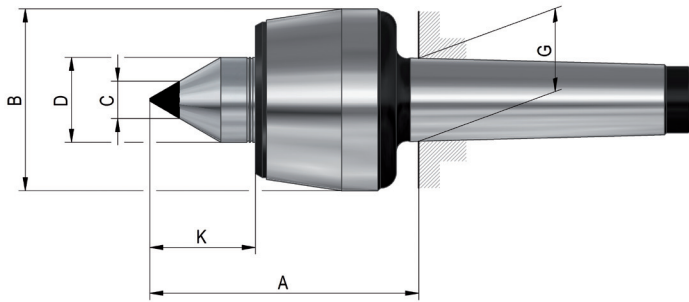
The revolving tailstock centres have been re-engineered in function and design. Due to the new features they are even better in daily use and offer additional advantages.

- **Even longer life due to:**
 - Splash water groove
 - Improved lubrication
 - Close toleranced bearing seat
- **Lower interference shape due to:**
 - Slim housing
- Body hardened and ground
- Centre hardened, repeated regrinding at will
- Triple bearing method
- High runout accuracy
- Life-time lubrication
- High speeds
- Heavy duty
- Long life
- Various type suitable to different applications

NEW

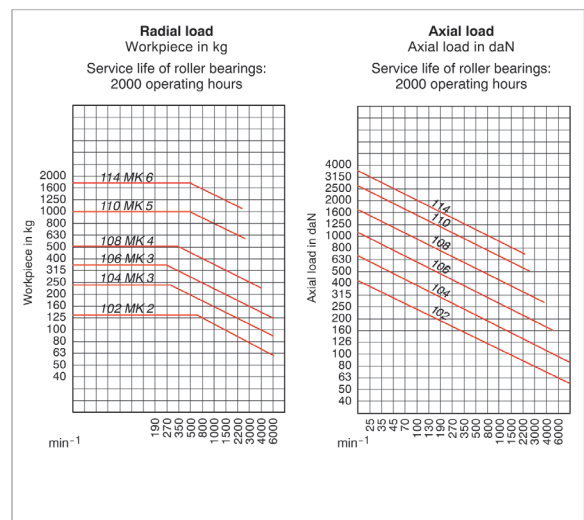
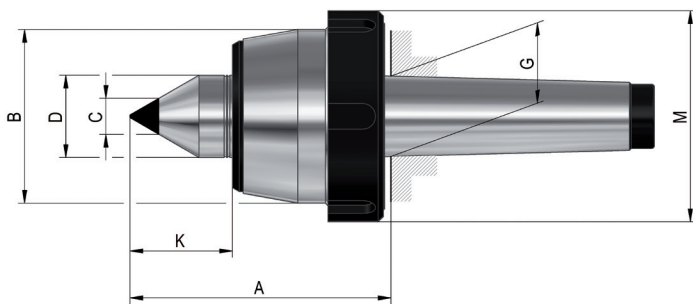


Basic - carbide insert



Tool group A06
Type 604 HM Basic
with **carbide insert**
body hardened and ground -
tip angle 60°

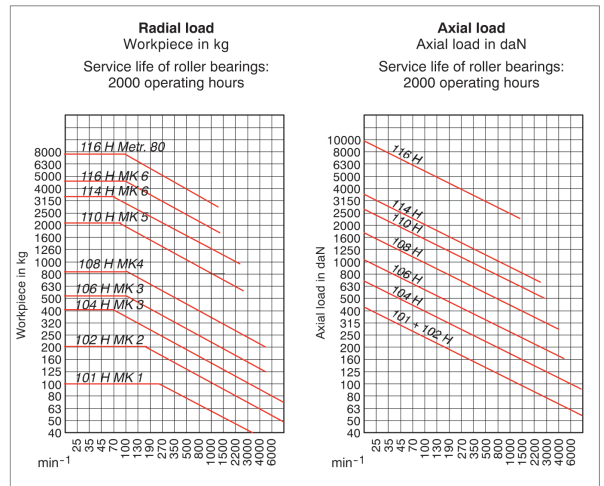
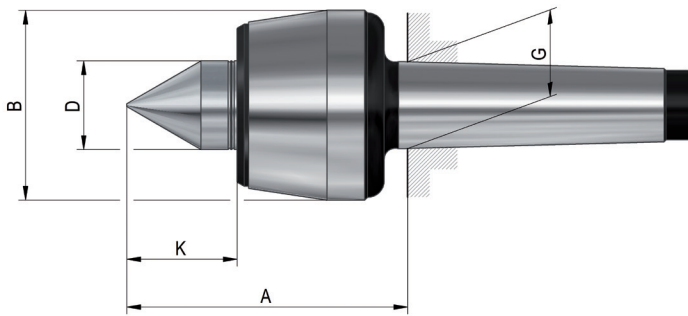
| Item no. | 225297 | 032140 | 090089 | 237413 | 093306 | 221016 | 221017 |
|------------------------------|---------|---------|---------|---------|---------|---------|---------|
| Mount MT | 1 | 2 | 3 | 3 | 4 | 5 | 6 |
| Size | 101 | 102 | 104 | 106 | 108 | 110 | 114 |
| A | 60,5 | 65 | 70,5 | 79,5 | 102,5 | 129 | 152 |
| B | 34,5 | 43 | 48,5 | 58,5 | 68,5 | 88,5 | 102,5 |
| C | 7 | 11 | 11 | 14 | 14 | 18 | 18 |
| D | 15 | 20 | 22 | 25 | 32 | 40 | 50 |
| G | 12,065 | 17,78 | 23,825 | 23,825 | 31,267 | 44,399 | 63,348 |
| K | 17 | 24 | 27,5 | 31 | 41 | 50,5 | 57,5 |
| Weight approx. g | 400 | 600 | 900 | 1300 | 2300 | 4700 | 10000 |
| Workpiece weight max. kg | 60 | 120 | 240 | 360 | 500 | 1000 | 1800 |
| Concentricity deviation | 0,005 | 0,005 | 0,005 | 0,005 | 0,005 | 0,005 | 0,01 |
| Speed max. min ⁻¹ | 7000 | 7000 | 6300 | 5000 | 3800 | 3000 | 2600 |
| Spare live centres | 1241741 | 1241742 | 1241743 | 1241744 | 1241745 | 1241746 | 1241747 |



Tool group A06
Type 604 HMG Basic
with **draw-off nut**
and **carbide insert**
body hardened and ground -
tip angle 60°

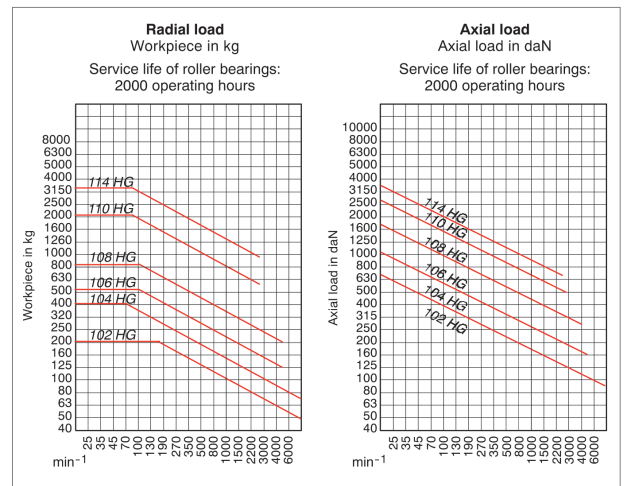
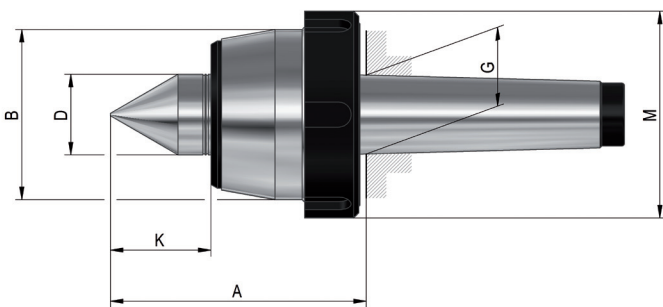
| Item no. | 221021 | 221022 | 221023 | 221024 | 221025 | 221026 |
|------------------------------|---------|---------|---------|---------|---------|---------|
| Mount MT | 2 | 3 | 3 | 4 | 5 | 6 |
| Size | 102 | 104 | 106 | 108 | 110 | 114 |
| A | 65 | 70,5 | 79,5 | 102,5 | 129 | 152 |
| B | 45 | 50 | 60 | 70 | 90 | 105 |
| C | 11 | 11 | 14 | 14 | 18 | 18 |
| D | 20 | 22 | 25 | 32 | 40 | 50 |
| G | 17,78 | 23,825 | 23,825 | 31,265 | 44,399 | 63,348 |
| K | 24 | 27,5 | 31 | 41 | 50,5 | 57,5 |
| M | 56 | 62 | 74 | 82 | 105 | 120 |
| Weight approx. g | 600 | 1000 | 1400 | 2400 | 5200 | 10500 |
| Workpiece weight max. kg | 120 | 240 | 360 | 500 | 1000 | 1800 |
| Concentricity deviation | 0,005 | 0,005 | 0,005 | 0,005 | 0,005 | 0,01 |
| Speed max. min ⁻¹ | 7000 | 6300 | 5000 | 3800 | 3000 | 2600 |
| Spare live centres | 1241742 | 1241743 | 1241744 | 1241745 | 1241746 | 1241747 |

Basic - standard design



Tool group A06
Type 604 H Basic
body hardened and ground -
tip angle 60°

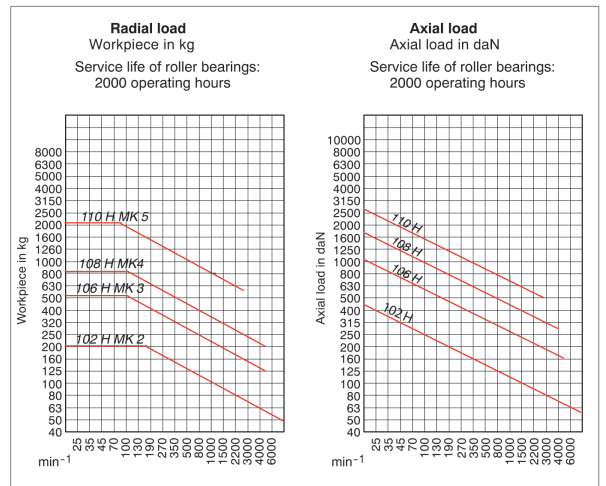
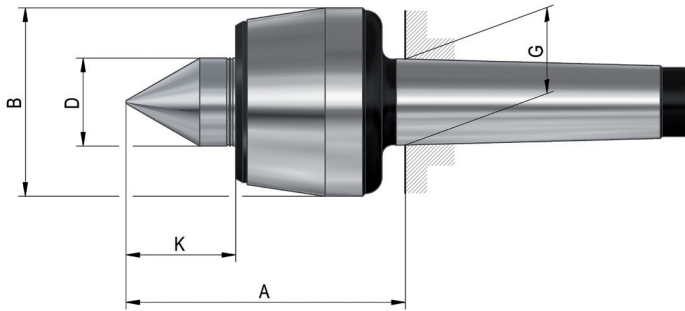
| Item no. | 043400 ● | 043115 ● | 042315 ● | 042776 ● | 042175 ● | 042843 ● | 043532 ● | 093439 ● | 093440 ● |
|------------------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| Mount MT | 1 | 2 | 3 | 3 | 4 | 5 | 6 | 6 | Metr. 80 |
| Size | 101 | 102 | 104 | 106 | 108 | 110 | 114 | 116 | 116 |
| A | 60,5 | 65 | 70,5 | 79,5 | 102,5 | 129 | 152 | 196 | 196 |
| B | 34,5 | 43 | 48,5 | 58,5 | 68,5 | 88,5 | 102,5 | 138 | 138 |
| D | 15 | 20 | 22 | 25 | 32 | 40 | 50 | 60 | 60 |
| G | 12,065 | 17,78 | 23,825 | 23,825 | 31,267 | 44,399 | 63,348 | 63,348 | 80 |
| K | 17 | 24 | 27,5 | 31 | 41 | 50,5 | 57,5 | 67 | 68 |
| Weight approx. g | 400 | 500 | 800 | 1300 | 2300 | 4700 | 10200 | 17800 | 23000 |
| Workpiece weight max. kg | 100 | 200 | 400 | 500 | 800 | 2000 | 3500 | 5000 | 8500 |
| Concentricity deviation | 0,005 | 0,005 | 0,005 | 0,005 | 0,005 | 0,005 | 0,008 | 0,01 | 0,015 |
| Speed max. min ⁻¹ | 7000 | 7000 | 6300 | 5000 | 3800 | 3000 | 2600 | 1500 | 1500 |
| Spare live centres | 1241726 | 1241725 | 1241724 | 1241723 | 1241722 | 1241721 | 1241728 | 1241729 | 1241730 |



Tool group A06
Type 604 HG Basic
with **draw-off nut**
body hardened and ground -
tip angle 60°

| Item no. | 221018 ● | 221019 ● | 205036 ● | 207148 ● | 074390 ● | 221020 ● |
|------------------------------|----------|----------|----------|----------|----------|----------|
| Mount MT | 2 | 3 | 3 | 4 | 5 | 6 |
| Size | 102 | 104 | 106 | 108 | 110 | 114 |
| A | 65 | 70,5 | 79,5 | 102,5 | 129 | 152 |
| B | 45 | 50 | 60 | 70 | 90 | 105 |
| D | 20 | 22 | 25 | 32 | 40 | 50 |
| G | 17,78 | 23,825 | 23,825 | 31,267 | 44,399 | 63,348 |
| K | 24 | 27,5 | 31 | 41 | 50,5 | 57,5 |
| M | 56 | 62 | 74 | 82 | 105 | 120 |
| Weight approx. g | 600 | 1000 | 1400 | 2400 | 5200 | 10500 |
| Workpiece weight max. kg | 200 | 400 | 500 | 800 | 2000 | 3500 |
| Concentricity deviation | 0,005 | 0,005 | 0,005 | 0,005 | 0,005 | 0,008 |
| Speed max. min ⁻¹ | 7000 | 6300 | 5000 | 3800 | 3000 | 2600 |
| Spare live centres | 1241725 | 1241724 | 1241723 | 1241722 | 1241721 | 1241728 |

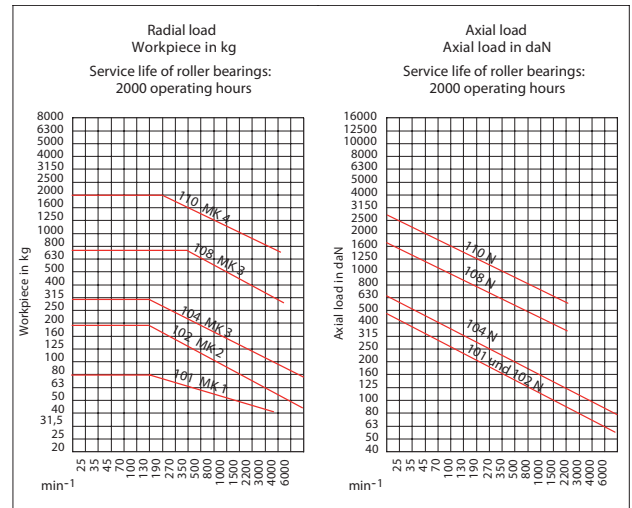
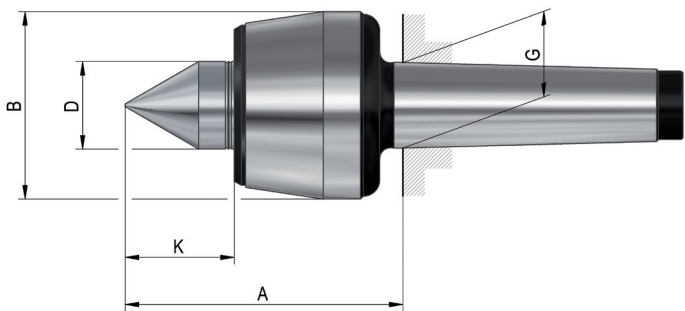
Basic - precision design



Tool group A06
Type 604 HP Basic
precision design
body hardened and ground -
tip angle 60°

| Item no. | 082392 ● | 318227 ● | 082394 ● | 082395 ● | 1263871 ● |
|------------------------------|----------|----------|----------|----------|-----------|
| Mount MT | 2 | 3 | 4 | 5 | 6 |
| Size | 102 | 106 | 108 | 110 | 114 |
| A | 65 | 82 | 102,5 | 129 | 152 |
| B | 43 | 55 | 68,5 | 88,5 | 102,5 |
| D | 20 | 25 | 32 | 40 | 50 |
| G | 17,78 | 23,825 | 31,267 | 44,399 | 63,348 |
| K | 24 | 30,5 | 41 | 50,5 | 57,5 |
| Weight approx. g | 500 | 1300 | 2300 | 4700 | 10200 |
| Workpiece weight max. kg | 200 | 500 | 800 | 2000 | 3500 |
| Concentricity deviation | 0,003 | 0,003 | 0,003 | 0,003 | 0,003 |
| Speed max. min ⁻¹ | 7000 | 5000 | 3800 | 3000 | 2600 |
| Spare live centres | 1241725 | 1243613 | 1241722 | 1241721 | 1241728 |

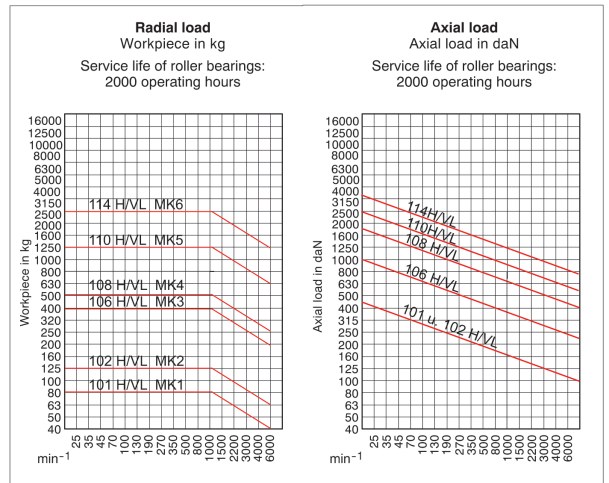
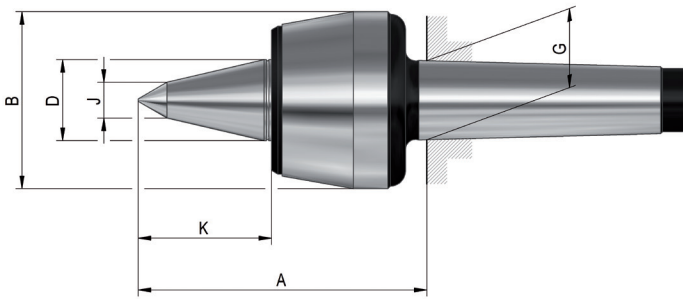
Basic - economy design



Tool group A06
Type 601 N Basic
body only ground not hardened -
tip angle 60°

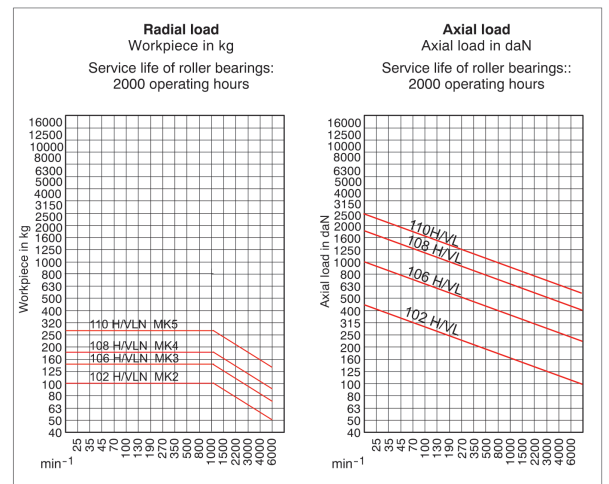
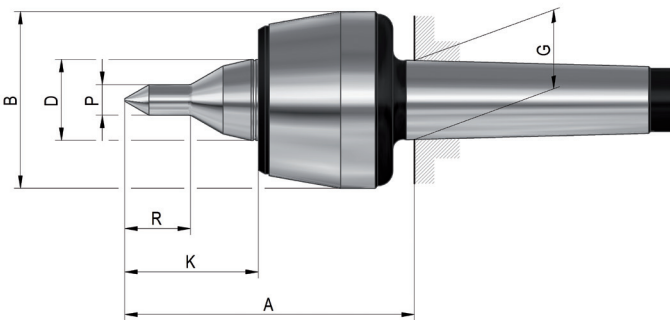
| Item no. | 061740 ● | 043395 ● | 043111 ● | 042310 ● | 042171 ● | 042839 ● |
|------------------------------|----------|----------|----------|----------|----------|----------|
| Mount MT | 0 | 1 | 2 | 3 | 4 | 5 |
| Size | 100 | 101 | 102 | 104 | 108 | 110 |
| A | 44 | 60,5 | 65 | 70,5 | 102,5 | 129 |
| B | 25 | 34,5 | 43 | 48,5 | 68,5 | 88,5 |
| D | 10 | 15 | 20 | 22 | 32 | 40 |
| G | 9,045 | 12,065 | 17,78 | 23,825 | 31,267 | 44,399 |
| K | 11 | 17 | 24 | 27,5 | 41 | 50,5 |
| Weight approx. g | 200 | 400 | 500 | 800 | 2300 | 4700 |
| Workpiece weight max. kg | 10 | 80 | 180 | 300 | 750 | 1800 |
| Concentricity deviation | 0,01 | 0,005 | 0,005 | 0,005 | 0,005 | 0,005 |
| Speed max. min ⁻¹ | 15000 | 7000 | 7000 | 6300 | 3800 | 3000 |
| Spare live centres | 1241727 | 1241726 | 1241725 | 1241724 | 1241722 | 1241721 |

Basic - extended live centre



Tool group A06
Type 604 HVL Basic
with **extended live centre**
body hardened and ground -
tip angle 60°

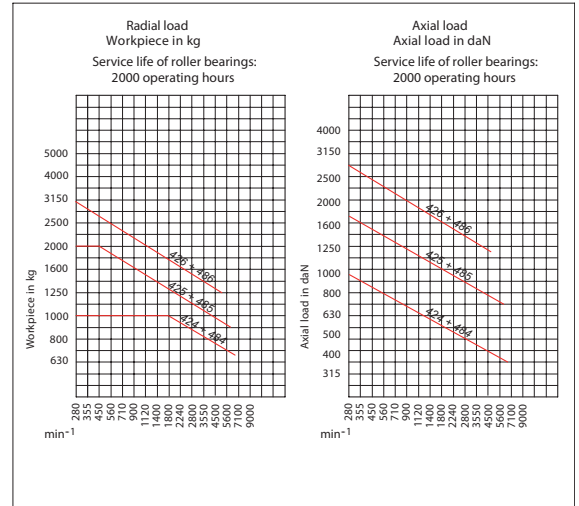
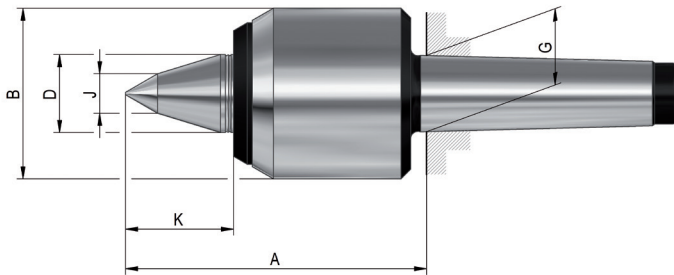
| Item no. | 058668 ● | 058669 ● | 058670 ● | 058671 ● | 058672 ● | 058673 ● |
|------------------------------|----------------|----------------|----------------|----------------|----------------|----------------|
| Mount MT | 1 | 2 | 3 | 4 | 5 | 6 |
| Size | 101 | 102 | 106 | 108 | 110 | 114 |
| A | 70,5 | 75 | 95,5 | 114,5 | 143,5 | 172,5 |
| B | 34,5 | 43 | 58,5 | 68,5 | 88,5 | 102,5 |
| D | 15 | 20 | 25 | 32 | 40 | 50 |
| G | 12,065 | 17,78 | 23,825 | 31,267 | 44,399 | 63,348 |
| K | 27 | 34 | 47 | 53 | 65 | 78 |
| J | 9 | 10 | 12 | 14 | 16 | 18 |
| Weight approx. g | 400 | 500 | 1300 | 2300 | 4800 | 10200 |
| Workpiece weight max. kg | 80 | 140 | 400 | 500 | 1200 | 2500 |
| Concentricity deviation | 0,01 | 0,005 | 0,005 | 0,005 | 0,005 | 0,01 |
| Speed max. min ⁻¹ | 7000 | 7000 | 5000 | 3800 | 3000 | 2600 |
| Spare live centres | 1241731 | 1241732 | 1241733 | 1241734 | 1241735 | 1241736 |



Tool group A06
Type 604 HVLN Basic
with **profiled centre point**
body hardened and ground -
tip angle 60°

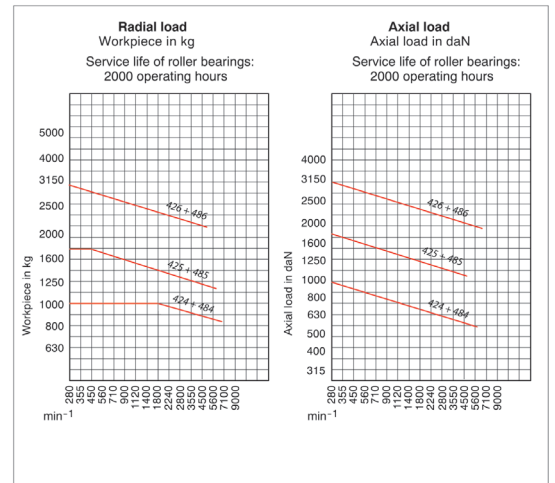
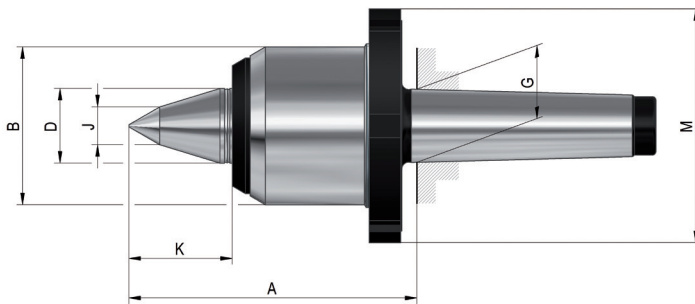
| Item no. | 1241689 ● | 1241691 ● | 1241693 ● | 1241694 ● |
|------------------------------|----------------|----------------|----------------|----------------|
| Mount MT | 2 | 3 | 4 | 5 |
| Size | 102 | 106 | 108 | 110 |
| A | 75 | 95,5 | 114,5 | 143,5 |
| B | 43 | 58,5 | 68,5 | 88,5 |
| D | 20 | 25 | 32 | 40 |
| G | 17,78 | 23,825 | 31,267 | 44,399 |
| K | 34 | 47 | 53 | 65 |
| P | 8 | 10 | 12 | 14 |
| R | 16 | 20 | 26 | 30 |
| Workpiece weight max. kg | 100 | 150 | 180 | 280 |
| Speed max. min ⁻¹ | 7000 | 5000 | 3800 | 3000 |
| Spare live centres | 1243677 | 1243678 | 1243679 | 1243680 |

Heavy - standard design



Tool group A06
Type 640-20 Heavy
especially for **high load**
at high speeds
body hardened and ground -
tip angle 60°

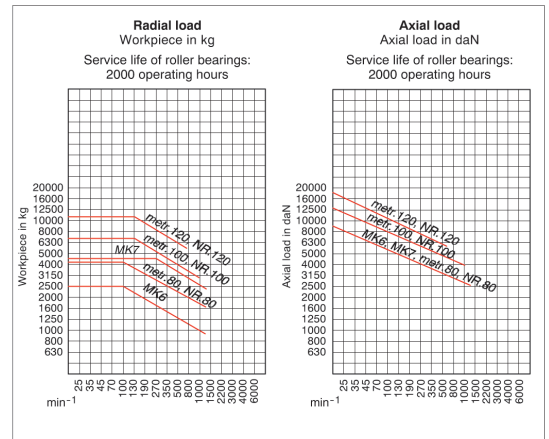
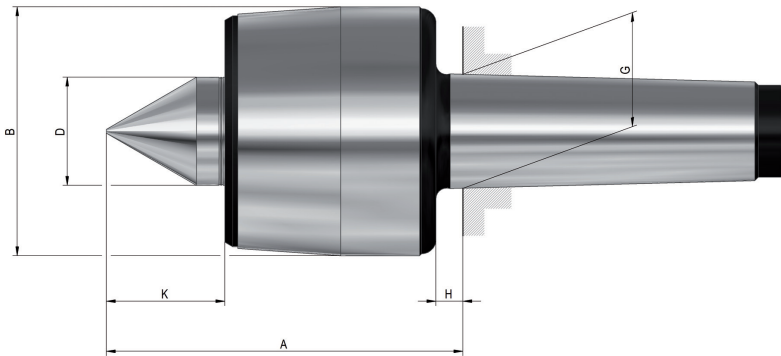
| Item no. | 303598 ● | 303599 ● | 301696 ■ |
|------------------------------|----------------|----------------|----------------|
| Mount MT | 4 | 5 | 6 |
| Size | 424 | 425 | 426 |
| A | 122 | 150 | 180 |
| B | 70 | 95 | 120 |
| D | 32 | 42 | 58 |
| G | 31,267 | 44,399 | 63,348 |
| J | 16 | 20 | 26 |
| K | 44 | 59 | 77 |
| Weight approx. g | 2600 | 5500 | 11500 |
| Workpiece weight max. kg | 1000 | 2000 | 3000 |
| Concentricity deviation | 0,005 | 0,005 | 0,005 |
| Speed max. min ⁻¹ | 7000 | 6000 | 4800 |
| Spare live centres | 1241762 | 1241763 | 1241764 |



Tool group A06
Type 640-80 Heavy
with **draw-off nut**
especially for **high load**
at high speeds
body hardened and ground -
tip angle 60°

| Item no. | 304521 ● | 304522 ● | 304523 ● |
|------------------------------|----------------|----------------|----------------|
| Mount MT | 4 | 5 | 6 |
| Size | 484 | 485 | 486 |
| A | 122 | 150 | 180 |
| B | 70 | 95 | 120 |
| D | 32 | 42 | 58 |
| G | 31,267 | 44,399 | 63,348 |
| J | 16 | 20 | 26 |
| K | 44 | 59 | 77 |
| M | 100 | 125 | 155 |
| Weight approx. g | 2800 | 5400 | 12300 |
| Workpiece weight max. kg | 1000 | 2000 | 3000 |
| Concentricity deviation | 0,005 | 0,005 | 0,005 |
| Speed max. min ⁻¹ | 7000 | 6000 | 4800 |
| Spare live centres | 1241762 | 1241763 | 1241764 |

Heavy - heavy duty design



Tool group A06
Type 604 Heavy -
heavy duty design
body hardened and ground -
tip angle 60°

| Item no. | 093439 ● | 466229 ■ | 093440 ● | 058674 ■ | 018801 ■ | 093446 ■ | 058675 ▲ | 466230 ▲ |
|------------------------------|----------|----------|----------|------------------|------------------|---------------|----------------|----------------|
| Mount | 6 | MK 7 | Metr. 80 | Metr. 100 (1:20) | Metr. 120 (1:20) | Nr. 80 (1:10) | Nr. 100 (1:10) | Nr. 120 (1:10) |
| A | 196 | 215 | 196 | 257 | 274 | 196 | 257 | 274 |
| B | 138 | 150 | 138 | 200 | 245 | 140 | 200 | 245 |
| D | 60 | 70 | 60 | 85 | 110 | 60 | 85 | 110 |
| G | 63,348 | 83,061 | 80 | 100 | 120 | 80 | 100 | 120 |
| H | 13 | 15 | 13 | 14 | 15 | 13 | 14 | 15 |
| K | 67 | 77 | 68 | 86 | 102 | 66 | 86 | 102 |
| Workpiece weight max. kg | 5000 | 9000 | 8500 | 13000 | 22000 | 8500 | 13000 | 22000 |
| Concentricity deviation | 0,01 | 0,01 | 0,015 | 0,02 | 0,015 | 0,01 | 0,01 | 0,01 |
| Speed max. min ⁻¹ | 1500 | 1500 | 1500 | 1000 | 800 | 1500 | 1000 | 800 |

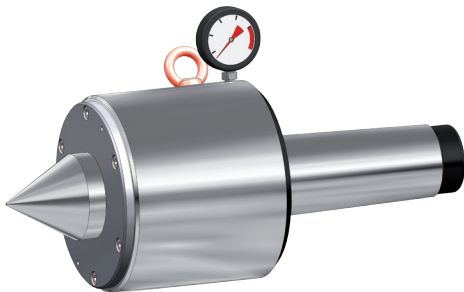
Heavy - heavy duty design

Revolving tailstock centres for heavy duty machining. Perfectly suitable for turning and grinding machines.

We have a lot of know-how and decades of experience in heavy duty machining. We offer highest concentricity deviation and best quality. Thanks to the lifetime lubrication our revolving tailstock centres are free of maintenance and ensure a very long life.

Have we aroused your interest in revolving tailstock centres for heavy duty machining? Please contact us.

We want you to receive exactly the right solution enabling you to achieve your goals in a reliable and economical manner.



Type 652

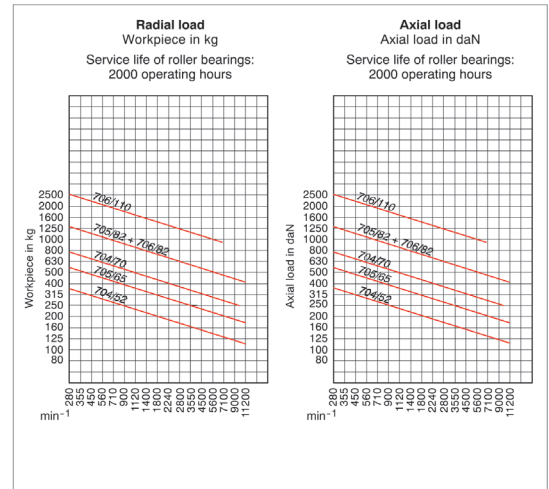
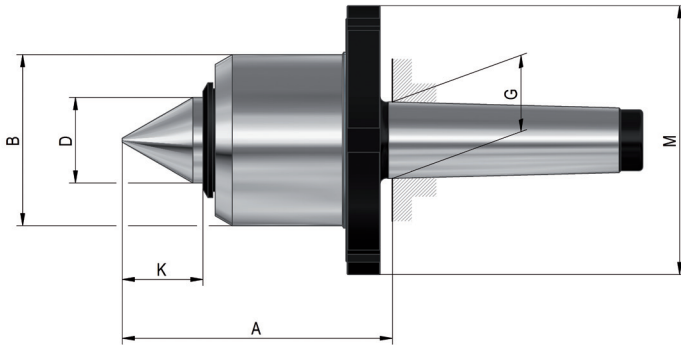
Revolving tailstock centres for heavy duty machining with length compensation and pressure display.



Type 604 MP

Revolving tailstock centres for heavy duty machining with tailstock support.

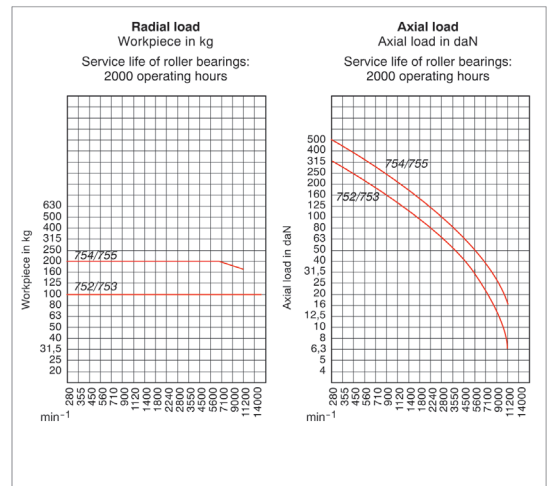
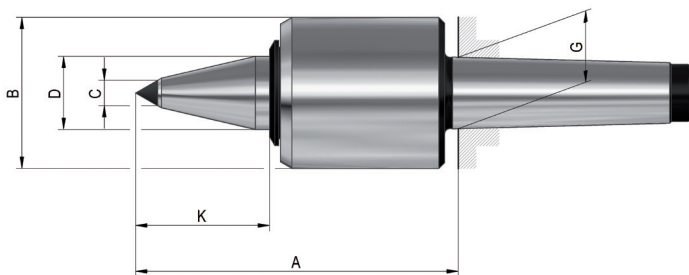
Speed - standard design



Tool group A06
Type 663 Speed
with **draw-off nut** -
for especially **high speeds**,
different head diameters at same
size of shank
body hardened and ground -
tip angle 60°

| Item no. | 340911 | 340910 | 338595 | 338594 | 344808 | 344809 |
|------------------------------|---------------|---------------|---------------|---------------|---------------|---------------|
| Mount MT | 4 | 4 | 5 | 5 | 6 | 6 |
| Size | 704/52 | 704/70 | 705/65 | 705/82 | 706/110 | 706/82 |
| A | 90 | 110 | 100 | 130 | 168 | 133 |
| B | 52 | 70 | 65 | 82 | 110 | 82 |
| D | 25 | 35 | 32 | 40 | 55 | 40 |
| G | 31,267 | 31,267 | 44,399 | 44,399 | 63,348 | 63,348 |
| K | 28 | 38 | 34 | 41 | 58 | 41 |
| M | 80 | 110 | 100 | 115 | 150 | 115 |
| Weight approx. g | 1900 | 2300 | 4000 | 5200 | 12000 | 8400 |
| Workpiece weight max. kg | 360 | 800 | 560 | 1250 | 2500 | 1250 |
| Concentricity deviation | 0,005 | 0,005 | 0,005 | 0,005 | 0,005 | 0,005 |
| Speed max. min ⁻¹ | 15000 | 10000 | 12000 | 10000 | 7000 | 10000 |
| Spare live centres | 344924 | 344923 | 338895 | 338901 | 344925 | 338901 |

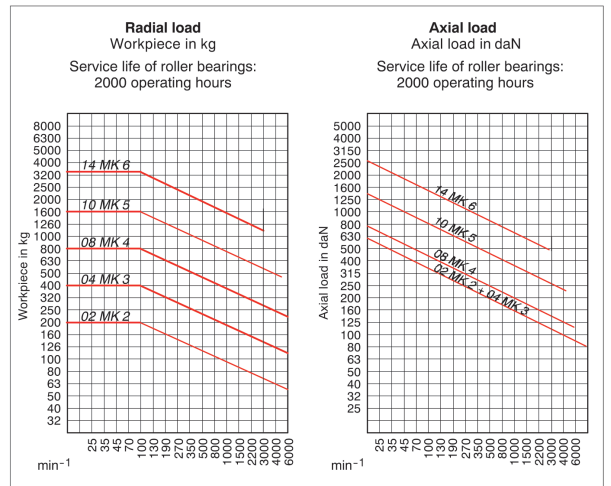
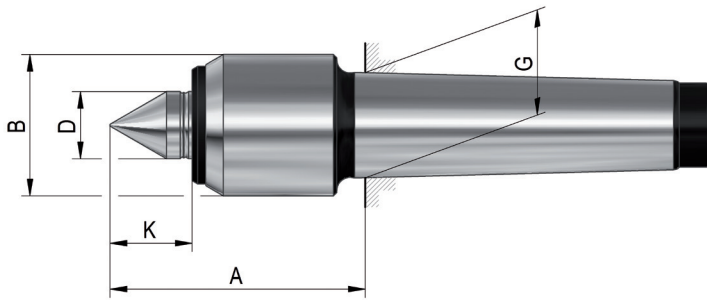
Speed - extended live centre



Tool group A06
Type 664 Speed
extended NC-centre
with **carbide insert**,
for high speed
body hardened and ground -
tip angle 60°

| Item no. | 772389 | 772390 | 772391 | 772392 |
|------------------------------|---------------|---------------|---------------|---------------|
| Mount MT | 2 | 3 | 4 | 5 |
| Size | 752 | 753 | 754 | 755 |
| A | 99 | 99 | 141 | 141 |
| B | 45 | 45 | 66 | 66 |
| C | 7 | 7 | 11 | 11 |
| D | 20 | 20 | 32 | 32 |
| G | 17,78 | 23,825 | 31,267 | 44,399 |
| K | 40 | 40 | 63 | 63 |
| Weight approx. g | 1200 | 1600 | 2600 | 5000 |
| Workpiece weight max. kg | 100 | 100 | 250 | 250 |
| Concentricity deviation | 0,01 | 0,01 | 0,01 | 0,01 |
| Speed max. min ⁻¹ | 12000 | 12000 | 9000 | 9000 |
| Spare live centres | 790267 | 790267 | 790291 | 790291 |

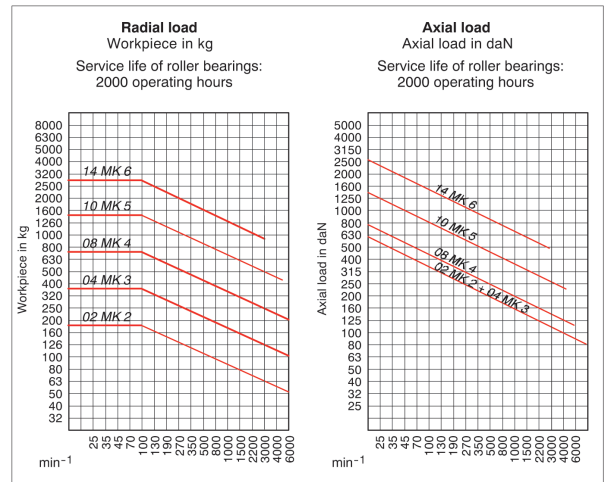
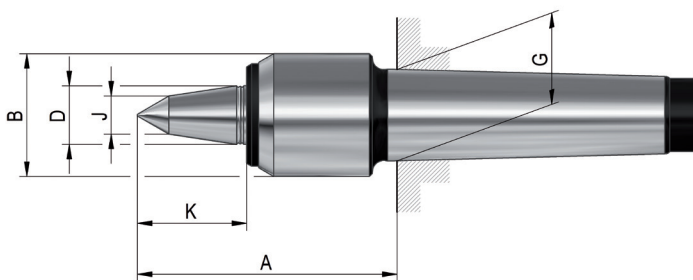
Slim - standard design



Tool group A06
Type 600 Slim
with **small casing diameter**
body hardened and ground -
tip angle 60°

| Item no. | 005336 ● | 005429 ● | 005469 ● | 005490 ● | 005547 ● |
|------------------------------|----------|----------|----------|----------|----------|
| Mount MT | 2 | 3 | 4 | 5 | 6 |
| Size | 02 | 04 | 08 | 10 | 14 |
| A | 62 | 62 | 75,5 | 106 | 143 |
| B | 32 | 34 | 42 | 58 | 80 |
| D | 15 | 15 | 20 | 30 | 42 |
| G | 17,78 | 23,825 | 31,267 | 44,399 | 63,348 |
| K | 18 | 18 | 25 | 34 | 49 |
| Weight approx. g | 300 | 400 | 1000 | 2600 | 7100 |
| Workpiece weight max. kg | 200 | 400 | 800 | 1600 | 3500 |
| Concentricity deviation | 0,005 | 0,005 | 0,005 | 0,01 | 0,02 |
| Speed max. min ⁻¹ | 7000 | 7000 | 6300 | 4300 | 3000 |
| Spare live centres | 1241748 | 1241749 | 1241750 | 1241751 | 1241752 |

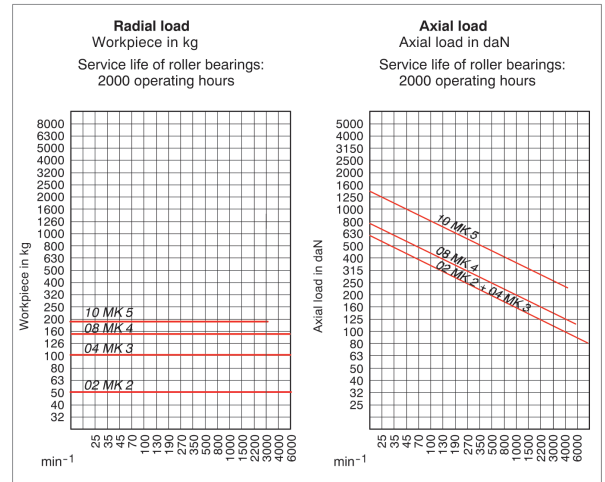
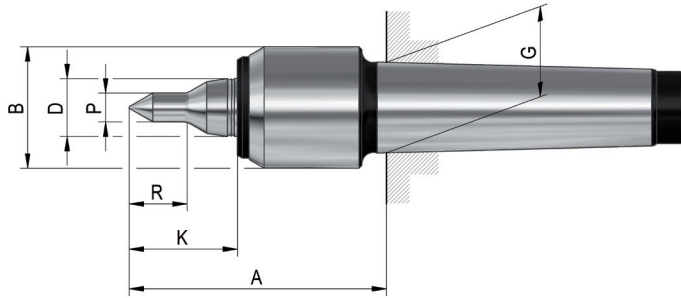
Slim - extended live centre



Tool group A06
Type 600-20 Slim
with **small casing diameter**
and **extended live centre**
body hardened and ground -
tip angle 60°

| Item no. | 362080 ● | 362081 ● | 362082 ● | 362083 ● | 362084 ● |
|------------------------------|----------|----------|----------|----------|----------|
| Mount MT | 2 | 3 | 4 | 5 | 6 |
| Size | 02 | 04 | 08 | 10 | 14 |
| A | 73 | 74 | 88,5 | 119 | 164 |
| B | 32 | 34 | 42 | 58 | 80 |
| D | 15 | 15 | 20 | 30 | 42 |
| G | 17,78 | 23,825 | 31,267 | 44,399 | 63,348 |
| K | 29 | 30 | 38 | 49 | 70 |
| J | 10 | 11 | 13 | 14 | 18 |
| Weight approx. g | 320 | 460 | 1000 | 2600 | 7100 |
| Workpiece weight max. kg | 170 | 340 | 700 | 1400 | 3000 |
| Concentricity deviation | 0,008 | 0,008 | 0,008 | 0,01 | 0,02 |
| Speed max. min ⁻¹ | 7000 | 7000 | 6300 | 4300 | 3000 |
| Spare live centres | 1241753 | 1241754 | 1241755 | 1241756 | 1241757 |

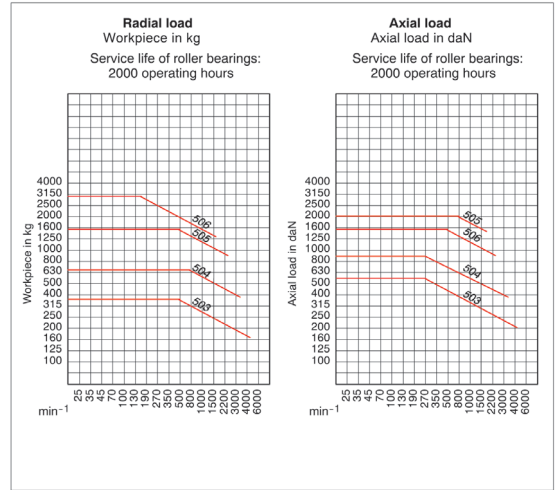
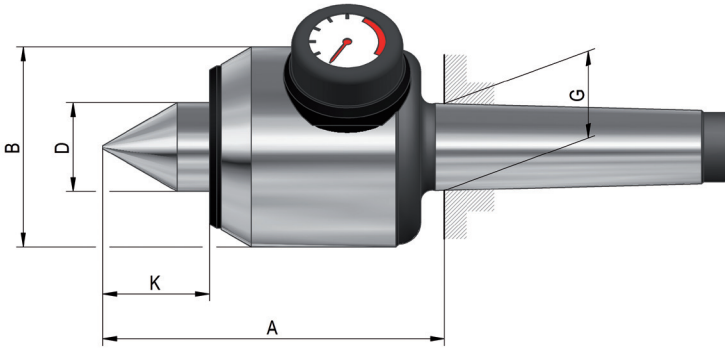
Slim - extended live centre



Tool group A06
Type 600-20 Slim
with **small casing diameter**
and **profiled centre point**
body hardened and ground -
tip angle 60°

| Item no. | 1241695 ● | 1243505 ● | 1243507 ● | 1243509 ● |
|------------------------------|-----------|-----------|-----------|-----------|
| Mount MT | 2 | 3 | 4 | 5 |
| Size | 02 | 04 | 08 | 10 |
| A | 73 | 74 | 88,5 | 119 |
| B | 32 | 34 | 42 | 58 |
| D | 15 | 15 | 20 | 30 |
| G | 17,78 | 23,825 | 31,267 | 44,399 |
| K | 29 | 30 | 38 | 49 |
| P | 6 | 8 | 10 | 12 |
| R | 12 | 16 | 20 | 26 |
| Workpiece weight max. kg | 50 | 100 | 150 | 180 |
| Speed max. min ⁻¹ | 7000 | 7000 | 6300 | 4300 |
| Spare live centres | 1241758 | 1241759 | 1241760 | 1241761 |

Control - standard design

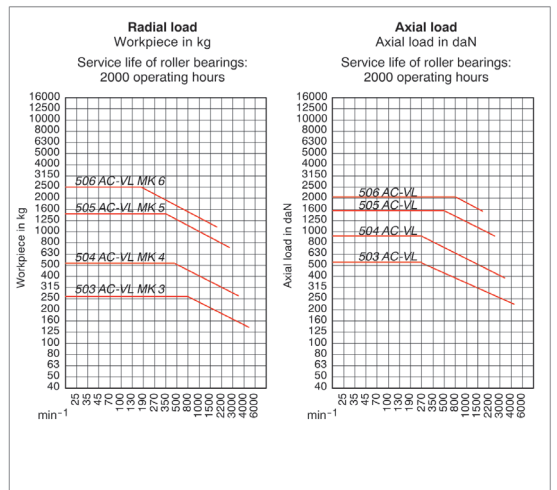
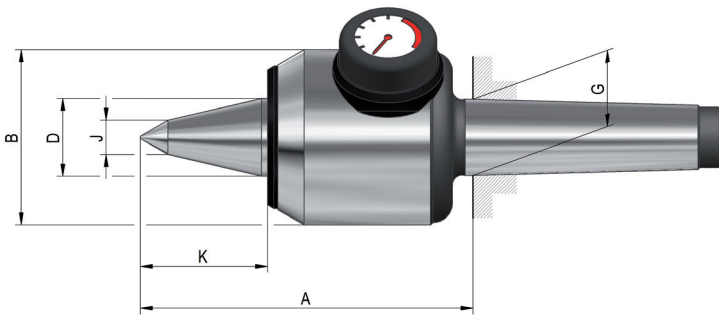


Tool group A06
Type 652 AC Control
with **pressure display** and **length compensation**
as counter centre with face drivers
body hardened and ground -
tip angle 60°

| Item no. | 060798 ● | 060874 ● | 060906 ● | 060915 ● |
|------------------------------|---------------|---------------|---------------|---------------|
| Mount MT | 3 | 4 | 5 | 6 |
| Size | 503 | 504 | 505 | 506 |
| A | 105 | 123,5 | 160,5 | 202 |
| B | 64 | 72 | 95 | 120 |
| D | 25 | 32 | 40 | 52 |
| G | 23,825 | 31,267 | 44,399 | 63,348 |
| K | 31,5 | 39 | 49 | 59 |
| Weight approx. g | 2100 | 3500 | 8300 | 17000 |
| Spring way ¹⁾ | 1,6 | 2 | 1,8 | 2,7 |
| Axial load max. | 550 | 900 | 1500 | 2000 |
| Workpiece weight max. kg | 400 | 800 | 1600 | 3200 |
| Concentricity deviation | 0,01 | 0,01 | 0,01 | 0,015 |
| Speed max. min ⁻¹ | 4000 | 3500 | 2500 | 1800 |
| Spare live centres | 009192 | 009205 | 009325 | 009413 |

¹⁾ at max. axial load

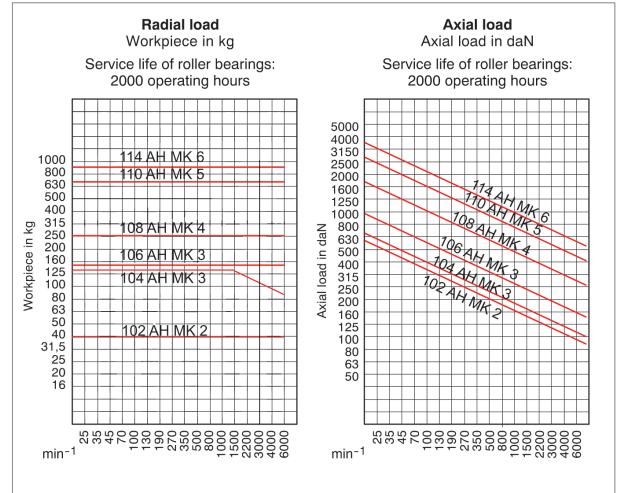
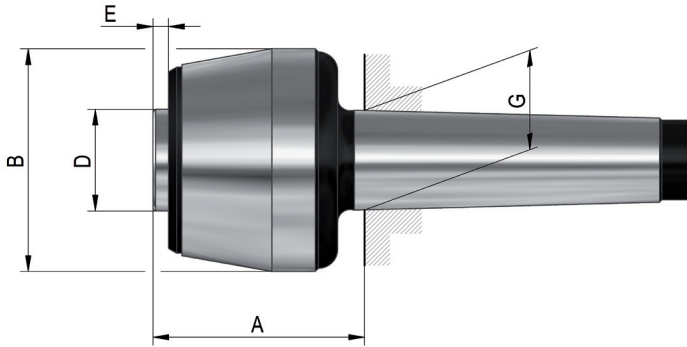
Control - extended live centre



Tool group A06
Type 652-AC-VL Control
with **pressure display**, **length compensation** and **extended live centre**
as counter centre with face drivers
body hardened and ground -
tip angle 60°

| Item no. | 079920 ● | 079921 ● | 079922 ● | 079923 ● |
|------------------------------|---------------|---------------|---------------|---------------|
| Mount MT | 3 | 4 | 5 | 6 |
| Size | 503 | 504 | 505 | 506 |
| A | 120 | 137,5 | 177,5 | 223 |
| B | 64 | 72 | 95 | 120 |
| D | 25 | 32 | 40 | 52 |
| G | 23,825 | 31,267 | 44,399 | 63,348 |
| K | 46,5 | 53 | 66 | 80 |
| J | 11 | 14 | 15 | 24 |
| Weight approx. g | 2200 | 3600 | 8400 | 17500 |
| Spring way ¹⁾ | 1,6 | 2 | 1,8 | 2,7 |
| Axial load max. | 550 | 900 | 1500 | 2000 |
| Workpiece weight max. kg | 260 | 550 | 1100 | 2500 |
| Concentricity deviation | 0,01 | 0,01 | 0,01 | 0,015 |
| Speed max. min ⁻¹ | 4000 | 3500 | 2500 | 1800 |
| Spare live centres | 079924 | 079925 | 079926 | 079927 |

¹⁾ at max. axial load

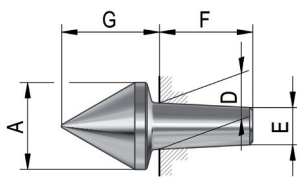


Tool group A06
Type 614 Flex
for interchangeable inserts
body hardened and ground

| Item no. | 061030 ● | 061031 ● | 061032 ● | 061038 ● | 061039 ● | 061040 ● |
|--------------------------|----------|----------|----------|----------|----------|----------|
| Mount MT | 2 | 3 | 3 | 4 | 5 | 6 |
| Size | 102 | 104 | 106 | 108 | 110 | 114 |
| A | 45 | 48 | 55 | 67 | 85 | 101 |
| B | 43 | 48,5 | 58,5 | 68,5 | 88,5 | 102,5 |
| D | 20 | 22 | 25 | 32 | 40 | 50 |
| E | 4 | 4,5 | 5 | 5 | 6 | 6 |
| G | 17,78 | 23,825 | 23,825 | 31,267 | 44,399 | 63,348 |
| Concentricity deviation | 0,01 | 0,01 | 0,01 | 0,01 | 0,01 | 0,015 |
| Workpiece weight max. kg | 40 | 130 | 150 | 250 | 650 | 900 |
| Weight without inserts | 440 | 750 | 1100 | 1900 | 4400 | 8600 |
| Weight | 900 | 1700 | 2200 | 3700 | 8000 | - |
| Spare live spindle | 009836 | 009838 | 009843 | 009870 | 009872 | 009874 |

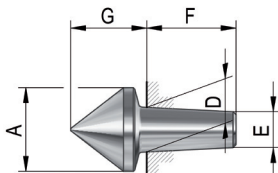
Flex - Interchangeable inserts

Tool group A06
Type 616 Interchangeable inserts **60°**



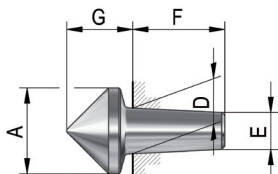
| Item no. | Size | A | D | E | F | G |
|----------|------|----|----|------|----|------|
| 070725 ● | 102 | 16 | 7 | 5,2 | 18 | 20 |
| 070728 ● | 104 | 20 | 12 | 9,6 | 24 | 24 |
| 070731 ● | 106 | 24 | 12 | 9,6 | 24 | 27,5 |
| 070734 ● | 108 | 28 | 15 | 12 | 30 | 31,5 |
| 070737 ● | 110 | 38 | 22 | 18,5 | 35 | 43 |
| 070740 ● | 114 | 50 | 28 | 24 | 40 | 54 |

Tool group A06
Type 616 Interchangeable inserts **75°**



| Item no. | Size | A | D | E | F | G |
|----------|------|----|----|------|----|------|
| 070726 ■ | 102 | 16 | 7 | 5,2 | 18 | 17 |
| 070729 ■ | 104 | 20 | 12 | 9,6 | 24 | 19,5 |
| 070732 ■ | 106 | 24 | 12 | 9,6 | 24 | 22,5 |
| 070735 ■ | 108 | 28 | 15 | 12 | 30 | 25,5 |
| 070738 ■ | 110 | 38 | 22 | 18,5 | 35 | 35 |
| 070741 ■ | 114 | 50 | 28 | 24 | 40 | 44 |

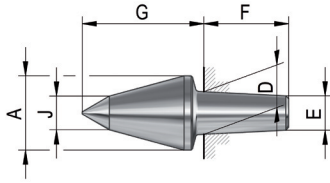
Tool group A06
Type 616 Interchangeable inserts **90°**



| Item no. | Size | A | D | E | F | G |
|----------|------|----|----|------|----|------|
| 070727 ● | 102 | 16 | 7 | 5,2 | 18 | 14,5 |
| 070730 ● | 104 | 20 | 12 | 9,6 | 24 | 16,5 |
| 070733 ● | 106 | 24 | 12 | 9,6 | 24 | 19 |
| 070736 ● | 108 | 28 | 15 | 12 | 30 | 21,5 |
| 070739 ● | 110 | 38 | 22 | 18,5 | 35 | 29 |
| 070742 ■ | 114 | 50 | 28 | 24 | 40 | 36 |

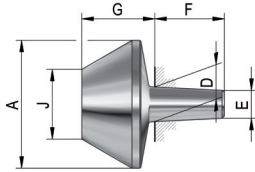
Flex - Interchangeable inserts

Tool group A06
Type 616 Interchangeable inserts 60°VL



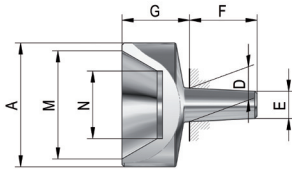
| Item no. | Size | A | D | E | F | G | J |
|----------|----------|----|----|------|----|----|------|
| 070719 ● | 102 | 14 | 7 | 5,2 | 18 | 25 | 6 |
| 070720 ● | 104; 106 | 18 | 12 | 9,6 | 24 | 30 | 8 |
| 070721 ● | 108 | 26 | 15 | 12 | 30 | 43 | 12 |
| 070722 ● | 110 | 32 | 22 | 18,5 | 35 | 55 | 13 |
| 070723 ● | 114 | 42 | 28 | 24 | 40 | 70 | 18,5 |

Tool group A06
Type 616 Interchangeable inserts for tubular workpieces 60°



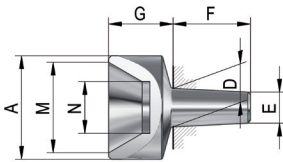
| Item no. | Size | A | D | E | F | G | J |
|----------|------|-----|----|------|----|------|----|
| 070700 ● | 102 | 25 | 7 | 5,2 | 18 | 21 | 10 |
| 070701 ● | 104 | 35 | 12 | 9,6 | 24 | 26 | 15 |
| 070702 ● | 106 | 45 | 12 | 9,6 | 24 | 27 | 25 |
| 070703 ● | 108 | 55 | 15 | 12 | 30 | 31,5 | 30 |
| 070704 ● | 110 | 70 | 22 | 18,5 | 35 | 39 | 40 |
| 070705 ● | 114 | 100 | 28 | 24 | 40 | 52 | 55 |

Tool group A06
Type 616 Interchangeable inserts **A** for centerless workpieces 60°



| Item no. | Size | A | D | E | F | G | M | N |
|----------|------|-----|----|------|----|----|----|----|
| 070707 ● | 102 | 25 | 7 | 5,2 | 18 | 18 | 20 | 10 |
| 070708 ● | 104 | 35 | 12 | 9,6 | 24 | 24 | 30 | 15 |
| 070709 ● | 106 | 45 | 12 | 9,6 | 24 | 25 | 40 | 25 |
| 070710 ● | 108 | 55 | 15 | 12 | 30 | 30 | 48 | 30 |
| 070711 ● | 110 | 70 | 22 | 18,5 | 35 | 39 | 63 | 40 |
| 070712 ● | 114 | 100 | 28 | 24 | 40 | 52 | 90 | 55 |

Tool group A06
Type 616 Interchangeable inserts **B** for centerless workpieces 60°



| Item no. | Size | A | D | E | F | G | M | N |
|----------|------|----|----|------|----|----|----|----|
| 228620 ● | 102 | 16 | 7 | 5,2 | 18 | 12 | 12 | 6 |
| 228621 ● | 106 | 22 | 12 | 9,6 | 24 | 16 | 18 | 10 |
| 228622 ● | 108 | 40 | 15 | 12 | 30 | 25 | 35 | 20 |
| 308632 ● | 110 | 52 | 22 | 18,5 | 35 | 30 | 45 | 30 |

Tool group A06
Type 616 Extractor



| Item no. | For size |
|----------|-------------|
| 061707 ● | 102 |
| 061708 ● | 104/106/108 |
| 061709 ● | 110/114 |

Flex - assortment

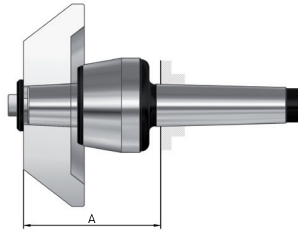


Tool group A06
Type 614-00 **complete** with all
inserts in a sturdy wooden case

| Item no. | 061702 ● | 061703 ● | 061704 ● | 061705 ● | 061706 ● |
|--------------------------|----------|----------|----------|----------|----------|
| Mount MT | 2 | 3 | 3 | 4 | 5 |
| Size | 102 | 104 | 106 | 108 | 110 |
| Workpiece weight max. kg | 40 | 130 | 150 | 250 | 650 |
| Weight | 900 | 1700 | 2200 | 3700 | 8000 |

MZK

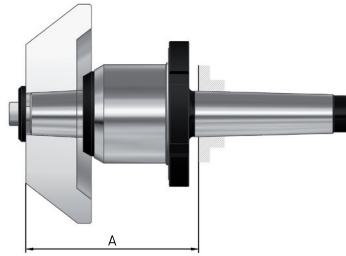
Tool group A06
Type 608-00 Revolving centering taper



| Item no. | Size | Mount MT | A | Workpiece weight max. kg | Weight |
|----------|------|----------|-----|--------------------------|--------|
| 304562 ● | 108 | 4 | 103 | 800 | 2200 |
| 304563 ● | 110 | 5 | 128 | 1600 | 4800 |
| 304564 ● | 114 | 6 | 159 | 3000 | 12000 |

Including fixing screw and washer, without insert

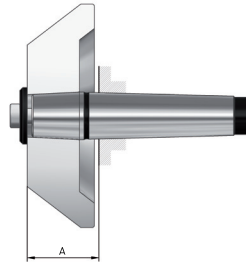
Tool group A06
Type 640-90 Revolving centering tapers **with draw-off nut**, for high load



| Item no. | Size | Mount MT | A | Workpiece weight max. kg | Weight |
|----------|------|----------|-----|--------------------------|--------|
| 304583 ● | 494 | 4 | 118 | 1000 | 3200 |
| 304584 ● | 495 | 5 | 140 | 2000 | 6500 |
| 304585 ■ | 496 | 6 | 168 | 3500 | 13500 |

Including fixing screw and washer, without insert

Tool group A07
Type 698-00 **Fixed shafts**

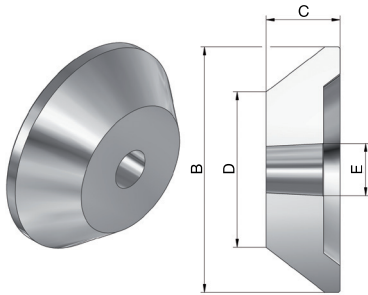


| Item no. | Mount MT | A | Workpiece weight max. kg | Weight |
|----------|----------|----|--------------------------|--------|
| 304580 ● | 4 | 45 | 2000 | 800 |
| 304581 ● | 5 | 60 | 4800 | 2000 |
| 304582 ● | 6 | 70 | 12000 | 5500 |

Including fixing screw and washer, without insert

Interchangeable inserts MZK

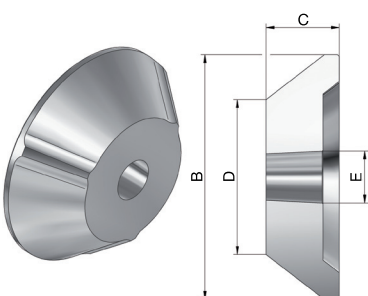
Tool group A06
Type 608-20 Suitable **inserts** for centering tapers **AZ**
Standard version, taper 75°



| Item no. | Size | for MT | B | C | D | E | Weight |
|------------------------|------|--------|-----|----|-----|----|--------|
| 304565 ¹⁾ ● | 1 | 4 | 60 | 68 | 5 | 32 | 900 |
| 304566 ● | 2 | 4 | 100 | 45 | 45 | 32 | 1500 |
| 304567 ● | 3 | 4 | 150 | 45 | 95 | 32 | 4100 |
| 304568 ● | 4 | 4 | 200 | 45 | 145 | 32 | 6000 |
| 304569 ● | 5 | 4 | 250 | 45 | 195 | 32 | 8500 |
| 304570 ● | 1 | 5 | 100 | 43 | 45 | 40 | 1500 |
| 304571 ● | 2 | 5 | 150 | 43 | 95 | 40 | 4400 |
| 304572 ● | 3 | 5 | 200 | 43 | 145 | 40 | 6100 |
| 304573 ● | 4 | 5 | 250 | 43 | 195 | 40 | 8100 |
| 304574 ● | 5 | 5 | 300 | 43 | 245 | 40 | 11600 |
| 304575 ● | 1 | 6 | 150 | 54 | 95 | 50 | 3000 |
| 304576 ● | 2 | 6 | 200 | 54 | 145 | 50 | 8100 |
| 304577 ● | 3 | 6 | 250 | 54 | 195 | 50 | 11100 |
| 304578 ● | 4 | 6 | 300 | 54 | 245 | 50 | 14000 |
| 304579 ● | 5 | 6 | 350 | 54 | 295 | 50 | 18800 |

¹⁾ Without fixing by screw and washer

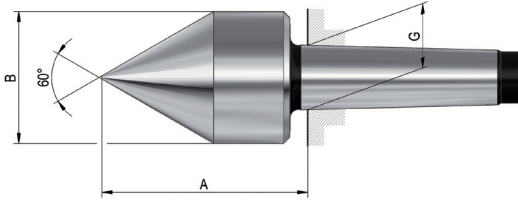
Tool group A06
Type 608-40 Suitable **inserts** for centering tapers **AZR**
with three support surfaces, for rough pieces 75°



| Item no. | Size | for MT | B | C | D | E | Weight |
|----------|------|--------|-----|----|-----|----|--------|
| 304736 ■ | 2 | 4 | 100 | 45 | 45 | 32 | 1500 |
| 304737 ■ | 3 | 4 | 150 | 45 | 95 | 32 | 4100 |
| 304738 ■ | 4 | 4 | 200 | 45 | 145 | 32 | 6000 |
| 304739 ■ | 5 | 4 | 250 | 45 | 195 | 32 | 8500 |
| 304740 ■ | 1 | 5 | 100 | 43 | 45 | 40 | 1500 |
| 304741 ■ | 2 | 5 | 150 | 43 | 95 | 40 | 4400 |
| 304742 ■ | 3 | 5 | 200 | 43 | 145 | 40 | 6100 |
| 304743 ■ | 4 | 5 | 250 | 43 | 195 | 40 | 8100 |
| 304744 ■ | 5 | 5 | 300 | 43 | 245 | 40 | 11600 |
| 304745 ■ | 1 | 6 | 150 | 54 | 95 | 50 | 3000 |
| 304746 ■ | 2 | 6 | 200 | 54 | 145 | 50 | 8100 |
| 304747 ■ | 3 | 6 | 250 | 54 | 195 | 50 | 11100 |
| 304748 ■ | 4 | 6 | 300 | 54 | 245 | 50 | 14000 |
| 304749 ■ | 5 | 6 | 350 | 54 | 295 | 50 | 18800 |

Tool group A06

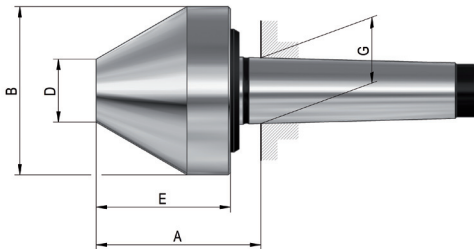
Type 627 Revolving centering taper, **pointed** as centering taper for tubular workpieces and as a revolving tailstock centre to machine normal workpieces



| Item no. | Size | Mount MT | A | B | G | Workpiece weight max. kg | Concentricity deviation | Weight |
|----------|------|----------|-------|-----|--------|--------------------------|-------------------------|--------|
| 010613 ● | 272 | 2 | 61 | 42 | 17,78 | 200 | 0,01 | 400 |
| 010635 ● | 273 | 3 | 79 | 56 | 23,825 | 400 | 0,008 | 1100 |
| 010638 ● | 274 | 4 | 100 | 64 | 31,267 | 800 | 0,008 | 1600 |
| 010642 ● | 275 | 5 | 115,5 | 78 | 44,399 | 1600 | 0,008 | 3600 |
| 306396 ● | 276 | 6 | 153 | 105 | 63,348 | 2500 | 0,008 | 10000 |

Tool group A06

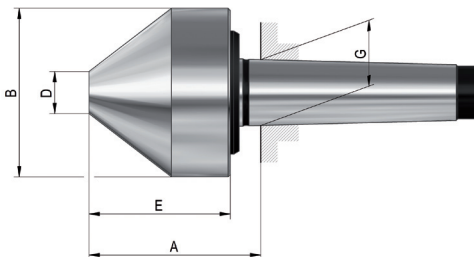
Type 617 Revolving tailstock center, **cone truncated, 60°**



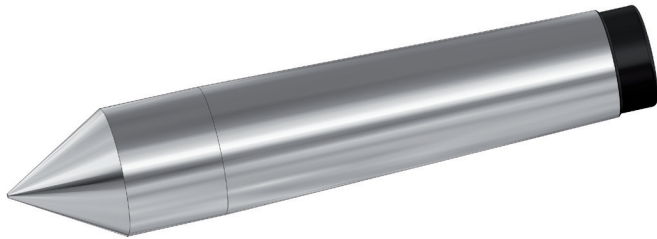
| Item no. | Size | Mount MT | A | B | D | E | G | Workpiece weight max. kg | Concentricity deviation | Weight |
|----------|------|----------|------|-----|----|----|--------|--------------------------|-------------------------|--------|
| 301615 ● | 171 | 1 | 64 | 50 | 20 | 52 | 12,065 | 100 | 0,008 | 900 |
| 301616 ● | 171a | 2 | 65 | 50 | 20 | 52 | 17,78 | 200 | 0,008 | 1200 |
| 301556 ● | 172 | 2 | 77 | 80 | 30 | 64 | 17,78 | 300 | 0,008 | 2000 |
| 301557 ● | 172a | 3 | 77 | 80 | 30 | 64 | 23,825 | 400 | 0,008 | 2200 |
| 221605 ● | 173 | 3 | 96,5 | 120 | 30 | 83 | 23,825 | 600 | 0,008 | 4200 |
| 301558 ● | 172b | 4 | 78,5 | 80 | 30 | 64 | 31,267 | 400 | 0,008 | 2300 |
| 044023 ● | 173a | 4 | 98 | 120 | 30 | 83 | 31,267 | 800 | 0,008 | 4500 |
| 090483 ● | 173b | 5 | 99 | 120 | 30 | 83 | 44,399 | 800 | 0,008 | 5300 |

Tool group A06

Type 618 Revolving tailstock center, **cone truncated, 75°**



| Item no. | Size | Mount MT | A | B | D | E | G | Workpiece weight max. kg | Concentricity deviation | Weight |
|----------|------|----------|-------|-----|-----|-----|--------|--------------------------|-------------------------|--------|
| 301559 ● | 172 | 2 | 80 | 80 | 20 | 67 | 17,78 | 300 | 0,008 | 2000 |
| 301560 ● | 172a | 3 | 80 | 80 | 20 | 67 | 23,825 | 400 | 0,008 | 2000 |
| 062211 ● | 173 | 3 | 85,5 | 120 | 30 | 72 | 23,825 | 600 | 0,008 | 4200 |
| 301561 ● | 172b | 4 | 81,5 | 80 | 20 | 67 | 31,267 | 400 | 0,008 | 2400 |
| 062224 ● | 173a | 4 | 87 | 120 | 30 | 72 | 31,267 | 800 | 0,008 | 4300 |
| 062299 ● | 174 | 4 | 107 | 170 | 50 | 90 | 31,267 | 1200 | 0,01 | 9700 |
| 062232 ● | 173b | 5 | 88 | 120 | 30 | 72 | 44,399 | 800 | 0,008 | 5100 |
| 063614 ● | 174a | 5 | 106 | 170 | 50 | 90 | 44,399 | 1600 | 0,01 | 10600 |
| 063662 ● | 175 | 5 | 146,5 | 250 | 75 | 130 | 44,399 | 2000 | 0,01 | 34000 |
| 063633 ● | 174b | 6 | 107,5 | 170 | 50 | 90 | 63,348 | 1600 | 0,01 | 13300 |
| 063656 ● | 175a | 6 | 148 | 250 | 75 | 130 | 63,348 | 2000 | 0,01 | 37000 |
| 063680 ● | 176 | 6 | 184 | 350 | 120 | 168 | 63,348 | 4000 | 0,015 | 82000 |



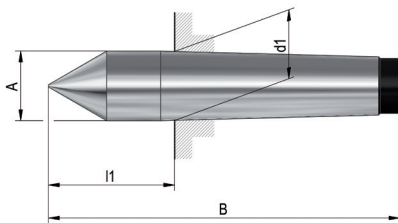
Dead centres DIN 806 and DIN 807 completely hardened and ground (with carbide-tipped ground only). Different types available.

Dead centres are manufactured with a concentricity of 5 micrometers. Versions with a concentricity of 3 micrometers or better are also available on request.

Technical features:

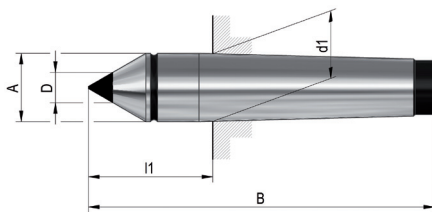
- completely hardened and ground
- high concentricity
- heavy duty

Tool group A07
Type 665 **DIN 806, full point**
material: tool steel



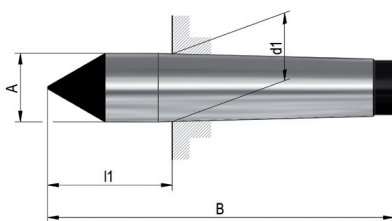
| Item no. | Mount MT | A | B | d1 | l1 | Weight |
|----------|----------|------|-----|--------|------|--------|
| 013706 ● | 0 | 9,2 | 70 | 9,045 | 20 | 30 |
| 013707 ● | 1 | 12,2 | 80 | 12,065 | 26,5 | 60 |
| 013709 ● | 2 | 18 | 100 | 17,78 | 36 | 150 |
| 013711 ● | 3 | 24,1 | 125 | 23,825 | 44 | 340 |
| 013712 ● | 4 | 31,6 | 160 | 31,267 | 57,5 | 760 |
| 013715 ● | 5 | 44,7 | 200 | 44,399 | 70,5 | 1920 |
| 013718 ● | 6 | 63,8 | 270 | 63,348 | 88 | 5200 |

Tool group A07
Type 667 **DIN 806, full point, ground only**
carbide-tipped



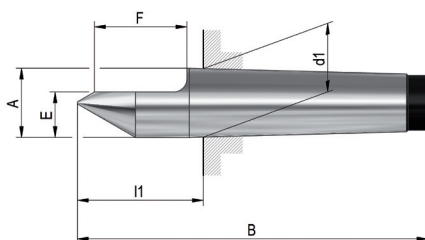
| Item no. | Mount MT | A | B | D | d1 | l1 | Weight |
|----------|----------|------|-----|----|--------|------|--------|
| 017169 ■ | 0 | 9,2 | 70 | 5 | 9,045 | 20 | 30 |
| 017170 ● | 1 | 12,2 | 80 | 7 | 12,065 | 26,5 | 55 |
| 017171 ● | 2 | 18 | 100 | 7 | 17,78 | 36 | 155 |
| 017172 ● | 3 | 24,1 | 125 | 11 | 23,825 | 44 | 360 |
| 017173 ● | 4 | 31,6 | 160 | 14 | 31,267 | 57,5 | 770 |
| 017174 ● | 5 | 44,7 | 200 | 18 | 44,399 | 70,5 | 1950 |
| 017175 ● | 6 | 63,8 | 270 | 18 | 63,348 | 88 | 5200 |

Tool group A07
Type 677 **DIN 806, full point, ground only**
carbide-tipped full point



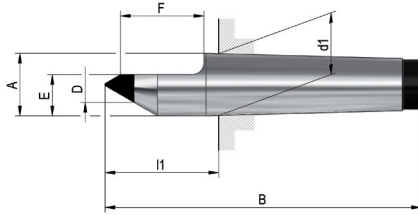
| Item no. | Mount MT | A | B | d1 | l1 | Weight |
|----------|----------|------|-----|--------|------|--------|
| 326786 ● | 2 | 18 | 100 | 17,78 | 36 | 175 |
| 306402 ● | 3 | 24,1 | 125 | 23,825 | 44 | 400 |
| 221398 ● | 4 | 31,6 | 160 | 31,267 | 57,5 | 855 |
| 326816 ● | 5 | 44,7 | 200 | 44,399 | 70,5 | 2160 |

Tool group A07
Type 668 **DIN 806, half point**
material: tool steel



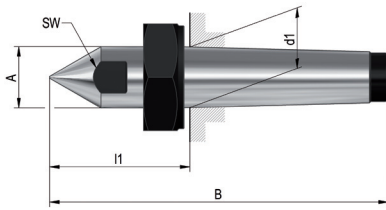
| Item no. | Mount MT | A | B | E | F | d1 | l1 | Weight |
|----------|----------|------|-----|------|----|--------|------|--------|
| 013867 ■ | 1 | 12,2 | 80 | 7,6 | 22 | 12,065 | 26,5 | 55 |
| 013868 ● | 2 | 18 | 100 | 11 | 30 | 17,78 | 36 | 145 |
| 013870 ● | 3 | 24,1 | 125 | 15 | 38 | 23,825 | 44 | 310 |
| 013871 ● | 4 | 31,6 | 160 | 21 | 50 | 31,267 | 57,5 | 710 |
| 013997 ■ | 5 | 44,7 | 200 | 29,4 | 63 | 44,399 | 70,5 | 1925 |
| 013999 ■ | 6 | 63,8 | 270 | 42 | 79 | 63,348 | 88 | 4800 |

Tool group A07
Type 670 **DIN 806, half point**, ground only
carbide-tipped



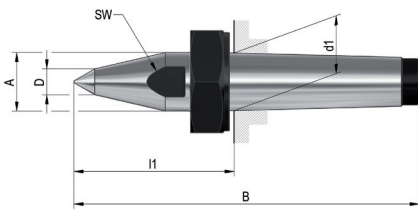
| Item no. | Mount MT | A | B | D | E | F | d1 | I1 | Weight |
|----------|----------|------|-----|----|------|----|--------|------|--------|
| 027438 ● | 1 | 12,2 | 80 | 7 | 7,6 | 22 | 12,065 | 26,5 | 55 |
| 027439 ● | 2 | 18 | 100 | 7 | 11 | 30 | 17,78 | 36 | 150 |
| 027440 ● | 3 | 24,1 | 125 | 11 | 15 | 38 | 23,825 | 44 | 335 |
| 026571 ● | 4 | 31,6 | 160 | 14 | 21 | 50 | 31,267 | 57,5 | 750 |
| 027441 ■ | 5 | 44,7 | 200 | 18 | 29,4 | 63 | 44,399 | 70,5 | 1830 |

Tool group A07
Type 671 similar **DIN 807, full point** with draw-off nut
material: tool steel



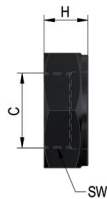
| Item no. | Mount MT | A | B | C | d1 | I1 | Key-width SW | Weight |
|----------|----------|------|-----|---------|--------|------|--------------|--------|
| 005361 ● | 1 | 12,2 | 90 | M16x1,5 | 12,065 | 36,5 | 10 | 140 |
| 005553 ● | 2 | 18 | 112 | M22x1,5 | 17,78 | 48 | 14 | 300 |
| 005654 ● | 3 | 24,1 | 138 | M27x1,5 | 23,825 | 57 | 19 | 580 |
| 005357 ● | 4 | 31,6 | 175 | M36x1,5 | 31,267 | 72,5 | 27 | 800 |
| 005381 ● | 5 | 44,7 | 217 | M48x1,5 | 44,399 | 87,5 | 36 | 2900 |
| 005426 ● | 6 | 63,8 | 290 | M68x1,5 | 63,348 | 108 | 55 | 7200 |

Tool group A07
Type 672 similar **DIN 807, full point** with draw-off nut, with extended point
material: tool steel



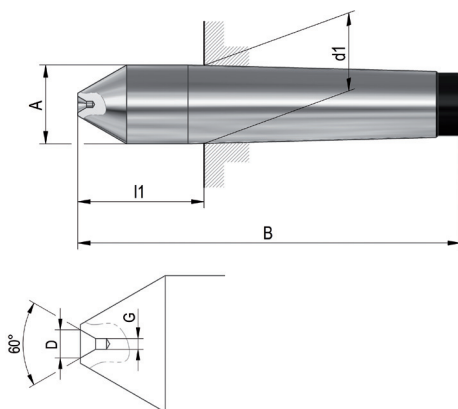
| Item no. | Mount MT | A | B | C | D | d1 | I1 | Key-width SW | Weight |
|----------|----------|------|-------|---------|----|--------|-----|--------------|--------|
| 249575 ● | 2 | 18 | 118 | M22x1,5 | 10 | 17,78 | 54 | 14 | 300 |
| 249576 ● | 3 | 24,1 | 148 | M27x1,5 | 10 | 23,825 | 67 | 19 | 600 |
| 249577 ● | 4 | 31,6 | 186,5 | M36x1,5 | 14 | 31,267 | 84 | 27 | 1285 |
| 249578 ● | 5 | 44,7 | 242 | M48x1,5 | 16 | 44,399 | 112 | 36 | 3000 |
| 249579 ● | 6 | 63,8 | 330 | M68x1,5 | 20 | 63,348 | 148 | 55 | 7900 |

Tool group A07
Type 671 **Draw-off nut**



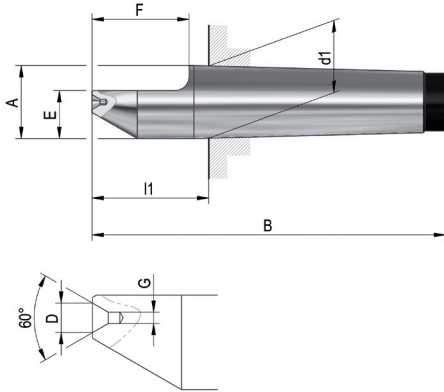
| Item no. | C | H | Key-width SW | Weight |
|----------|---------|------|--------------|--------|
| 005363 ● | M16x1,5 | 12 | 24 | 26 |
| 005555 ● | M22x1,5 | 15,5 | 32 | 55 |
| 005656 ● | M27x1,5 | 17,5 | 41 | 110 |
| 005359 ● | M36x1,5 | 21 | 55 | 240 |
| 005383 ● | M48x1,5 | 23 | 75 | 480 |
| 005428 ● | M68x1,5 | 25,5 | 100 | 900 |

Tool group A07
Type 673 **full point** with centre bore
material: tool steel



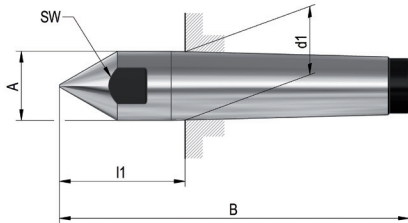
| Item no. | Mount MT | A | B | D | G | d1 | I1 | Weight |
|----------|----------|------|------|-----|------|--------|------|--------|
| 015001 ■ | 1 | 12,2 | 77 | 2,5 | 1 | 12,065 | 23,5 | 60 |
| 015003 ■ | 2 | 18 | 95,5 | 4 | 1,6 | 17,78 | 31,5 | 170 |
| 015004 ● | 3 | 24,1 | 120 | 5 | 2 | 23,825 | 39 | 350 |
| 015005 ■ | 4 | 31,6 | 153 | 6,5 | 2,5 | 31,267 | 50,5 | 800 |
| 015006 ■ | 5 | 44,7 | 191 | 8 | 3,19 | 44,399 | 61,5 | 1900 |

Tool group A07
 Typ 674 **half point** with centre bore
 material: tool steel



| Item no. | Mount MT | A | B | D | E | F | G | d1 | l1 | Weight |
|----------|----------|------|------|-----|------|----|------|--------|------|--------|
| 015009 ● | 1 | 12,2 | 77 | 2,5 | 8,6 | 19 | 1 | 12,065 | 23,5 | 55 |
| 015010 ● | 2 | 18 | 95,5 | 4 | 12 | 26 | 1,6 | 17,78 | 31,5 | 150 |
| 015011 ● | 3 | 24,1 | 120 | 5 | 15,7 | 32 | 2 | 23,825 | 39 | 310 |
| 015022 ■ | 4 | 31,6 | 153 | 6,5 | 20,8 | 42 | 2,5 | 31,267 | 50,5 | 705 |
| 015023 ■ | 5 | 44,7 | 191 | 8 | 29,4 | 53 | 3,15 | 44,399 | 61,5 | 1800 |

Tool group A07
 Type 695 **DIN 806, full point** with spanner flat
 material: tool steel



| Item no. | Mount MT | A | B | d1 | l1 | Key-width SW | Weight |
|----------|----------|------|-----|--------|------|--------------|--------|
| 015028 ■ | 1 | 12,2 | 80 | 12,065 | 26,5 | 10 | 55 |
| 015032 ● | 2 | 18 | 100 | 17,78 | 36 | 14 | 145 |
| 015039 ● | 3 | 24,1 | 125 | 23,825 | 44 | 19 | 340 |
| 015042 ● | 4 | 31,6 | 160 | 31,267 | 57,5 | 27 | 740 |
| 015040 ● | 5 | 44,7 | 200 | 44,399 | 70,5 | 36 | 1860 |

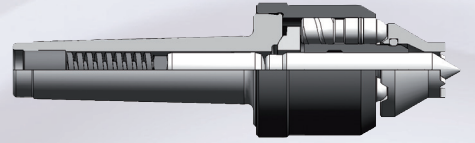
Overview

CoE

For efficient high-precision turning of workpieces along their whole length without rechucking. In the same operation there may be also milled a groove or toothing. This could save a retooling, i. e. to a vice, which may turn out to be both time and money saving.

The modular principle design allows the unlimited exchange of driver discs and centres. The mechanical compensation system guarantees equal clamping forces even on uneven workpiece faces. The spring cushioned centre allows the axial stop at the face of the workpiece.

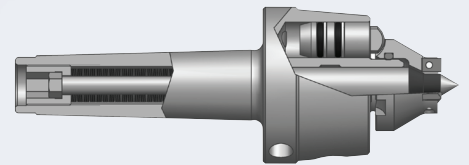
Clamping diameter 8-80 mm
Max. workpiece weight 100 kg



CoA

For efficient high-precision turning of workpieces along their whole length without rechucking. The modular principle design allows the unlimited exchange of driver discs and centres. The hydraulic or mechanical compensation system guarantees equal clamping forces even on uneven workpiece faces. The spring cushioned centre allows the axial stop at the face of the workpiece.

Clamping diameter 8-80 mm
Max. workpiece weight 100 kg

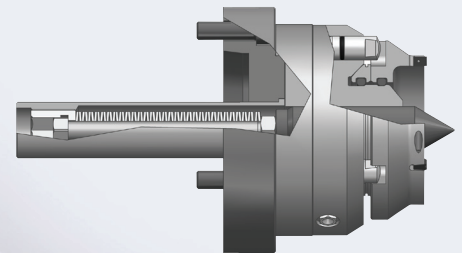


CoM

With spring loaded centre, attachable driver disc and mechanical compensation system. Adaptor flange with disc spring package or basic body with morse taper.

For the clamping of big and heavy workpieces.

Clamping diameter 50-250 mm
Max. workpiece weight 500 kg



CoB

For the clamping of big and heavy workpieces. Also for extremely uneven faces.

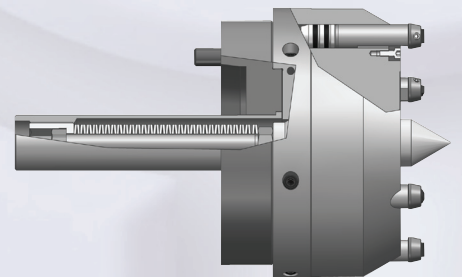
Basic body with morse taper or adaptor flange with disc spring package.

Different driver heads with interchangeable driver pins and hydraulic compensation system.

Rigid and axial adjustable spring loaded centres.

Max. workpiece weight: 500 kg

With intensified disc spring package: 1000 kg



CoK

Power-operated Face driver. For machining workpieces which are highly unbalanced, very heavy, for high chip removal or for irregular cutting, e.g. square billets, forged gear components etc. High precision concentricity by virtue of the solid centre even in permanent hard use. Longitudinal workpiece stop provided in centering.

Precise tripping to workpiece centre, particularly advantageous for consecutive machining, e.g. plunge-cut grinding etc.

CoK Type 690-00:

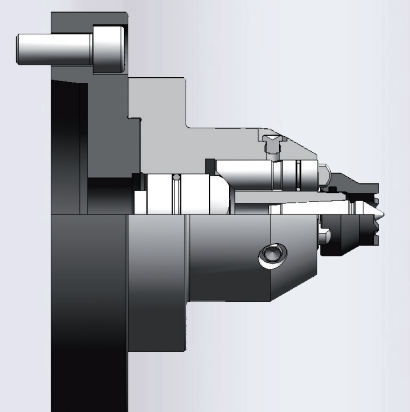
Clamping-Ø 8-80 mm mechanical compensation, slip-on driving discs

CoK Typ 690-50:

Clamping-Ø 50-250 mm mechanical compensation, slip-on driving discs

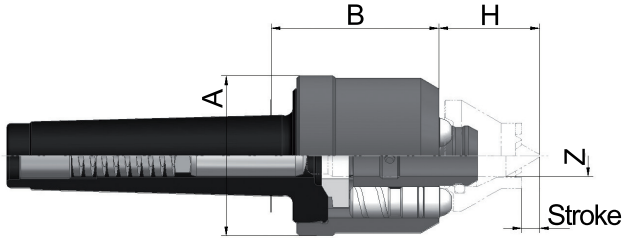
CoK Driving heads Type 689:

Clamping-Ø 63-160 mm hydraulic compensation, interchangeable driving pins



For rational turning of workpieces on their entire length without reclamping with high precision.

Developed according to the modular system, therefore universal exchange of driving discs and centres possible. One set consists of one basic body, one driving disc and suitable centre. Easy to maintain



Technical features:

- mechanic pressure compensation provides a uniform clamping force also on uneven faces of workpieces
- the spring loaded centre provides a longitudinal workpiece stop on the front side
- workpiece weight max. 100 kg
- Clamping circuit \varnothing 8-80 mm
- approx. value for an axially admitted total load of the 3 supporting pistons: 900 daN

Customer advantage:

- face driver for turning and milling
- compensating driving plates with radial freedom of movement
- easy mechanical compensation of the driving plates
- stable and consistent length stop
- high concentricity



Visit our new YouTube channel and take a look at the product video CoE.

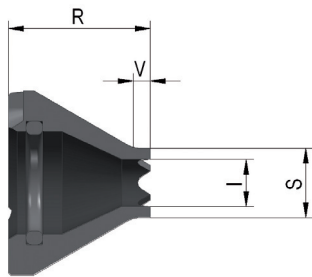
Tool group A14
Type 684-90 **Basic body CoE**
with **morsetaper**
(all basic bodies without centre)
mechanical

| Item no. | MT | A | B | H | Z | Stroke | Centres | Weight approx. g |
|----------|----|----|----|-----------------|----|--------|---------|------------------|
| 310065 | 3 | 62 | 65 | max. 38 min. 26 | 16 | 10 | | 1800 |
| 310066 | 4 | 62 | 65 | max. 38 min. 26 | 16 | 10 | | 1900 |
| 310068 | 5 | 62 | 65 | max. 38 min. 26 | 16 | 10 | | 2000 |

¹⁾ Mounting with short taper and centering diameter on request

Accessories CoE

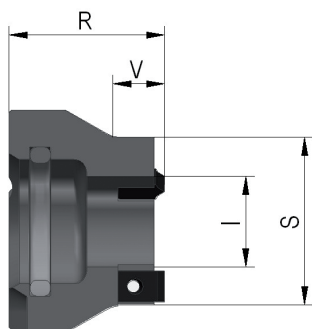
Tool group A14
Type 684-30 **Driving discs**, toothed
right- **and** left-hand rotation, free from play



| Item no. | Clamping circuit \varnothing S | Approx. turning range | l | R | V | Matching center point \varnothing Y | Weight approx. g |
|----------|----------------------------------|-----------------------|-----|----|----|---------------------------------------|------------------|
| 1209000 | 8 | 9-16 | 4,5 | 38 | 4 | 4 | 120 |
| 1209001 | 10 | 11-20 | 4,5 | 38 | 4 | 4 | 120 |
| 1209002 | 12 | 13-24 | 7 | 36 | 4 | 6 | 120 |
| 1209003 | 16 | 17-32 | 11 | 33 | 4 | 10 | 120 |
| 1209004 | 20 | 21-40 | 13 | 30 | 4 | 12 | 120 |
| 1209005 | 25 | 26-50 | 17 | 30 | 8 | 16 | 130 |
| 1209006 | 32 | 33-64 | 22 | 30 | 10 | 16 | 160 |

Driving discs with carbide toothing on request

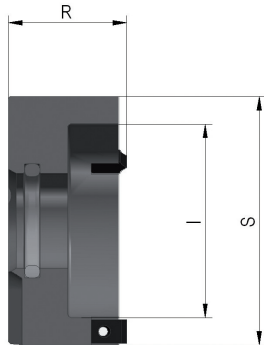
Tool group A14
Type 684-31 **Driving discs**,
with interchangeable hard metal driving plates 6 x 3,2
right- **and** left-hand rotation



| Item no. | Clamping circuit \varnothing S | Approx. turning range | l | R | V | Matching center point \varnothing Y | Weight approx. g |
|----------|----------------------------------|-----------------------|------|----|----|---------------------------------------|------------------|
| 1209007 | 20 | 21-40 | 7 | 30 | 8 | 6 | 125 |
| 1209008 | 25 | 26-50 | 11 | 30 | 8 | 10 | 140 |
| 1209009 | 32 | 33-64 | 17,5 | 30 | 10 | 16 | 160 |
| 1209010 | 40 | 41-80 | 27 | 30 | 16 | 16 | 180 |

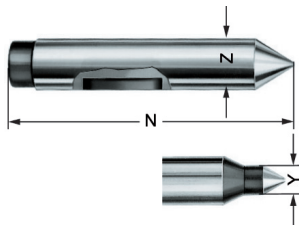
Accessories CoE

Tool group A14
Type 684-31 **Driving discs**,
with interchangeable hard metal driving plates 6 x 3,2
which can be used on 4 sides
right- **and** left-hand rotation, free from play



| Item no. | Clamping circuit Ø S | Approx. turning range | I | R | Matching center point ØY | Weight approx. g |
|---|----------------------|-----------------------|----|----|--------------------------|------------------|
| 1209011 ■ | 50 | 51-100 | 36 | 30 | 16 | 260 |
| 1209012 ■ | 63 | 64-126 | 49 | 30 | 16 | 420 |
| 1209013 ■ | 80 | 81-160 | 66 | 30 | 16 | 680 |

Tool group A14
Type 684-40 **Centres**, CoE



| Item no. | Clamping circuit Ø | N | Y | Z | Weight approx. g |
|---|--------------------|----|----|----|------------------|
| 1209016 ■ | 8-10 | 90 | 4 | 16 | 110 |
| 1209017 ■ | 12 | 90 | 6 | 16 | 110 |
| 1209018 ■ | 16 | 90 | 10 | 16 | 110 |
| 1209019 ■ | 20 | 90 | 12 | 16 | 110 |
| 1209020 ■ | 25-80 | 90 | 16 | 16 | 120 |

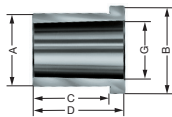
Centres with head on request

Tool group A14
Type 680-93 **Hard metal driving plates**
right- **and** left-hand rotation



| Item no. | Size | Clamping circuit Ø | Weight approx. g |
|---|-------|--------------------|------------------|
| 088970 ● | 6x3,2 | 20-32 | 2 |

Tool group A14
Type 680-72 **Mounting sleeve**
for the clamping of a face driver in lathe chuck



| Item no. | MT inside | A | B | C | D | G | Weight approx. g |
|---|-----------|----|----|----|----|--------|------------------|
| 085033 ● | 3 | 31 | 39 | 32 | 40 | 23,825 | 150 |
| 085034 ● | 4 | 39 | 47 | 42 | 50 | 31,267 | 250 |
| 085035 ● | 5 | 54 | 62 | 52 | 60 | 44,399 | 480 |

CoE - Assortments

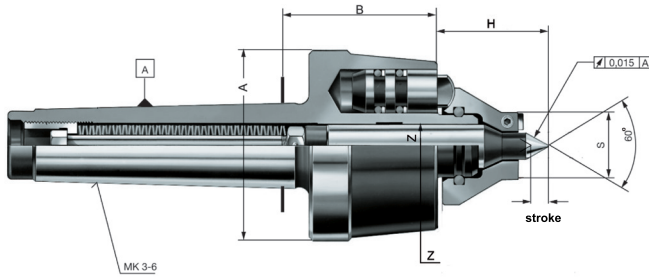
Tool group A14
Type 684-31 **CoE-Small assortment** in wooden box
mechanical, clamping dia. 12-50 mm, turning range 13-100 mm

Included in delivery:

- 1x Basic body
- 4x Driving discs (clamping-Ø 12, 20, 32, 50)
- 3x Centres (center-Ø 6, 12, 16)



| Item no. | MT | Weight approx. g |
|--|----|------------------|
| 1209048 ● | 3 | 3600 |
| 1209049 ● | 4 | 3870 |
| 1209050 ● | 5 | 4550 |



For rational turning of workpieces on their entire length without reclamping with high precision.

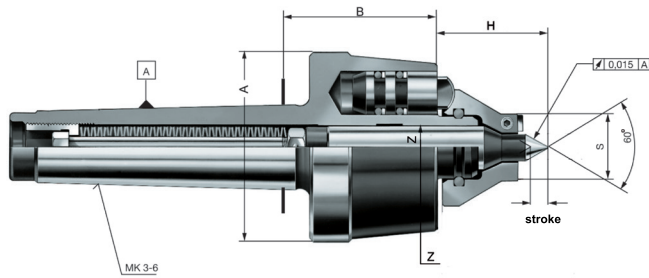
Developed according to the modular system, therefore universal exchange of driving discs and centres possible. One set consists of one basic body, one driving disc and suitable centre.

Technical features:

- hydraulic pressure compensation provides a uniform clamping force also on uneven faces of workpieces
- the spring loaded centre provides a longitudinal workpiece stop on the front side
- workpiece weight max. 100 kg
- approx. value for an axially admitted total load of the 3 supporting pistons: 2000 daN

Tool group A14
Type 680-50 **Basic body**
with **morsetaper** (basic bodies without centre) CoA
hydraulic

| Item no. | MT | A | B | H | Z | Stroke Centres | Weight approx. g |
|----------|----|----|------|-----------------|----|----------------|------------------|
| 088173 ● | 3 | 70 | 54 | max. 45 min. 26 | 16 | 10 | 1600 |
| 088174 ● | 4 | 70 | 56,5 | max. 45 min. 26 | 16 | 15 | 1800 |
| 088175 ● | 5 | 70 | 56,5 | max. 45 min. 26 | 16 | 15 | 2800 |
| 088176 ▲ | 6 | 70 | 56,5 | max. 45 min. 26 | 16 | 15 | 4400 |



For rational turning of workpieces on their entire length without reclamping with high precision.

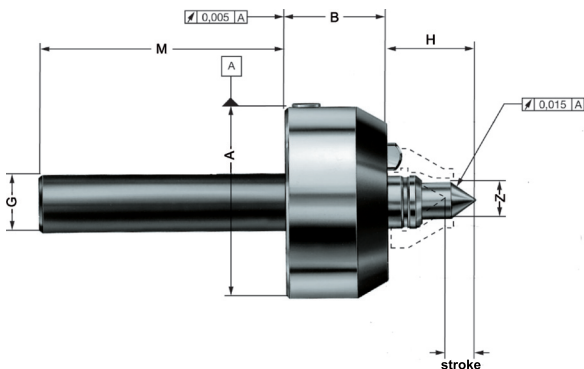
Developed according to the modular system, therefore universal exchange of driving discs and centres possible. One set consists of one basic body, one driving disc and suitable centre.

Technical features:

- hydraulic pressure compensation provides a uniform clamping force also on uneven faces of workpieces
- the spring loaded centre provides a longitudinal workpiece stop on the front side
- workpiece weight max. 100 kg
- approx. value for an axially admitted total load of the 3 supporting pistons: 2000 daN

Tool group A14
Type 680-55 **Basic body**
with **morsetaper**,
with **draw-offnut**, CoA
hydraulic

| Item no. | MT | A | B | H | Z | Stroke Centres | Weight approx. g |
|----------|----|----|------|-----------------|----|----------------|------------------|
| 088177 ▲ | 3 | 70 | 54 | max. 45 min. 26 | 16 | 10 | 1800 |
| 088178 ● | 4 | 70 | 56,5 | max. 45 min. 26 | 16 | 15 | 2200 |
| 088179 ● | 5 | 70 | 56,5 | max. 45 min. 26 | 16 | 15 | 3000 |
| 088180 ● | 6 | 70 | 56,5 | max. 45 min. 26 | 16 | 15 | 4600 |



For rational turning of workpieces on their entire length without reclamping with high precision.

For clamping in lathe chucks with unstepped jaws

Developed according to the modular system, therefore universal exchange of driving discs and centres possible. One set consists of one basic body, one driving disc and suitable centre.

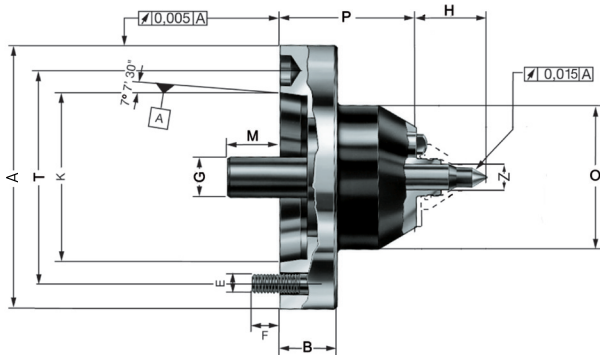
Technical features:

- hydraulic or mechanical pressure compensation provides a uniform clamping force also on uneven faces of workpieces
- the spring loaded centre provides a longitudinal workpiece stop on the front side
- workpiece weight max. 100 kg

Tool group A14
Type 680-65 **Basic body**
for clamping in lathe chucks,
with **springset**, CoA
mechanical / hydraulic

| Item no. | A | B | G | H | M | Z | Stroke Centres | Weight approx. g |
|------------------------|----|----|----|-----------------|-----|----|----------------|------------------|
| 088074 ¹⁾ ● | 85 | 45 | 25 | max. 45 min. 26 | 110 | 16 | 15 | 2300 |
| 313085 ²⁾ ▲ | 85 | 45 | 25 | max. 45 min. 26 | 110 | 16 | 15 | 2300 |

¹⁾ with hydraulic compensation
²⁾ with mechanical compensation



For rational turning of workpieces on their entire length without reclamping with high precision.

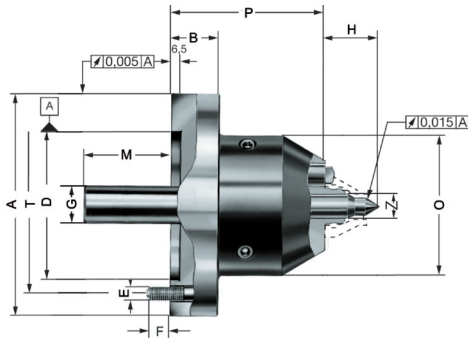
Developed according to the modular system, therefore universal exchange of driving discs and centres possible. One set consists of one basic body, one driving disc and suitable centre.

Technical features:

- mechanic pressure compensation provides a uniform clamping force also on uneven faces of workpieces
- the spring loaded centre provides a longitudinal workpiece stop on the front side
- workpiece weight max. 100 kg

Tool group A14
Type 681-85 **Basic body**
with **short taper ISO 702-1**
(DIN 55026)
mechanical compensation,
with **spring set, CoA**
mechanical

| Item no. | Taper | A | B | E | F | G | H | K | M | O | P | T | Z | Stroke Centres | Weight approx. g |
|----------|-------|-----|----|------|----|----|-----------------|---------|----|----|----|-------|----|----------------|------------------|
| 313905 | 5 | 133 | - | M 10 | 15 | 25 | max. 45 min. 26 | 82,563 | 32 | 90 | 86 | 104,8 | 16 | 11 | 6500 |
| 313906 | 6 | 165 | 35 | M 12 | 18 | 25 | max. 45 min. 26 | 106,375 | 32 | 90 | 86 | 133,4 | 16 | 11 | 7000 |
| 313907 | 8 | 210 | 40 | M 16 | 23 | 25 | max. 45 min. 26 | 139,719 | 32 | 90 | 86 | 171,4 | 16 | 11 | 8100 |



For rational turning of workpieces on their entire length without reclamping with high precision.

Developed according to the modular system, therefore universal exchange of driving discs and centres possible. One set consists of one basic body, one driving disc and suitable centre.

Technical features:

- hydraulic respectively mechanical pressure compensation provides a uniform clamping force also on uneven faces of workpieces
- the spring loaded centre provides a longitudinal workpiece stop on the front side
- workpiece weight max. 100 kg

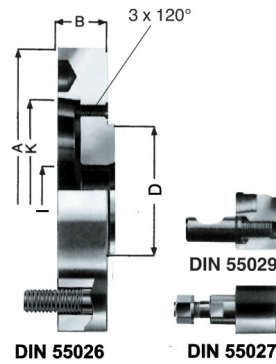
Tool group A14
Type 680-60 **Basic body flange**
type, with springset, CoA
mechanical / hydraulic

| Item no. | A | B | D | E | F | G | H | M | O | P | T | Z | Stroke Centres | Weight approx. g |
|----------------------|-----|----|-----|------|----|----|-----------------|----|----|----|-----|----|----------------|------------------|
| 088046 ¹⁾ | 142 | 30 | 100 | M 10 | 15 | 25 | max. 45 min. 26 | 61 | 90 | 98 | 120 | 16 | 15 | 7300 |
| 313910 ²⁾ | 142 | 30 | 100 | M 10 | 15 | 25 | max. 45 min. 26 | 61 | 90 | 98 | 120 | 16 | 15 | 7300 |

¹⁾ with hydraulic compensation
²⁾ with mechanical compensation

Adapter plate CoA

Constant Face Drivers CoA

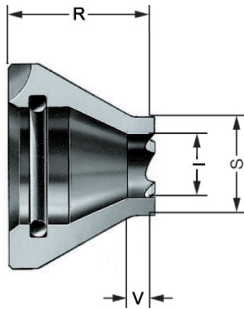


Tool group A14
Type 688-87 Adapter plate
short taper
without spring set

| Item no. | Design | Taper | A | B | D | I | K | Weight approx. g |
|----------|-----------|-------|-----|----|-----|----|---------|------------------|
| 088485 ■ | DIN 55026 | 5 | 140 | 30 | 100 | 38 | 82,563 | 3100 |
| 088486 ■ | DIN 55026 | 6 | 167 | 35 | 100 | 38 | 106,39 | 4800 |
| 088487 ● | DIN 55026 | 8 | 216 | 40 | 100 | 38 | 139,735 | 8700 |
| 088488 ■ | DIN 55026 | 11 | 280 | 45 | 100 | 38 | 196,885 | 17000 |
| 088480 ▲ | DIN 55027 | 5 | 140 | 30 | 100 | 38 | 82,563 | 3100 |
| 088481 ▲ | DIN 55027 | 6 | 167 | 35 | 100 | 38 | 106,39 | 4800 |
| 088482 ▲ | DIN 55027 | 8 | 216 | 40 | 100 | 38 | 139,735 | 8700 |
| 088483 ▲ | DIN 55027 | 11 | 280 | 45 | 100 | 38 | 196,885 | 17000 |
| 088495 ▲ | DIN 55029 | 5 | 140 | 30 | 100 | 38 | 82,563 | 3100 |
| 088496 ▲ | DIN 55029 | 6 | 167 | 35 | 100 | 38 | 106,39 | 4800 |
| 088497 ▲ | DIN 55029 | 8 | 216 | 40 | 100 | 38 | 139,735 | 8700 |
| 088498 ▲ | DIN 55029 | 11 | 280 | 45 | 100 | 38 | 196,885 | 17000 |

Accessories CoA

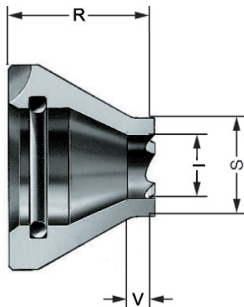
Tool group A14
Type 680-10 **Driving discs**, toothed
right-hand rotation



| Item no. | Clamping circuit Ø S | Approx. turning range | l | R | V | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|-----|----|----|--------------------------|------------------|
| 088061 ● | 8 | 9-16 | 4,5 | 38 | 4 | 4 | 120 |
| 088062 ● | 10 | 11-20 | 4,5 | 38 | 4 | 4 | 120 |
| 088063 ● | 12 | 13-24 | 7 | 36 | 4 | 6 | 120 |
| 088064 ● | 16 | 17-32 | 11 | 33 | 4 | 10 | 120 |
| 088065 ● | 20 | 21-40 | 13 | 30 | 4 | 12 | 120 |
| 088066 ● | 25 | 26-50 | 17 | 30 | 8 | 16 | 150 |
| 088067 ● | 32 | 33-64 | 22 | 30 | 10 | 16 | 190 |

Driving discs with carbide tothing, friction lining or diamant granulation on request

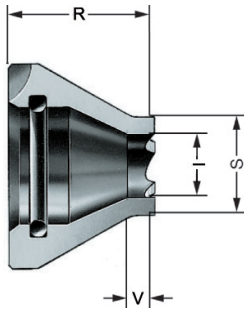
Tool group A14
Type 680-20 **Driving discs**, toothed
left-hand rotation



| Item no. | Clamping circuit Ø S | Approx. turning range | l | R | V | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|-----|----|----|--------------------------|------------------|
| 088081 ● | 8 | 9-16 | 4,5 | 38 | 4 | 4 | 120 |
| 088082 ● | 10 | 11-20 | 4,5 | 38 | 4 | 4 | 120 |
| 088083 ● | 12 | 13-24 | 7 | 36 | 4 | 6 | 120 |
| 088084 ● | 16 | 17-32 | 11 | 33 | 4 | 10 | 120 |
| 088085 ● | 20 | 21-40 | 13 | 30 | 4 | 12 | 120 |
| 088086 ● | 25 | 26-50 | 17 | 30 | 8 | 16 | 150 |
| 088087 ● | 32 | 33-64 | 22 | 30 | 10 | 16 | 190 |

Driving discs with carbide tothing on request

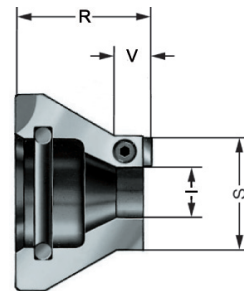
Tool group A14
Type 680-30 **Driving discs**, toothed
right- and left-hand rotation



| Item no. | Clamping circuit Ø S | Approx. turning range | l | R | V | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|-----|----|---|--------------------------|------------------|
| 088541 ● | 8 | 9-16 | 4,5 | 38 | 4 | 4 | 120 |
| 088542 ● | 10 | 11-20 | 4,5 | 38 | 4 | 4 | 120 |
| 088543 ● | 12 | 13-24 | 7 | 36 | 4 | 6 | 120 |
| 088544 ● | 16 | 17-32 | 11 | 33 | 4 | 10 | 120 |

Driving discs with carbide tothing on request

Tool group A14
Type 680-11 **Driving discs**,
with interchangeable hard metal driving plates 6 x 3,2
right-hand rotation

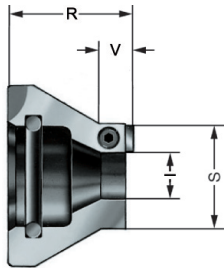


| Item no. | Clamping circuit Ø S | Approx. turning range | l | R | V | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|------|----|----|--------------------------|------------------|
| 089065 ● | 20 H | 21-40 | 7 | 30 | 5 | 6 | 125 |
| 089066 ● | 25 H | 26-50 | 11 | 30 | 8 | 10 | 140 |
| 089067 ● | 32 H | 33-64 | 17,5 | 30 | 10 | 16 | 200 |

Accessories CoA

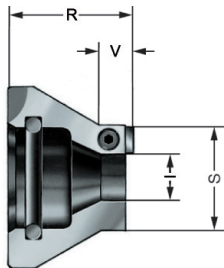
Accessories
Face Drivers CoA

Tool group A14
Type 680-21 **Driving discs**,
with interchangeable hard metal driving plates 6 x 3,2
left-hand rotation



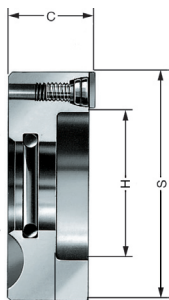
| Item no. | Clamping circuit Ø S | Approx. turning range | I | R | V | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|------|----|----|--------------------------|------------------|
| 089085 ● | 20 H | 21-40 | 7 | 30 | 5 | 6 | 125 |
| 089086 ● | 25 H | 26-50 | 11 | 30 | 8 | 10 | 140 |
| 089087 ● | 32 H | 33-64 | 17,5 | 30 | 10 | 16 | 200 |

Tool group A14
Type 680-31 **Driving discs**,
with interchangeable hard metal driving plates 6 x 3,2
right- and left-hand rotation



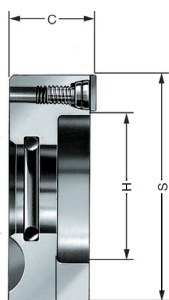
| Item no. | Clamping circuit Ø S | Approx. turning range | I | R | V | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|------|----|----|--------------------------|------------------|
| 088545 ● | 20 H | 21-40 | 7 | 30 | 5 | 6 | 125 |
| 088546 ● | 25 H | 26-50 | 11 | 30 | 8 | 10 | 140 |
| 088547 ● | 32 H | 33-64 | 17,5 | 30 | 10 | 16 | 200 |

Tool group A14
Type 680-12 **Driving discs**,
with interchangeable hard metal driving plates 6 x 3,2
which can be used on 4 sides
right-hand rotation



| Item no. | Clamping circuit Ø S | Approx. turning range | H | C | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|----|----|--------------------------|------------------|
| 088068 ● | 40 | 41-80 | 20 | 24 | 16 | 200 |
| 088069 ● | 50 | 51-100 | 28 | 24 | 16 | 240 |
| 088070 ● | 63 | 64-126 | 41 | 24 | 16 | 400 |
| 088071 ● | 80 | 81-160 | 58 | 24 | 16 | 600 |

Tool group A14
Type 680-22 **Driving discs**,
with interchangeable hard metal driving plates 6 x 3,2
which can be used on 4 sides
left-hand rotation

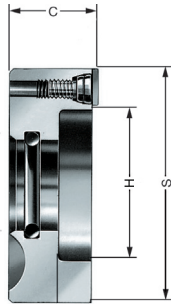


| Item no. | Clamping circuit Ø S | Approx. turning range | H | C | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|----|----|--------------------------|------------------|
| 088088 ● | 40 | 41-80 | 20 | 24 | 16 | 200 |
| 088089 ● | 50 | 51-100 | 28 | 24 | 16 | 240 |
| 088090 ● | 63 | 64-126 | 41 | 24 | 16 | 400 |
| 088091 ● | 80 | 81-160 | 58 | 24 | 16 | 600 |

Accessories CoA

Tool group A14

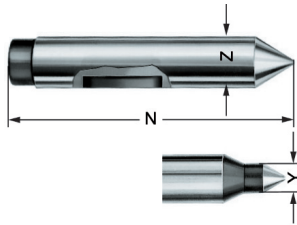
Type 680-32 **Driving discs**,
with interchangeable hard metal driving plates 6 x 3,2
which can be used on 4 sides
right- **and** left-hand rotation



| Item no. | Clamping circuit Ø S | Approx. turning range | H | C | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|----|----|--------------------------|------------------|
| 088548 ● | 40 | 41-80 | 20 | 24 | 16 | 200 |
| 088549 ● | 50 | 51-100 | 28 | 24 | 16 | 240 |
| 088550 ● | 63 | 64-126 | 41 | 24 | 16 | 400 |
| 088551 ● | 80 | 81-160 | 58 | 24 | 16 | 600 |

Tool group A14

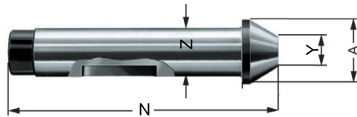
Type 680-40 **Centres**, CoA



| Item no. | Clamping circuit Ø | N | Y | Z | Weight approx. g |
|----------|--------------------|-----|----|----|------------------|
| 088351 ● | 8-10 | 90 | 4 | 16 | 110 |
| 088352 ● | 12 | 90 | 6 | 16 | 110 |
| 088353 ● | 16 | 90 | 10 | 16 | 110 |
| 088354 ● | 20 | 90 | 12 | 16 | 110 |
| 088355 ● | 25-80 | 90 | 16 | 16 | 120 |
| 086758 ● | 25-80 | 110 | 16 | 16 | 150 |

Tool group A14

Type 680-45, **Centres with head**, CoA



| Item no. | Taper Ø A | Y | N | Z | Weight approx. g |
|----------|-----------|----|----|----|------------------|
| 086619 ● | 21 | 10 | 90 | 16 | 136 |
| 086620 ● | 27 | 16 | 90 | 16 | 153 |
| 688878 ● | 34 | 23 | 90 | 16 | 190 |
| 086621 ● | 40 | 29 | 90 | 16 | 210 |
| 688880 ● | 48 | 37 | 90 | 16 | 250 |
| 086622 ● | 56 | 45 | 90 | 16 | 312 |

Tool group A14

Type 680-90 **Hard metal driving plates**
right- **or** left-hand rotation



| Item no. | Size | Clamping circuit Ø | Weight approx. g |
|----------|---------|--------------------|------------------|
| 088810 ● | 6x3,2 | 20-32 | 2 |
| 088209 ● | 9,5x3,2 | 40-80 | 4 |

Tool group A14

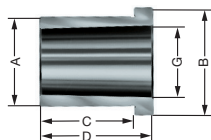
Type 680-93 **Hard metal driving plates**
right- **and** left-hand rotation



| Item no. | Size | Clamping circuit Ø | Weight approx. g |
|----------|---------|--------------------|------------------|
| 088970 ● | 6x3,2 | 20-32 | 2 |
| 087931 ● | 9,5x3,2 | 40-80 | 4 |

Tool group A14

Type 680-72 **Mounting sleeve**
for the clamping of a face driver in lathe chuck



| Item no. | MT inside | A | B | C | D | G | Weight approx. g |
|----------|-----------|----|----|----|----|--------|------------------|
| 085033 ● | 3 | 31 | 39 | 32 | 40 | 23,825 | 150 |
| 085034 ● | 4 | 39 | 47 | 42 | 50 | 31,267 | 250 |
| 085035 ● | 5 | 54 | 62 | 52 | 60 | 44,399 | 480 |
| 085036 ■ | 6 | 75 | 83 | 62 | 70 | 63,448 | 1050 |

Accessories CoA

Accessories
Face Drivers CoA

Tool group C15
Type 0167-Y
Threaded pin



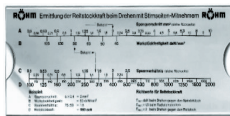
| Item no. | Size | Clamping circuit Ø | Weight approx. g |
|----------|---------|--------------------|------------------|
| 234695 ● | M 4 x 6 | 20 | 1 |
| 048205 ● | M 5 x 8 | 25+32 | 1 |
| 088205 ● | M 5 x 8 | 40-80 | 2 |

Tool group C15
Type 5191-Y
O-ring



| Item no. | Size |
|----------|------------|
| 006252 ● | 21,82x3,53 |

Tool group A14
Type 680
RÖHM slide rule to calculate axial tailstock loading



| Item no. | Weight approx. g |
|----------|------------------|
| 088230 ● | 35 |

CoA - Assortments

Tool group A14
Type 680 **Basic equipment** in a carton
hydraulic, clamping dia. 12 + 32 mm, turning range 13-64 mm



| Item no. | MT | right-hand rotation | left-hand rotation | with draw-off nut | Weight approx. g |
|----------|----|---------------------|--------------------|-------------------|------------------|
| 088553 ● | 3 | • | | | 2100 |
| 088557 ■ | 3 | • | | • | 2400 |
| 088573 ■ | 3 | | • | | 2100 |
| 088577 ■ | 3 | | • | • | 2400 |
| 088554 ● | 4 | • | | | 2400 |
| 088558 ▲ | 4 | • | | • | 2700 |
| 088574 ▲ | 4 | | • | | 2400 |
| 088578 ▲ | 4 | | • | • | 2700 |
| 088555 ● | 5 | • | | | 3300 |
| 088559 ▲ | 5 | • | | • | 3600 |
| 088575 ▲ | 5 | | • | | 3300 |
| 088579 ▲ | 5 | | • | • | 3600 |
| 088556 ▲ | 6 | • | | | 4900 |
| 088560 ▲ | 6 | • | | • | 5200 |
| 088576 ▲ | 6 | | • | | 4900 |
| 088580 ▲ | 6 | | • | • | 5200 |

Tool group A14
Type 680 **Small assortment** in wooden box
hydraulic, clamping dia. 12-50 mm, turning range 13-100 mm



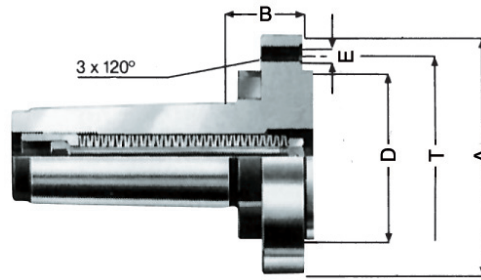
| Item no. | MT | right-hand rotation | left-hand rotation | with draw-off nut | Weight approx. g |
|----------|----|---------------------|--------------------|-------------------|------------------|
| 088501 ● | 3 | • | | | 3900 |
| 088511 ■ | 3 | • | | • | 4200 |
| 088521 ■ | 3 | | • | | 3900 |
| 088531 ▲ | 3 | | • | • | 4200 |
| 088502 ● | 4 | • | | | 4300 |
| 088512 ▲ | 4 | • | | • | 4600 |
| 088522 ■ | 4 | | • | | 4300 |
| 088532 ▲ | 4 | | • | • | 4600 |
| 088503 ● | 5 | • | | | 4900 |
| 088513 ▲ | 5 | • | | • | 5200 |
| 088523 ▲ | 5 | | • | | 4900 |
| 088533 ▲ | 5 | | • | • | 5200 |
| 088504 ● | 6 | • | | | 6600 |
| 088514 ▲ | 6 | • | | • | 6800 |
| 088524 ▲ | 6 | | • | | 6600 |
| 088534 ▲ | 6 | | • | • | 6800 |

Tool group A14
Type 680 **Large assortment** in wooden box
hydraulic, clamping dia. 10-80 mm, turning range 11-160 mm



| Item no. | MT | right-hand rotation | left-hand rotation | with draw-off nut | Weight approx. g |
|----------|----|---------------------|--------------------|-------------------|------------------|
| 088218 ■ | 3 | • | | | 5600 |
| 088223 ■ | 3 | | • | | 5600 |
| 088233 ■ | 3 | • | | • | 5900 |
| 088238 ■ | 3 | | • | • | 5900 |
| 088219 ▲ | 4 | • | | | 6000 |
| 088224 ▲ | 4 | | • | | 6000 |
| 088234 ● | 4 | • | | • | 6300 |
| 088239 ▲ | 4 | | • | • | 6300 |
| 088220 ▲ | 5 | • | | | 6600 |
| 088225 ▲ | 5 | | • | | 6600 |
| 088235 ▲ | 5 | • | | • | 6900 |
| 088240 ▲ | 5 | | • | • | 6900 |
| 088221 ▲ | 6 | • | | | 8300 |
| 088226 ▲ | 6 | | • | | 8300 |
| 088236 ▲ | 6 | • | | • | 8500 |
| 088241 ▲ | 6 | | • | • | 8500 |

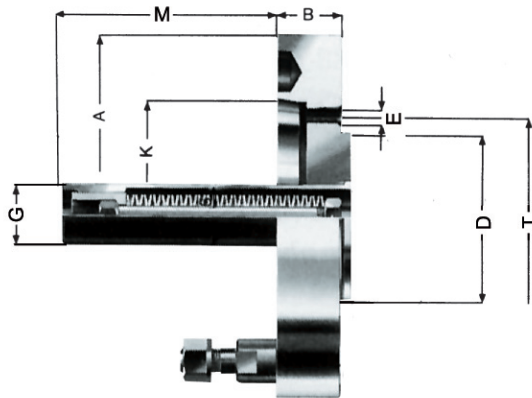
CoM



Tool group A14
Type 688 Basic body
with morse taper
and draw-off nut
mechanical / hydraulic

| Item no. | MT | A | B | D | E | T | Weight approx. g |
|----------|----|-----|----|-----|------|-----|------------------|
| 088295 | 5 | 140 | 45 | 100 | M 10 | 120 | 5800 |
| 088296 | 6 | 140 | 45 | 100 | M 10 | 120 | 7480 |

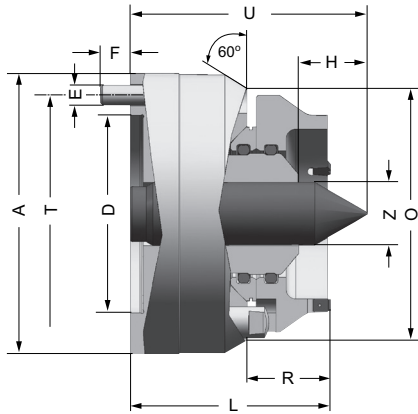
Adapter plate CoM



Tool group A14
Type 688 Adapter plate short
taper with spring set

| Item no. | Taper | Design | A | B | D | E | G | K | M | T | Weight approx. g |
|----------|-------|-----------|-----|----|-----|------|------|---------|-----|-----|------------------|
| 088331 | 5 | DIN 55026 | 140 | 30 | 100 | M 10 | 37,5 | 82,563 | 144 | 120 | 4500 |
| 088332 | 6 | DIN 55026 | 165 | 35 | 100 | M 10 | 37,5 | 106,39 | 139 | 120 | 7000 |
| 088333 | 8 | DIN 55026 | 216 | 40 | 100 | M 10 | 37,5 | 139,735 | 134 | 120 | 11500 |
| 088334 | 11 | DIN 55026 | 280 | 45 | 100 | M 10 | 37,5 | 196,885 | 129 | 120 | 23000 |
| 088335 | 5 | DIN 55027 | 140 | 30 | 100 | M 10 | 37,5 | 82,563 | 144 | 120 | 5500 |
| 088336 | 6 | DIN 55027 | 165 | 35 | 100 | M 10 | 37,5 | 106,39 | 139 | 120 | 7000 |
| 088337 | 8 | DIN 55027 | 216 | 40 | 100 | M 10 | 37,5 | 139,735 | 134 | 120 | 11500 |
| 088338 | 11 | DIN 55027 | 280 | 45 | 100 | M 10 | 37,5 | 196,885 | 129 | 120 | 23000 |
| 088339 | 5 | DIN 55029 | 140 | 30 | 100 | M 10 | 37,5 | 82,563 | 144 | 120 | 4500 |
| 088340 | 6 | DIN 55029 | 165 | 35 | 100 | M 10 | 37,5 | 106,39 | 139 | 120 | 7000 |
| 088341 | 8 | DIN 55029 | 216 | 40 | 100 | M 10 | 37,5 | 139,735 | 134 | 120 | 11500 |
| 088342 | 11 | DIN 55029 | 280 | 45 | 100 | M 10 | 37,5 | 196,885 | 129 | 120 | 23000 |

Driving head CoM



For clamping large and heavy workpieces, even with extremely uneven faces.

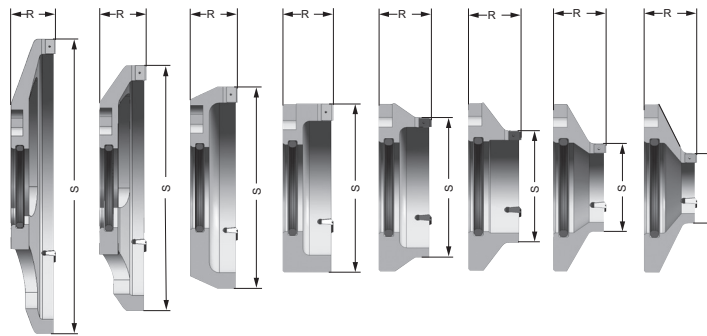
Technical features:

- spring loaded, rigid centre, axially adjustable
- basic body with morse taper or adapter plate with cup spring set
- workpiece weight max. 500 kg
- slip-on driving discs - clamping diameter 50-250 mm
- mechanical compensation

Tool group A14
Type 687 Face driving head
with cylindrical centre mount
mechanical

| Item no. | A | D | E | F | H | L | O | R | T | U | Z | Weight approx. g |
|----------|-----|-----|------|----|----|-----|-----|----|-----|-----|----|------------------|
| 689080 | 142 | 100 | M 10 | 15 | 35 | 102 | 128 | 38 | 120 | 120 | 32 | 7400 |

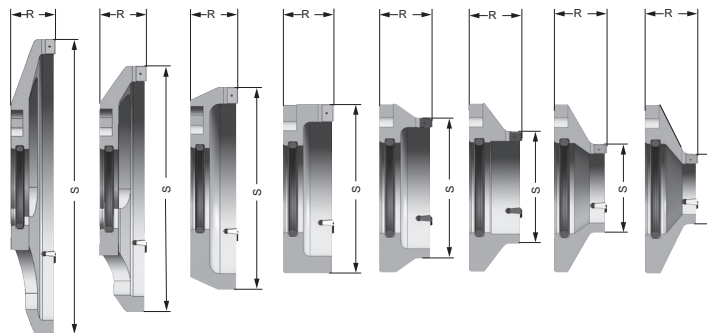
Driving discs CoM



Tool group A14
Type 687-13 **Driving discs**
with interchangeable hard metal
driving plates
right-hand rotation

| Item no. | Clamping circuit Ø S | R | Hard metal driving plate | Weight approx. g |
|----------------------|----------------------|----|--------------------------|------------------|
| 689461 | 50 | 48 | 6 x 5T | 1400 |
| 689462 | 63 | 45 | 6 x 5T | 1500 |
| 689463 | 80 | 38 | 6 x 5T | 1500 |
| 689464 | 100 | 38 | 6 x 5T | 1400 |
| 689465 | 125 | 38 | 12 x 5T | 1800 |
| 689466 | 160 | 38 | 12 x 5T | 2500 |
| 689467 ¹⁾ | 200 | 38 | 12 x 5T | 2500 |
| 689468 ¹⁾ | 250 | 38 | 12 x 5T | 3200 |

¹⁾ Weight reduced



Tool group A14
Type 687-23 **Driving discs**
with interchangeable hard metal
driving plates
left-hand rotation

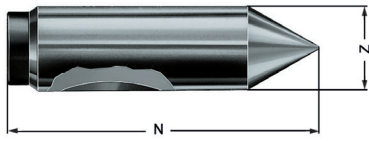
| Item no. | Clamping circuit Ø S | R | Hard metal driving plate | Weight approx. g |
|----------------------|----------------------|----|--------------------------|------------------|
| 689091 | 50 | 48 | 6 x 5T | 1400 |
| 689092 | 63 | 45 | 6 x 5T | 1500 |
| 689093 | 80 | 38 | 6 x 5T | 1500 |
| 689094 | 100 | 38 | 6 x 5T | 1400 |
| 689095 | 125 | 38 | 12 x 5T | 1800 |
| 689096 | 160 | 38 | 12 x 5T | 2500 |
| 689097 ¹⁾ | 200 | 38 | 12 x 5T | 2500 |
| 689098 ¹⁾ | 250 | 38 | 12 x 5T | 3200 |

¹⁾ Weight reduced

Accessories CoM

Accessories Face Drivers CoM

Tool group A14
Type 688-40 **Centres**



| Item no. | N | Z | Weight approx. g |
|----------|-----|----|------------------|
| 088292 ● | 120 | 32 | 620 |
| 088293 ● | 140 | 32 | 750 |

Tool group A14
Type 680-90 **Hard metal driving plates**
right- or left-hand rotation



| Item no. | Size | Weight approx. g |
|----------|----------|------------------|
| 312675 ● | 6 x 5 T | 3 |
| 312911 ● | 12 x 5 T | 6 |

Tool group C15
Type 0167-Y
Threaded pin



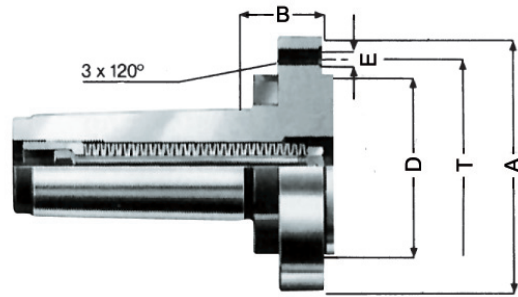
| Item no. | Size | Weight approx. g |
|----------|----------|------------------|
| 048205 ● | M 5 x 8 | 1 |
| 036461 ● | M 5 x 10 | 1 |

Tool group C15
Type 5191-Y
O-ring



| Item no. | Size |
|----------|------------|
| 006283 ■ | 59,69x5,33 |

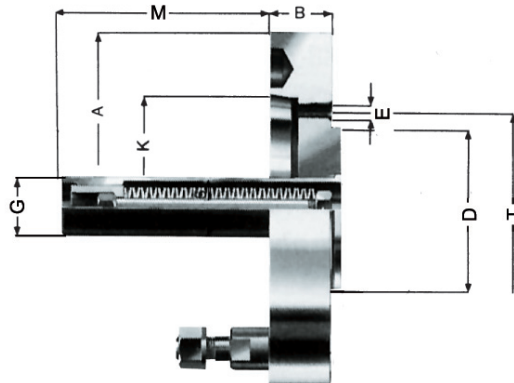
CoB



Tool group A14
Type 688 Basic body
with morse taper
and draw-off nut
mechanical / hydraulic

| Item no. | MT | A | B | D | E | T | Weight approx. g |
|----------|----|-----|----|-----|------|-----|------------------|
| 088295 ■ | 5 | 140 | 45 | 100 | M 10 | 120 | 5800 |
| 088296 ■ | 6 | 140 | 45 | 100 | M 10 | 120 | 7480 |

Adapter plate CoB

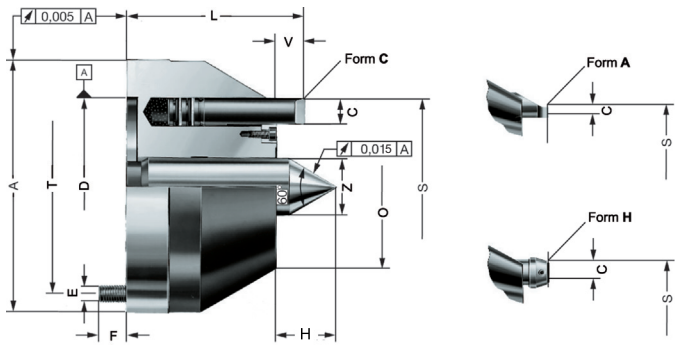


Tool group A14
Type 688 Adapter plate
short taper with spring set

| Item no. | Taper | Design | A | B | D | E | G | K | M | T | Weight approx. g |
|----------|-------|-----------|-----|----|-----|------|------|---------|-----|-----|------------------|
| 088331 ■ | 5 | DIN 55026 | 140 | 30 | 100 | M 10 | 37,5 | 82,563 | 144 | 120 | 4500 |
| 088332 ■ | 6 | DIN 55026 | 165 | 35 | 100 | M 10 | 37,5 | 106,39 | 139 | 120 | 7000 |
| 088333 ■ | 8 | DIN 55026 | 216 | 40 | 100 | M 10 | 37,5 | 139,735 | 134 | 120 | 11500 |
| 088334 ■ | 11 | DIN 55026 | 280 | 45 | 100 | M 10 | 37,5 | 196,885 | 129 | 120 | 23000 |
| 088335 ▲ | 5 | DIN 55027 | 140 | 30 | 100 | M 10 | 37,5 | 82,563 | 144 | 120 | 5500 |
| 088336 ▲ | 6 | DIN 55027 | 165 | 35 | 100 | M 10 | 37,5 | 106,39 | 139 | 120 | 7000 |
| 088337 ▲ | 8 | DIN 55027 | 216 | 40 | 100 | M 10 | 37,5 | 139,735 | 134 | 120 | 11500 |
| 088338 ▲ | 11 | DIN 55027 | 280 | 45 | 100 | M 10 | 37,5 | 196,885 | 129 | 120 | 23000 |
| 088339 ▲ | 5 | DIN 55029 | 140 | 30 | 100 | M 10 | 37,5 | 82,563 | 144 | 120 | 4500 |
| 088340 ▲ | 6 | DIN 55029 | 165 | 35 | 100 | M 10 | 37,5 | 106,39 | 139 | 120 | 7000 |
| 088341 ▲ | 8 | DIN 55029 | 216 | 40 | 100 | M 10 | 37,5 | 139,735 | 134 | 120 | 11500 |
| 088342 ▲ | 11 | DIN 55029 | 280 | 45 | 100 | M 10 | 37,5 | 196,885 | 129 | 120 | 23000 |

Driving heads CoB

Constant Face Drivers CoB



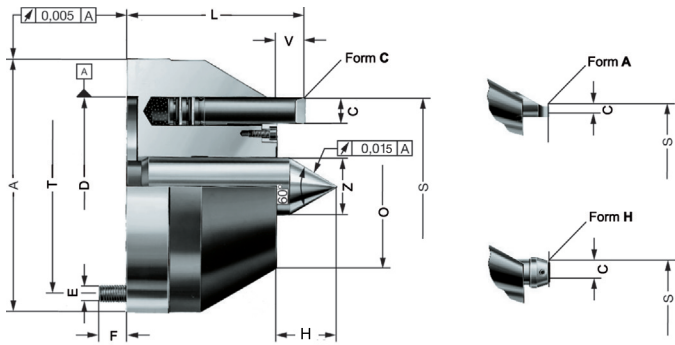
For clamping large and heavy workpieces, even with extremely uneven faces.
 With hydraulic compensation - interchangeable driving pins
 Workpiece weight with single layer disc spring package: 500 kg
 Workpiece weight with double layer disc spring package: 1000 kg

Technical features:

- bolt-on face driver heads with interchangeable driving pins
- driving pins can be changed to allow right-hand or left-hand rotation
- spring loaded, rigid centre, axially adjustable

Tool group A14
 Type 688-10 Face Driving Head
size 1 CoB;
 hydraulic
 right-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | H | L | O | T | V | Z | Pin | Weight approx. g |
|----------|----|-----------------------|-----|------|-----|------|----|-----------------|-----|----|-----|----|----|----------|------------------|
| 088301 | 63 | 65-125 | 142 | 6 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 72 | 120 | 16 | 25 | 6 x 16 A | 7000 |
| 088361 | 75 | 80-150 | 142 | 9,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 72 | 120 | 16 | 25 | 6 x 16 H | 7000 |
| 088302 | 80 | 82-160 | 142 | 14,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 72 | 120 | 16 | 25 | 6 x 16 C | 7000 |



For clamping large and heavy workpieces, even with extremely uneven faces.
 With hydraulic compensation - interchangeable driving pins
 Workpiece weight with single layer disc spring package: 500 kg
 Workpiece weight with double layer disc spring package: 1000 kg

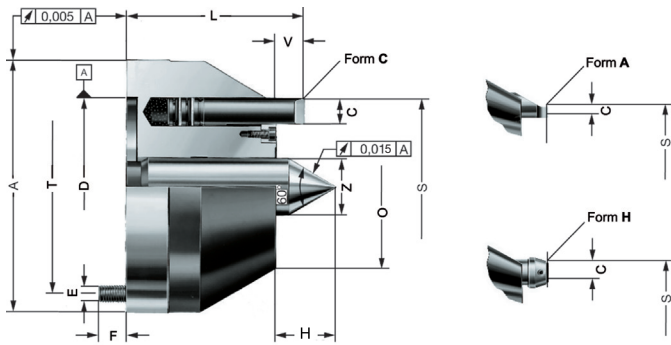
Technical features:

- bolt-on face driver heads with interchangeable driving pins
- driving pins can be changed to allow right-hand or left-hand rotation
- spring loaded, rigid centre, axially adjustable

Tool group A14
 Type 688-10 Face Driving Head
size 2 CoB;
 hydraulic
 right-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | H | L | O | T | V | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|-----------------|-----|----|-----|----|----|----------|------------------|
| 088303 | 83 | 85-165 | 142 | 6 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 92 | 120 | 16 | 32 | 6 x 16 A | 8200 |
| 088362 | 95 | 100-190 | 142 | 9,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 92 | 120 | 16 | 32 | 6 x 16 H | 8200 |
| 088304 | 100 | 102-200 | 142 | 14,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 92 | 120 | 16 | 32 | 6 x 16 C | 8200 |

Driving heads CoB

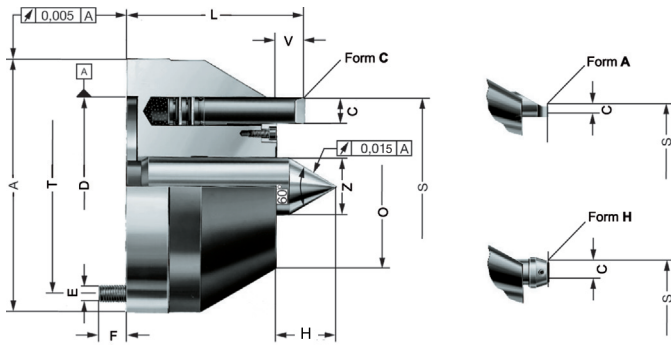


For clamping large and heavy workpieces, even with extremely uneven faces.
 With hydraulic compensation - interchangeable driving pins
 Workpiece weight with single layer disc spring package: 500 kg
 Workpiece weight with double layer disc spring package: 1000 kg

- Technical features:**
- bolt-on face driver heads with interchangeable driving pins
 - driving pins can be changed to allow right-hand or left-hand rotation
 - spring loaded, rigid centre, axially adjustable

Tool group A14
 Type 688-10 Face Driving Head
size 3 CoB;
hydraulic
right-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | H | L | O | T | V | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|-----------------|-----|-----|-----|----|----|----------|------------------|
| 088305 | 108 | 110-215 | 142 | 6 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 117 | 120 | 16 | 32 | 6 x 16 A | 9500 |
| 088363 | 120 | 125-240 | 142 | 9,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 117 | 120 | 16 | 32 | 6 x 16 H | 9500 |
| 088306 | 125 | 127-250 | 142 | 14,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 117 | 120 | 16 | 32 | 6 x 16 C | 9500 |



For clamping large and heavy workpieces, even with extremely uneven faces.
 With hydraulic compensation - interchangeable driving pins
 Workpiece weight with single layer disc spring package: 500 kg
 Workpiece weight with double layer disc spring package: 1000 kg

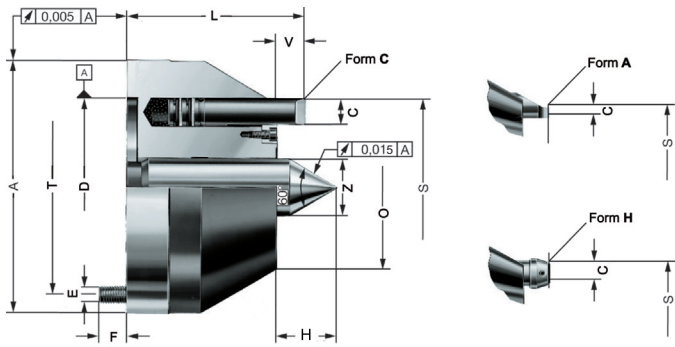
- Technical features:**
- bolt-on face driver heads with interchangeable driving pins
 - driving pins can be changed to allow right-hand or left-hand rotation
 - spring loaded, rigid centre, axially adjustable

Tool group A14
 Type 688-10 Face Driving Head
size 4 CoB;
hydraulic
right-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | H | L | O | T | V | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|-----------------|-----|-----|-----|----|----|----------|------------------|
| 088307 | 143 | 145-285 | 182 | 6 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 152 | 120 | 16 | 32 | 6 x 16 A | 16000 |
| 088364 | 155 | 160-310 | 182 | 9,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 152 | 120 | 16 | 32 | 6 x 16 H | 16000 |
| 088308 | 160 | 162-320 | 182 | 14,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 152 | 120 | 16 | 32 | 6 x 16 C | 16000 |

Driving heads CoB

Constant Face Drivers CoB



For clamping large and heavy workpieces, even with extremely uneven faces.

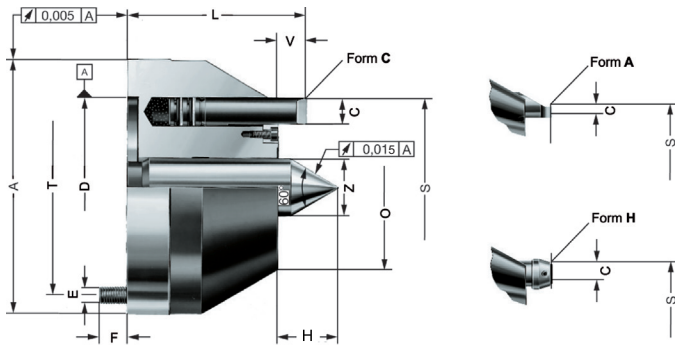
With hydraulic compensation - interchangeable driving pins
 Workpiece weight with single layer disc spring package: 500 kg
 Workpiece weight with double layer disc spring package: 1000 kg

Technical features:

- bolt-on face driver heads with interchangeable driving pins
- driving pins can be changed to allow right-hand or left-hand rotation
- spring loaded, rigid centre, axially adjustable

Tool group A14
 Type 688-20 Face Driving Head
 size 1 CoB;
 hydraulic
 left-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | H | L | O | T | V | Z | Pin | Weight approx. g |
|----------|----|-----------------------|-----|------|-----|------|----|-----------------|-----|----|-----|----|----|----------|------------------|
| 088321 | 63 | 65-125 | 142 | 6 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 72 | 120 | 16 | 25 | 6 x 16 A | 7000 |
| 088381 | 75 | 80-150 | 142 | 9,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 72 | 120 | 16 | 25 | 6 x 16 H | 7000 |
| 088322 | 80 | 82-160 | 142 | 14,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 72 | 120 | 16 | 25 | 6 x 16 C | 7000 |



For clamping large and heavy workpieces, even with extremely uneven faces.

With hydraulic compensation - interchangeable driving pins
 Workpiece weight with single layer disc spring package: 500 kg
 Workpiece weight with double layer disc spring package: 1000 kg

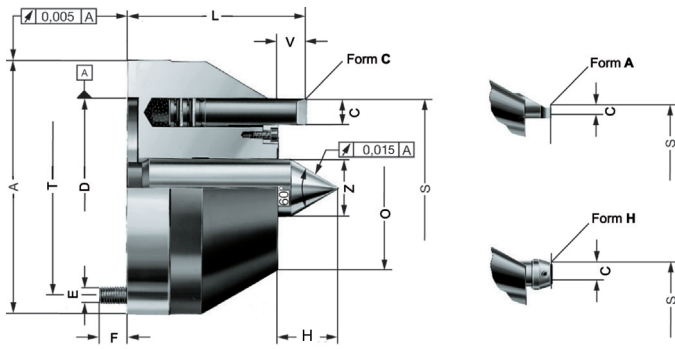
Technical features:

- bolt-on face driver heads with interchangeable driving pins
- driving pins can be changed to allow right-hand or left-hand rotation
- spring loaded, rigid centre, axially adjustable

Tool group A14
 Type 688-20 Face Driving Head
 size 2 CoB;
 hydraulic
 left-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | H | L | O | T | V | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|-----------------|-----|----|-----|----|----|----------|------------------|
| 088323 | 83 | 85-165 | 142 | 6 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 92 | 120 | 16 | 32 | 6 x 16 A | 8200 |
| 088382 | 95 | 100-190 | 142 | 9,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 92 | 120 | 16 | 32 | 6 x 16 H | 8200 |
| 088324 | 100 | 102-200 | 142 | 14,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 92 | 120 | 16 | 32 | 6 x 16 C | 8200 |

Driving heads CoB



For clamping large and heavy workpieces, even with extremely uneven faces.

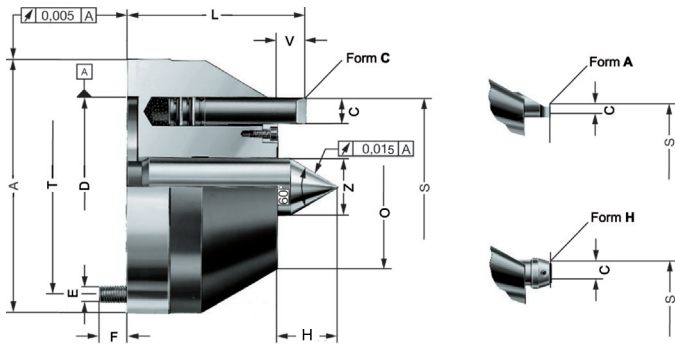
With hydraulic compensation - interchangeable driving pins
 Workpiece weight with single layer disc spring package: 500 kg
 Workpiece weight with double layer disc spring package: 1000 kg

Technical features:

- bolt-on face driver heads with interchangeable driving pins
- driving pins can be changed to allow right-hand or left-hand rotation
- spring loaded, rigid centre, axially adjustable

Tool group A14
 Type 688-20 Face Driving Head
size 3 CoB;
 hydraulic
 left-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | H | L | O | T | V | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|-----------------|-----|-----|-----|----|----|----------|------------------|
| 088325 | 108 | 110-215 | 142 | 6 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 117 | 120 | 16 | 32 | 6 x 16 A | 9500 |
| 088383 | 120 | 125-240 | 142 | 9,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 117 | 120 | 16 | 32 | 6 x 16 H | 9500 |
| 088326 | 125 | 127-250 | 142 | 14,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 117 | 120 | 16 | 32 | 6 x 16 C | 9500 |



For clamping large and heavy workpieces, even with extremely uneven faces.

With hydraulic compensation - interchangeable driving pins
 Workpiece weight with single layer disc spring package: 500 kg
 Workpiece weight with double layer disc spring package: 1000 kg

Technical features:

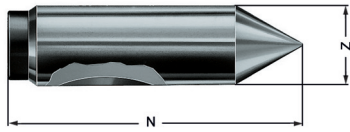
- bolt-on face driver heads with interchangeable driving pins
- driving pins can be changed to allow right-hand or left-hand rotation
- spring loaded, rigid centre, axially adjustable

Tool group A14
 Type 688-20 Face Driving Head
size 4 CoB;
 hydraulic
 left-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | H | L | O | T | V | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|-----------------|-----|-----|-----|----|----|----------|------------------|
| 088327 | 143 | 145-285 | 182 | 6 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 152 | 120 | 16 | 32 | 6 x 16 A | 16000 |
| 088384 | 155 | 160-310 | 182 | 9,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 152 | 120 | 16 | 32 | 6 x 16 H | 16000 |
| 088328 | 160 | 162-320 | 182 | 14,5 | 100 | M 10 | 15 | max. 45 min. 18 | 102 | 152 | 120 | 16 | 32 | 6 x 16 C | 16000 |

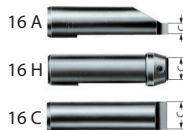
Accessories CoB

Tool group A14
Type 688-40 **Centres**



| Item no. | N | Z | Weight approx. g |
|----------|-----|----|------------------|
| 088291 ● | 120 | 25 | 390 |
| 088292 ● | 120 | 32 | 620 |
| 088293 ● | 140 | 32 | 750 |

Tool group C15
Type 689-91
driving pins, right-hand rotation



| Item no. | Diameter | Size | C | Length | Weight approx. g |
|----------|----------|------|------|--------|------------------|
| 085383 ● | 16 | 16 A | 6 | 60 | 80 |
| 088100 ● | 16 | 16 H | 9,5 | 60 | 90 |
| 085052 ● | 16 | 16 C | 14,5 | 60 | 85 |

Tool group C15
Type 689-92
driving pins, left-hand rotation



| Item no. | Diameter | Size | C | Length | Weight approx. g |
|----------|----------|------|------|--------|------------------|
| 085016 ● | 16 | 16 A | 6 | 60 | 80 |
| 088099 ● | 16 | 16 H | 9,5 | 60 | 90 |
| 085051 ● | 16 | 16 C | 14,5 | 60 | 85 |

Tool group A14
Type 680-90 **Hard metal driving plates**
right- or left-hand rotation



| Item no. | Size | Clamping circuit Ø | Weight approx. g |
|----------|---------|--------------------|------------------|
| 088209 ● | 9,5x3,2 | 40-80 | 4 |

Tool group A14
Type 688-89
Sleeve with spring set, suitable for adapter plates



| Item no. | Workpiece weight max. kg | Weight approx. g |
|----------|--------------------------|------------------|
| 086806 ■ | 500 | 800 |
| 087286 ■ | 1000 | 800 |

Power operated Face Driver CoK



CoK Type 690-00

Clamping dia. 8-80 mm mechanical compensation, slip-on driving discs

CoK Type 690-50

Clamping dia. 50 -250 mm mechanical compensation, slip-on driving discs

CoK Type 689 driving heads

Clamping dia. 63-160 mm hydraulic compensation, with interchangeable driving pins

Longitudinal workpiece stop provided in centering.

Precise tripping to workpiece centre, particularly advantageous for consecutive machining, e.g. plunge-cut grinding, etc.

Particularly suitable for turning, copying and transfer machines with automatic infeed. Can also be used for milling and plain grinding machines by virtue of the solid centre.

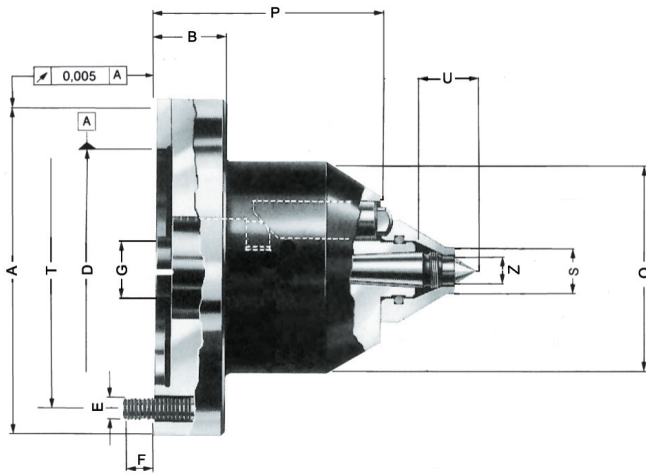
For machining workpieces which are highly unbalanced, very heavy, and require substantial removal of material or irregular cutting, e.g. square billets, forged gear components, etc.

High precision concentricity by virtue of the solid centre even with continuous hard use. Minimal centering power even with maximum cutting load.

Drivers are pressed against the workpiece by power-operated means. Uniformed loading of the mechanically or hydraulically equalising drivers. No change in the longitudinal workpiece stop through regrinding of the driving cutters. Optimum cutter run-in during opposed copy-turning through bevelled driving heads.

All wearing parts are rapidly and easily replaced. The choice of clamping cylinder required depends upon the machine and workpiece conditions. As a rule size 105 suffices with the hydraulic actuating cylinders, size 150 with the pneumatic actuating cylinders.

CoK 8-80 mm



High precision concentricity due to fixed centre point.
Driving discs are pressed against the workpiece by power operated means.

Clamping circuit Ø 8-80 mm
Mechanically compensated
Longitudinal workpiece stop in the centre

Technical features:

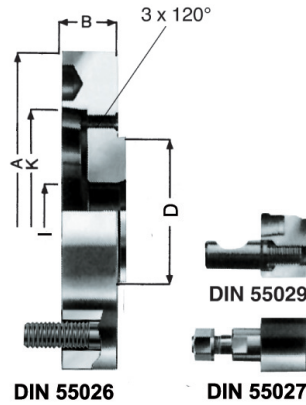
- high precision concentricity due to fixed centre point also under hard continuous operating conditions
- minimal centering power even with maximum cutting load
- workpiece weight max. 350 kg
- slip-on driving discs, solid centre

Tool group C15
Type 690-00 **basic body**
(without centre,
without draw-off nut) CoK
mechanical

| Item no. | A | B | D | E | F | G | O | P | T | Z | Stroke Centres | Weight approx. g |
|----------|-----|----|-----|------|----|----|----|----|-----|----|----------------|------------------|
| 313900 ● | 142 | 30 | 100 | M 10 | 15 | 25 | 90 | 93 | 120 | 15 | 5 | 6500 |

Draw-off nut M 14x1,5 item-no. 089229

Adapter plate CoK

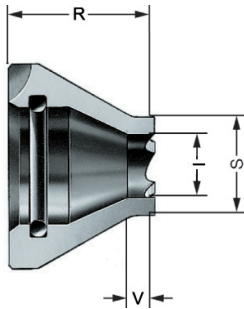


Tool group A14
Type 688-87 Adapter plate
short taper
without spring set

| Item no. | Design | Taper | A | B | D | I | K | Weight approx. g |
|----------|-----------|-------|-----|----|-----|----|---------|------------------|
| 088485 ● | DIN 55026 | 5 | 140 | 30 | 100 | 38 | 82,563 | 3100 |
| 088486 ● | DIN 55026 | 6 | 167 | 35 | 100 | 38 | 106,39 | 4800 |
| 088487 ● | DIN 55026 | 8 | 216 | 40 | 100 | 38 | 139,735 | 8700 |
| 088488 ● | DIN 55026 | 11 | 280 | 45 | 100 | 38 | 196,885 | 17000 |
| 088480 ▲ | DIN 55027 | 5 | 140 | 30 | 100 | 38 | 82,563 | 3100 |
| 088481 ▲ | DIN 55027 | 6 | 167 | 35 | 100 | 38 | 106,39 | 4800 |
| 088482 ▲ | DIN 55027 | 8 | 216 | 40 | 100 | 38 | 139,735 | 8700 |
| 088483 ▲ | DIN 55027 | 11 | 280 | 45 | 100 | 38 | 196,885 | 17000 |
| 088495 ▲ | DIN 55029 | 5 | 140 | 30 | 100 | 38 | 82,563 | 3100 |
| 088496 ▲ | DIN 55029 | 6 | 167 | 35 | 100 | 38 | 106,39 | 4800 |
| 088497 ▲ | DIN 55029 | 8 | 216 | 40 | 100 | 38 | 139,735 | 8700 |
| 088498 ▲ | DIN 55029 | 11 | 280 | 45 | 100 | 38 | 196,885 | 17000 |

Accessories CoK

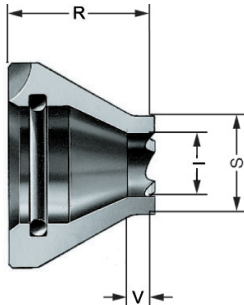
Tool group A14
Type 680-10 **Driving discs**, toothed
right-hand rotation



| Item no. | Clamping circuit Ø S | Approx. turning range | I | R | V | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|-----|----|----|--------------------------|------------------|
| 088061 ● | 8 | 9-16 | 4,5 | 38 | 4 | 4 | 120 |
| 088062 ● | 10 | 11-20 | 4,5 | 38 | 4 | 4 | 120 |
| 088063 ● | 12 | 13-24 | 7 | 36 | 4 | 6 | 120 |
| 088064 ● | 16 | 17-32 | 11 | 33 | 4 | 10 | 120 |
| 088065 ● | 20 | 21-40 | 13 | 30 | 4 | 12 | 120 |
| 088066 ● | 25 | 26-50 | 17 | 30 | 8 | 16 | 150 |
| 088067 ● | 32 | 33-64 | 22 | 30 | 10 | 16 | 190 |

Driving discs with carbide toothing, friction lining or diamant granulation on request

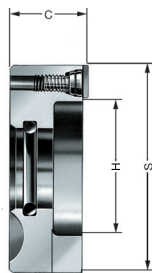
Tool group A14
Type 680-20 **Driving discs**, toothed
left-hand rotation



| Item no. | Clamping circuit Ø S | Approx. turning range | I | R | V | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|-----|----|----|--------------------------|------------------|
| 088081 ● | 8 | 9-16 | 4,5 | 38 | 4 | 4 | 120 |
| 088082 ● | 10 | 11-20 | 4,5 | 38 | 4 | 4 | 120 |
| 088083 ● | 12 | 13-24 | 7 | 36 | 4 | 6 | 120 |
| 088084 ● | 16 | 17-32 | 11 | 33 | 4 | 10 | 120 |
| 088085 ● | 20 | 21-40 | 13 | 30 | 4 | 12 | 120 |
| 088086 ● | 25 | 26-50 | 17 | 30 | 8 | 16 | 150 |
| 088087 ● | 32 | 33-64 | 22 | 30 | 10 | 16 | 190 |

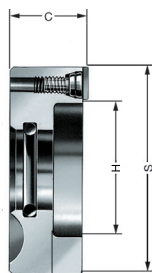
Driving discs with carbide toothing on request

Tool group A14
Type 680-12 **Driving discs**,
with interchangeable hard metal driving plates 6 x 3,2
which can be used on 4 sides
right-hand rotation



| Item no. | Clamping circuit Ø S | Approx. turning range | H | C | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|----|----|--------------------------|------------------|
| 088068 ● | 40 | 41-80 | 20 | 24 | 16 | 200 |
| 088069 ● | 50 | 51-100 | 28 | 24 | 16 | 240 |
| 088070 ● | 63 | 64-126 | 41 | 24 | 16 | 400 |
| 088071 ● | 80 | 81-160 | 58 | 24 | 16 | 600 |

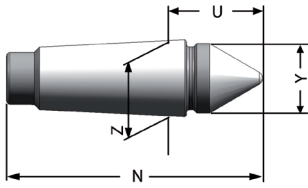
Tool group A14
Type 680-22 **Driving discs**,
with interchangeable hard metal driving plates 6 x 3,2
which can be used on 4 sides
left-hand rotation



| Item no. | Clamping circuit Ø S | Approx. turning range | H | C | Matching center point ØY | Weight approx. g |
|----------|----------------------|-----------------------|----|----|--------------------------|------------------|
| 088088 ● | 40 | 41-80 | 20 | 24 | 16 | 200 |
| 088089 ● | 50 | 51-100 | 28 | 24 | 16 | 240 |
| 088090 ● | 63 | 64-126 | 41 | 24 | 16 | 400 |
| 088091 ● | 80 | 81-160 | 58 | 24 | 16 | 600 |

Accessories CoK

Tool group C15
Type 689-40 **Centres, CoK**



| Item no. | Clamping circuit Ø | N | U | Y | Z | Workpiece weight max. kg | Weight approx. g |
|----------|--------------------|------|----|----------|----|--------------------------|------------------|
| 088121 ● | 8-10 | 67,5 | 28 | 4 | 15 | 25 | 55 |
| 088122 ● | 12 | 67 | 28 | 6 | 15 | 75 | 55 |
| 088123 ● | 16 | 67 | 28 | 10 | 15 | 150 | 55 |
| 088124 ● | 20-32 | 64 | 25 | 12 | 15 | 250 | 55 |
| 085002 ● | 40-80 | 60 | 21 | M 14x1,5 | 15 | 350 | 55 |

Tool group A14
Type 680-90 **Hard metal driving plates**
right- or left-hand rotation



| Item no. | Size | Clamping circuit Ø | Weight approx. g |
|----------|---------|--------------------|------------------|
| 088209 ● | 9,5x3,2 | 40-80 | 4 |

Tool group A14
Type 680-93 **Hard metal driving plates**
right- and left-hand rotation



| Item no. | Size | Clamping circuit Ø | Weight approx. g |
|----------|---------|--------------------|------------------|
| 087931 ● | 9,5x3,2 | 40-80 | 4 |

Tool group C15
Typ 680-90 **Clamping spindle**



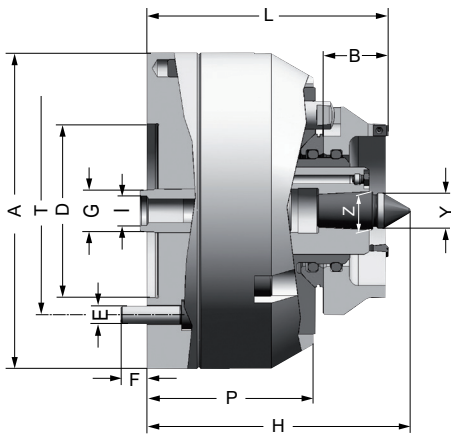
| Item no. | Size | Clamping circuit Ø | Weight approx. g |
|----------|---------|--------------------|------------------|
| 088205 ● | M 5 x 8 | 40-80 | 2 |

Tool group C15
Type 5191-Y
O-ring



| Item no. | Size |
|----------|------------|
| 006252 ● | 21,82x3,53 |

CoK 50-250 mm



High precision concentricity due to fixed centre point.
Driving discs are pressed against the workpiece by power operated means.

Clamping circuit Ø 50-250 mm
Mechanically compensated
Longitudinal workpiece stop in the centre

Technical features:

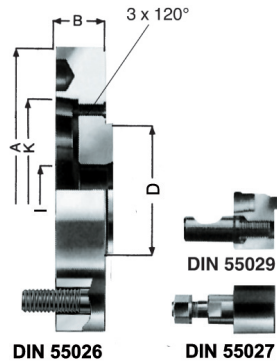
- high precision concentricity due to fixed centre point also under hard continuous operating conditions
- minimal centering power even with maximum cutting load
- workpiece weight max. 500 kg
- slip-on driving discs, solid centre

Tool group C15
Type 690-50 Power-operated
driving head with centre
Mechanically compensated

| Item no. | A | D | E | F | G | H | I | L | P | R | T | Y | Z | Weight approx. g |
|----------|-----|-----|------|----|----|-----|----|-----------------|----|----|-----|----------|----|------------------|
| 689085 ▲ | 182 | 100 | M 10 | 15 | 25 | 154 | 16 | max 150 min 134 | 96 | 38 | 120 | M 20x1,5 | 22 | 18000 |

Draw-off nut M 20x1,5 item-no. 089302

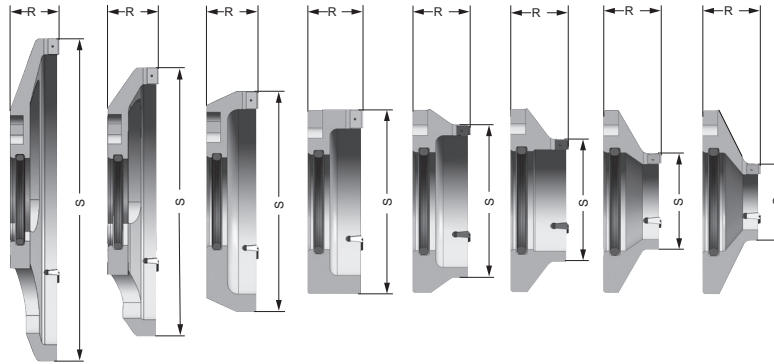
Adapter plate CoK



Tool group A14
Type 688-87 Adapter plate
short taper
without spring set

| Item no. | Design | Taper | A | B | D | I | K | Weight approx. g |
|----------|-----------|-------|-----|----|-----|----|---------|------------------|
| 088485 ■ | DIN 55026 | 5 | 140 | 30 | 100 | 38 | 82,563 | 3100 |
| 088486 ■ | DIN 55026 | 6 | 167 | 35 | 100 | 38 | 106,39 | 4800 |
| 088487 ● | DIN 55026 | 8 | 216 | 40 | 100 | 38 | 139,735 | 8700 |
| 088488 ■ | DIN 55026 | 11 | 280 | 45 | 100 | 38 | 196,885 | 17000 |
| 088480 ▲ | DIN 55027 | 5 | 140 | 30 | 100 | 38 | 82,563 | 3100 |
| 088481 ▲ | DIN 55027 | 6 | 167 | 35 | 100 | 38 | 106,39 | 4800 |
| 088482 ▲ | DIN 55027 | 8 | 216 | 40 | 100 | 38 | 139,735 | 8700 |
| 088483 ▲ | DIN 55027 | 11 | 280 | 45 | 100 | 38 | 196,885 | 17000 |
| 088495 ▲ | DIN 55029 | 5 | 140 | 30 | 100 | 38 | 82,563 | 3100 |
| 088496 ▲ | DIN 55029 | 6 | 167 | 35 | 100 | 38 | 106,39 | 4800 |
| 088497 ▲ | DIN 55029 | 8 | 216 | 40 | 100 | 38 | 139,735 | 8700 |
| 088498 ▲ | DIN 55029 | 11 | 280 | 45 | 100 | 38 | 196,885 | 17000 |

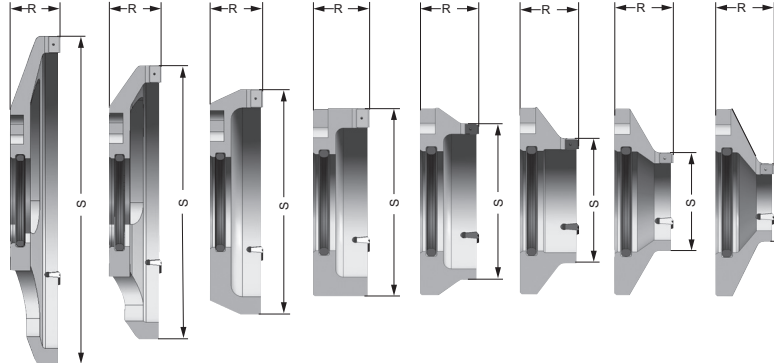
Driving discs CoK



Tool group A14
Type 687-13 **Driving discs**
with interchangeable hard metal
driving plates
right-hand rotation

| Item no. | Clamping circuit Ø S | R | Hard metal driving plate | Weight approx. g |
|------------------------|----------------------|----|--------------------------|------------------|
| 689461 ■ | 50 | 48 | 6 x 5T | 1400 |
| 689462 ■ | 63 | 45 | 6 x 5T | 1500 |
| 689463 ■ | 80 | 38 | 6 x 5T | 1500 |
| 689464 ■ | 100 | 38 | 6 x 5T | 1400 |
| 689465 ■ | 125 | 38 | 12 x 5T | 1800 |
| 689466 ■ | 160 | 38 | 12 x 5T | 2500 |
| 689467 ¹⁾ ■ | 200 | 38 | 12 x 5T | 2500 |
| 689468 ¹⁾ ■ | 250 | 38 | 12 x 5T | 3200 |

¹⁾ Weight reduced



Tool group A14
Type 687-23 **Driving discs**
with interchangeable hard metal
driving plates
left-hand rotation

| Item no. | Clamping circuit Ø S | R | Hard metal driving plate | Weight approx. g |
|------------------------|----------------------|----|--------------------------|------------------|
| 689371 ▲ | 50 | 48 | 6 x 5T | 1400 |
| 689372 ▲ | 63 | 45 | 6 x 5T | 1500 |
| 689093 ■ | 80 | 38 | 6 x 5T | 1500 |
| 689094 ■ | 100 | 38 | 6 x 5T | 1400 |
| 689095 ■ | 125 | 38 | 12 x 5T | 1800 |
| 689096 ■ | 160 | 38 | 12 x 5T | 2500 |
| 689097 ¹⁾ ■ | 200 | 38 | 12 x 5T | 2500 |
| 689098 ¹⁾ ■ | 250 | 38 | 12 x 5T | 3200 |

¹⁾ Weight reduced

Accessories CoK

Tool group A14
Type 680-90 **Hard metal driving plates**
right- or left-hand rotation



| Item no. | Size | Weight approx. g |
|----------|----------|------------------|
| 312675 ● | 6 x 5 T | 3 |
| 312911 ● | 12 x 5 T | 6 |

Tool group C15
Type 0167-Y
Threaded pin



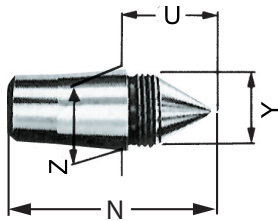
| Item no. | Size | Weight approx. g |
|----------|----------|------------------|
| 048205 ● | M 5 x 8 | 1 |
| 036461 ● | M 5 x 10 | 1 |

Tool group C15
Type 5191-Y
O-ring



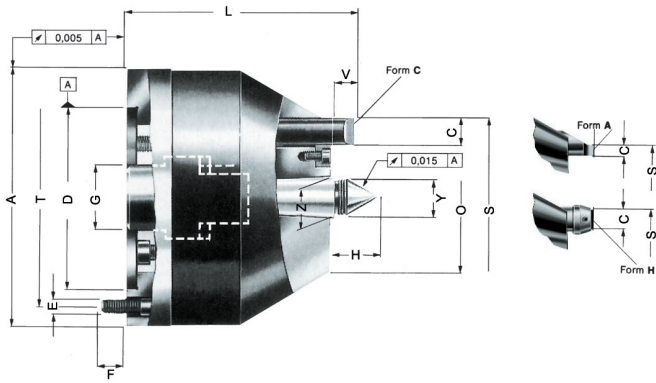
| Item no. | Size |
|----------|------------|
| 006283 ■ | 59,69x5,33 |

Tool group C15
Type 689-40 **Centres, CoK**



| Item no. | N | U | Y | Z | Weight approx. g |
|----------|----|----|----------|----|------------------|
| 313621 ● | 54 | 24 | M 20x1,5 | 22 | 112 |

Power-operated Driving Heads CoK



CoK, for hard continuous operating conditions.

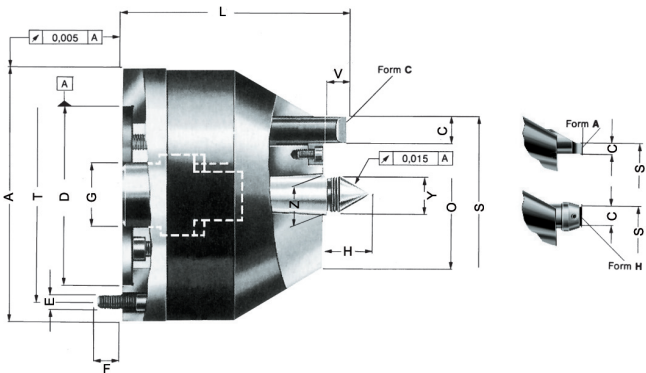
Bolt on power-operated face driver heads, hydraulically compensated with interchangeable driving pins. Driving pins can be changed to allow right-hand and left-hand rotation.

Technical features:

- max. compensating range of driving pins approx. 8 mm
- nominal value for max. loading approx. 4000 daN
- max. workpiece weight 800 kg
- **On request:** power-operated Face Driving Head CoK mechanically compensated and special designs

Tool group C15
Type 689-10 Power-operated
Face Driving Head **size 1** CoK;
hydraulic
right-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | G | H | L | O | T | V | Y | Z | Pin | Weight approx. g |
|----------|----|-----------------------|-----|------|-----|------|----|----|----|--------------|----|-----|------------|----------|----|------|------------------|
| 088441 ▲ | 63 | 65-125 | 142 | 6 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 72 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 A | 12000 |
| 088442 ▲ | 75 | 80-150 | 142 | 9,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 72 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 H | 12000 |
| 088443 ▲ | 80 | 82-160 | 142 | 14,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 72 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 C | 12000 |



CoK, for hard continuous operating conditions.

Bolt on power-operated face driver heads, hydraulically compensated with interchangeable driving pins. Driving pins can be changed to allow right-hand and left-hand rotation.

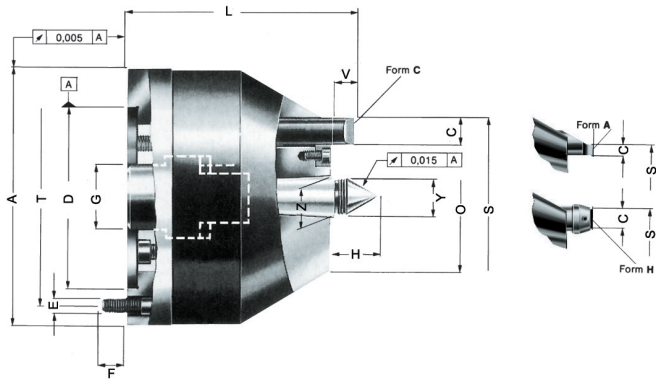
Technical features:

- max. compensating range of driving pins approx. 8 mm
- nominal value for max. loading approx. 4000 daN
- max. workpiece weight 800 kg
- **On request:** power-operated Face Driving Head CoK mechanically compensated and special designs

Tool group C15
Type 689-10 Power-operated
Face Driving Head **size 2** CoK;
hydraulic
right-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | G | H | L | O | T | V | Y | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|----|----|--------------|----|-----|------------|----------|----|------|------------------|
| 088444 ▲ | 83 | 85-165 | 142 | 6 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 92 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 A | 13000 |
| 088445 ▲ | 95 | 100-190 | 142 | 9,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 92 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 H | 13000 |
| 088446 ▲ | 100 | 102-200 | 142 | 14,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 92 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 C | 13000 |

Power-operated Driving Heads CoK



CoK, for hard continuous operating conditions.

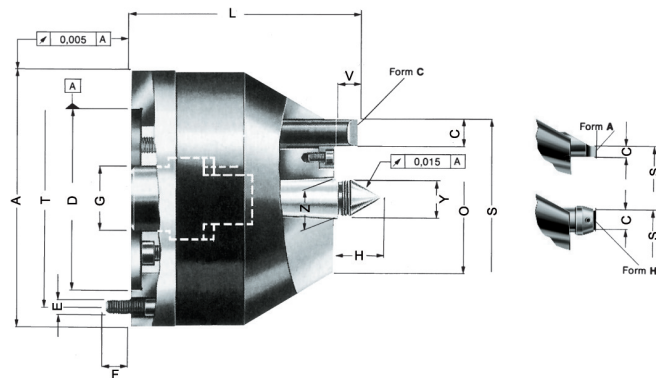
Bolt on power-operated face driver heads, hydraulically compensated with interchangeable driving pins. Driving pins can be changed to allow right-hand and left-hand rotation.

Technical features:

- max. compensating range of driving pins approx. 8 mm
- nominal value for max. loading approx. 4000 daN
- max. workpiece weight 800 kg
- **On request:** power-operated Face Driving Head CoK mechanically compensated and special designs

Tool group C15
Type 689-10 Power-operated Face Driving Head size 3 CoK; hydraulic right-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | G | H | L | O | T | V | Y | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|----|----|--------------|-----|-----|------------|----------|----|------|------------------|
| 088447 ▲ | 108 | 100-215 | 152 | 6 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 117 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 A | 16000 |
| 088448 ▲ | 120 | 125-240 | 152 | 9,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 117 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 H | 16000 |
| 088449 ▲ | 125 | 127-250 | 152 | 14,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 117 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 C | 16000 |



CoK, for hard continuous operating conditions.

Bolt on power-operated face driver heads, hydraulically compensated with interchangeable driving pins. Driving pins can be changed to allow right-hand and left-hand rotation.

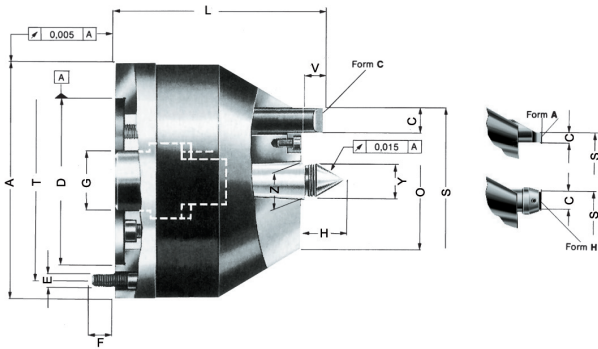
Technical features:

- max. compensating range of driving pins approx. 8 mm
- nominal value for max. loading approx. 4000 daN
- max. workpiece weight 800 kg
- **On request:** power-operated Face Driving Head CoK mechanically compensated and special designs

Tool group C15
Type 689-10 Power-operated Face Driving Head size 4 CoK; hydraulic right-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | G | H | L | O | T | V | Y | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|----|----|--------------|-----|-----|------------|----------|----|------|------------------|
| 088450 ▲ | 143 | 145-285 | 182 | 6 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 152 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 A | 23000 |
| 088451 ▲ | 155 | 160-310 | 182 | 9,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 152 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 H | 23000 |
| 088452 ▲ | 160 | 162-320 | 182 | 14,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 152 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 C | 23000 |

Power-operated Driving Heads CoK



CoK, for hard continuous operating conditions.

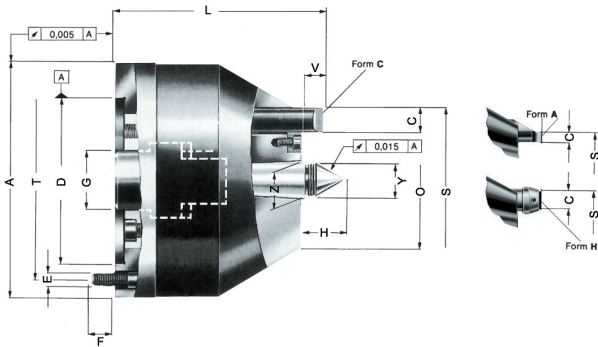
Bolt on power-operated face driver heads, hydraulically compensated with interchangeable driving pins. Driving pins can be changed to allow right-hand and left-hand rotation.

Technical features:

- max. compensating range of driving pins approx. 8 mm
- nominal value for max. loading approx. 4000 daN
- max. workpiece weight 800 kg
- **On request:** power-operated Face Driving Head CoK mechanically compensated and special designs

Tool group C15
Type 689-20 Power-operated
Face Driving Head **size 1** CoK;
hydraulic
left-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | G | H | L | O | T | V | Y | Z | Pin | Weight approx. g |
|----------|----|-----------------------|-----|------|-----|------|----|----|----|--------------|----|-----|------------|----------|----|------|------------------|
| 088461 ▲ | 63 | 65-125 | 142 | 6 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 72 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 A | 12000 |
| 088462 ▲ | 75 | 80-150 | 142 | 9,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 72 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 H | 12000 |
| 088463 ▲ | 80 | 82-160 | 142 | 14,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 72 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 C | 12000 |



CoK, for hard continuous operating conditions.

Bolt on power-operated face driver heads, hydraulically compensated with interchangeable driving pins. Driving pins can be changed to allow right-hand and left-hand rotation.

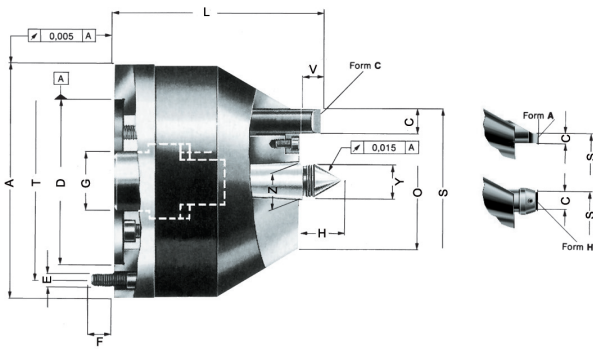
Technical features:

- max. compensating range of driving pins approx. 8 mm
- nominal value for max. loading approx. 4000 daN
- max. workpiece weight 800 kg
- **On request:** power-operated Face Driving Head CoK mechanically compensated and special designs

Tool group C15
Type 689-10 Power-operated
Face Driving Head **size 2** CoK;
hydraulic
left-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | G | H | L | O | T | V | Y | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|----|----|--------------|----|-----|------------|----------|----|------|------------------|
| 088464 ▲ | 83 | 85-165 | 142 | 6 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 92 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 A | 13000 |
| 088465 ▲ | 95 | 100-190 | 142 | 9,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 92 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 H | 13000 |
| 088466 ▲ | 100 | 102-200 | 142 | 14,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 92 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 C | 13000 |

Power-operated Driving Heads CoK



CoK, for hard continuous operating conditions.

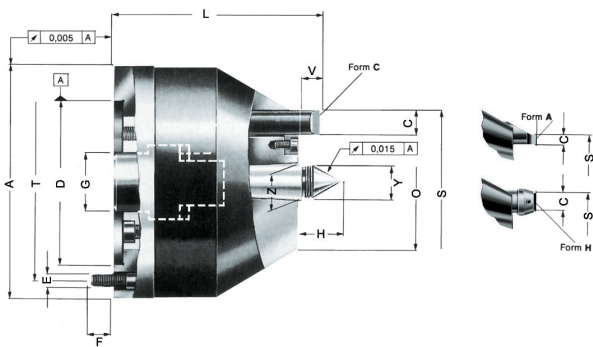
Bolt on power-operated face driver heads, hydraulically compensated with interchangeable driving pins. Driving pins can be changed to allow right-hand and left-hand rotation.

Technical features:

- max. compensating range of driving pins approx. 8 mm
- nominal value for max. loading approx. 4000 daN
- max. workpiece weight 800 kg
- **On request:** power-operated Face Driving Head CoK mechanically compensated and special designs

Tool group C15
Type 689-20 Power-operated Face Driving Head size 3 CoK; hydraulic left-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | G | H | L | O | T | V | Y | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|----|----|--------------|-----|-----|------------|----------|----|------|------------------|
| 088467 ▲ | 108 | 100-215 | 152 | 6 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 117 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 A | 16000 |
| 088468 ▲ | 120 | 125-240 | 152 | 9,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 117 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 H | 16000 |
| 088469 ▲ | 125 | 127-250 | 152 | 14,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 117 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 C | 16000 |



CoK, for hard continuous operating conditions.

Bolt on power-operated face driver heads, hydraulically compensated with interchangeable driving pins. Driving pins can be changed to allow right-hand and left-hand rotation.

Technical features:

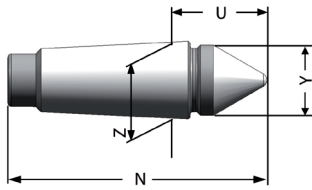
- max. compensating range of driving pins approx. 8 mm
- nominal value for max. loading approx. 4000 daN
- max. workpiece weight 800 kg
- **On request:** power-operated Face Driving Head CoK mechanically compensated and special designs

Tool group C15
Type 689-20 Power-operated Face Driving Head size 4 CoK; hydraulic left-hand rotation

| Item no. | S | Approx. turning range | A | C | D | E | F | G | H | L | O | T | V | Y | Z | Pin | Weight approx. g |
|----------|-----|-----------------------|-----|------|-----|------|----|----|----|--------------|-----|-----|------------|----------|----|------|------------------|
| 088470 ▲ | 143 | 145-285 | 182 | 6 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 152 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 A | 23000 |
| 088471 ▲ | 155 | 160-310 | 182 | 9,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 152 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 H | 23000 |
| 088472 ▲ | 160 | 162-320 | 182 | 14,5 | 100 | M 10 | 15 | 35 | 26 | 138 max. 143 | 152 | 120 | 16 max. 21 | M 20x1,5 | 22 | 16 C | 23000 |

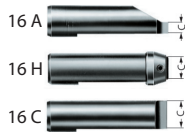
Accessories CoK

Tool group C15
Type 689-40 **Centres, CoK**



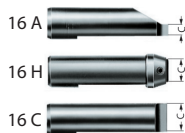
| Item no. | N | U | Y | Z | Weight approx. g |
|----------|----|----|----------|----|------------------|
| 085015 ● | 76 | 26 | M 20x1,5 | 22 | 150 |

Tool group C15
Type 689-91
driving pins, right-hand rotation



| Item no. | Diameter | Size | C | Length | Weight approx. g |
|----------|----------|------|------|--------|------------------|
| 085383 ● | 16 | 16 A | 6 | 60 | 80 |
| 088100 ● | 16 | 16 H | 9,5 | 60 | 90 |
| 085052 ● | 16 | 16 C | 14,5 | 60 | 85 |

Tool group C15
Type 689-92
driving pins, left-hand rotation



| Item no. | Diameter | Size | C | Length | Weight approx. g |
|----------|----------|------|------|--------|------------------|
| 085016 ● | 16 | 16 A | 6 | 60 | 80 |
| 088099 ● | 16 | 16 H | 9,5 | 60 | 90 |
| 085051 ● | 16 | 16 C | 14,5 | 60 | 85 |

Tool group A14
Type 680-90 **Hard metal driving plates**
right- or left-hand rotation



| Item no. | Size | Clamping circuit Ø | Weight approx. g |
|----------|---------|--------------------|------------------|
| 088209 ● | 9,5x3,2 | 40-80 | 4 |

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.

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

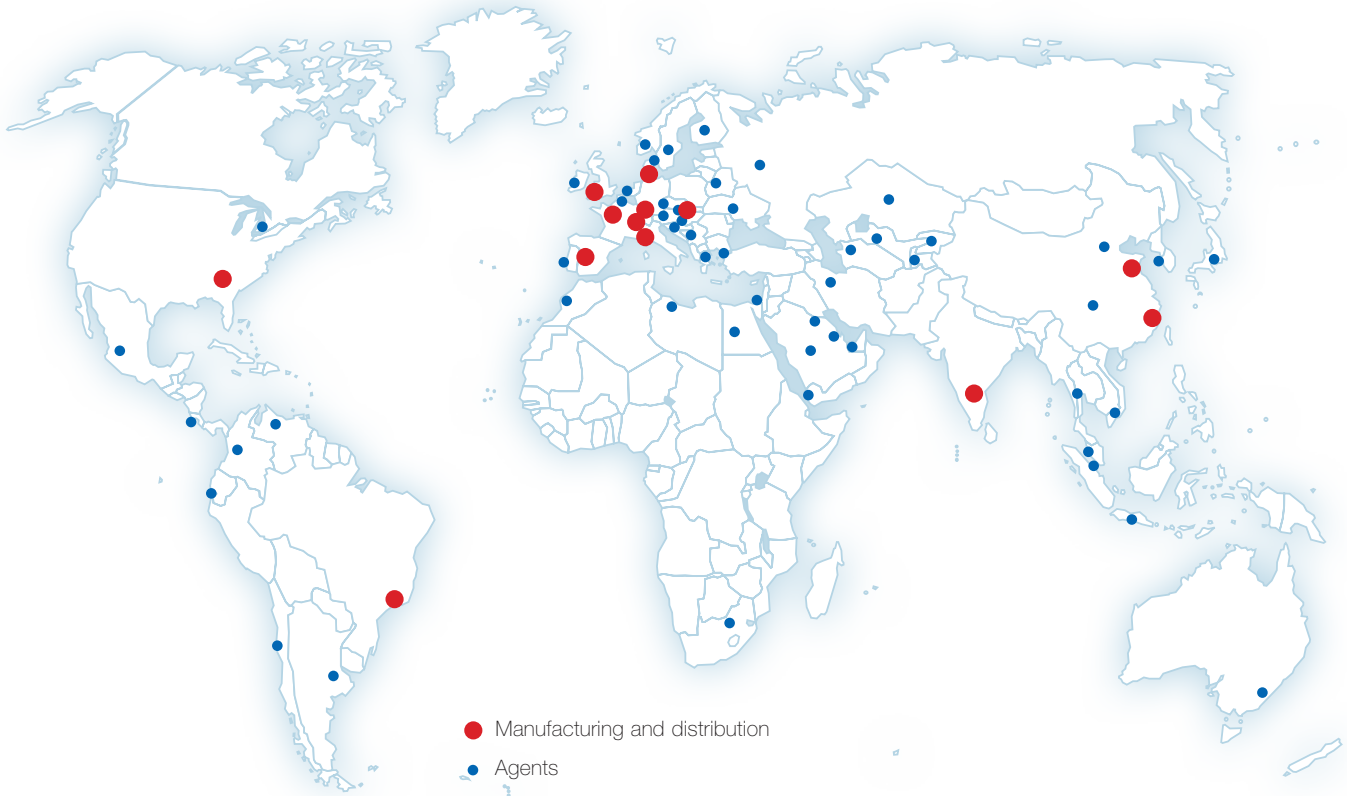


St. Georgen

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.



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.

The RÖHM manufacturing and distribution bases:



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China



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Denmark



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ROHM (Great Britain) LTD.
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§ 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 over-reached, 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 on 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.

General conditions of sale and delivery

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].

ROHM GmbH

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Revised: September 2012

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